

# 1995 SYMPOSIUM ON VLSI TECHNOLOGY

DIGEST OF TECHNICAL PAPERS



TECHNOLOGY  
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## DIGEST OF TECHNICAL PAPERS



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# FIFTEENTH ANNIVERSARY 1995 SYMPOSIUM ON VLSI TECHNOLOGY

For the fifteenth anniversary of the Symposium on VLSI Technology we have brought the Symposium to Oiso, Japan. At this occasion, as we look back at the fruitful years after the tenth anniversary of the Symposium, we have requested the chairmen of the past five years to give us their perspective of the Symposium. We would like to recognize and appreciate the dedication and hard work of these people in shaping the Symposium on VLSI Technology into one of the leading meetings in our industry.

## Takashi Tokuyama



Chairman,  
1991 Oiso

First Symposium was held in Maui in 1981 after three years of careful preparation from the original proposal of Prof. Tanaka and Prof. Kosonocky in 1978. The primary aim of the Symposium was to exchange information between Japan and US VLSI engineers and scientists. However, the other side of the purpose was to create personal friendship between Symposium attendants. I recollect the discussions made at the 10th anniversary (1990) Symposium in Honolulu on the future issue of VLSI technology. The recognition among attendants was an urgent necessity of R&D collaborations between the companies since big amount of investment is expected unavoidable in the future VLSI developments. Today, five years past since then, international collaborations between the companies are becoming common. The success of these collaborations, unnecessary to say, depends very much on the human relations between engineers and scientists, which I would like to emphasize, were being built during 15 years of personal relations among Symposium attendants.

The development of 1GbitDRAM prototype was already reported. The cost of information processing should be improved continuously in the next 5~10 years through the realization of low cost distribution of such highly integrated ULSIs. On the other hand, future semiconductor industry should be developed in the form gentle and friendly to the living earth since environmental requirements and resource preservation will become more and more important. I believe our Symposium will continuously play an significant role in the evolution of VLSI technology.

## Dirk J. Bartelink



Co-Chairman,  
1991 Oiso

Chairman,  
1992 Seattle

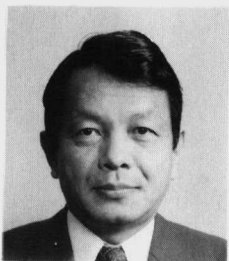


The ancient traditions of Kyoto present an excellent backdrop for reflecting on the history and future of the VLSI Technology Symposium. The globalization of the semiconductor industry is proof of the wisdom in launching the Symposium 15 years ago. It is now widely recognized that the penetration of VLSI in our society is too pervasive and its economic impact too great to prevent the semiconductor industry from spreading around the globe. What is not so widely recognized, other than by the specialists gathered here for the VLSI Symposia, is that only mainstream standardization provides the ability to solve the many nearly insurmountable barriers to progress. Therefore, cooperation is critical. Cooperation amongst companies is just as important to keeping the whole industry moving forward as competitiveness is critical to advancing the individual company. This cooperation begins with the informal exchange of views as provided at the Symposia and succeeds through the friendship and trust generated by years of repeat encounters. Congratulations to the organizers of this 15th Anniversary meeting in maintaining the proven traditions of the VLSI Technology Symposium.

As the world semiconductor industry tries to maintain its momentum in providing ever improving cost per function, new concepts will be required. These concepts must respect the manufacturing experience that is central to VLSI. Through their focus on VLSI and now ULSI, the Symposia provide a unique forum for assessing alternative device technologies in the full light of manufacturing and design concerns. There is no better way of shedding this light than through the traditions of cooperation established at the VLSI Symposia.

RB007 / 03

## Shojiro Asai



Co-Chairman,  
1992 Seattle

Chairman,  
1993 Kyoto

Anything that can be called a world-class success underlies an open-minded philosophy that calls on all possibly available talents from all over the world. The Symposium on VLSI Technology has been successful because it could get the cream of world's VLSI engineering community to contribute over its entire history. It has served, as envisioned by Professors Shoji Tanaka and Walter Kosonocky, as a forum of exchange of information on the most advanced technology and as a meeting place for those who are making all that happen. Everybody who has participated has had the sense of excitement and reward being part of the growth of a very important technology—the VLSI. I hope that the Symposium will keep playing the role it has played over the past fifteen years, and that its spirit will outlive the physical limits of the technology.

## James T. Clemens



Co-Chairman,  
1993 Kyoto

Chairman,  
1994 Honolulu

It is indeed interesting to reflect back on the VLSI Symposia and my personal involvement with it. Silicon technology has grown exponentially for the past thirty years. VLSI ( $>10^6$  components per circuit) began to develop in the late 1970's, and it was at this time that Prof. Tanaka and Prof. Kosonocky perceived the need for an international forum, where individuals could exchange their ideas concerning the wide variety of issues facing this industry. VLSI is now embedded in essentially every part of our daily life. And the technical challenges of the future are clearly in front of us. There is much to be done. As with VLSI technology itself, the Symposia have grown in a profound manner during the past fifteen years. The VLSI Symposia are now truly the premier symposia in the field of microelectronics, with its yearly attendees representing the dynamic international nature of this scientific field.

In 1987, I was asked to present an invited paper on deep ultraviolet lithography in Karuizawa, and my affiliation with the Symposia's organizational effort then began. I feel honored to have met and collaborated with a such a distinguished, international group of individuals. Each year at the Symposia, we witness new technical advancements and new technical leaders emerge. It has been a privilege to serve this Symposia and help disseminate the technical information that has so positively affected the quality of life. At its fifteenth anniversary, I would like to offer my congratulations to everyone who has been involved, from the attendees, to the authors, and to the organizers, and to extend my wishes for continued success. Finally, I would like to thank the Symposia for enriching the experiences of both my personal and professional life.

## Hiroyoshi Komiya



Co-Chairman,  
1994 Honolulu

Chairman,  
1995 Kyoto

Since the tenth anniversary of the symposium in 1990 in Hawaii, a rapid increase in the production cost of VLSIs has been being given more attention. This increase might result primarily from the increase in the difficulty of VLSI technology, although the progress in DRAM generations has been continuing with the same rate as that in the past. We must make a big breakthrough in the next five years to overcome this problem. VLSI Symposia have been ones of leading conferences for the progress in the technology of the semiconductor industry and growing together with its expansion. I believe that VLSI Symposia would play an important role to make this breakthrough and will continue to keep their high position in the field of VLSI technology. In such circumstances, however, the number of papers which describe the technology having the high novelty but low usefulness or little feasibility of industrialization often tends to increase. For keeping a position of VLSI Symposia high, we shall have to make more effort to gather high quality papers in future.

This year, we had a big disaster due to the earthquake in Kobe area. Fortunately, however, there occurred little and relatively small damages in Kyoto and Osaka areas, respectively. I am very happy as the chairman to hold the conference with little trouble.

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# CONTENTS

## Session 1: Welcome and Plenary Session [Shunju]

1-2	Semiconductor CIM System; Innovation Toward The Year 2000 (Invited) . . . . .	1
	. . . . . M. Iiri, G. Inoue and S. Asakura	
1-3	Manufacturing Technology Challenges for Low Power Electronics (Invited) . . . . .	5
	. . . . . Z. J. Lemnios	

## Session 2: High Performance CMOS Technologies [Shunju]

2-1	High Performance Sub-Tenth Micron CMOS Using Advanced Boron Doping and WSi <sub>2</sub> Dual Gate Process . . . . .	9
	. . . . . K. Takeuchi, T. Yamamoto, A. Furukawa, T. Tamura and K. Yoshida	
2-2	Silicided Silicon-Sidewall Source and Drain (S <sup>4</sup> D) Structure for High-Performance 75-nm Gate Length pMOSFETs . . . . .	11
	. . . . . T. Yoshitomi, M. Saito, T. Ohguro, M. Ono, H. S. Momose and H. Iwai	
2-3	A 6.93- $\mu\text{m}^2$ n-Gate Full CMOS SRAM Cell Technology with High-Performance 1.8-V Dual-Gate CMOS for Peripheral Circuits . . . . .	13
	. . . . . M. Minami, N. Ohki, H. Ishida, T. Yamanaka, K. Ishibashi, A. Shimizu, T. Kure, T. Nishida and T. Nagano	
2-4	A Fully Planarized 0.25 $\mu\text{m}$ CMOS Technology for 256 Mbit DRAM and Beyond . . . . .	15
	. . . . . G. Bronner, H. Aochi, M. Gall, J. Gambino, S. Gernhardt, E. Hammerl, H. Ho, J. Iba, H. Ishiuchi, M. Jaso, R. Kleinhenz, T. Mii, M. Narita, L. Nesbit, W. Neumueller, A. Nitayama, T. Ohiwa, S. Parke, J. Ryan, T. Sato, H. Takato and S. Yoshikawa	

## Session 3A: 0.1-Micron (0.1 $\mu\text{m}$ ) MOSFETs [Shunju I]

3A-1	New CoSi <sub>2</sub> SALICIDE Technology for 0.1 $\mu\text{m}$ Processes and Below . . . . .	17
	. . . . . Q. F. Wang, K. Maex, S. Kubicek, R. Jonckheere, B. Kerkwijk, R. Verbeeck, S. Biesemans and K. De Meyer	
3A-2	Highly Reliable 0.15 $\mu\text{m}$ MOSFETs with Surface Proximity Gettering (SPG) and Nitrided Oxide Spacer Using Nitrogen Implantation . . . . .	19
	. . . . . T. Kuroi, S. Shimizu, A. Furukawa, S. Komori, Y. Kawasaki, S. Kusunoki, Y. Okumura, M. Inuishi, N. Tsubouchi and K. Horie	
3A-3	The Influence of Oxygen at Epitaxial Si/Si Substrate Interface for 0.1 $\mu\text{m}$ Epitaxial Si Channel N-MOSFETs Grown by UHV-CVD . . . . .	21
	. . . . . T. Ohguro, N. Sugiyama, K. Imai, K. Usuda, M. Saito, T. Yoshitomi, M. Ono, H. S. Momose and H. Iwai	
3A-4	A Channel Engineering Combined with Channel Epitaxy Optimization and TED Suppression for 0.15 $\mu\text{m}$ n-n Gate CMOS Technology . . . . .	23
	. . . . . H. Abiko, A. Ono, R. Ueno, S. Masuoka, S. Shishiguchi, K. Nakajima and I. Sakai	

## Session 3B: Interconnect Technology (I) [Shunju II]

3B-1	Copper Integration into 0.5 $\mu\text{m}$ BiCMOS Technology . . . . .	25
	. . . . . A. V. Gelatos, B.-Y. Nguyen, K. Perry, R. Marsh, J. Peschke, S. Filipiak, E. Travis, N. Bhat, L. B. La, M. Thompson, T. Saarinen and P. J. Tobin	
3B-2	A Half-Micron Pitch Cu Interconnection Technology . . . . .	27
	. . . . . K. Ueno, K. Ohto and K. Tsunenari	



3B-3	Performance of MOCVD Tantalum Nitride Diffusion Barrier for Copper Metallization . . . . .	29
	. . . . . S. C. Sun, M. H. Tsai, C. E. Tsai and H. T. Chiu	
3B-4	A Novel Self-Aligned Surface-Silicide Passivation Technology for Reliability Enhancement in Copper Interconnects . . . . .	31
	. . . . . T. Takewaki, T. Ohmi and T. Nitta	

## **Session 4A: SOI Technology [Shunju I]**

4A-1	High-Current, Small Parasitic Capacitance MOS FET on a Poly-Si Interlayered(PSI:Ψ) SOI Wafer . . . . .	33
	. . . . . M. Horiuchi, T. Teshima, K. Tokumasu and K. Yamaguchi	
4A-2	Suppression of the Floating-Body Effects in SOI MOSFETs by Bandgap Engineering . . . . .	35
	. . . . . M. Terauchi, M. Yoshimi, A. Murakoshi and Y. Ushiku	
4A-3	A PELOX Isolated Sub-0.5 Micron Thin-Film SOI Technology . . . . .	37
	. . . . . P. V. Gilbert and S.-W. Sun	
4A-4	$\alpha$ -Particle-Induced Soft Errors in Submicron SOI SRAM . . . . .	39
	. . . . . Y. Tosaka, K. Suzuki and T. Sugii	

## **Session 4B: Interconnect Technology (II) [Shunju II]**

4B-1	Novel Si Surface Cleaning Technology with Plasma Hydrogenation and Its Application to Selective CVD-W Clad Layer Formation . . . . .	41
	. . . . . T. Kosugi, H. Ishii and Y. Arita	
4B-2	Pressure-Controlled Two-Step TEOS-O <sub>3</sub> CVD Eliminating the Base Material Effect . . . . .	43
	. . . . . M. Saito, Y. Kudoh and Y. Homma	
4B-3	Application of Force Fill Al-Plug Technology to 64 Mb DRAM and 0.35 $\mu$ m Logic . . . . .	45
	. . . . . K. Mizobuchi, K. Hamamoto, M. Utsugi, G. A. Dixit, S. Poarch, R. H. Havemann, C. D. Dobson, A. I. Jeffries, P. J. Holverson, P. Rich, D. C. Butler, N. Rimmer and A. McGeown	
4B-4	Fully Integrated Multilevel Interconnect Process for Low Cost Sub-Half-Micron ASIC Applications . . . . .	47
	. . . . . M. Norishima, T. Matsuno, M. B. Anand, M. Murota, M. Inohara, K. Inoue, H. Ohtani, K. Miyamoto, R. Ogawa, M. Seto, C. Fukuhara, H. Shibata and M. Kakumu	

## **Session 5: 15th Anniversary Session (Key Note Addresses) [Shunju]**

5-1	Evolution of Integrated Electronics from Microelectronics to Nanoelectronics (Invited) . . . . .	49
	. . . . . T. Sugano	
5-2	Manufacturing Gigachips in the Year 2005 (Invited) . . . . .	53
	. . . . . P. K. Chatterjee and R. Doering	

## **Session 6: Advanced Deep Sub-Micron Process [Shunju]**

6-1	Sub-Quarter Micron Titanium Salicide Technology with In-Situ Silicidation Using High-Temperature Sputtering . . . . .	57
	. . . . . K. Fujii, K. Kikuta and T. Kikkawa	
6-2	Low Capacitance Multilevel Interconnection Using Low- $\epsilon$ Organic Spin-on Glass for Quarter-Micron High-Speed ULSIs . . . . .	59
	. . . . . T. Furusawa and Y. Homma	
6-3	Highly Porous Interlayer Dielectric for Interconnect Capacitance Reduction . . . . .	61
	. . . . . S.-P. Jeng, K. Taylor, T. Seha, M.-C. Chang, J. Fattaruso and R. H. Havemann	
6-4	Reoxidized Nitric Oxide(ReoxNO) Process and Its Effect on the Dielectric Reliability of the LOCOS Edge . . . . .	63
	. . . . . B. Maiti, P. J. Tobin, Y. Okada, S. Ajuria, K. G. Reid, R. I. Hegde and V. Kaushik	

## Session 7A: Low Power CMOS Devices [Shunju I]

7A-1	A Symmetric 0.25 $\mu\text{m}$ CMOS Technology for Low-Power, High-Performance ASIC Applications Using 248 nm DUV Lithography	65
	D. M. Boulton, W. M. Mansfield, K. J. O'Connor, J. Bevk, D. Brasen, M. Cheng, R. A. Cirelli, S. A. Eshraghi, M. L. Green, K. V. Guinn, S. J. Hillenius, D. E. Ibbotson, D. C. Jacobson, Y. O. Kim, C. A. King, R. C. Kistler, F. P. Klemens, K. S. Krisch, A. Kornblit, J. T. C. Lee, L. Manchanda, S. C. McNevin, S. V. Moccio, D. P. Monroe, K. K. Ng, M. L. O'Malley, C. S. Rafferty, G. P. Schwartz, S. Vaidya, G. R. Weber, L. C. Feldman, M. R. Pinto, T. Itani, T. Tounai, K. Kasama, H. Miyamoto, E. Ikawa, E. Hasagawa, A. Ishitani, H. Ito, T. Horiuchi, S. Saito and M. Nakamae	
7A-2	A Self-Aligned Counter Well-Doping Technology Utilizing Channeling Ion Implantation and Its Application to 0.25 $\mu\text{m}$ CMOS Process	67
	H. Nakamura and T. Horiuchi	
7A-3	Impact of the Reduction of the Gate to Drain Capacitance on Low Voltage Operated CMOS Devices	69
	K. Yamashita, H. Nakaoka, K. Kurimoto, H. Umimoto and S. Odanaka	
7A-4	Advantage of Small Geometry Silicon MOSFETs for High-Frequency Analog Applications under Low Power Supply Voltage of 0.5 V	71
	M. Saito, M. Ono, R. Fujimoto, C. Takahashi, H. Tanimoto, N. Ito, T. Ohguro, T. Yoshitomi, H. S. Momose and H. Iwai	

## Session 7B: Lithography [Shunju II]

7B-1	CVD SiNx Anti-Reflective Coating for Sub-0.5 $\mu\text{m}$ Lithography	73
	T. P. Ong, B. Roman, W. Paulson, J. H. Lin, C. King, J. Hayden, Y. C. Ku, C. C. Fu, M. Luo, C. Philbin, M. Rossow, T. Mele and K. Kemp	
7B-2	High Performance 0.3 $\mu\text{m}$ CMOS Using I-Line Lithography and BARC	75
	G. V. Thakar, S. K. Madan, C. M. Garza, W. L. Krisa, P. E. Nicollan, J. L. Wise, C. K. Lee, J. A. McKee, A. T. Appel, A. L. Esquivel, V. M. McNeil, D. A. Prinslow, B. R. Riemenschneider, T. Utsumi, R. H. Eklund and R. A. Chapman	
7B-3	Analysis of Critical Dimension Control for Optical-, EB-, and X-Ray Lithography below the 0.2- $\mu\text{m}$ Region	77
	H. Fukuda and S. Okazaki	
7B-4	Phase Edge Lithography for Sub 0.1 $\mu\text{m}$ Electrical Channel Length in a 200 MM Full CMOS Process	79
	P. Agnello, T. Newman, E. Crabbé, S. Subbanna, E. Ganin, L. Liebmann, J. Comfort and D. Sunderland	

## Session 8A: VLSI Reliability [Shunju I]

8A-1	Boron as a Primary Source of Radiation in High Density DRAMS	81
	R. Baumann, T. Hossain, E. Smith, S. Murata and H. Kitagawa	
8A-2	A New Method to Monitor Gate-Oxide Reliability Degradation	83
	K. P. Cheung	
8A-3	An ESD Protection Scheme for Deep Sub-Micron ULSI Circuits	85
	U. Sharma, J. Campbell, H. Choe, C. Kuo, E. Prinz, R. Raghunathan, P. Gardner and L. Avery	
8A-4	Effects of Process-Induced Mechanical Stress on ESD Performance	87
	K. Kubota, K. Okuyama, H. Miura, Y. Kawashima, H. Ishizuka and C. Hashimoto	

## Session 8B: Advanced Process Technology [Shunju II]

8B-1	An Etching Model to Predict Minimum-Microloading Gas Pressure	89
	M. Izawa, T. Kumihashi and Y. Ohji	
8B-2	Metal Etch with HI-Addition to Conventional Chemistry	91
	W. E. Frank	
8B-3	Low-Energy Large-Mass Ion Bombardment Process for Low-Temperature High-Quality Silicon Epitaxy	93
	W. Shindo and T. Ohmi	
8B-4	A Smart Batch Type RTA Technology for Beyond 256 Mbit DRAM	95
	G. G. Lee, K. Fujihara, S. J. Kim, C. W. Oh, U. I. Chung, S. T. Ahn and M. Y. Lee	

## Rump Sessions

R-1	Next Wafer Size -When Will It Happen?- .....	T. Abe and T. Seidel	97
R-2	Mini-fabs vs Mega-fabs .....	E. Arai and B. Doering	97
R-3	Gigabit DRAM vs Gigabit Flash .....	T. Kunio and S. Ogura	97
R-4	Scaling Limit of Gate Dielectrics .....	K. Taniguchi and J. Y.-C. Sun	98
R-5	Interconnect Limitation for Sub-0.25 $\mu\text{m}$ Devices (Technology and Circuits Joint Session) .....	K. Asada, S. Ogawa and W. Bidermann	98

## Session 9A: MOS Process & Device Technology (I) [Shunju I]

9A-1	Accurate Modeling of Coulombic Scattering, and Its Impact on Scaled MOSFETs .....	A. Mujtaba, S. Takagi and R. Dutton	99
9A-2	Gate Current by Impact Ionization Feedback in Sub-Micron MOSFET Technologies .....	J. D. Bude	101
9A-3	Direct Observation of the Lateral Nonuniform Channel Doping Profile in Submicron MOSFET's from an Anomalous Charge Pumping Measurement Results .....	S. S. Chung, S. M. Cheng, G. H. Lee and J. C. Guo	103
9A-4	Sub 0.1 $\mu\text{m}$ nMOSFETs Fabricated Using Experimental Design Techniques to Optimise Performance and Minimise Process Sensitivity .....	S. Kubicek, S. Biesemans, Q. F. Wang, K. Maex and K. De Meyer	105

## Session 9B: Gate Dielectrics [Shunju II]

9B-1	Novel Oxynitridation Technology for Highly Reliable Thin Dielectrics .....	M.-S. Joo, S.-H. Lee, S.-K. Lee, B.-J. Cho, J.-C. Kim and S.-H. Choi	107
9B-2	Extending Gate Dielectric Scaling Limit by Use of Nitride or Oxynitride .....	X. W. Wang, Y. Shi, T. P. Ma, G. J. Cui, T. Tamagawa, J. W. Golz, B. L. Halpern and J. J. Schmitt	109
9B-3	High Quality Ultra-Thin(4 nm) Gate Oxide by UV/O <sub>3</sub> Surface Pre-Treatment of Native Oxide .....	S. Ohkubo, Y. Tamura, R. Sugino, T. Nakanishi, Y. Sugita, N. Awaji and K. Takasaki	111
9B-4	Isolation Dependence of Gate Oxide Quality at the LOCOS Edge Using an In-Situ HCl-Based Pre-Gate Pyroclean .....	S. A. Ajuria, P. J. Tobin, B.-Y. Nguyen, Y. Limb and T. C. Mele	113

## Session 10A: MOS Process & Device Technology (II) [Shunju I]

10A-1	High-Performance Sub-0.1- $\mu\text{m}$ CMOS with Low-Resistance T-Shaped Gates Fabricated by Selective CVD-W .....	D. Hisamoto, K. Umeda, Y. Nakamura, N. Kobayashi, S. Kimura and R. Nagai	115
10A-2	A New SSS-OSLO Technology for 0.15- $\mu\text{m}$ Low-Defect Isolation .....	Y. Sudoh, T. Kaga, J. Yugami and T. Kure	117
10A-3	Characteristics of CMOSFETs with Sputter-Deposited W/TiN Stack Gate .....	D. H. Lee, S. H. Joo, G. H. Lee, J. Moon, T. E. Shim and J. G. Lee	119
10A-4	Rapid Thermal Chemical Vapor Deposition of In-Situ Nitrogen-Doped Polysilicon for Dual Gate CMOS .....	S. C. Sun, L. S. Wang, F. L. Yeh and C. H. Chen	121

## **Session 10B: Memory Capacitor Technology [Shunju II]**

- 10B-1 A Ferroelectric Capacitor over Bit-Line (F-COB) Cell for High Density Nonvolatile Ferroelectric Memories . . . . N. Tanabe, T. Matsuki, S. Saitoh, T. Takeuchi, S. Kobayashi, T. Nakajima, Y. Maejima, Y. Hayashi, K. Amanuma, T. Hase, Y. Miyasaka and T. Kunio 123
- 10B-2 Ultra-Thin Fatigue Free Lead Zirconate Titanate Thin Films for Gigabit DRAMs . . . . . K. Torii, H. Kawakami, K. Kushida, F. Yano and Y. Ohji 125
- 10B-3 A Novel Low-Temperature Process for High Dielectric Constant BST Thin Films for ULSI DRAM Applications . . . . . R. Khamankar, B. Jiang, R. Tsu, W.-Y. Hsu, J. Nulman, S. Summerfelt, M. Anthony and J. Lee 127
- 10B-4 Fast and Accurate Programming Method for Multi-Level NAND EEPROMs . . . . . G. J. Hemink, T. Tanaka, T. Endoh, S. Aritome and R. Shiota 129

## **Session 11: High Performance Technologies [Shunju]**

- 11-1 A 62.8 GHz Fmax LP-CVD Epitaxially Grown Silicon Base Bipolar Transistor with Extremely High Early Voltage of 85.7 V . . . . . C. Yoshino, K. Inou, S. Matsuda, H. Nakajima, Y. Tsuboi, H. Naruse, H. Sugaya, Y. Katsumata and H. Iwai 131
- 11-2 A Low Thermal Budget, Fully Self-Aligned Lateral BJT on Thin Film SOI Substrate for Low Power BiCMOS Applications . . . . . V. M. C. Chen and J. C. S. Woo 133
- 11-3 A New 3-D MCM Fabrication Technology for High-Speed Chip-to-Chip Communication: Vertically Connected Thin-Film Chip(VCTC) Technology . . . . . S. Takahashi, T. Onodera, Y. Hayashi and T. Kunio 135

## **Session 12: Novel DRAM Structures [Shunju]**

- 12-1 0.29- $\mu\text{m}^2$  Trench Cell Technologies for 1G-Bit DRAMs with Open/Folded-Bit-Line Layout and Selective Growth Technique . . . . . M. Noguchi, T. Ozaki, M. Aoki, T. Hamamoto, M. Habu, Y. Kato, Y. Takigami, T. Shibata, T. Nakasugi, H. Niiyama, K. Tokano, Y. Saito, T. Hoshi and S. Watanabe 137
- 12-2 Planar Gain Cell for Low Voltage Operation and Gigabit Memories . . . . . W. H. Krautschneider, F. Hofmann, E. Ruderer and L. Risch 139
- 12-3 Leakage Mechanism due to Floating Body and Countermeasure on Dynamic Retention Mode of SOI-DRAM . . . . . F. Morishita, K. Suma, M. Hirose, T. Tsuruda, Y. Yamaguchi, T. Eimori, T. Oashi, K. Arimoto, Y. Inoue and T. Nishimura 141
- 12-4 A High Performance 16M DRAM on a Thin Film SOI . . . . . H.-S. Kim, S.-B. Lee, D.-U. Choi, J.-H. Shim, K.-C. Lee, K.-P. Lee, K.-N. Kim and J.-W. Park 143
- 12-5 Direct Measurement of the Soft-Error Immunity on the DRAM Well Structure by Using the Nuclear Microprobe . . . . . Y. Ohno, T. Kishimoto, K. Sonoda, H. Sayama, S. Komori, A. Kinomura, Y. Horino, K. Fujii, T. Nishimura, M. Takai and H. Miyoshi 145

## Semiconductor CIM System ; Innovation Toward The Year 2000

Giichi Inoue, Shigeaki Asakura, and Masahiro Iiri

Integrated Circuit Manufacturing Dept. Toshiba Corporation  
1, Komukai Toshiba-Cho, Saiwaiku, Kawasaki, 210, Japan

## 1. Introduction

The business environment around the semiconductor industry has been rapidly changing compared with other industries. The prospect around the year 2000 will probably be as follows. First of all, devices in terms of DRAM, 256MDRAM will be in mass production and 1GDRAM will be at an earlier stage of production. 300mm wafers are sure to be used in the production. Equipment with single wafer processing are expected to be dominant for larger wafers and more cluster tools would be used in the production. Yield and device monitoring during the production rather than at the end of the whole processes on final chips may also be more commonly practiced for the earlier detection of failures. Insitu monitoring with single wafer processing may be used for finer process control. To reduce the ever increasing cost of clean rooms including the running cost, mini-environment technologies will be applied more to production in clean rooms. Material handling automation will be essential for dealing with heavy load of larger wafers. To share the higher investment such as for equipment and facilities, international alliance among foreign companies will be accelerated, and production environment needs to be global. Technology trends toward the year 2000 are shown in table 1.

Under these circumstances, the role of CIM systems in the semiconductor industry has become increasingly important for dealing with new technologies as well as with their difficulties. Their importance and expected roles are discussed in this paper.

Table 1. Technology Trend

	1993	1994	1995	1996	1997	1998	1999	2000	2001
Feature Size	0.5 $\mu$ m		0.35 $\mu$ m			0.25 $\mu$ m		0.15 $\mu$ m	
DRAM	16 MD		64MD			256MD		1GD	
Wafer Size	150mm $\phi$							300mm $\phi$	
			200mm $\phi$						
Equipment	Stand alone					Small Scale Cluster			
						Larger Scale Cluster			
Material Handling	By Lot							By Wafer	

## 2. Requirements for CIM systems

The roles of CIM system are basically the same as today. Not many new roles are required but their importance will be more acute in the field of integration to get the total effect on production and yield improvement. This also means that the domain of the problems is getting wider and more complicated so that CIM system needs to provide total solutions rather than local ones.

## (1) Shorter "Time-to-Market"

For marketing the new and advanced semiconductor devices like 256MDRAM and 1GDRAM, shorter lead time from the design cycle, process development and mass production ramp-up is the key for competitiveness. For the future devices, it will be more difficult and take longer to improve their yield because the longer process steps and more complicated device structure as well as the finer process are required. The development stage is also expected to be longer and more difficult than today. At the moment, contribution of CIM system is largely focusing on mass production and automation. To realize the minimum "Time-to-market", however, CIM is required to solve a different problem domain. That is, how to speed up the design and process development cycle and transfer to mass-production smoothly. More CIM support should be required for linking device design and process development as well as the integration of development cycle and mass-production.

## (2) Flexibility for changes

The variety of products becomes ever wider. Even in DRAM, several generations are produced within the same factory for maximum utilization of facilities and equipment which leads to the frequent re-configuration of production lines. To cope with these changes, CIM system needs to be flexible and re-configurable. As is often the case with CIM system that once it is in operation for production, it is not allowed to stop so as not to disturb the production. Plug-in characteristics are preferable to add-in new functions, or refine existing functions without stopping entire system.

## (3) Efficiency in large volume data handling

In 300 mm wafer fabrication, wafer by wafer processing data for process control and analysis will be necessary. From the quality assurance(QA) point of view, chip level data are more and more required for traceability. As for the yield improvement, failure detection at an earlier stage and quicker analysis for finding the cause of failure require



the handling of large volume of data in real time and quick judgment. These are the requirements lead us to the higher level of data base integration with the capability of efficient data handling. Automation in data handling, especially that of data analysis, involves the replacement of human judgment to a certain extent. Expert system capability is necessary in this field. Efficiency of data handling is sure to be one of the keys for achieving quick device development and speedy yield improvement.

#### (5) Productivity enhancement

Efficient lot scheduling and improvement of equipment utilization are the major contribution of CIM system to enhance productivity. Considering that cluster tools are expected to be widely used in 300 mm production, more detailed scheduling down to chamber level as well as equipment performance monitoring at chamber level will be necessary for higher utilization of cluster tools.

### 3. CIM solutions for requirements

#### 3.1 Time to market

Total speed of yield improvement from device design, process development to mass production ramp-up is the key for minimizing "Time-to-Market". Fig. 1 shows the scenario of yield improvement throughout the development and the mass-production phases. The following are the points of improvement.

- Reduction of mismatches between process and device design by earlier detection of failure and quick feed back at the development phase.
- Quick tuning of process and design at the earlier stage of mass production to improve the process and design margin.

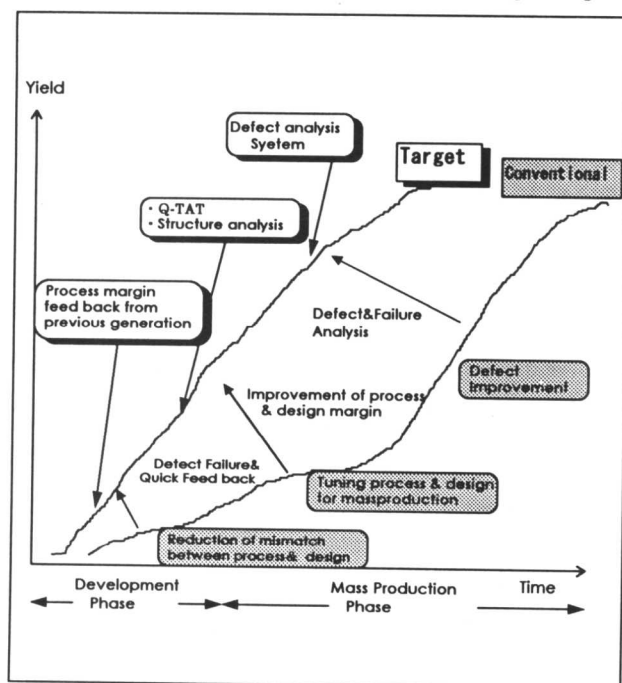


Fig.1 Scenario of yield improvement

- Defect improvement for farther yield ramp-up in mass-production.

#### 3.2 Yield domain integration

To realize the previous scenario, the device design, process, and manufacturing should be integrated by CIM. It can be called "yield domain integration" in which the wider range of yield improvement cycle is performed. "Production domain integration" is more commonly practiced which combines the production with sales for mass-production marketing. As achieving higher rate of yield ramp-up seems to be more and more difficult for future devices, "device and process domain integration" will be the important direction in CIM application to establish the yield improvement cycle. Fig. 2 shows both domains of integration.

Fig. 2 also shows the outline of the integration. Device design provides target process specification based on device and process simulation to fulfill product specification. In process development, process flow, processing condition with recipe for equipment are prepared. Then processes are evaluated in development lines. Their results are inspected with in-process and in-line analysis. Failures are detected in earlier stage and fed back to device design and process development quickly. To shorten the development cycle, Q-TAT for trial production is important. After the trial production, new product are passed on to mass production. At the initial stage, process tuning for equipment is necessary. To realize short turn around cycle for development and yield improvement, CIM can provide the following.

##### (1) For quick development cycle

- Share the process data between trial production and mass-production and make use of data in mass production of a new product in the trial phase.
- Support for device design and process development by providing production data.
- Earlier detection of failure by in-process analysis.
- Data integration from device simulation, target process specification to process condition and process recipe.

##### (2) From trial to mass-production

- Standardized data for process condition and process flow for smoother process data transfer.
- History of trial production and equipment condition as well as the result for process tuning.

##### (3) For the yield ramp-up

- Thorough data collection.
- Yield analysis tools for detecting the defect and causes.
- Expert system for analysis to deal with large amount of data in a short time.

##### (4) Common structure

- Common database shared among production lines.
- Standardization of data and user interface for accessing it.
- Sufficient networking for remote access.

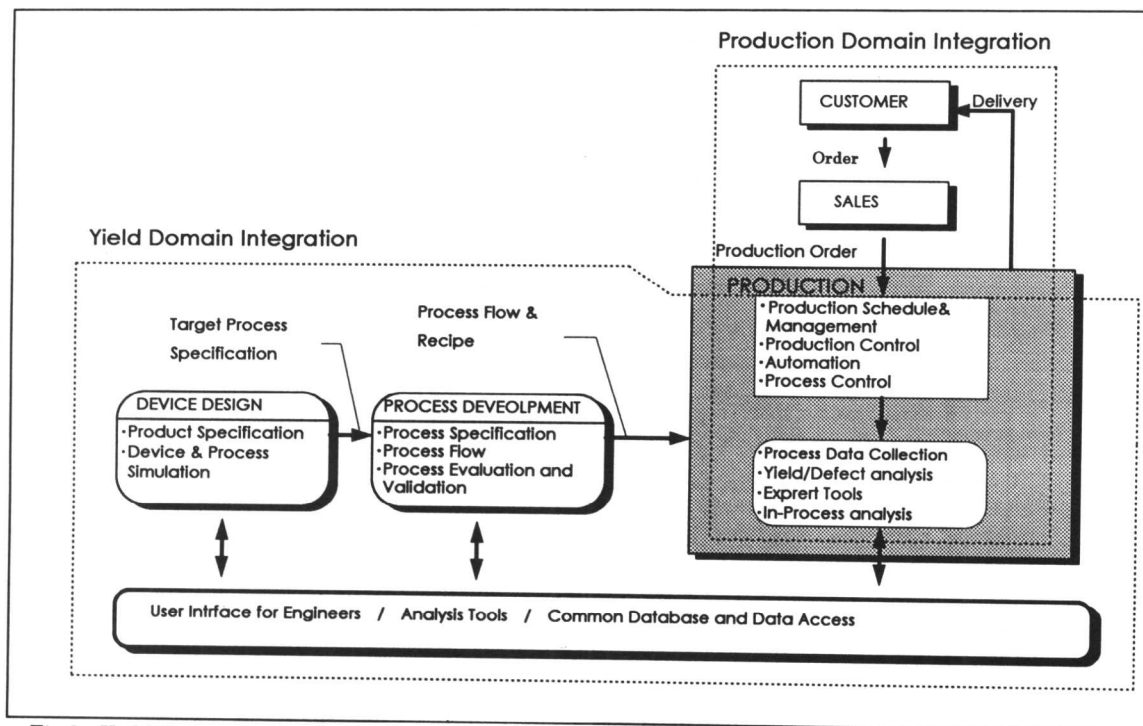


Fig.2 Yield domain and production domain integration

### 3.3. Productivity enhancement

The major contributions of CIM to productivity are lot scheduling and equipment utilization. Lot scheduling is largely dependent on products and on any factory's own application so that it is difficult to generalize. Wafer by wafer scheduling in cluster tools, however, is a different matter because it greatly affects equipment efficiency. Scheduling is basically the role of the host, but it is rather difficult for the host to deal with wafer by wafer scheduling to process modules within cluster tools, because it is closely related to real time control. The scheduling capability may need to be provided by cluster tools if they intend to supply higher efficiency and flexibility within them. This implies equipment with higher intelligence which is more closely involved taking part in the CIM system. Other subjects of the intelligence for cluster tools are the automated process tuning and maintenance management which are closely related to wafer scheduling. The former is necessary for adjusting recipe parameters to module specific values at the assignment of wafers to modules in real time which cannot be pre-determined by the host. The latter is dependent on module utilization which should be taken into account at module assignment in scheduling. All cluster tools cannot be expected to be able to provide these intelligent services. If not, hosts should provide them instead. In any case, as wafer by wafer scheduling would affect productivity, a host needs to monitor the performance and the utilization of modules for productivity enhancement and stable operation. Fig. 3 shows the example of wafer by wafer scheduling within a cluster tool.

### 4. Supporting System Technologies

Distributed system technologies and networking make it possible to integrate various systems which otherwise function separately, and enable us to get total effect on semiconductor development and manufacturing. This integration is expected to be extended and continue on a wider scale for efficiency and competitiveness.

There are two system technologies acknowledged in semiconductor CIM field, framework technology and object oriented method. Framework is an integration technology which provides the integration goal and baseline by showing how each sub-system and system component should fit in<sup>1)</sup>. The object oriented method realises the "Plug and play" concept which can add flexibility to systems by putting in or changing sub-systems and system components without affecting the rest of the system. It is also increase the re-usability of sub-systems and system component. Recently, SEMATECH proposed to use both of them for a semiconductor CIM system, and SEMI standard has started to use these concept<sup>2)</sup>. This is the right direction for technology to take because they are addressing for the system integration, flexibility, and re-usability are sure to be key issues for CIM systems.

Another important technology is human and system interface for data processing. Wider integration enables us to access and use of various information and data through networks. On the other hand, the volume of data needing to be handled has been getting ever larger. In this situation,

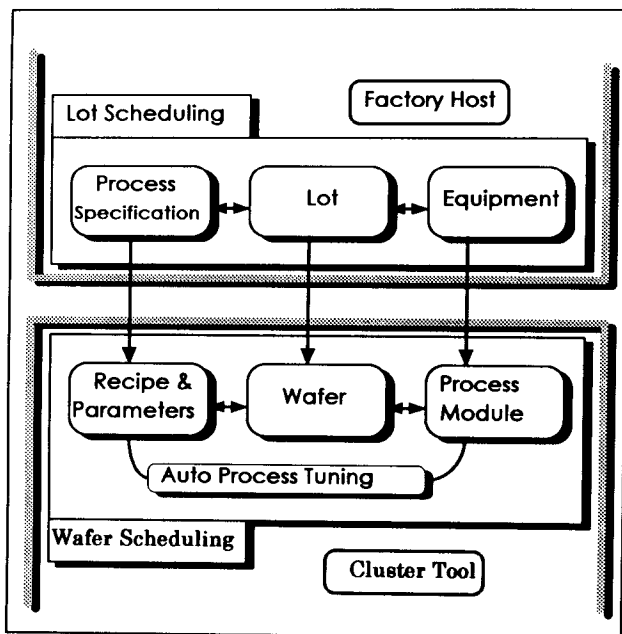


Fig. 3 Example of wafer by wafer scheduling in cluster tools

data utilization will be another key for making full use of CIM. One way is to automate data handling and analysis like the application of expert systems for yield analysis. The major part of data processing, however, will still be done by people so that user interface with easier and friendlier operation as well as end user computing will be more important for this purpose.

## 5. Summary and conclusion

To break through the difficulty in realizing the speedy device development and yield improvement in future devices, which is the key for quick "Time-to-Market", yield domain integration is necessary, as well as the efficiency in large volume data handling. Wafer by wafer scheduling for cluster tools will be one of the important factors for productivity enhancement. Framework and object oriented technologies will be accepted for system integration and flexibility. A wider scale of system integration will be practiced for total system solution and contribution.

As the larger and wider scale of CIM system integration proceeds, cost and time as well as resources for system development will be serious problems. The appearance of intelligent equipment which takes charge of some roles within CIM system adds more complication to the relationship between host and equipment. International business alliance requires certain standards as a common base. To address these issues, international standard should play an important role, especially to avoid unnecessary duplication of system development considering that these duplication will be more and more time, cost and resource consuming. To maintain the lead of semiconductor industry, industry wide agreement is necessary to make the maximum use of resources for developing new technology and innovation.

## 6. References

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# Manufacturing Technology Challenges for Low Power Electronics

Zachary J. Lemnios

Advanced Research Projects Agency  
3701 N. Fairfax Drive  
Arlington, VA 22203 USA

## Introduction

Portability of electronic systems has become a critical issue in many product areas. A new class of wireless, portable consumer electronics has been enabled by advances in IC manufacturing and innovations in design. The capabilities of these new electronic products include completely integrated functionality, embedded signal processing, high-speed data processing, and high bandwidth communication channels. However, limitations of practical battery sources and thermal management are being reached since the greater computational capability and throughput of leading-edge ICs has also led to increased electrical power dissipation. System size and weight, along with functionality and cost, are the factors that define portable electronics. Substantially reducing IC power dissipation will allow smaller batteries with longer useful lifetimes, reduce packaging costs, and decrease the need for heat sinks or forced air cooling.

Recently, the Advanced Research Projects Agency, working with the semiconductor industry has begun an aggressive program to develop fully-depleted silicon-on-insulator (SOI) substrate technologies for low power applications. SOI offers significant advantages in operating low voltage, short-channel transistors from a speed-power perspective. SOI technology may also provide process simplification as compared to conventional bulk CMOS technology. However, SOI for future leading-edge microelectronics technology generations will require the development of high-quality, thin buried oxide (BOX) layers and growth of gate oxide films near the tunneling limit. These and other requirements will challenge the capabilities of future fabrication processes.

## Low Power System Drivers

Portability of electronic systems has become a key driver of advanced semiconductor technologies. Advances in both battery technologies and electronics has enabled the emergence and huge growth of the portable electronics industry. Although battery form factors, energy densities and battery lifetimes have improved tremendously over the past decade, revolutionary improvements for very long-life compact

power sources are still over the horizon. In spite of this, there are very promising semiconductor technologies for VLSI applications that can provide high functional performance and extremely low power dissipation, orders of magnitude lower than conventional technologies.

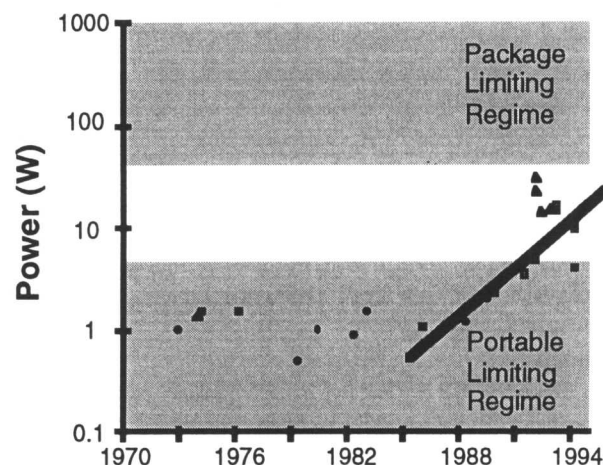


Figure 1: Power trends in microprocessors

Some trends in power dissipation of commercial volume microprocessors are shown in Figure 1. The microprocessors shown in this figure were fabricated in bulk CMOS technologies. As microprocessor performance has improved through integration and architecture, power dissipation has tended to increase as well, resulting in shortened lifetimes of practical battery sources. Over the past few generations, microprocessor power dissipation has nearly tripled every 3 years. The trends for random logic, gate arrays, and ASICs are similar. With current product trends toward mobile portable electronic systems, it is clear that it will be necessary to decouple, or at least decrease the constant of proportionality between power dissipation and performance/functionality.

Two limiting regions are indicated in Figure 1 as well. In the portable-limit, it becomes difficult to carry systems that dissipate over 5W. There are cooling and energy storage issues that preclude easy portability. In