

# Contents

<b>Series Preface</b>	<b>xi</b>
<b>Preface</b>	<b>xiii</b>
<b>1 Low and Ultralow Dielectric Constant Films Prepared by Plasma-enhanced Chemical Vapor Deposition</b>	<b>1</b>
<i>A. Grill</i>	
1.1 Introduction	1
1.2 Property Requirements for Integration	3
1.3 Characterization	4
1.4 Organic PECVD Dielectrics: Diamond-like Carbon and Fluorinated Diamond-like Carbon	6
1.4.1 Preparation	6
1.4.2 Properties of DLC-type low- <i>k</i> dielectrics	7
1.4.3 Processing of DLC-type low- <i>k</i> dielectrics	12
1.4.4 Integration of DLC-type low- <i>k</i> dielectrics	14
1.4.5 Summary	15
1.5 SiCOH Films as Low- <i>k</i> and Ultralow- <i>k</i> Dielectrics	15
1.5.1 Preparation	16
1.5.2 Properties of SiCOH and pSiCOH dielectrics	18
1.5.3 Integration of SiCOH as the interconnect dielectric	29
1.6 Conclusions	30
Addendum	30
References	30
<b>2 Spin-on Dielectric Materials</b>	<b>33</b>
<i>Geraud Dubois, Robert D. Miller, and Willi Volksen</i>	
2.1 Introduction	33
2.2 Spin-on Dense Materials	37
2.2.1 Organic polymers	37
2.2.2 Inorganic polymers	38
2.3 Spin-on Porous Materials	47
2.3.1 Porogen free systems	48
2.3.2 Porogen-containing systems	51
2.4 New Processing Strategy to Integration Issues	70
2.5 Summary	71
Acknowledgments	72
References	73

<b>3 Porosity of Low Dielectric Constant Materials</b>	<b>85</b>
3.1 Introduction	86
3.2 Positron Annihilation Spectroscopy	86
<i>David W. Gidley, Hua-Gen Peng, and Richard Vallery</i>	
3.2.1 Introduction	86
3.2.2 Overview of the PALS experimental technique	87
3.2.3 Ps in porous films	89
3.2.4 Pore characterization with PALS	91
3.2.5 Future improvements in PAS capabilities	98
3.2.6 Conclusion	99
Acknowledgments	100
3.3 Structure Characterization of Nanoporous Interlevel Dielectric Thin Films with X-ray and Neutron Radiation	100
<i>Christopher L. Soles, Hae-Jeong Lee, Bryan D. Vogt, Eric K. Lin,     and Wen-li Wu</i>	
3.3.1 Introduction	100
3.3.2 Thin film density by X-ray reflectivity (XR)	101
3.3.3 Small-angle X-ray/neutron scattering	103
3.3.4 Pore wall density and pore structure	103
3.3.5 X-ray porosimetry	106
3.3.6 Comparison of small-angle scattering and X-ray porosimetry	114
3.3.7 Conclusions	116
Acknowledgments	117
3.4 Ellipsometric Porosimetry	117
<i>Mikhail R. Baklanov</i>	
3.4.1 Introduction	117
3.4.2 Fundamentals of ellipsometric porosimetry	117
3.4.3 Porosity characterization by EP	120
3.4.4 Conclusions	130
Acknowledgments	131
References	131
<b>4 Mechanical and Transport Properties of Low-<i>k</i> Dielectrics</b>	<b>137</b>
<i>J.L. Plawsky, R. Achanta, W. Cho, O. Rodriguez, R. Saxena, and W.N. Gill</i>	
4.1 Introduction	137
4.1.1 Classification of Low- <i>k</i> Dielectrics	137
4.2 Mechanical Properties	145
4.2.1 Introduction	145
4.2.2 Modulus	146
4.2.3 Interfacial properties	150
4.3 Thermal Properties of Low- <i>k</i> Materials	171
4.3.1 Thermal stability	171
4.3.2 Thermal conductivity of low- <i>k</i> dielectric films	173
4.4 Interaction of Porous Materials with Metals and Barrier Materials	179
4.4.1 The effect of the chemistry of the dielectric	179
4.4.2 The effect of dielectric morphology	187
4.5 Conclusions	188
References	190

<b>5</b>	<b>Integration of Low-<math>k</math> Dielectric Films in Damascene Processes</b>	<b>199</b>
	<i>R.J.O.M. Hoofman, V.H. Nguyen, V. Arnal, M. Broekaart, L.G. Gosset, W.F.A. Besling, M. Fayolle, and F. Iacopi</i>	
5.1	Introduction	199
5.2	Damascene Integration Approaches	201
5.2.1	From aluminum to copper in integrated circuits	201
5.2.2	Dual damascene architectures	204
5.3	Low- $k$ Integration Challenges	212
5.3.1	Resist poisoning	212
5.3.2	Compatibility of low- $k$ materials with wet cleaning	214
5.3.3	Compatibility of metallic diffusion barriers with low- $k$ materials	215
5.3.4	Pore sealing	223
5.3.5	Processing damage to low- $k$ films	227
5.3.6	CMP compatibility	235
5.4	Reliability Challenges	238
	Acknowledgments	239
	References	240
<b>6</b>	<b>ONO Structures and Oxynitrides in Modern Microelectronics: Material Science, Characterization and Application</b>	<b>251</b>
	<i>Yakov Roizin and Vladimir Gritsenko</i>	
6.1	Introduction	252
6.2	Technology and Basic Properties of Silicon Nitride/Oxynitride Films and ONO Stacks	253
6.2.1	Traditional deposition techniques	254
6.2.2	Silicon nitrides and oxynitrides as gate dielectrics	255
6.2.3	ONO stacks for advanced memories	259
6.2.4	Compositional analyses of device-quality ONO stack	263
6.3	Atomic Structure of Silicon Oxynitride	269
6.4	Traps in the Nitride Layer of ONO	272
6.5	Charge Transport in Silicon Nitride	274
6.6	Device Applications of ONO Structures	280
6.6.1	Traditional SONOS	280
6.6.2	NROM memories	283
6.6.3	High- $k$ dielectrics in SONOS memories	286
6.7	Conclusion	290
	References	290
<b>7</b>	<b>Material Engineering of High-<math>k</math> Gate Dielectrics</b>	<b>297</b>
	<i>Akira Toriumi and Koji Kita</i>	
7.1	Introduction	297
7.2	Dielectric Permittivity of High- $k$ Insulators	299
7.2.1	General	299
7.2.2	Microscopic polarization	300
7.3	Lattice Vibration	302
7.4	Electronic Structure	305
7.5	High- $k$ Film Growth	308
7.6	Interface Layer	310

7.6.1	Interface layer properties	311
7.6.2	Interface layer formation process	312
7.7	HfO <sub>2</sub> -based Ternary Oxides	317
7.7.1	HfSiO <sub>x</sub> and HfAlO <sub>x</sub>	317
7.7.2	New candidates for amorphous High- <i>k</i> dielectric films	321
7.7.3	Dielectric permittivity engineering	324
7.8	High- <i>k</i> MOSFET	330
7.8.1	Inversion layer mobility	330
7.8.2	Threshold voltage	332
7.9	Summary	332
	Acknowledgments	333
	References	333
<b>8</b>	<b>Physical Characterization of Ultra-thin High-<i>k</i> Dielectric</b>	<b>337</b>
	<i>T. Conard, H. Bender, and W. Vandervorst</i>	
8.1	Introduction	337
8.2	Surface Preparation	340
8.2.1	HfO <sub>2</sub> on Si by ALCVD	340
8.2.2	SrTiO <sub>3</sub> on Si by MBE	342
8.2.3	HfO <sub>2</sub> on Ge by MOCVD	342
8.3	Growth Mode	343
8.4	Film Thickness	346
8.5	Density	349
8.6	Composition	350
8.6.1	Bulk composition	350
8.6.2	Contamination	353
8.6.3	Interfacial layer characterization	354
8.7	Bandgap and band-offset	359
8.8	Crystallography	362
8.9	Defects	363
8.10	Conclusion	366
	References	366
<b>9</b>	<b>Electrical Characterization of Advanced Gate Dielectrics</b>	<b>371</b>
	<i>Robin Degraeve, Jurriaan Schmitz, Luigi Pantisano, Eddy Simoen, Michel Houssa, Ben Kaczer and Guido Groeseneken</i>	
9.1	Introduction	371
9.2	Impact of Scaling of SiO <sub>2</sub> -based Gate Dielectrics	374
9.2.1	Gate leakage current	374
9.2.2	<i>C-V</i> measurements and interpretation	377
9.2.3	Charge pumping	381
9.2.4	Noise characterization and modeling	386
9.2.5	Time-dependent dielectric breakdown	392
9.2.6	Negative-bias temperature instability	400
9.3	Characterization of High- <i>k</i> Dielectrics and Metal Gates	404
9.3.1	Effective oxide thickness: EOT vs CET	404
9.3.2	Gate workfunction	405

9.3.3 Interface and bulk defect characterization	409
9.3.4 Noise characterization and modeling	414
9.3.5 Time-dependent dielectric breakdown	416
9.3.6 Negative-bias temperature instability	420
9.4 Conclusions	422
References	423
<b>10 Integration Issues of High-<i>k</i> Gate Dielectrics</b>	<b>437</b>
<i>Yasuo Nara</i>	
10.1 Introduction	437
10.2 Thermal Stability Improvement by Nitrogen Incorporation	439
10.3 Interfacial Characteristics Between High- <i>k</i> and Silicon Substrate	440
10.4 Gate Material Selection: Poly-Si Gate vs Metal Gate	443
10.5 Integration of 65 nm Node HfSiON Transistor with SRAM	447
Acknowledgments	449
References	450
<b>11 Anisotropic Conductive Film (ACF) for Advanced Microelectronic Interconnects</b>	<b>453</b>
<i>Yi Li and C. P. Wong</i>	
11.1 Introduction	454
11.2 Materials	456
11.2.1 Adhesive matrix	457
11.2.2 Conductive fillers	458
11.3 Electrical Properties	458
11.3.1 Self-assembled monolayer (SAM)	458
11.3.2 Thermal behavior of monolayer coating	461
11.3.3 Electrical properties of ACA with SAM	462
11.3.4 Thermal conductivity of ACA	462
11.3.5 Low-temperature sintering of nano-Ag-filled ACE	464
11.4 Assembly	464
11.5 Applications	467
11.5.1 Application of ACA/ACF in flip-chip	467
11.5.2 SMT applications	468
11.5.3 ACF for liquid crystal display (LCD) applications	468
11.6 Reliability	470
11.7 Future Advances of ACF	471
11.7.1 Materials development	471
11.7.2 High-frequency compatibility	471
11.7.3 Reliability	472
11.7.4 Wafer-level application	472
11.8 Conclusion	472
References	473
<b>Index</b>	<b>477</b>

