

MULTILAYER CERAMIC SUBSTRATE -TECHNOLOGY FOR VLSI PACKAGE/ MULTICHIP MODULE

K.OTSUKA

CERAMIC RESEARCH AND DEVELOPMENT IN JAPAN

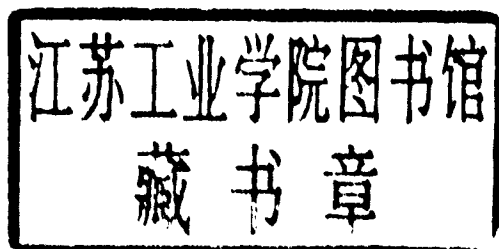
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Multilayer ceramic substrate-technology for VLSI package/multichip module

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Ceramic Research and Development in Japan

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Foreword

Dr. Kanji Otsuka graduated from the Department of Ceramics, Kyoto Institute of Technology in 1959 and the following year joined the staff of Hitach Co. Ltd. Since that time, he has worked and developed semiconductors, multilayers ceramic substrate and their devices. This book is one of the results of study by Dr. Kanji Otsuka.

Dr. Kanji Otsuka studied multilayer printed board made with alumina ceramics. Embedded printed wiring of metal was one of the subjects. The attainment of a wiring pattern with high accuracy is described in this book.

It is necessary to be cofired between alumina and tungsten metal powder. Therefore the firing shrinkages between the ceramics and metal powder need to be matched and be simultaneously made up to the final dimensions of design values. These controls are done by the ceramic porosity adjustment. Powder arrangement and the characteristics of bulk density and air permeation in the green forming ceramics should consequently be well under control.

Many parameters underlying this composite structure must be in the optimization. Therefore, quantitative scientific analysis in each process and these relations are needed. This book illustrates this point and leads to a guide line for the fine products.

I recommended him to publish his results as a book style, because this book promotes R & D of multilayer ceramic substrates for semiconductors and computer usage. This book is recommended to students, researchers and engineers in the fields of electronic ceramics, makers and users, all over the world, developed countries and underdeveloped countries because as for starting materials, he used natural raw materials. I am sure this book will prove to be a milestone in the field of ceramic multilayer substrates.

Shigeyuki Sóniya
Dean Professor
The Nishi Tokyo University
Professor Emeritus
Tokyo Institute of Technology

Contents

Foreword

vii

1	Introduction	
1.1	Introduction	1
1.2	Past and current studies	4
1.3	Objects and significance of this research	9
2	Modeling of fine powder mixing and measurement of the degree of mixing	
2.1	Object of this study	11
2.2	Study of mixing models	12
2.3	Experimental methods	17
	2.3.1 Mixing method	17
	2.3.2 Methods of measurement	18
2.4	Result and discussion	22
	2.4.1 Decision of sample size	22
	2.4.2 Sample size and degree of mixing	22
	2.4.3 Mixing speed	25
	2.4.4 The density of the green material in relation to the degree of mixing	31
	2.4.5 Sintering density and the degree of mixing	31
2.5	Summary	36
3	Simulation of the flowpath in the doctor-blade and its application to raising the precision of green sheet thickness	
3.1	Object of the study	39
3.2	Experimental procedure	40
	3.2.1 Slurry preparation method	40
	3.2.2 Forming green sheets	45
3.3	Derivation of an equation relating casting conditions and green sheet thickness	47
3.4	Experimental results and discussion	53
3.5	Improving thickness precision by means of a 2-stage blade	59
	3.5.1 Derivation of an equation for calculating sheet thickness with a 2-stage blade	
	3.5.2 Correlation between experimental results and simulation calculations for the 2-stage blade	64

3.6	Preliminary validation of the dimensional stability of green sheets	69
3.6.1	The purpose of the confirmation and experimental methods	69
3.6.2	Study of the stability of sheet dimension during printing and drying	73
3.6.3	Validation of creep characteristics	74
3.6.4	Adhesion of sheets with different binder contents	75
3.7	Summary	77
4	Improving dimensional precision by firing in a reducing atmosphere	
4.1	Purpose of the studies	81
4.2	Experimental methods	82
4.2.1	Green sheet preparation	82
4.2.2	Sample preparation for measurement	83
4.2.3	Firing method	83
4.2.4	Methods for measuring the various conditions	86
4.2.4.1	Observations on the process of binder decomposition	86
4.2.4.2	Observation on sintering in ceramics	87
4.2.4.3	Measurements of sintering sample characteristics	88
4.3	Results related to binder burn-out and ceramic sintering, and discussion	91
4.3.1	Investigation of the thermal decomposition of the binder burn-out	91
4.3.2	Study of the sintering process in this ceramic system without organic binder	95
4.3.3	Study of the relationship between binder burn-out and ceramic sintering	97
4.3.4	Summary	101
4.4	The relationship between the binder burn-out and sintering under varied mixing conditions	103
4.4.1	Changes in shrinkage and bulk density in air firing in green sheets mixed under varied conditions	103
4.4.2	Relationship between shrinkage in dimensions and bulk density with firing in a moist reducing gas atmosphere in sheets made under different mixing conditions	107
4.4.3	Changes in the sintering mechanism with differing mixing conditions	110

4.4.4	The relationship between firing temperature and gas permeability in green sheets mixed under different conditions	119
4.4.5	Discussion of variation in firing shrinkage	120
4.5	Summary	124
5	Effect of forming and firing conditions on the dimensions of ceramics	
5.1	Object of the study	127
5.2	Experimental method	127
5.2.1	Preparation of green sheets	127
5.2.2	Firing conditions	128
5.3	Relationship between green sheet thickness and firing shrinkage or bulk density	131
5.4	Relationship between sheet thickness and shrinkage in the casting direction	133
5.5	Experiments on the relationships between furnace structure, atmosphere and organic binder content, and dimensional shrinkage	138
5.5.1	Effect of water vapour concentration in the firing atmosphere	138
5.5.2	Binder content and variation in firing shrinkage	139
5.5.3	Relationship of gas flow rate and location in the furnace to variation in shrinkage	142
5.6	Summary	146
5.6.1	The relationship of dimensions and shrinkage with physical dimensions, furnace structure, atmosphere and amount of binder	146
5.7	Systematic consideration of starting material particle size and particle alignment in preforming	147
5.8	Systematic consideration of sheet thickness	154
5.9	Systematic consideration of ceramic firing conditions	157
5.10	Overall summary of Chapter 4 and Chapter 5	161
5.10.1	The mutual relationship between the removal of polyvinyl butyral binder in firing alumina ceramics in an atmosphere of reducing gas and the sintering of the ceramics	161
6	Improving the strength of tungsten metallization on alumina ceramics	
6.1	Purpose of the study	163
6.2	Experimental methods	165
6.2.1	Starting materials	165
6.2.2	Preparation of specimens	168

6.2.3	Methods of measurement	169
6.2.3.1	Bonding strength	169
6.2.3.2	Air-tightness	170
6.2.3.3	Bending strength	171
6.3	Results and discussion	171
6.3.1	Effect of metallizing particle size and thickness on bonding strength	171
6.3.2	Effect of alumina content of the ceramics on bonding strength	175
6.3.3	Effect of firing conditions on bonding strength	175
6.3.4	The bending strength after firing of mixed ceramic-tungsten powders	176
6.3.5	Analysis of the ceramic/metal interface by SEM and XMA	180
6.4	Summary	182
7	Study of fine wire aluminium metallization on alumina ceramics	
7.1	Purpose of the studies	185
7.2	Experimental methods	185
7.2.1	Specific preparation	185
7.2.2	Measurement methods (Fig. 7.4)	189
7.3	Experimental result and discussion	190
7.4	Summary	195
8	Electrical insulation between fine metallization on alumina ceramics, and its protection	
8.1	Purpose of the study	197
8.2	Experimental methods	198
8.2.1	Sample preparation	198
8.2.1.1	Samples for measuring electrical current leakage	198
8.2.1.2	Samples forming protecting structures	202
8.2.2	Measurement method	202
8.2.2.1	Measurement of changes in surface state	202
8.2.2.2	Measurement of the reliability of the protecting structures	203
8.3	Experimental result and discussion	203
8.3.1	Changes in surface electrical resistance	203
8.3.2	Study of protecting structures	207
8.3.3	Summary	214

9	Summary	
9.1	Guidelines obtained by production process	215
9.1.1	Formulation of ceramic raw materials and organic binders	215
9.1.2	Dry mixing	215
9.1.3	Addition of organic solvents	217
9.1.4	Wet mixing	217
9.1.5	Casting and drying	217
9.1.6	Punching registration holes	217
9.1.7	Printing tungsten paste into patterns and drying	217
9.1.8	Through hole punching	218
9.1.9	Hot pressure lamination	218
9.1.10	Organic binder burn-out and the firing of ceramics	218
9.1.11	Additional metallization and metal surface finishing	219
9.1.12	Protection of metallization pattern	219
9.2	Overall summary	219
	<i>References</i>	223
	<i>Index</i>	233

1 | Introduction

1.1 INTRODUCTION

Recent developments in computers, computer peripherals and electronic consumer products owe much to the development of semiconductor devices, namely ICs and LSIs. There have also been considerable developments in the technology for incorporating these LSIs into equipment. Wiring substrates are particularly important as components for connecting semiconductor devices with each other and with input/output devices. To enable high-speed signal exchange, the wiring on wiring substrates needs to be short. In order to achieve this, fine wiring techniques become necessary to decrease the horizontal surface of the wiring substrates; this also fulfils the need for size reduction. The development of highly integrated high performance LSIs also entails the necessity for raising the wiring density of wiring substrates, leading to the wide adoption of multilayer wiring.

Techniques for producing fine and highly integrated (multilayer) wiring substrates have received a lot of effort. Broadly speaking there are two types of so called printed circuits, employing glass-fibre-reinforced epoxy resin boards and copper metallization; and multilayer ceramic wiring substrates, with tungsten or molybdenum metallization on alumina ceramic. The former type is used for applications requiring wiring over a relatively large surface area; the latter type is mainly intended for applications requiring small highly-integrated wiring systems. The upshot of this distinction is that microfine processing is more advanced for the latter type than the former type, and the method for making the latter type is more suited to fine processing. This book is concerned with the latter type-multilayer alumina ceramic wiring substrates, and with syste-

matic studies into improving dimensional precision, and into techniques for metallization.

In making multilayer alumina ceramic wiring substrates, preforms already furnished with metallized wiring are hardened by passing through a firing process. At this time they shrink by 10% or more; in terms of surface area there is a large shrinkage of something under 30%. Variations in this shrinkage are reflected in variations in the dimensions of the finished products, and this hinders the production of high-precision fine wired packages for semiconductors. Because the metallized wiring is also fired, it is necessary to have some means for preventing the oxidization of the metal making up the metallized wiring (firing in a reducing atmosphere), but this also hinders the loss of the organic binder employed when making the preform. In the preform, the ceramics and the metallization are both in the form of powders held firm by binders, and the filled state differs with the particle size of the

Table 1.1. Typical Ceramic Materials for the LSI Packages and Boards

<i>Materials</i>	<i>Composition</i>	<i>Thermal coefficient of expansion 0–100°C (10⁻⁶ °C⁻¹)</i>	<i>Thermal conductivity (W/m · K)</i>	<i>Dielectric constant/ MHz</i>	<i>Young's modulus (GPa)</i>	<i>Modulus of rupture (MPa)</i>
Alumina	Al ₂ O ₃ 92–95% SiO ₂ , MgO etc	6.0–6.5	15–30	8.5–9.5	270–380	300–350
Silicon carbide	SiC > 99%	3.5	150–270	40	420	450
Aluminum nitride	AlN > 99%	4.0	100–170	8.5–9.0	320	450
Mullite	3Al ₂ O ₃ ·2SiO ₂ , SiO ₂ , CaO etc	3.6–4.0	4–6	5–6.8	180	80–200
Glass-ceramics	Borosilicate glass and alumina	3.5–4.0	3–7	5–7	160–200	80–200

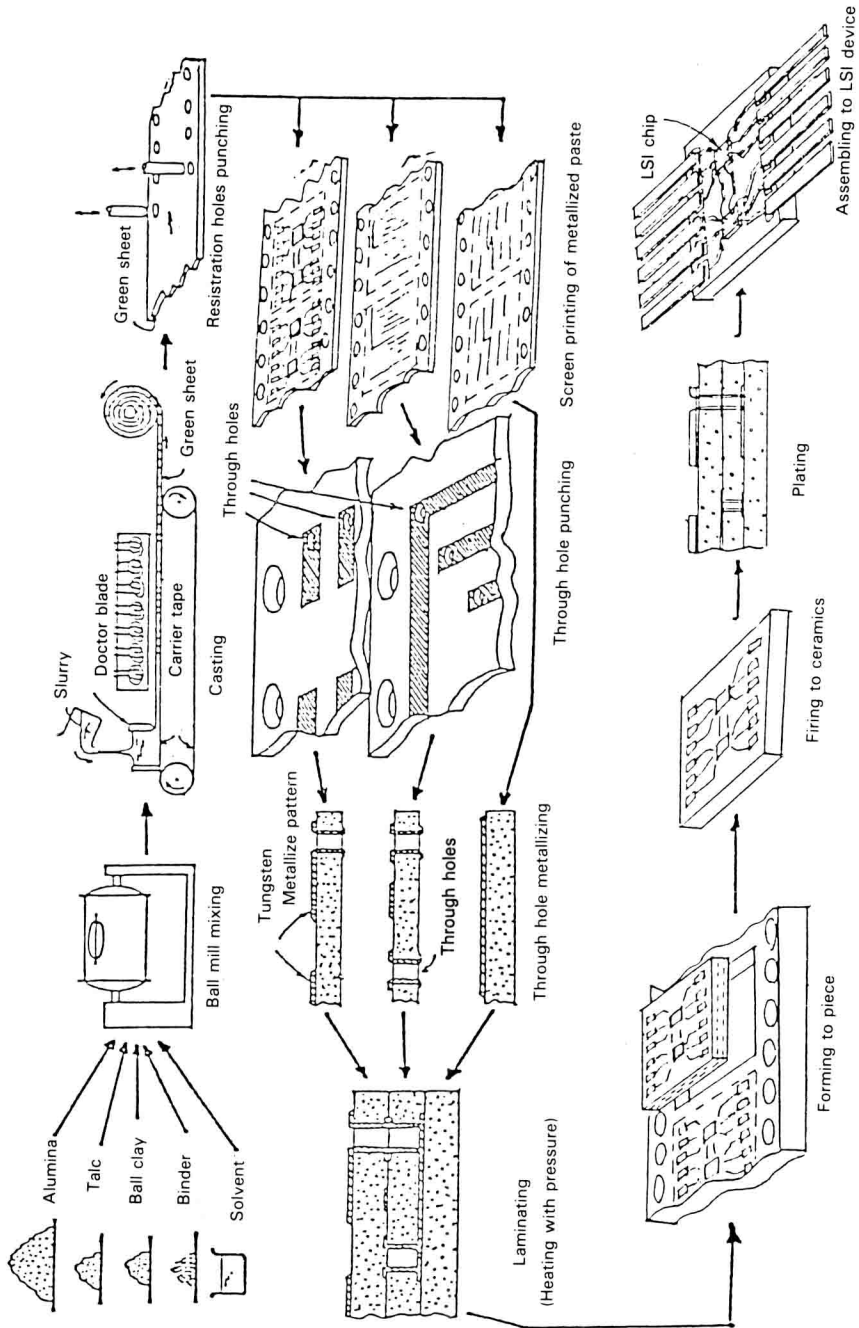


Fig. 1.1. Production Process for multilayer package of LSI's.

powders and the state of mixing. Many factors, such as the sintering reaction of the powder, binding between the ceramic and the metallization, and the degree to which shrinkages are matched, etc., during firing contribute to variations in dimensions. When it comes to optimizing the system as a whole, trade-offs are necessary among these various factors. To date there have been few theoretical or practical studies concerned with these systems as a whole, so this was the main thrust of this research. Because raising dimensional precision affects the strength of metallization bonding, studies were also undertaken on the conditions for obtaining this strength and on the mechanism of bonding. Additional studies concerned suitable ways to protect the insulation of metallization arranged with very small gaps and to prevent it from breaking down.

1.2 PAST AND CURRENT STUDIES

The concept of alumina ceramic multilayer circuit boards was announced by Gyurk and Liederbach (1960), incorporating the current processing method (green sheets being produced using a doctor blade and lamination of sheets with metallized patterns). Since the announcement of this method, this technology has been that normally employed for advanced substrates for semiconductor elements. Stetson and Schwartz (1961) developed this concept, and announced an idea for enabling complex and free wiring bonding, in which wiring, embedded in a layered structure, intersected in three dimensions. Liederbach and Stetson (1961) gave examples of practical applications for this structure; and this concept has continued to the present time. The processes involved in the most common method are shown in Fig. 1.1 and the material possibility is listed in Table 1.1.

A lot of research has subsequently been carried out on improving this method of manufacture, improving the materials, etc. Alm and Miller (1966) proposed a method of copper impregnation, to overcome the drawbacks of molybdenum wiring materials, which cultivate porosity and have high electrical resistance. Schwartz and Wilcox (1967) enumerated the factors that need to be controlled in this method, and discussed the need for design optimization balancing all of these factors, singling out the main factors to control. Thus, by preparing and mixing particulate ceramic starting materials, a binder and a solvent, green sheets like paper are made

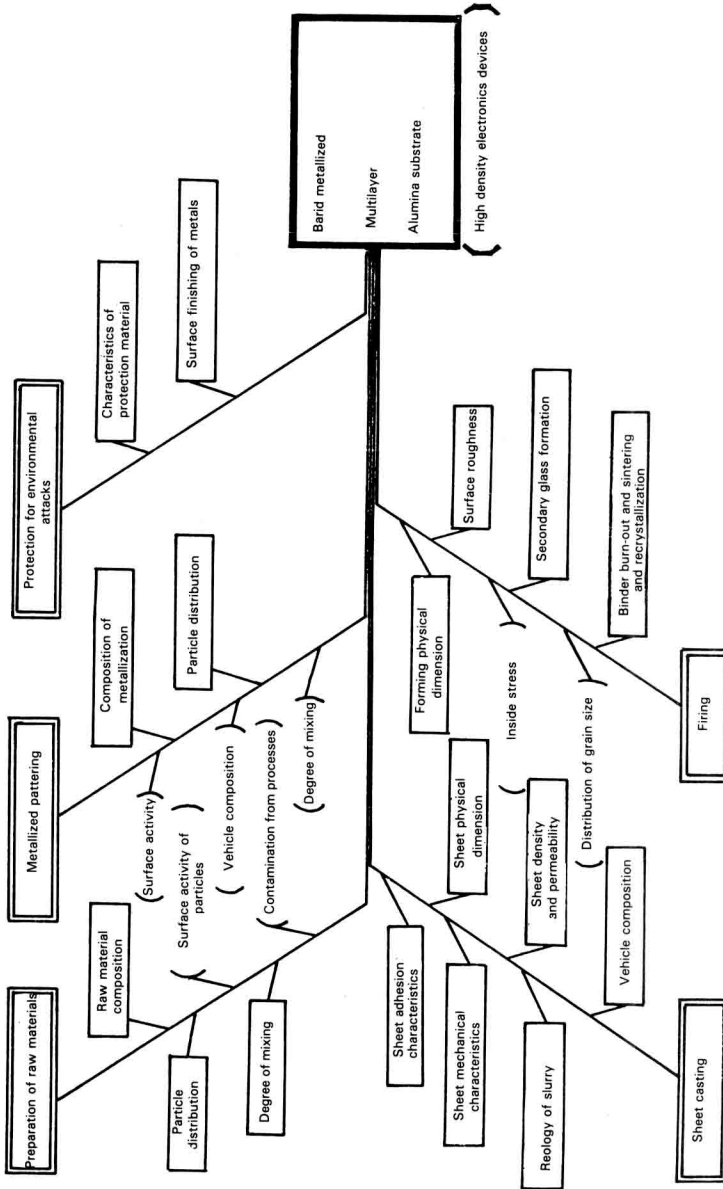


Fig. 1.2. Essential factors in high-precision processing of internal wired multilayered alumina ceramic wiring substrates with protecting structures. 1. Preparation of alumina starting materials; 2. Metallization; 3. Protection from the environment; 4. Starting material composition; 5. Metallization composition; 6. Protecting material characteristics; a. (degree of activity); b. (degree of activity of starting materials); c. (vehicle composition); d. (process contaminants); e. (degree of mixing); 7. Particle size distribution; 8. Metallization particle size; 9. Added metallization characteristics; 10. Degree of mixing; 11. Multilayer alumina ceramic substrates with internal metallized wiring, fitted with a protecting structure f. (devices with high density electronic circuits); 12. Sheet adhesion characteristics; 13. Product dimensions and shape; 14. Sheet mechanical properties; 15. Sheet dimensions and shape; 16. Surface roughness; g. (stresses within the complex); h. (grain size distribution); 17. Slurry rheology; 18. Sheet density and porosity; 19. Amount of glass recrystallization; 20. Vehicle composition; 21. Porosity after burn-out of organic binder; 22. Sheet processing; 23. Firing.

with a constant controlled porosity. As well as enabling metallizing paste to be printed without blotting, this is also beneficial when it comes to embedding the thickness of the metallized wires in the green sheet during lamination. Changes in porosity are caused by pressure during lamination, and in order to keep the changes uniform it is important to improve the flatness of the green sheets, i.e. improve precision with regard to thickness. By ensuring a constant degree of activation among particles in the aligned state before firing, variations in firing shrinkage can be kept within $\pm 1\%$. Metallizing materials are chosen which have a similar firing shrinkage and coefficient of thermal expansion to those of the ceramic, and which react well (sinterability) with the ceramic. Firing is carried out in a reducing atmosphere so as to prevent the oxidation of the metallization, and sintering is carried out after burning out the organic binder. And the control of particle size and pore size in the ceramic is important for obtaining stable firing shrinkage and strength. However, Schwartz and Wilcox do not deal in any way with quantitative aspects. The factors which are generally controlled at the present time, including the suggestions of Schwartz and Wilcox, are summarized in Fig. 1.2. Everett (1969) reported that with the above method the variation in firing shrinkage could be kept to $\pm 1\%$, and that fine wiring 100 μm wide could be printed, but there are no reports that this has actually been achieved. Keeping the variation in firing shrinkage small leads to improvements in the dimensional precision of the finished multilayer substrates (precision in the relative positioning of the wires), and is an important factor when it comes to making high-precision multilayer substrates, but in more than 20 years since the publication of these reports there have been no reports directly concerning the stabilization of shrinkage.

The inventor of the concept, Gyurk (1960), pointed out that substrate firing should be carried out in an atmosphere of reducing gas with water vapour to keep a balance between the promotion of binder burn-off and the prevention of metal oxidization, but he did not establish a firing temperature curve. Finch (1960) reported that binder burn-off required holding at a temperature of 600°C. It is now widely recognized that binder burn-off is difficult to accomplish in a reducing atmosphere, and this is one factor which causes large variations in firing shrinkage. Use of platinum metallization to enable firing in an oxidizing atmosphere was proposed by Keller, Pirigyi, Cole and Budd (1969). This approach had the advantage of

burning the binder off easily and keeping variations in firing shrinkage low; however, it has not been used in practice because of the high cost of platinum. Chance (1970) showed that when tungsten metallization was fired the whole substrate was put under a strain by differences in shrinkage, and he investigated the effects of matching shrinkages on the strength of bonding between the metallization and the ceramic. Wilcox (1971) investigated the pros and cons of the selection of a wide variety of ceramic materials and metallization materials, and concluded that alumina and beryllia ceramics, and molybdenum and tungsten metallization were most suitable. He also reported that these materials were more suitable than epoxy-resin printed circuits or thick film wiring substrates for fine wiring, enabling wire widths of 100 μm , through holes 100 μm in diameter, and virtually infinite lamination. This is generally acknowledged at the present time. Finch, Kaiser, Pakulski and Reardon (1970) proposed the concept of continuous manufacture of multilayer wiring substrates (loop conveyor belt process).

Surtani (1971) reported that the air-tightness of Mo/Mn metallization on alumina ceramics was completed by permeation of the metallization layer by a glass matrix formed from the alumina ceramic. Because it is necessary for the metallization in multilayer substrates to be firmly secured when it comes to soldering on the external connecting pins, this research, together with that of Chance mentioned above, includes many indications for future research.

Hargis (1971) suggested that at that time the actual variation in firing shrinkage was $\pm 1\%$, but that it was possible to decrease it to $\pm 0.5\%$ by optimizing the different manufacturing processes. However, they did not make any concrete proposals as to optimum conditions. Shanefield and Mistler (1971) were the first to reveal the doctor-blade method for making thin ceramic sheets (green sheets); the method which they proposed was similar to that used today. They also obtained a variation of $\pm 0.5\%$ in firing shrinkage (not including metallization). Shanefield and Mistler (1974) also reported that for avoiding the agglomeration of powdered ceramics in mixtures with organic solvents it is important to add a defloculating agent, and that fish oil is suitable for this purpose.

Gardner and Nufer (1984) investigated the mechanical properties of green sheets and clarified the relationships among effective solvent permeability with respect to metallization printing, deformation during lamination, each of punching holes, and binder content.