

Contents

Preface	XV
Obituary	XVII
List of Contributors	XXI
Introduction	XXV

Part One Technologies 1

A. Adhesive and Anodic Bonding 3

1	Glass Frit Wafer Bonding	3
	<i>Roy Knechtel</i>	
1.1	Principle of Glass Frit Bonding	3
1.2	Glass Frit Materials	4
1.3	Screen Printing: Process for Bringing Glass Frit Material onto Wafers	5
1.4	Thermal Conditioning: Process for Transforming Printed Paste into Glass for Bonding	8
1.5	Wafer Bond Process: Essential Wafer-to-Wafer Mounting by a Glass Frit Interlayer	11
1.6	Characterization of Glass Frit Bonds	14
1.7	Applications of Glass Frit Wafer Bonding	15
1.8	Conclusions	16
	References	17
2	Wafer Bonding Using Spin-On Glass as Bonding Material	19
	<i>Viorel Dragoi</i>	
2.1	Spin-On Glass Materials	19
2.2	Wafer Bonding with SOG Layers	21
2.2.1	Experimental	21
2.2.2	Wafer Bonding with Silicate SOG Layers	22
2.2.3	Wafer Bonding with Planarization SOG	28

2.2.4	Applications of Adhesive Wafer Bonding with SOG Layers	29
2.2.5	Conclusion	30
	References	31
3	Polymer Adhesive Wafer Bonding	33
	<i>Frank Niklaus and Jian-Qiang Lu</i>	
3.1	Introduction	33
3.2	Polymer Adhesives	34
3.2.1	Polymer Adhesion Mechanisms	34
3.2.2	Properties of Polymer Adhesives	36
3.2.3	Polymer Adhesives for Wafer Bonding	38
3.3	Polymer Adhesive Wafer Bonding Technology	42
3.3.1	Polymer Adhesive Wafer Bonding Process	43
3.3.2	Localized Polymer Adhesive Wafer Bonding	50
3.4	Wafer-to-Wafer Alignment in Polymer Adhesive Wafer Bonding	52
3.5	Examples for Polymer Adhesive Wafer Bonding Processes and Programs	54
3.5.1	Bonding with Thermosetting Polymers for Permanent Wafer Bonds (BCB) or for Temporary Wafer Bonds (mr-I 9000)	54
3.5.2	Bonding with Thermoplastic Polymer (HD-3007) for Temporary and Permanent Wafer Bonds	56
3.6	Summary and Conclusions	57
	References	58
4	Anodic Bonding	63
	<i>Adriana Cozma Lapadatu and Kari Schjølberg-Henriksen</i>	
4.1	Introduction	63
4.2	Mechanism of Anodic Bonding	64
4.2.1	Glass Polarization	64
4.2.2	Achieving Intimate Contact	65
4.2.3	Interface Reactions	66
4.3	Bonding Current	67
4.4	Glasses for Anodic Bonding	68
4.5	Characterization of Bond Quality	69
4.6	Pressure Inside Vacuum-Sealed Cavities	70
4.7	Effect of Anodic Bonding on Flexible Structures	71
4.8	Electrical Degradation of Devices during Anodic Bonding	71
4.8.1	Degradation by Sodium Contamination	72
4.8.2	Degradation by High Electric Fields	73
4.9	Bonding with Thin Films	75
4.10	Conclusions	76
	References	77

B. Direct Wafer Bonding 81

- 5 Direct Wafer Bonding 81**
Manfred Reiche and Ulrich Gösele
- 5.1 Introduction 81
 - 5.2 Surface Chemistry and Physics 82
 - 5.3 Wafer Bonding Techniques 84
 - 5.3.1 Hydrophilic Wafer Bonding 84
 - 5.3.2 Hydrophobic Wafer Bonding 86
 - 5.3.3 Low-Temperature Wafer Bonding 88
 - 5.3.4 Wafer Bonding in Ultrahigh Vacuum 89
 - 5.4 Properties of Bonded Interfaces 90
 - 5.5 Applications of Wafer Bonding 93
 - 5.5.1 Advanced Substrates for Microelectronics 93
 - 5.5.2 MEMS and Nanoelectromechanical Systems 95
 - 5.6 Conclusions 95
 - References 96
- 6 Plasma-Activated Bonding 101**
Maik Wiemer, Dirk Wuensch, Joerg Braeuer, and Thomas Gessner
- 6.1 Introduction 101
 - 6.2 Theory 102
 - 6.2.1 (Silicon) Direct Bonding 102
 - 6.2.2 Mechanisms of Plasma on Silicon Surfaces 103
 - 6.2.3 Physical Definition of a Plasma 104
 - 6.3 Classification of PAB 104
 - 6.3.1 Low-Pressure PAB 105
 - 6.3.2 Atmospheric-Pressure PAB 106
 - 6.4 Procedure of PAB 107
 - 6.4.1 Process Flow 107
 - 6.4.2 Characterization Techniques 108
 - 6.4.3 Experiments and Results 110
 - 6.5 Applications for PAB 111
 - 6.5.1 Pressure Sensor 112
 - 6.5.2 Optical Microsystem 112
 - 6.5.3 Microfluidics Packaging 113
 - 6.5.4 Backside-Illuminated CMOS Image Sensor 113
 - 6.5.5 CMOS Compatibility of Low-Pressure PAB 114
 - 6.6 Conclusion 115
 - References 115
- C. Metal Bonding 119**
- 7 Au/Sn Solder 119**
Hermann Oppermann and Matthias Hutter
- 7.1 Introduction 119

7.2	Au/Sn Solder Alloy	120
7.3	Reflow Soldering	127
7.4	Thermode Soldering	130
7.5	Aspects of Three-Dimensional Integration and Wafer-Level Assembly	132
7.6	Summary and Conclusions	135
	References	136
8	Eutectic Au–In Bonding	139
	<i>Mitsumasa Koyanagi and Makoto Motoyoshi</i>	
8.1	Introduction	139
8.2	Organic/Metal Hybrid Bonding	140
8.3	Organic/In–Au Hybrid Bonding	142
8.3.1	In–Au Phase Diagram and Bonding Principle	142
8.3.2	Formation of In–Au Microbumps by a Planarized Liftoff Method	144
8.3.3	Eutectic In–Au Bonding and Epoxy Adhesive Injection	146
8.3.4	Electrical Characteristics of In–Au Microbumps	148
8.4	Three-Dimensional LSI Test Chips Fabricated by Eutectic In–Au Bonding	149
8.5	High-Density and Narrow-Pitch Microbump Technology	152
8.6	Conclusion	157
	Acknowledgment	157
	References	157
9	Thermocompression Cu–Cu Bonding of Blanket and Patterned Wafers	161
	<i>Kuan-Neng Chen and Chuan Seng Tan</i>	
9.1	Introduction	161
9.2	Classification of the Cu Bonding Technique	162
9.2.1	Thermocompression Cu Bonding	162
9.2.2	Surface-Activated Cu Bonding	162
9.3	Fundamental Properties of Cu Bonding	163
9.3.1	Morphology and Oxide Examination of Cu Bonded Layer	163
9.3.2	Microstructure Evolution during Cu Bonding	164
9.3.3	Orientation Evolution during Cu Bonding	165
9.4	Development of Cu Bonding	166
9.4.1	Fabrication and Surface Preparation of Cu Bond Pads	166
9.4.2	Parameters of Cu Bonding	167
9.4.3	Structural Design	168
9.5	Characterization of Cu Bonding Quality	169
9.5.1	Mechanical Tests	169
9.5.2	Image Analysis	170
9.5.3	Electrical Characterization	171
9.5.4	Thermal Reliability	171

9.6	Alignment Accuracy of Cu–Cu Bonding	171
9.7	Reliable Cu Bonding and Multilayer Stacking	172
9.8	Nonblanket Cu–Cu Bonding	174
9.9	Low-Temperature (<300°C) Cu–Cu Bonding	176
9.10	Applications of Cu Wafer Bonding	178
9.11	Summary	178
	References	179
10	Wafer-Level Solid–Liquid Interdiffusion Bonding	181
	<i>Nils Hoivik and Knut Aasmundtveit</i>	
10.1	Background	181
10.1.1	Solid–Liquid Interdiffusion Bonding Process	181
10.1.2	SLID Bonding Compared with Soldering	182
10.1.3	Material Systems for SLID Bonding	183
10.2	Cu–Sn SLID Bonding	189
10.2.1	Cu–Sn Material Properties and Required Metal Thicknesses	190
10.2.2	Bonding Processes	191
10.2.3	Pretreatment Requirements for SLID Bonding	195
10.2.4	Fluxless Bonding	196
10.3	Au–Sn SLID Bonding	199
10.3.1	Au–Sn Material Properties and Required Metal Thicknesses	199
10.3.2	Bonding Processes	199
10.4	Application of SLID Bonding	201
10.4.1	Cu–Sn Bonding	201
10.4.2	Au–Sn Bonding	204
10.5	Integrity of SLID Bonding	207
10.5.1	Electrical Reliability and Electromigration Testing	207
10.5.2	Mechanical Strength of SLID Bonds	207
10.6	Summary	210
	References	212
	D. Hybrid Metal/Dielectric Bonding	215
11	Hybrid Metal/Polymer Wafer Bonding Platform	215
	<i>Jian-Qiang Lu, J. Jay McMahon, and Ronald J. Gutmann</i>	
11.1	Introduction	215
11.2	Three-Dimensional Platform Using Hybrid Cu/BCB Bonding	217
11.3	Baseline Bonding Process for Hybrid Cu/BCB Bonding Platform	220
11.4	Evaluation of Cu/BCB Hybrid Bonding Processing Issues	222
11.4.1	CMP and Bonding of Partially Cured BCB	222
11.4.2	Cu/BCB CMP Surface Profile	223

11.4.3	Hybrid Cu/BCB Bonding Interfaces	224
11.4.4	Topography Accommodation Capability of Partially Cured BCB	227
11.4.5	Electrical Characterization of Hybrid Cu/BCB Bonding	231
11.5	Summary and Conclusions	232
	Acknowledgments	233
	References	233
12	Cu/SiO₂ Hybrid Bonding	237
	<i>Léa Di Cioccio</i>	
12.1	Introduction	237
12.2	Blanket Cu/SiO ₂ Direct Bonding Principle	239
12.2.1	Chemical Mechanical Polishing Parameters	239
12.2.2	Bonding Quality and Alignment	243
12.3	Blanket Copper Direct Bonding Principle	245
12.4	Electrical Characterization	251
12.5	Die-to-Wafer Bonding	255
12.5.1	Daisy Chain Structures	256
12.6	Conclusion	257
	Acknowledgment	257
	References	258
13	Metal/Silicon Oxide Hybrid Bonding	261
	<i>Paul Enquist</i>	
13.1	Introduction	261
13.2	Metal/Non-adhesive Hybrid Bonding—Metal DBI®	261
13.3	Metal/Silicon Oxide DBI®	262
13.3.1	Metal/Silicon Oxide DBI® Surface Fabrication	263
13.3.2	Metal/Silicon Oxide DBI® Surface Patterning	264
13.3.3	Metal/Silicon Oxide DBI® Surface Topography	264
13.3.4	Metal/Silicon Oxide DBI® Surface Roughness	264
13.3.5	Metal/Silicon Oxide DBI® Surface Activation and Termination	265
13.3.6	Metal/Silicon Oxide DBI® Alignment and Hybrid Surface Contact	265
13.3.7	Metal Parameters Relevant to DBI® Surface Fabrication and Electrical Interconnection	268
13.3.8	DBI® Metal/Silicon Oxide State of the Art	270
13.4	Metal/Silicon Nitride DBI®	271
13.5	Metal/Silicon Oxide DBI® Hybrid Bonding Applications	273
13.5.1	Pixelated 3D ICs	273
13.5.2	Three-Dimensional Heterogeneous Integration	275
13.5.3	CMOS (Ultra) Low-k 3D Integration	276
13.6	Summary	276
	References	277

Part Two Applications 279

- 14 Microelectromechanical Systems 281**
Maaïke M.V. Taklo
- 14.1 Introduction 281
 - 14.2 Wafer Bonding for Encapsulation of MEMS 282
 - 14.2.1 Protection during Wafer Dicing 282
 - 14.2.2 Routing of Electrical Signal Lines 282
 - 14.3 Wafer Bonding to Build Advanced MEMS Structures 284
 - 14.3.1 Stacking of Several Wafers 284
 - 14.3.2 Post-processing of Bonded Wafers 285
 - 14.4 Examples of MEMS and Their Requirements for the Bonding Process 286
 - 14.5 Integration of Some Common Wafer Bonding Processes 287
 - 14.5.1 Fusion Bonding of Patterned Wafers 287
 - 14.5.2 Anodic Bonding of Patterned Wafers 290
 - 14.5.3 Eutectic Bonding of Patterned Wafers: AuSn 293
 - 14.6 Summary 297
 - References 297
- 15 Three-Dimensional Integration 301**
Philip Garrou, James Jian-Qiang Lu, and Peter Ramm
- 15.1 Definitions 301
 - 15.2 Application of Wafer Bonding for 3D Integration Technology 303
 - 15.3 Motivations for Moving to 3D Integration 305
 - 15.4 Applications of 3D Integration Technology 307
 - 15.4.1 Three-Dimensional Applications by Evolution Not Revolution 307
 - 15.4.2 Microbump Bonding/No TSV 308
 - 15.4.3 TSV Formation/No Stacking 310
 - 15.4.4 Memory 312
 - 15.4.5 Memory on Logic 321
 - 15.4.6 Repartitioning Logic 322
 - 15.4.7 Foundry and OSAT Activity 323
 - 15.4.8 Other 3D Applications 323
 - 15.5 Conclusions 325
 - References 325
- 16 Temporary Bonding for Enabling Three-Dimensional Integration and Packaging 329**
Rama Puligadda
- 16.1 Introduction 329
 - 16.2 Temporary Bonding Technology Options 330
 - 16.2.1 Key Requirements 331
 - 16.2.2 Foremost Temporary Wafer Bonding Technologies 332

16.3	Boundary Conditions for Successful Processing	337
16.3.1	Uniform and Void-Free Bonding	337
16.3.2	Protection of Wafer Edges during Thinning and Subsequent Processing	337
16.4	Three-Dimensional Integration Processes Demonstrated with Thermomechanical Debonding Approach	338
16.4.1	Via-Last Process on CMOS Image Sensor Device Wafers	338
16.4.2	Via-Last Process with Aspect Ratio of 2:1	341
16.4.3	Via-Last Process with 50 μm Depth Using High-Temperature TEOS Process	341
16.4.4	Die-to-Wafer Stacking Using Interconnect Via Solid-Liquid Interdiffusion Process	342
16.5	Concluding Remarks	343
	Acknowledgments	344
	References	344
17	Temporary Adhesive Bonding with Reconfiguration of Known Good Dies for Three-Dimensional Integrated Systems	347
	<i>Armin Klumpp and Peter Ramm</i>	
17.1	Die Assembly with SLID Bonding	347
17.2	Reconfiguration	348
17.3	Wafer-to-Wafer Assembly by SLID Bonding	349
17.4	Reconfiguration with Ultrathin Chips	351
17.5	Conclusion	352
	Acknowledgments	353
	References	354
18	Thin Wafer Support System for above 250 °C Processing and Cold De-bonding	355
	<i>Werner Pamler and Franz Richter</i>	
18.1	Introduction	355
18.2	Process Flow	356
18.2.1	Release Layer Processing	357
18.2.2	Carrier Wafer Processing	357
18.2.3	Bonding Process	357
18.2.4	Thinning	359
18.2.5	De-bonding Process	360
18.2.6	Equipment	361
18.3	Properties	361
18.3.1	Device Wafer Thickness	361
18.3.2	Thickness Uniformity	361
18.3.3	Stability	362
18.4	Applications	362
18.4.1	Bonding of Bumped Wafers	363

18.4.2	Packaging of Ultrathin Dies	363
18.4.3	TSV Processing	364
18.4.4	Re-using the Carrier	364
18.5	Conclusions	364
	Acknowledgments	365
	References	365
19	Temporary Bonding: Electrostatic	367
	<i>Christof Landesberger, Armin Klumpp, and Karlheinz Bock</i>	
19.1	Basic Principles: Electrostatic Forces between Parallel Plates	367
19.1.1	Electric Fields and Electrostatic Forces in a Plate Capacitor	368
19.1.2	Electrostatic Attraction in a Bipolar Configuration	369
19.1.3	Johnsen–Rahbek Effect	370
19.2	Technological Concept for Manufacture of Mobile Electrostatic Carriers	371
19.2.1	Selection of Substrate Material	371
19.2.2	Selection of Thin-Film Dielectric Layers	372
19.2.3	Electrode Patterns: Materials and Geometry	374
19.2.4	Examples of Mobile Electrostatic Carriers	375
19.3	Characterization of Electrostatic Carriers	376
19.3.1	Electrical and Thermal Properties, Leakage Currents	376
19.3.2	Possible Influence of Electrostatic Fields on CMOS Devices	378
19.4	Electrostatic Carriers for Processing of Thin and Flexible Substrates	379
19.4.1	Handling and Transfer of Thin Semiconductor Wafers	379
19.4.2	Wafer Thinning and Backside Metallization	380
19.4.3	Electrostatic Carriers in Plasma Processing	380
19.4.4	Electrostatic Carriers Enable Bumping of Thin Wafers	380
19.4.5	Electrostatic Carriers in Wet-Chemical Environments	381
19.4.6	Electrostatic Handling of Single Dies	381
19.4.7	Processing of Foils and Insulating Substrates	381
19.5	Summary and Outlook	382
	References	383
	Index	385

