

Introduction to Microelectronics Technologies and Industry

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Outline

1. The semiconductor industry
 - overview
 - technology roadmap
 - brief history
2. Outline of chip products: logic, memory, storage,
3. Fundamentals of device physics
4. Fundamentals of Chip Manufacturing
 - Front-end processes (FEOL & BEOL)
 - Back-end processes
5. Summary

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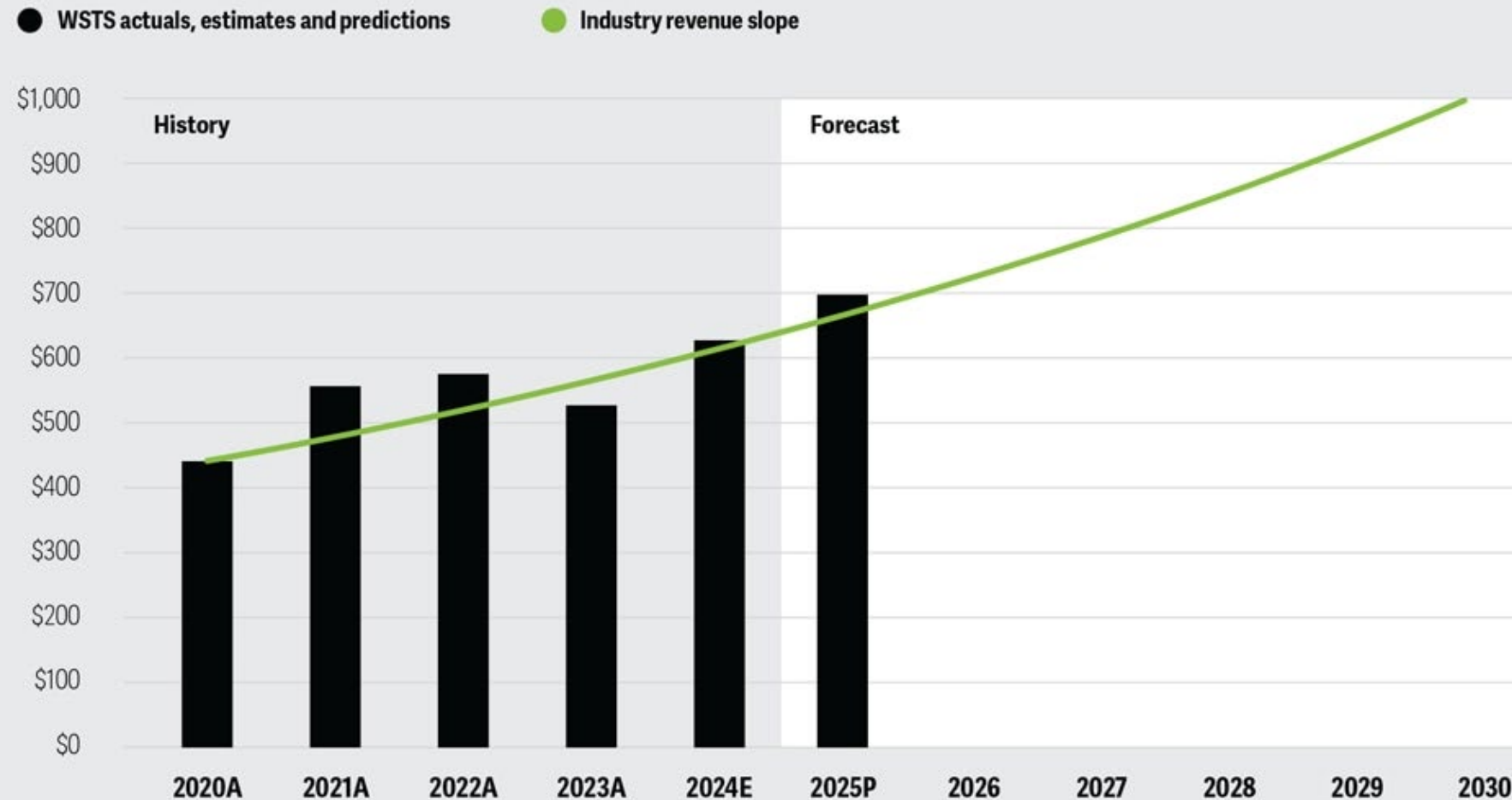
Semiconductor Industry: growth & challenges

- Continued growth: WW Revenues of \$628 (2024) up by 19.1% from \$ 527 B (2023)
- The supply chain is global, causing concern on national security issues.
- End of Moore's law; **paradigm shift in technology**
 - Sizes of some devices are approaching atomic scale
 - Devices with new materials & new 3D structures must be manufactured.
- For the manufacturing of advanced semiconductor products, **plasma processing** is becoming one of the bottle-neck technologies.

Figure 1

Revenues indicate the possibility of the chip industry hitting US\$1 trillion in 2030

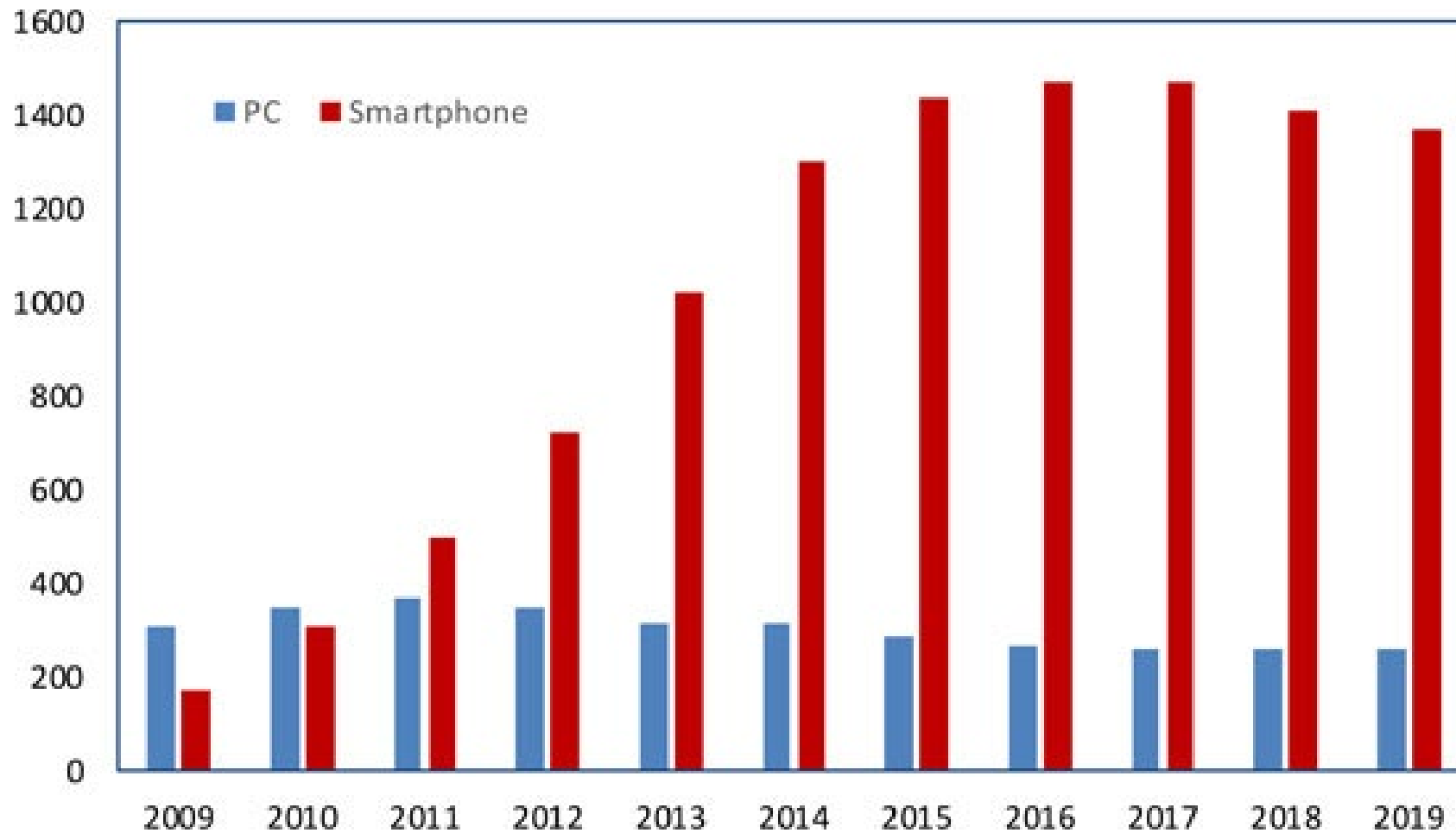
The path to \$1 trillion in semiconductor revenues (\$Billions)



Note: A = Actual, E = Estimate, P = Prediction.

Source: Deloitte analysis and extrapolation based on data from World Semiconductor Trade Statistics.

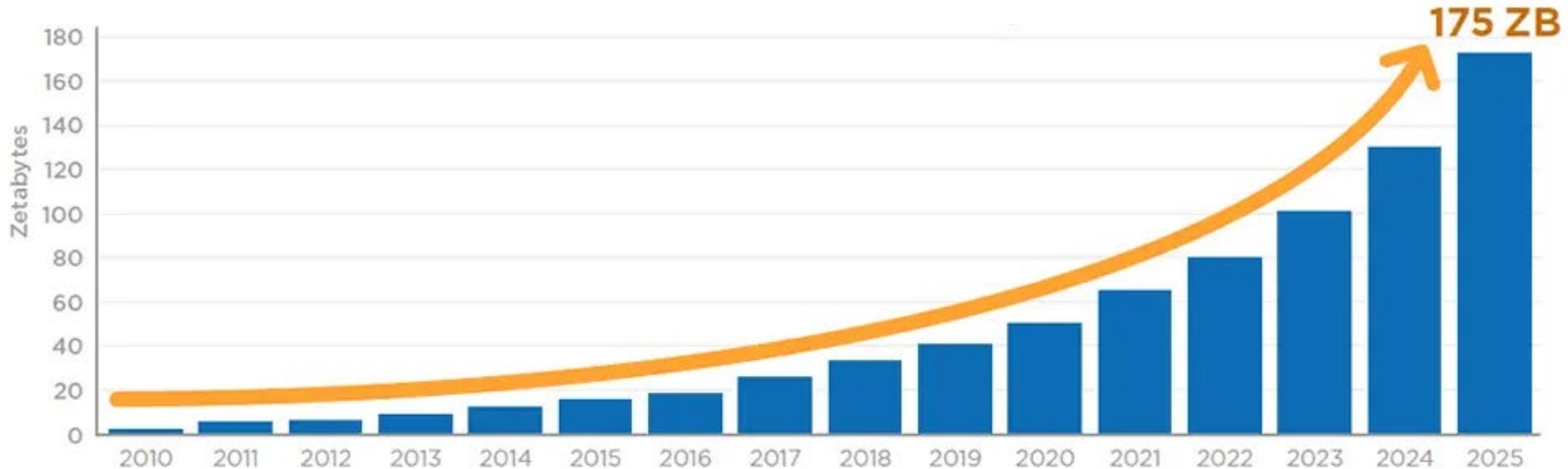
Global Sales of PCs and Smartphones (Millions of Units)



Published in May 2020 : IMF e-Library

<https://www.elibrary.imf.org/view/journals/001/2020/070/article-A001-en.xml>

Amount of data created and stored each year



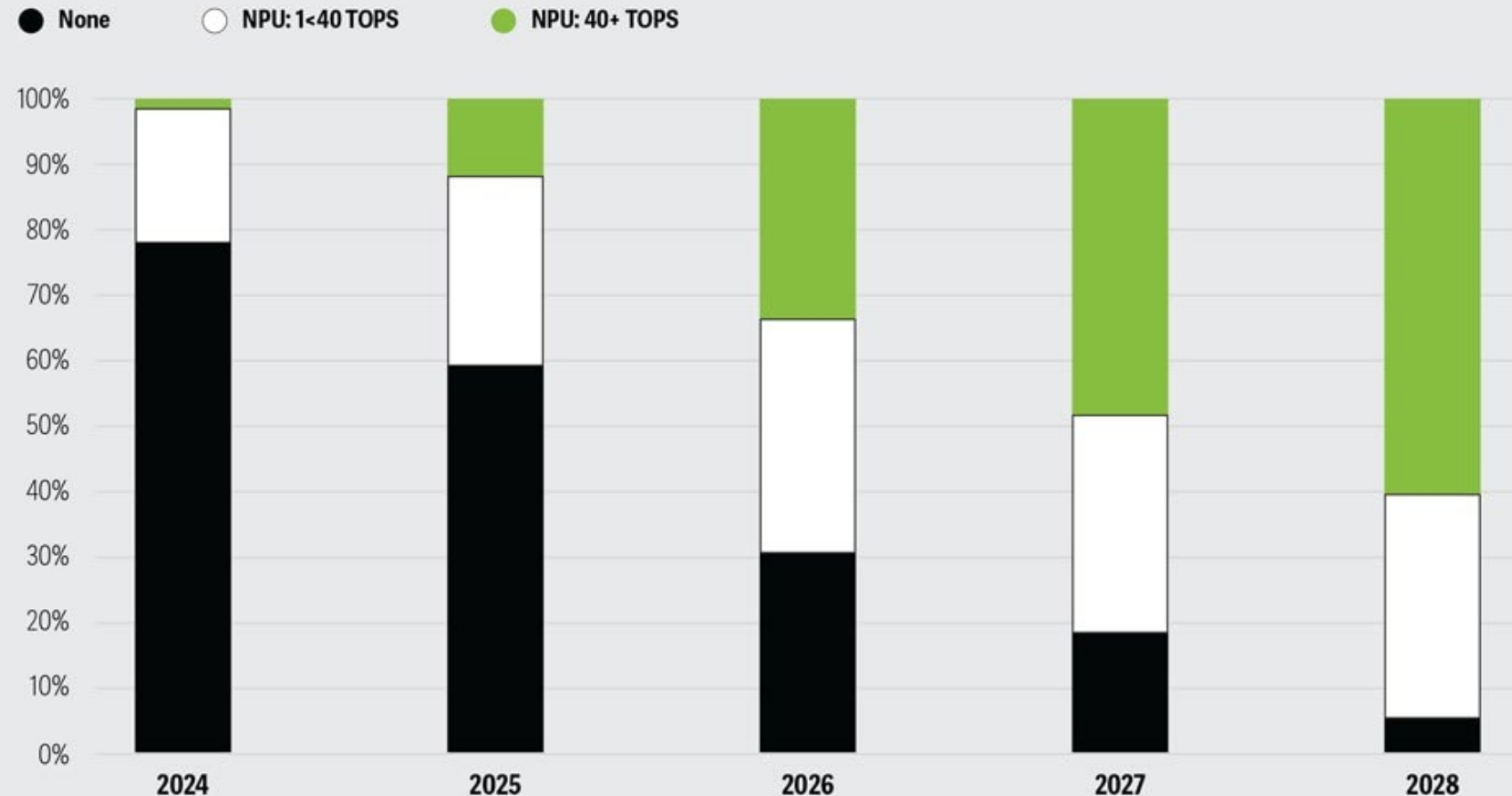
source: IDC Datasphere whitepaper

<https://www.i-scoop.eu/big-data-action-value-context/data-age-2025-datasphere/>

Figure 4

Almost all PCs are expected to have some gen AI processing—also known as neural processing units (NPUs)—by 2028

Expected sales of NPU-enabled PCs of all PCs worldwide from 2024 to 2028



Note: TOPS = trillion operations per second.

Source: International Data Corporation Worldwide Quarterly Personal Computing Device Tracker, September 2024.

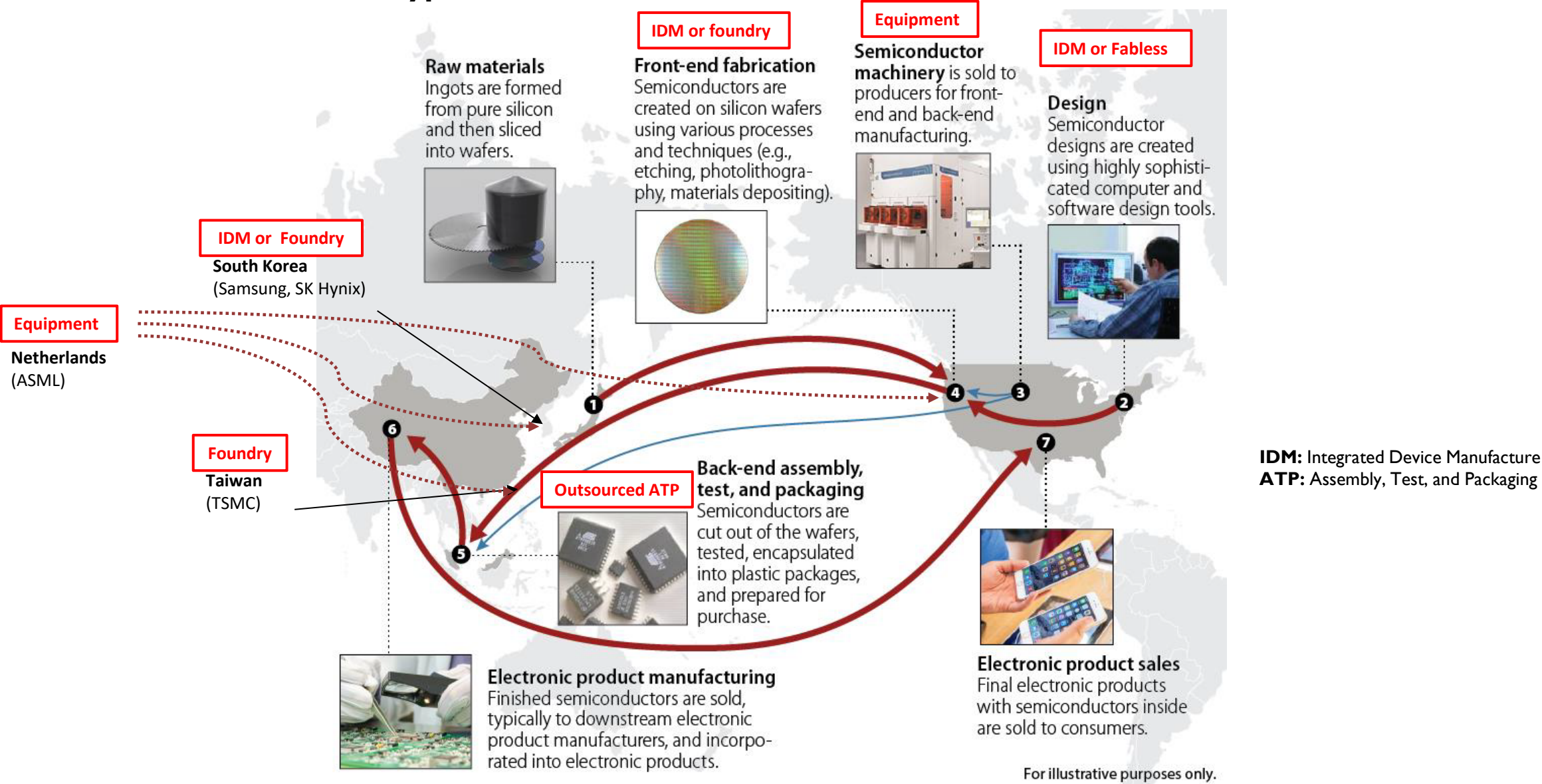
AI will drive the future semiconductor industry

- AI data centers
- Edge computing¹⁾ (Pervasive computing)
- Autonomic computing²⁾

1) “What is the edge computing” <https://www.ibm.com/topics/edge-computing>

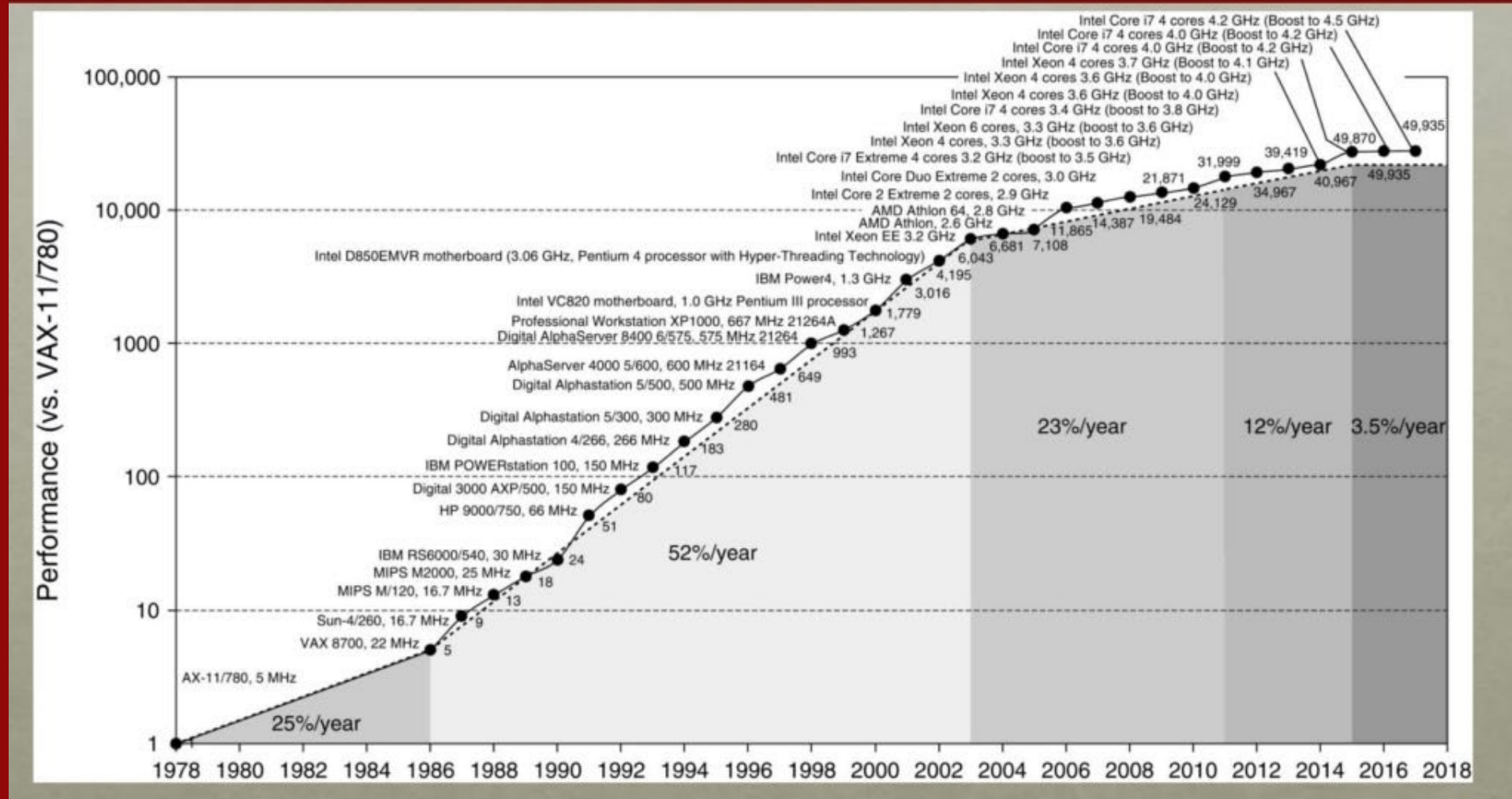
2) Autonomic computing (AC) is distributed computing resources with self-managing characteristics, adapting to unpredictable changes while hiding intrinsic complexity to operators and users (https://en.wikipedia.org/wiki/Autonomic_computing)

Typical Global Semiconductor Production Pattern

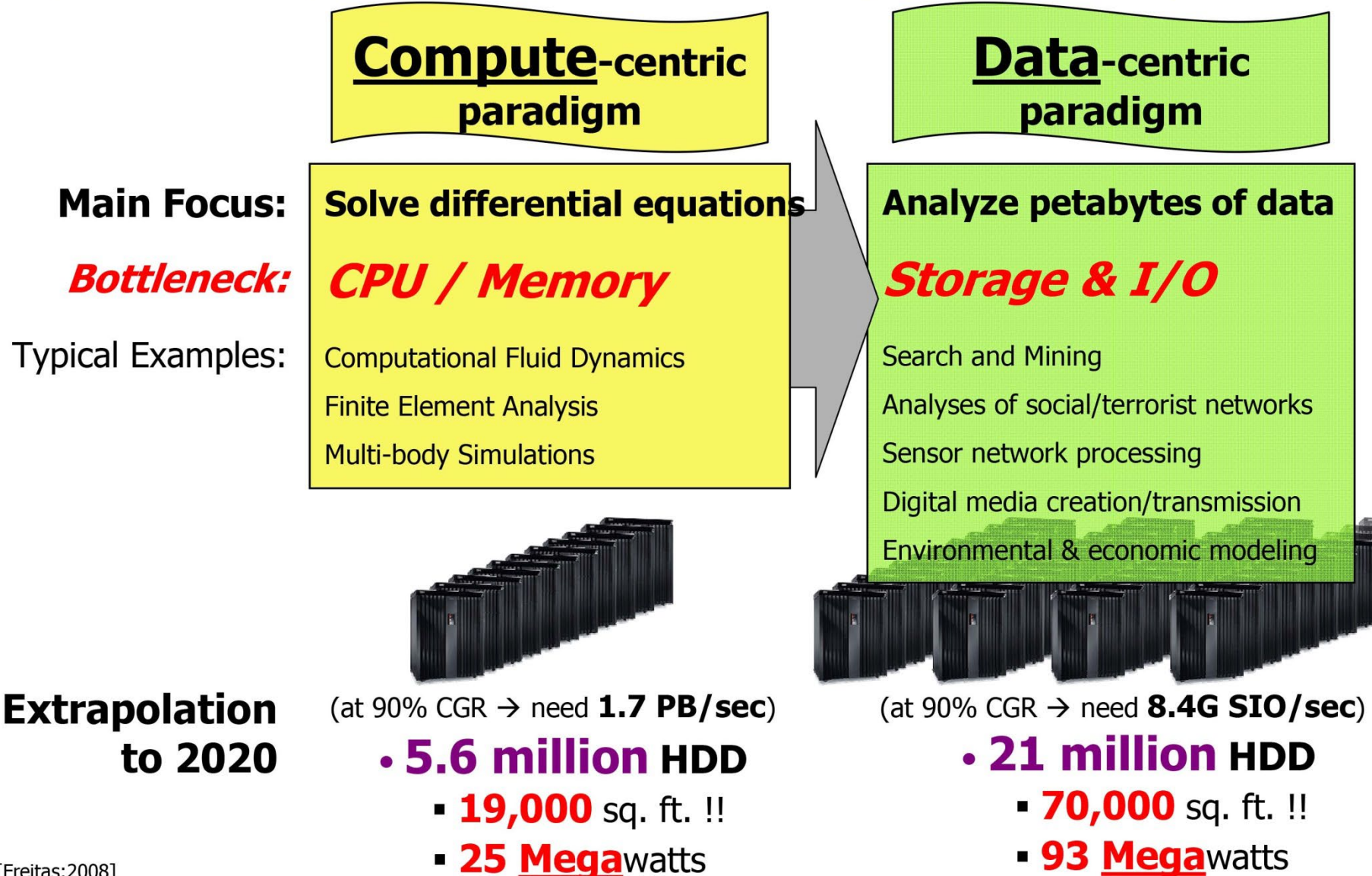


End of Moore's Law

UNIPROCESSOR PERFORMANCE (SINGLE CORE)



...yet critical applications are also undergoing a paradigm shift

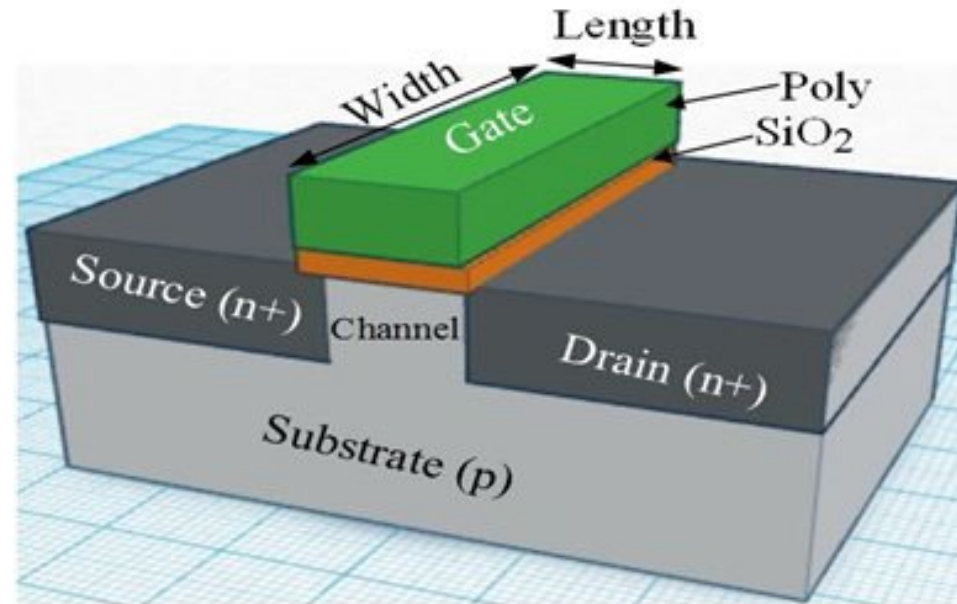


[Freitas:2008]

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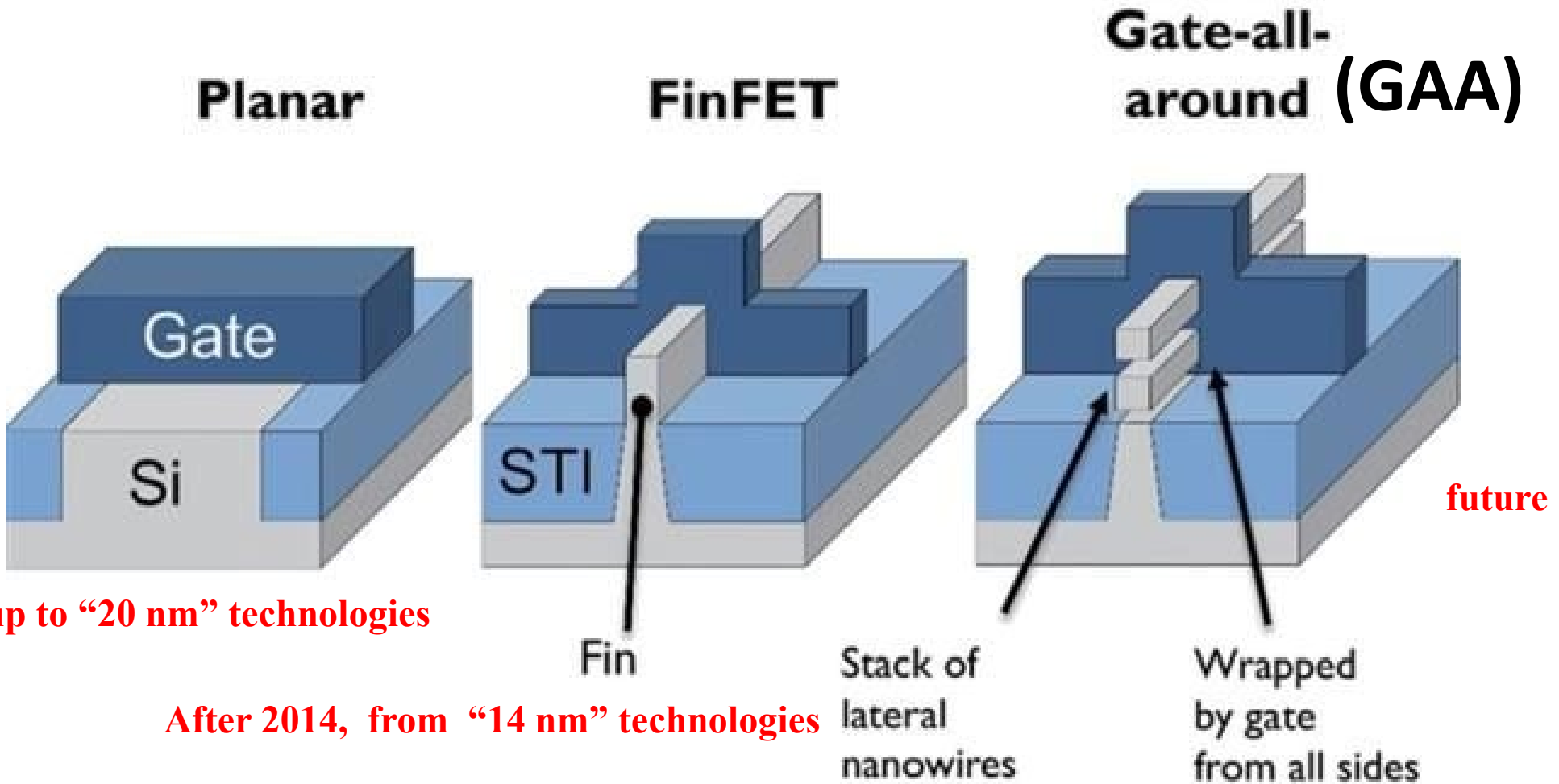
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device shapes get more complex



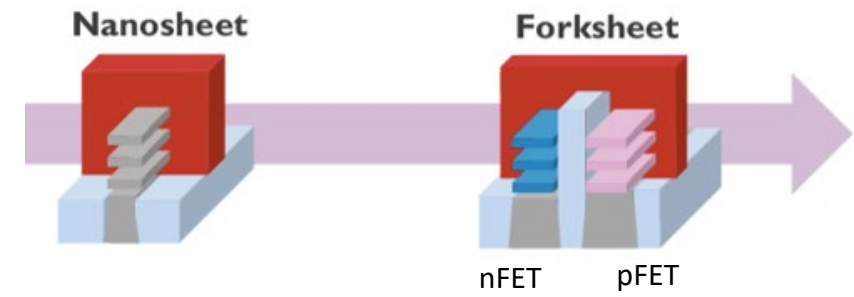
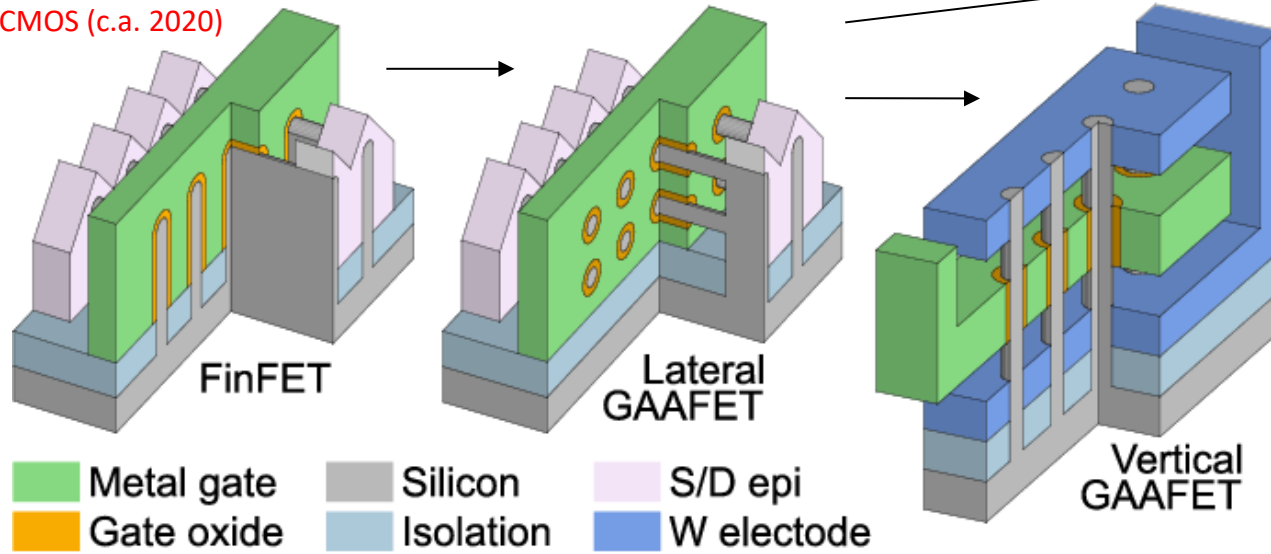
Before 2014, up to “20 nm” technologies

device shapes get more complex

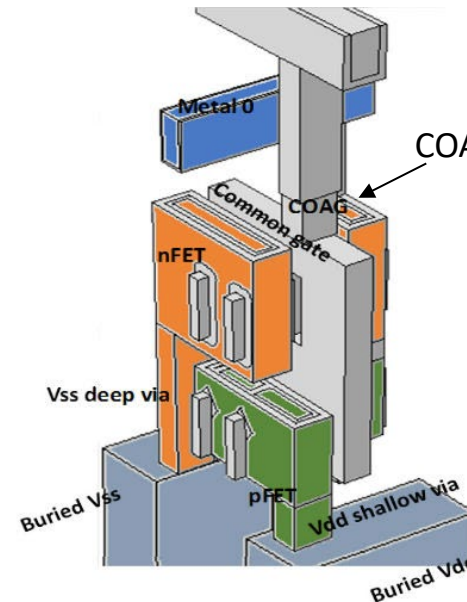
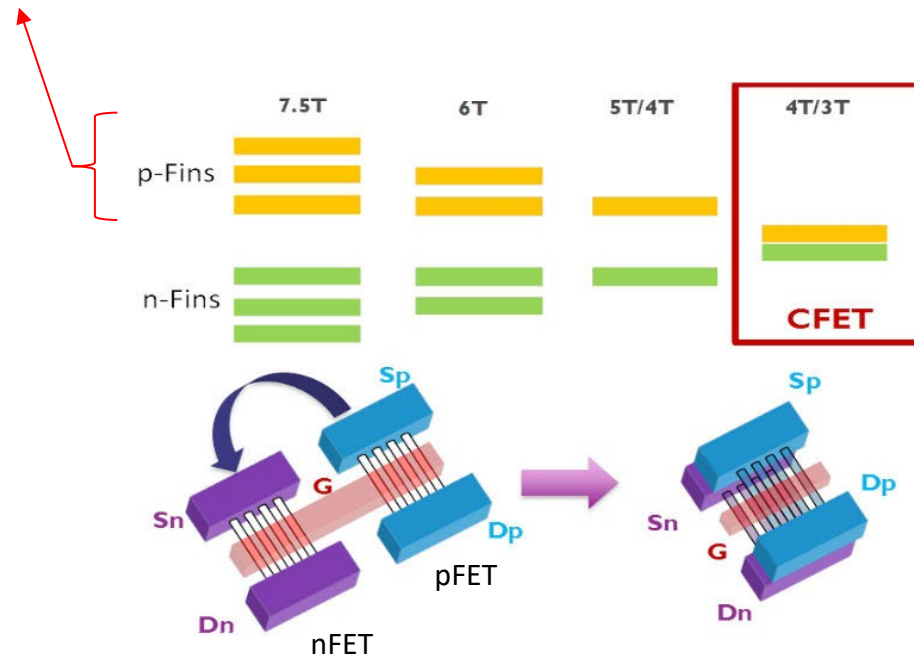


STI: shallow trench isolation

current generation
CMOS (c.a. 2020)



Complementary FET (CFET)



nFET and pFET are placed vertically

IMEC

<https://www.eedesignit.com/fetnodesn3/>

Development of Device Structures















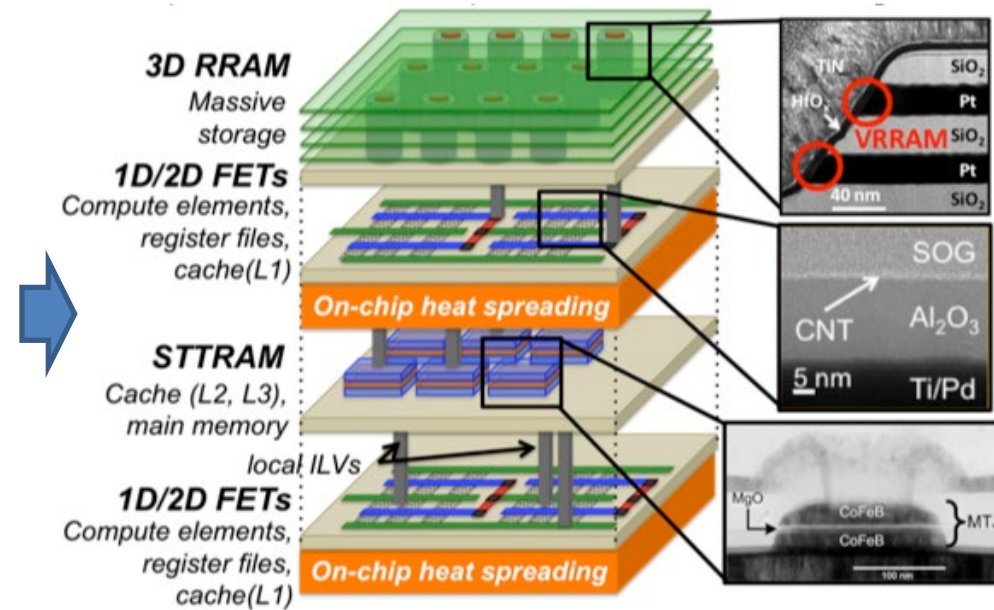
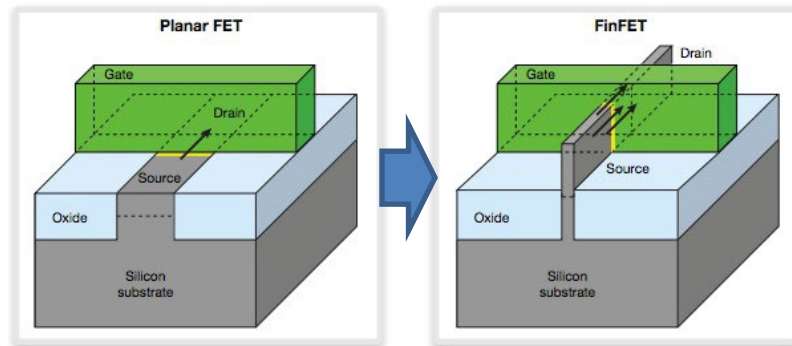


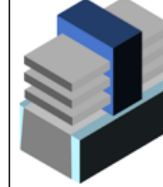
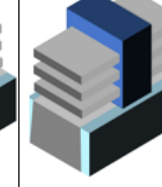
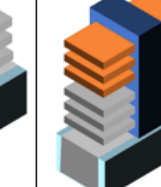
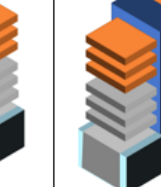
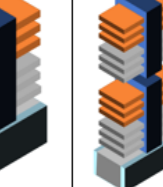
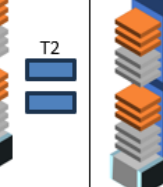

YEAR OF PRODUCTION	2015	2017	2019	2021	2024	2027	2030
Logic device technology naming	P70M56	P48M36	P42M24	P32M20	P24M12G1	P24M12G2	P24M12G3
Logic industry "Node Range" Labeling (nm)	"16/14"	"11/10"	"8/7"	"6/5"	"4/3"	"3/2.5"	"2/1.5"
Logic device structure options	finFET FDSOI	finFET FDSOI	finFET LGAA	finFET LGAA VGAA	VGAA, M3D	VGAA, M3D	VGAA, M3D
							
							

Figure MM3: Transistor structure roadmap: FDSOI, finFET, lateral nanowire, vertical nanowire, and monolithic 3D.

2015 International Technology
Roadmap for Semiconductors (ITRS)

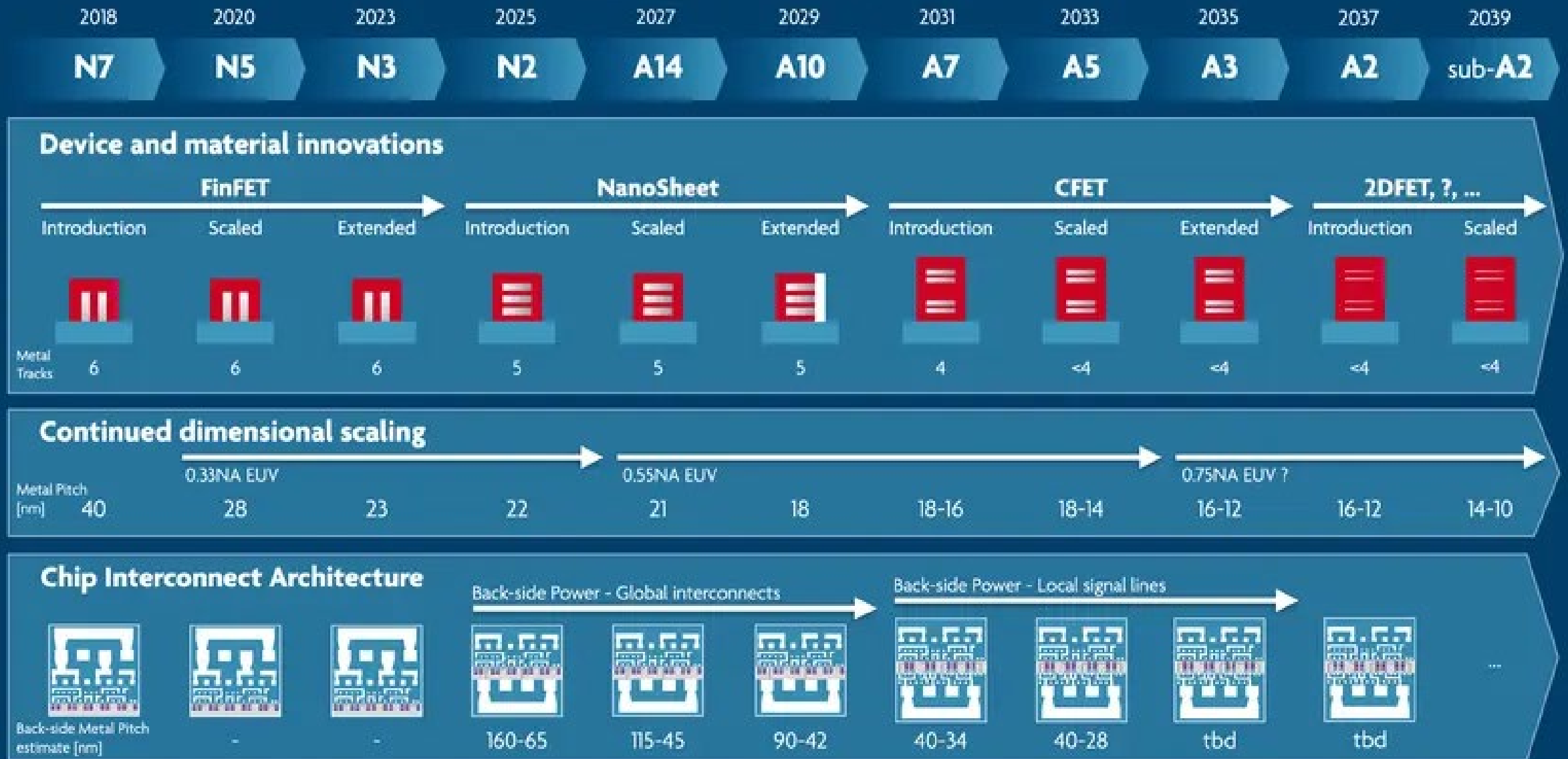


YEAR OF PRODUCTION	2024	2025	2027	2029	2031	2033	2035	2037	2039
	G48M24	G48M22	G48M22	G46M20	G44M18	G44M16	G42M14/T2	G42M14/T4	G42M14/T6
Logic industry "Node Range" Labeling	"3nm" Enhanced	"2nm"	"1.4nm"	"A10 eq"	"A7 eq"	"A5 eq"	"A3.5 eq"	"A2.5 eq"	"A1.8 eq"
Fine-pitch 3D integration scheme	Stacking	Stacking	Stacking	Stacking	CFET	CFET	3DVLSI	3DVLSI	3DVLSI
Logic device structure options	finFET	LGAA	LGAA	LGAA	CFET	CFET	CFET-3D	CFET-3D	CFET-3D
Backside structure options	-	Backside via	Direct contact	Decap+ESD	Active devices	Active devices	Active devices	Active devices	Active devices
Platform device for logic	finFET	LGAA	LGAA	LGAA	CFET	CFET	CFET	CFET	CFET
									
LOGIC DEVICE GROUND RULES									
Mx pitch (nm)	32	24	24	20	18	16	14	14	14
M1 pitch (nm)	32	32	32	46	44	44	42	42	42
M0 pitch (nm)	24	22	22	20	18	16	14	14	14
Gate pitch (nm)	48	48	48	46	44	44	42	42	42
Lg: Gate Length - HP (nm)	16	14	12	12	12	10	10	10	10
Lg: Gate Length - HD (nm)	18	14	12	12	12	10	10	10	10
Channel overlap ratio - two-sided	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20	0.20
Spacer width (nm)	6	6	5	5	4	4	4	4	4
Spacer k value	3.5	3.3	3.0	3.0	2.7	2.7	2.7	2.7	2.7
Contact CD (nm) - finFET, LGAA	20	22	26	24	24	26	24	24	24
Device architecture key ground rules									
Device lateral pitch (nm)	24	26	24	24	22	22	22	22	22
Device gate vertical overhang (nm)	15	15	15	10	10	10	10	10	10
Device height (nm)	48	57	72	64	75	62	60	53	53
FinFET Fin width (nm)	5.0								
Footprint drive efficiency - finFET	4.21								
Lateral GAA vertical pitch (nm)		18.0	17.0	16.0	15.0	14.0	13.0	12.0	12.0
Lateral GAA (nanosheet) thickness (nm)		6.0	6.0	6.0	5.0	4.0	4.0	4.0	4.0
Number of vertically stacked nanosheets on one device		3	4	4	3	3	3	3	3
LGAA width (nm) - HP		30	20	12	30	25	20	15	12
LGAA width (nm) - HD		15	10	6	15	12	10	8	8
LGAA width (nm) - SRAM		7	6	6	6	6	6	6	6
Footprint drive efficiency - lateral GAA - HP		4.41	5.47	4.80	4.57	4.24	4.00	3.68	3.43
Device effective width (nm) - HP	101.0	216.0	208.0	144.0	210.0	174.0	144.0	114.0	96.0
Device effective width (nm) - HD	101.0	126.0	128.0	96.0	120.0	96.0	84.0	72.0	72.0
PN seperation width (nm)	45	40	30	20					
CFET PN seperation vertical space (nm)					30	20	20	15	15

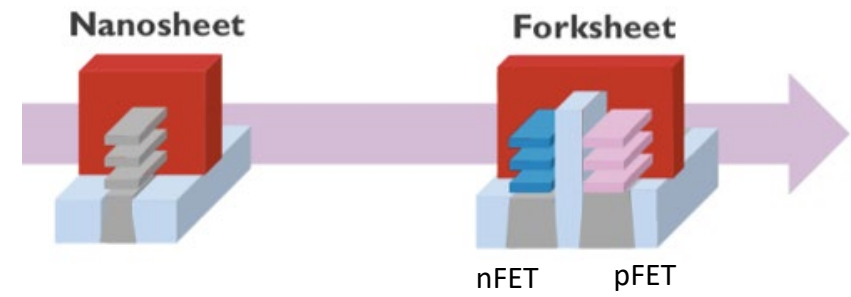
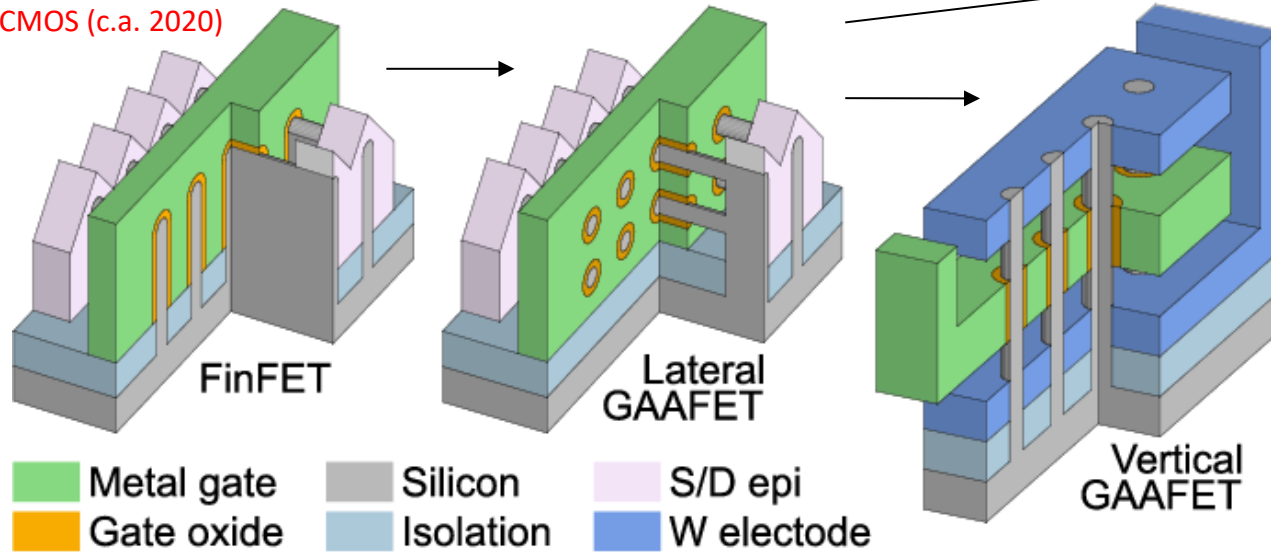
Device Architecture and Ground Rules Roadmap for Logic Devices.

Note: GxxMxx/Tx notation refers to Gxx: contacted gate pitch, Mxx: tightest metal pitch in nm, Tx: number of tiers. This notation illustrates the technology pitch scaling capability. On top of pitch scaling there are other elements such as cell height, number of stacked devices, DTCO constructs, 3D integration, etc. that define the target area scaling (gates/mm²). LGAA—lateral gate-all-around-device (GAA), CFET (Complementary Field Effect Transistor), 3DVLSI—fine-pitch 3D logic sequential integration. (https://irds.ieee.org/images/files/pdf/2024/2024IRDS_MM.pdf)

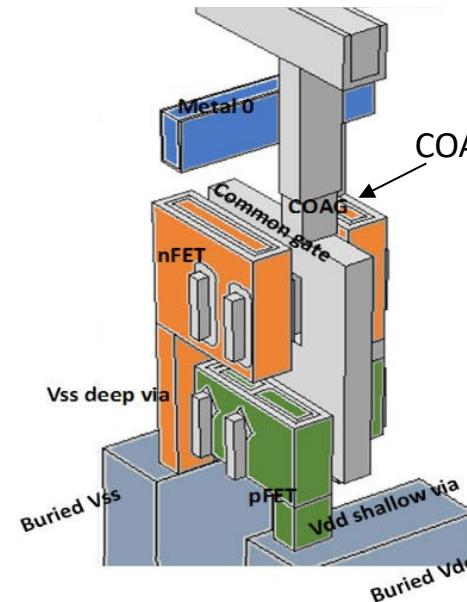
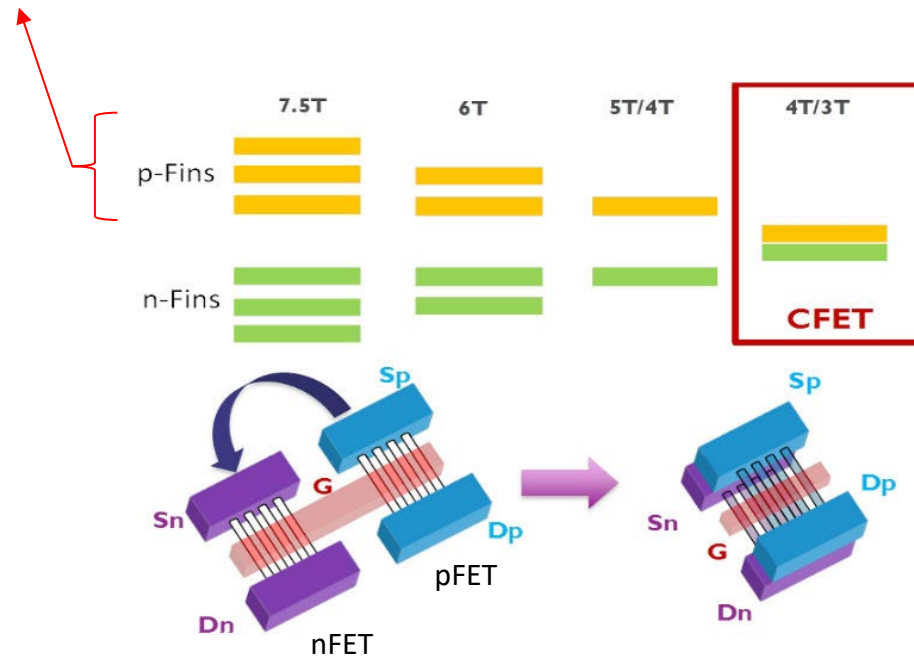
Options extending the roadmap



current generation
CMOS (c.a. 2020)



Complementary FET (CFET)



nFET and pFET are placed vertically

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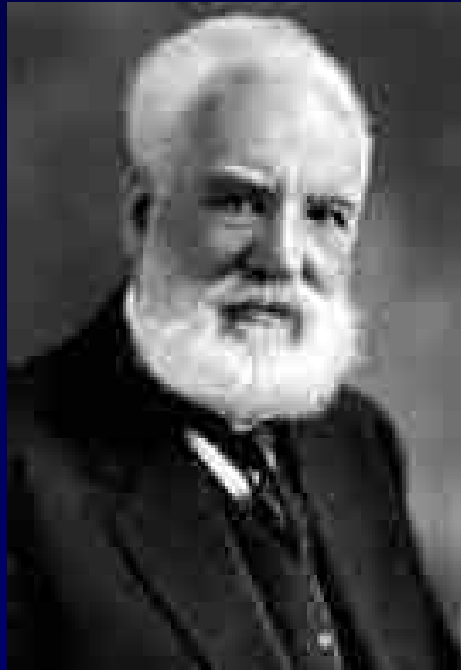
Brief History of IC

How were the Semiconductor Industry and
Silicon Valley born?

New technologies are driven by “Needs”

Necessity is the mother of invention (Plato)

- AT&T(America Telephone & Telegram) in the late 19 Century
 - Monopoly of the telephone business due to the patent by Alexander Graham Bell(1876)



Alexander Graham Bell

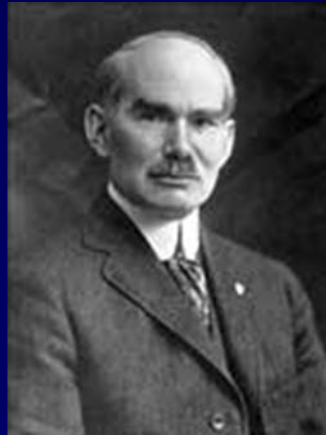


AT&T HQ in 1958

Loss of telephone monopoly by AT&T

- Problem at 1894: AT&T
 - Expiration of Bell's telephone patent: competition in the telephone business with other companies
- Problem at 1895: Bologna, Italy
 - Invention of radio transmission by Guglielmo Marconi
 - 1897: Establishment of Marconi Wireless Telegraph Company: the age of wireless telecommunication

- Strategy of AT&T (1907)
 - Plan to build the first transcontinental phone line
 - Problem: signal needs to be amplified
 - Solution: bought the patent of a triode vacuum tube by Lee De Forest (1906) and started to develop amplifiers.



American Inventor: Lee De Forest



triode vacuum tube amplifier

- 1909: Announcement by Vail (president of AT&T) of the plan to build the first transcontinental telephone line
- 1914: Completion of the transcontinental line



Theodore Vail (President of AT&T) making long-distance phone call, 1915, Courtesy AT&T

- 1925: Bell Laboratories became a subsidiary company of AT&T
(number of employees = 3,600, annual budget 12 million dollars: the largest R&D organization in the US by then)
— Objectives: to solve all technical problems for telephone lines in the US

MURRAY HILL, NJ - MARCH 13, 1942: Bell Telephone Laboratory, Murray Hill, New Jersey. Main group from acoustics laboratory roof. Gottscho-Schleisner, Inc./Courtesy Library of Congress Prints and Photographs Division Washington, D.C., call no. LC-G612- 42005

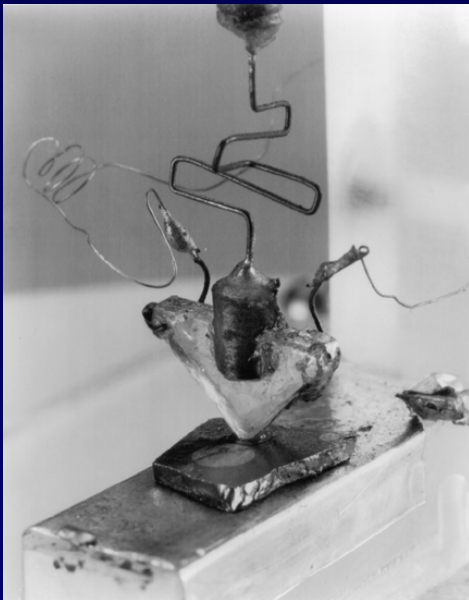


- Big Problem of telephone lines then: vacuum tubes have low reliability and large power consumption
- In 1936, Mervin Kelly became Research Director of Bell Laboratories and, after the WWII, formed a Solid State Physics group (led by W. Shockley) to develop solid-state amplifiers.



Mervin Kelly: director 1936-50, president of Bell Labs 1951-59

- In the Solid State Physics Group of Bell Labs led by William Shockley, experimentalist Walter Brattain and theorist John Bardeen invented a transistor. The Nobel Prize in Physics was granted to Bardeen, Brattain, and Shockley in 1956.
- The team applied quantum mechanics, which was just born in the 1930s, to the development of solid-state devices



pnp point-contact
germanium transistor



Bardeen, Shockley, and Brattain

- AT&T replaced all vacuum-tube-based signal amplifiers with those with transistors in the 1950s and made the system work without switchboard operators.
- Transistors are in high demand for military use:
 - US semiconductor companies did not show much interest in civilian applications.



The first commercial transistor (1949)

The first transistor radio
Regency T1 (1954)
(Co-produced by Regency and
Texas Instrument)



Despite its very successful sales, the company stopped production in 1955 in order to focus on other products.



Tokyo Telecommunication Engineering Co. (which later became SONY) entered the US market for transistor radios after the retreat of T1 and became very successful.

Masaru Ibuka, left, with Akio Morita, Sony Corp.

Birth of Silicon Valley

- In 1955, Shockley left Bell Labs and established Shockley Semiconductor in Mountain View, Ca, to develop and manufacture new semiconductor devices.
- In 1957, 8 young scientists (“the Traitorous Eight”) left Shockley Semiconductor and established Fairchild Semiconductor.
- In 1960, Shockley Semiconductor was bought by Clevite Transistor .

Invention of IC (Integrated Circuits)

- In 1957, 8 former Shockley Semiconductor scientists established Fairchild Semiconductor. The 3rd company in the current Silicon Valley.
- In 1959, Robert Noyce of Fairchild Semiconductor invented ICs. (The first IC patent in 1961)
- Around the same time (1958), Jack Kilby of Texas Instruments (TI) independently invented IC.



The first IC of TI

Fairchild Semiconductor & Intel

- Fairchild Semiconductor grew rapidly in the business of developing and manufacturing ICs. The number of employees grew from 12 to 12,000.
- Noyce introduced Californian style management: casual atmosphere in business.
- Many of co-founders of Fairchild Semiconductor left the company and built their own companies, which became the base of the present-day Silicon Valley. (Fairchildren)
- In 1968, Robert Noyce and Gordon Moore left Fairchild and founded Intel.
- Other include National Semiconductors and Advanced Micro Devices.

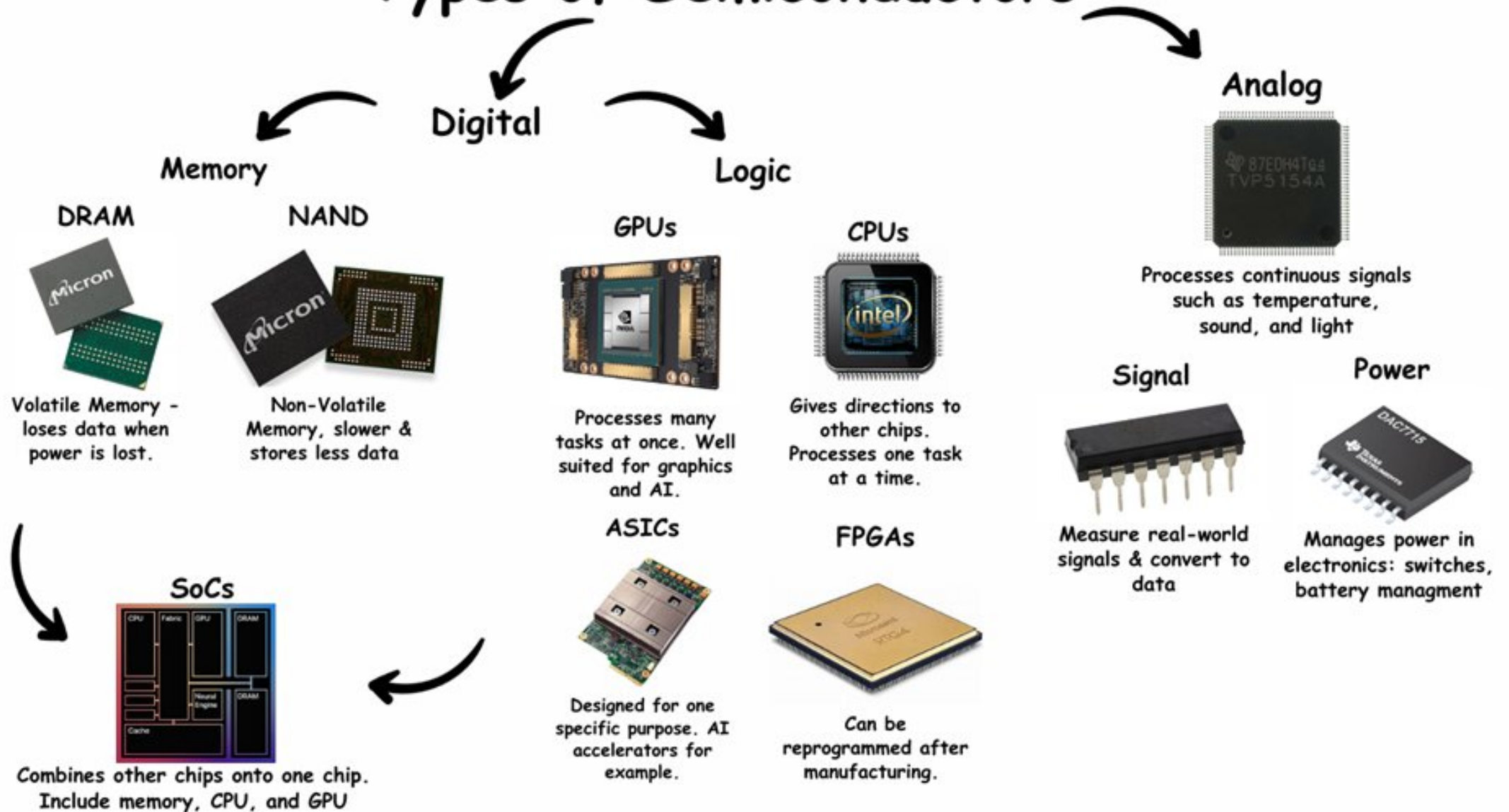
Success of Transistors & IC development

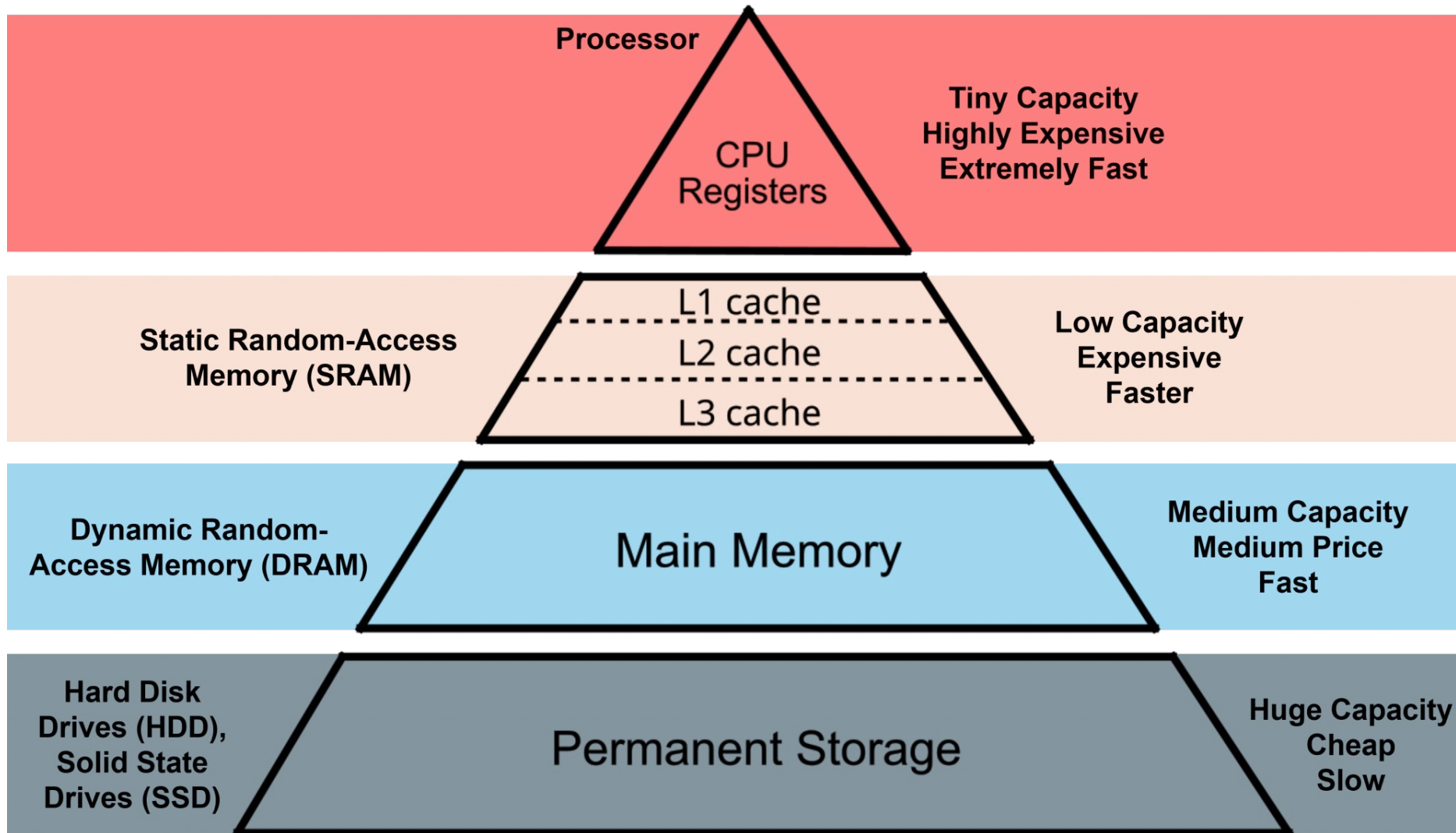
- Needs → long-distance telephone line solid-state devices
- Method of development
 - The latest theory of fundamental science (quantum mechanics)
 - Systematic search of materials
- Development of the market
 - Technological innovation (e.g., invention of IC) and market development by Fairchild & Intel

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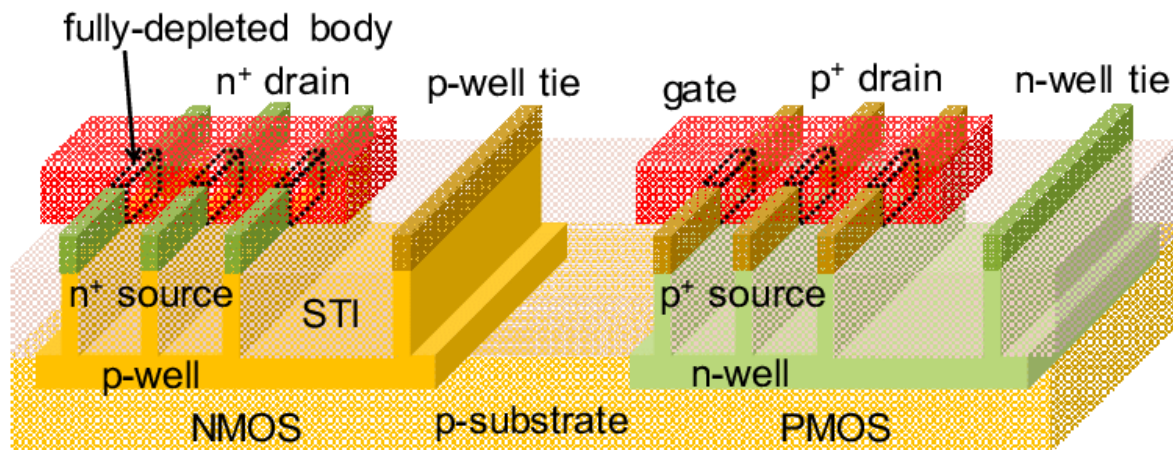
Types of Semiconductors



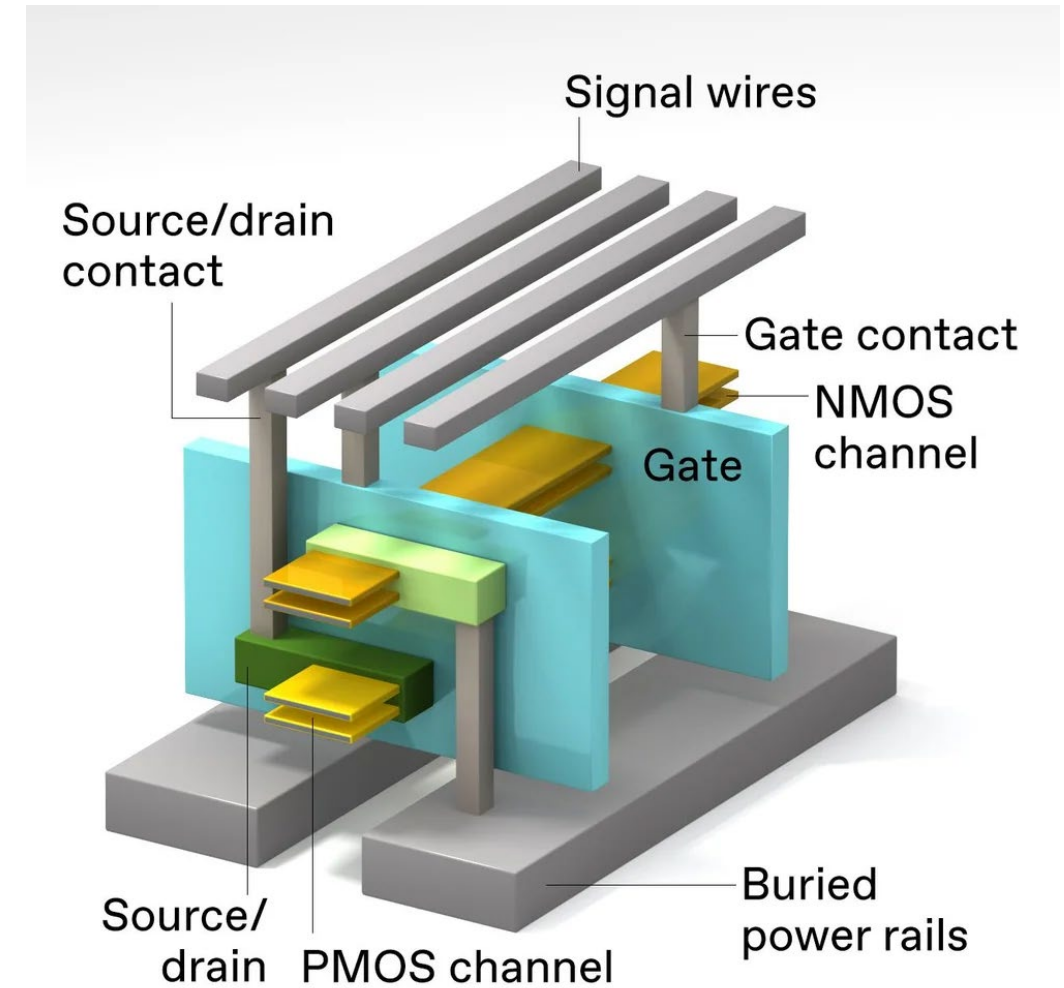


Future CMOS? 3D-stacked CMOS

FinFET CMOS: current generation

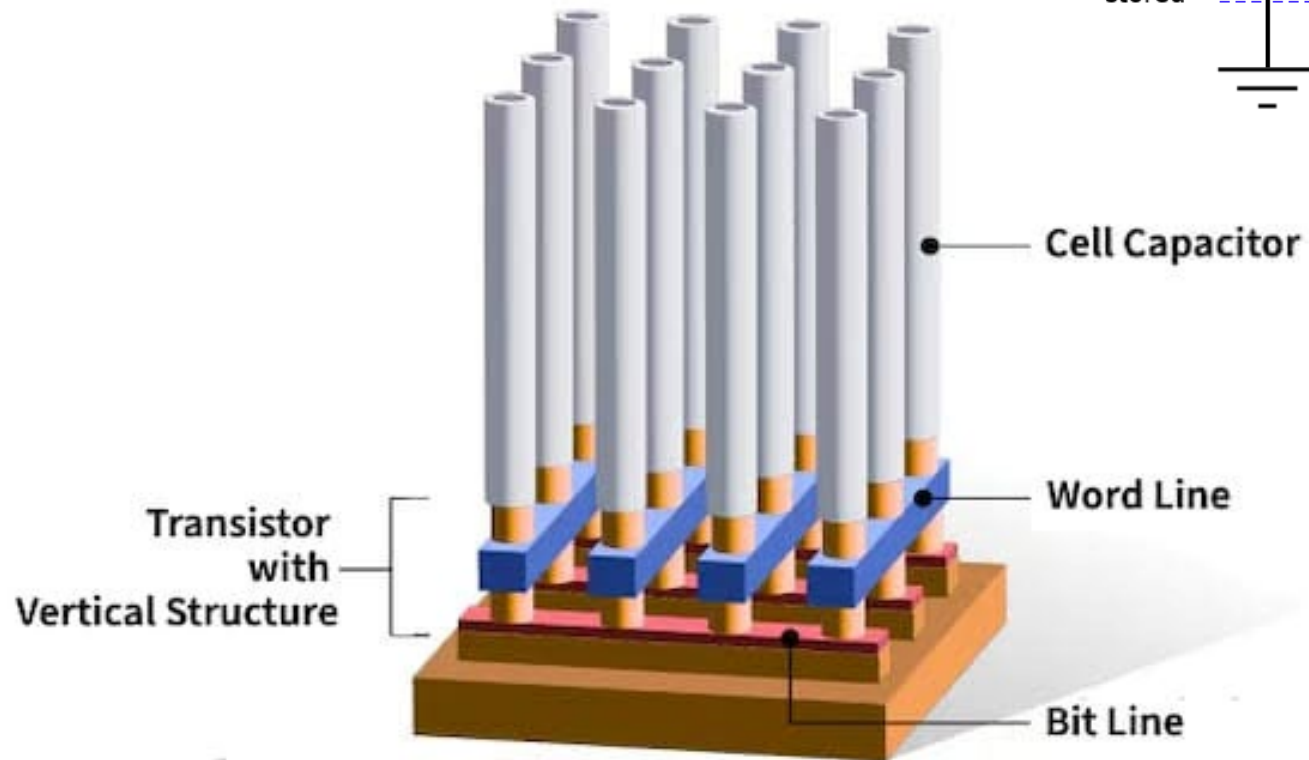


<https://www.researchgate.net/publication/324608238/figure/download/fig1/AS:617287212097542@1524184148757/Fully-depleted-bulk-CMOS-finFETs.png>

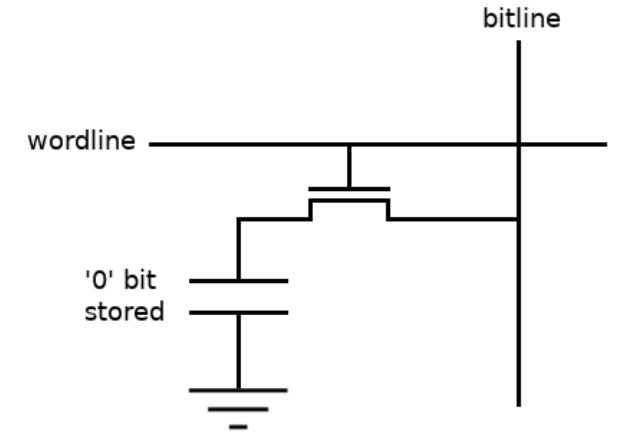
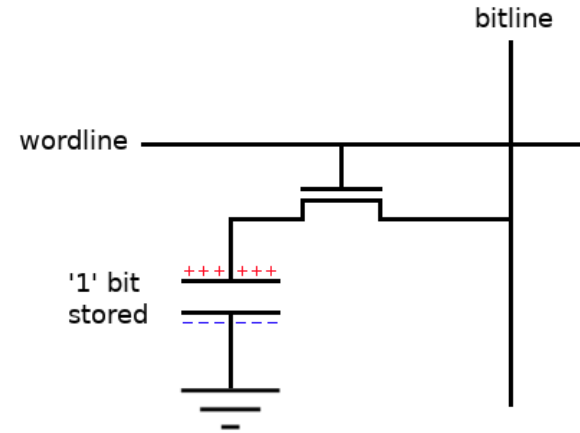


<https://spectrum.ieee.org/media-library/orange-elongated-blocks-connect-to-several-narrower-blocks-of-a-variety-of-colors.jpg?id=30542266&width=1000&quality=85>

4F² DRAM Structure Diagram



ChosunBiz

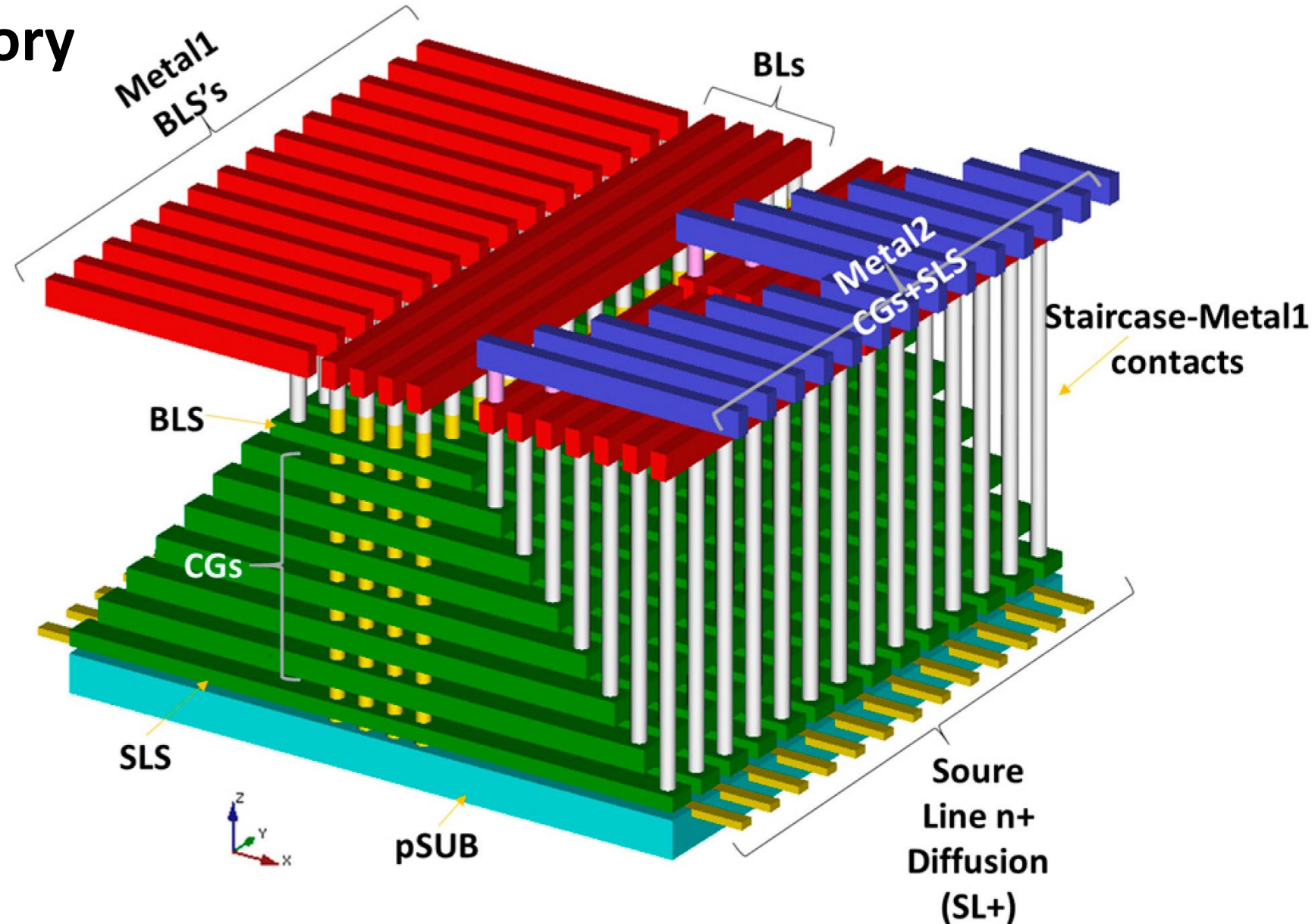


3D NAND Flash memory

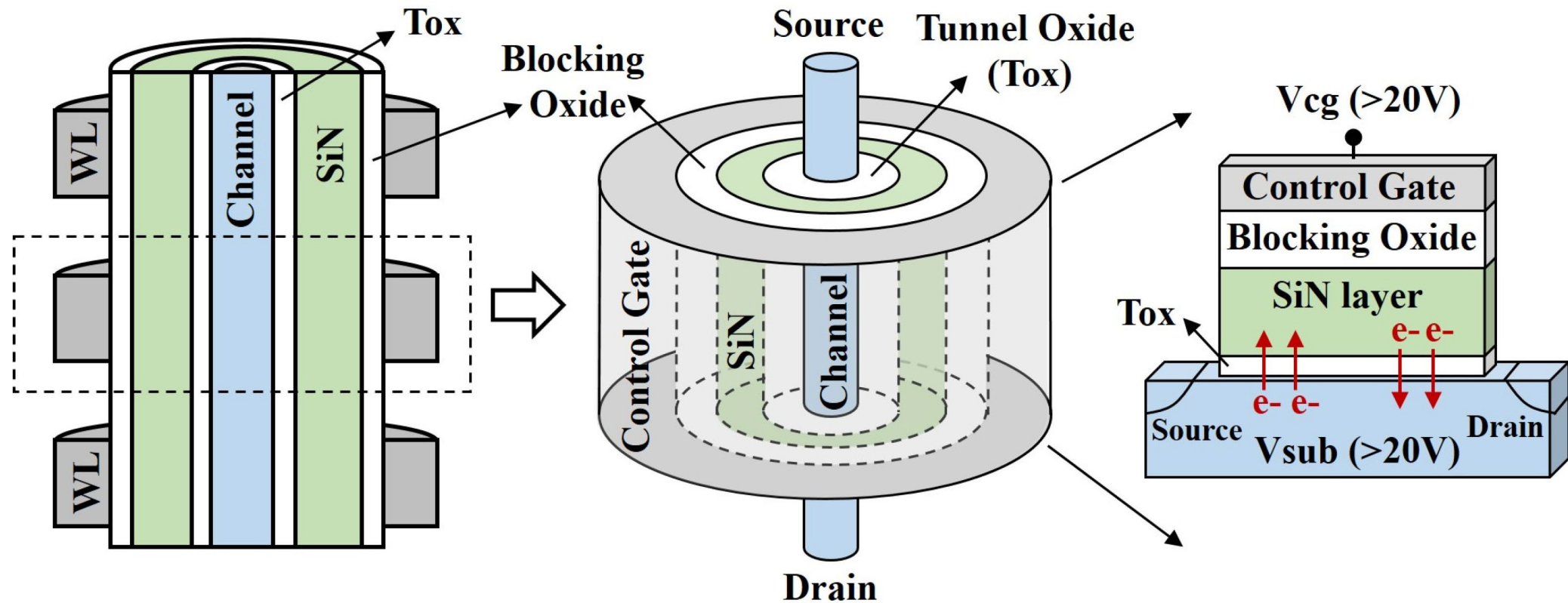


<https://dmassests.micron.com/is/image/microntechnology/nand-flash-worlds-first-layers%3A3-2-all-others?ts=1750894890969&dpr=off>

BLS: bit line selector
SLS: source line selector
CG: control gate (word line)
BL: bitline
pSUB: p-type substrate

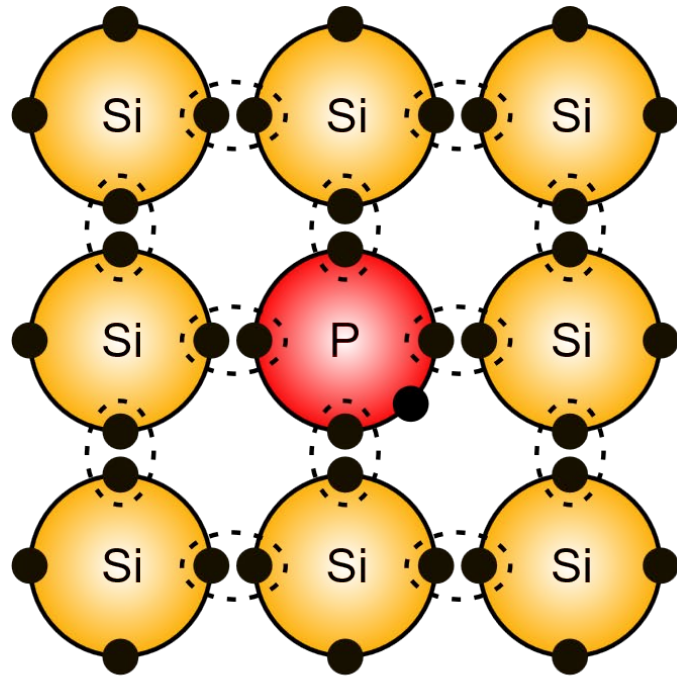


3D NAND Flash memory: memory cell

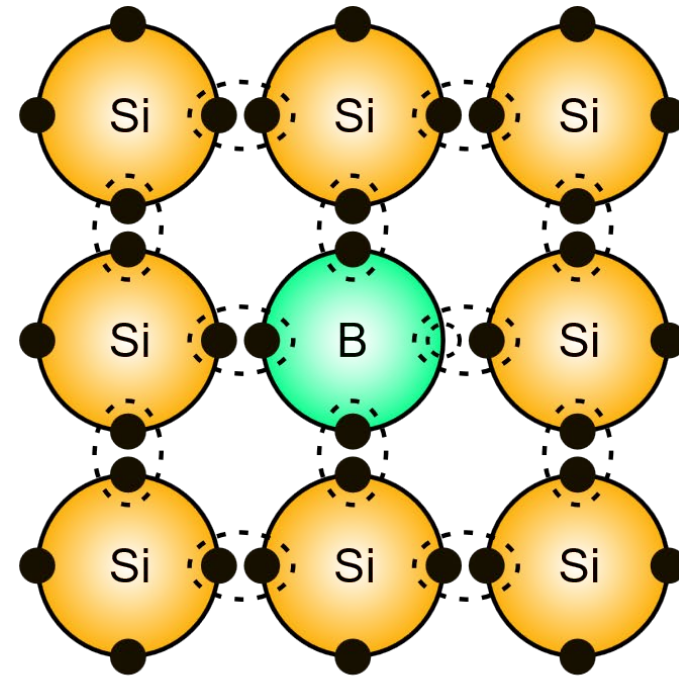


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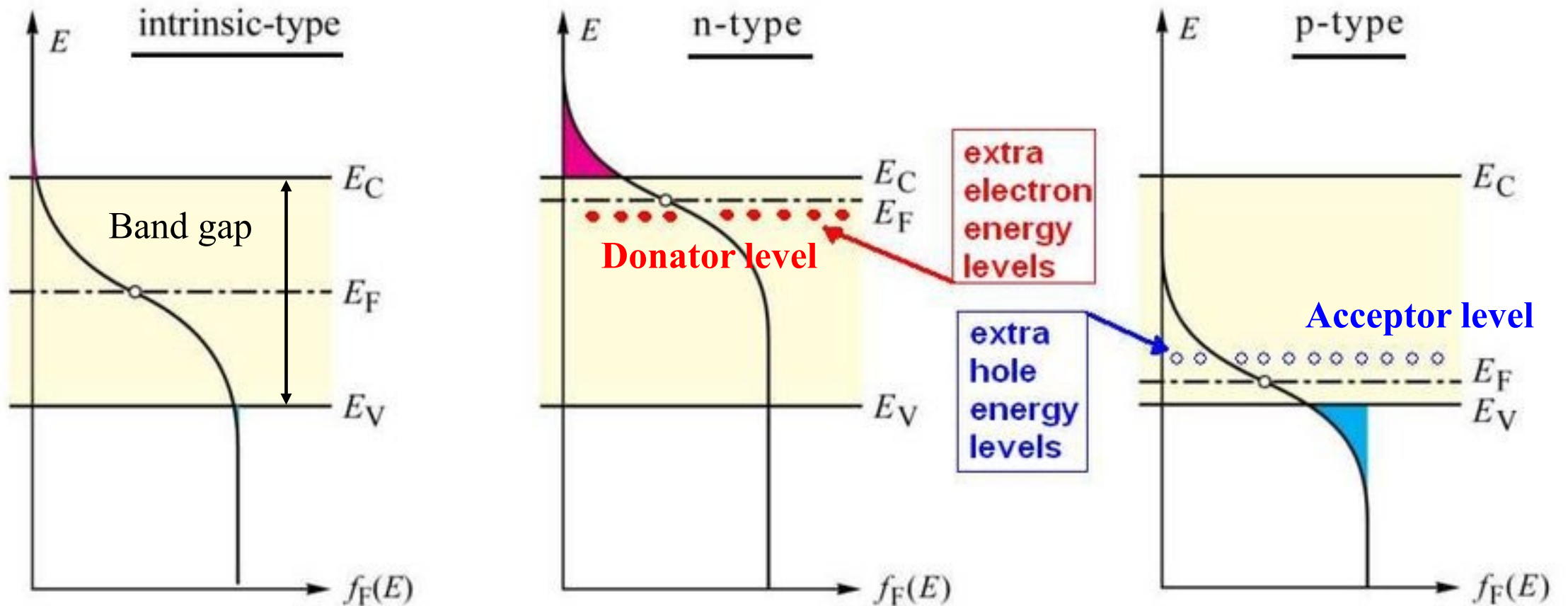


n-type



p-type

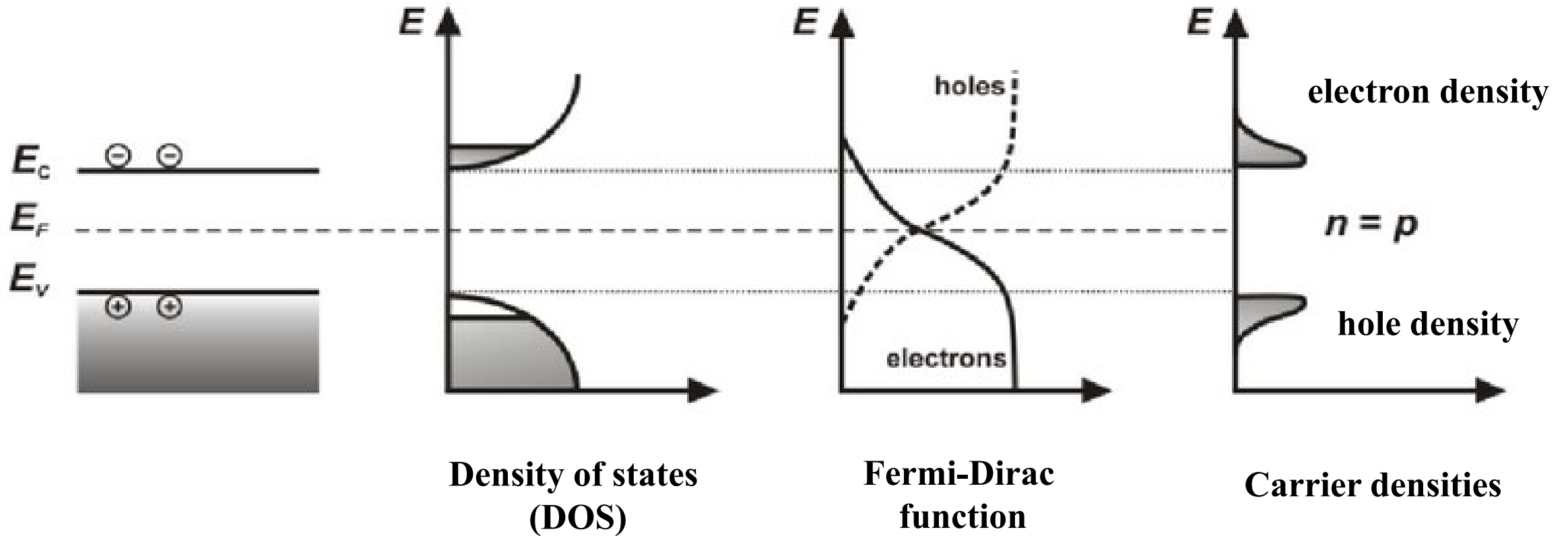
$f_F(E)$: Fermi-Dirac distribution function



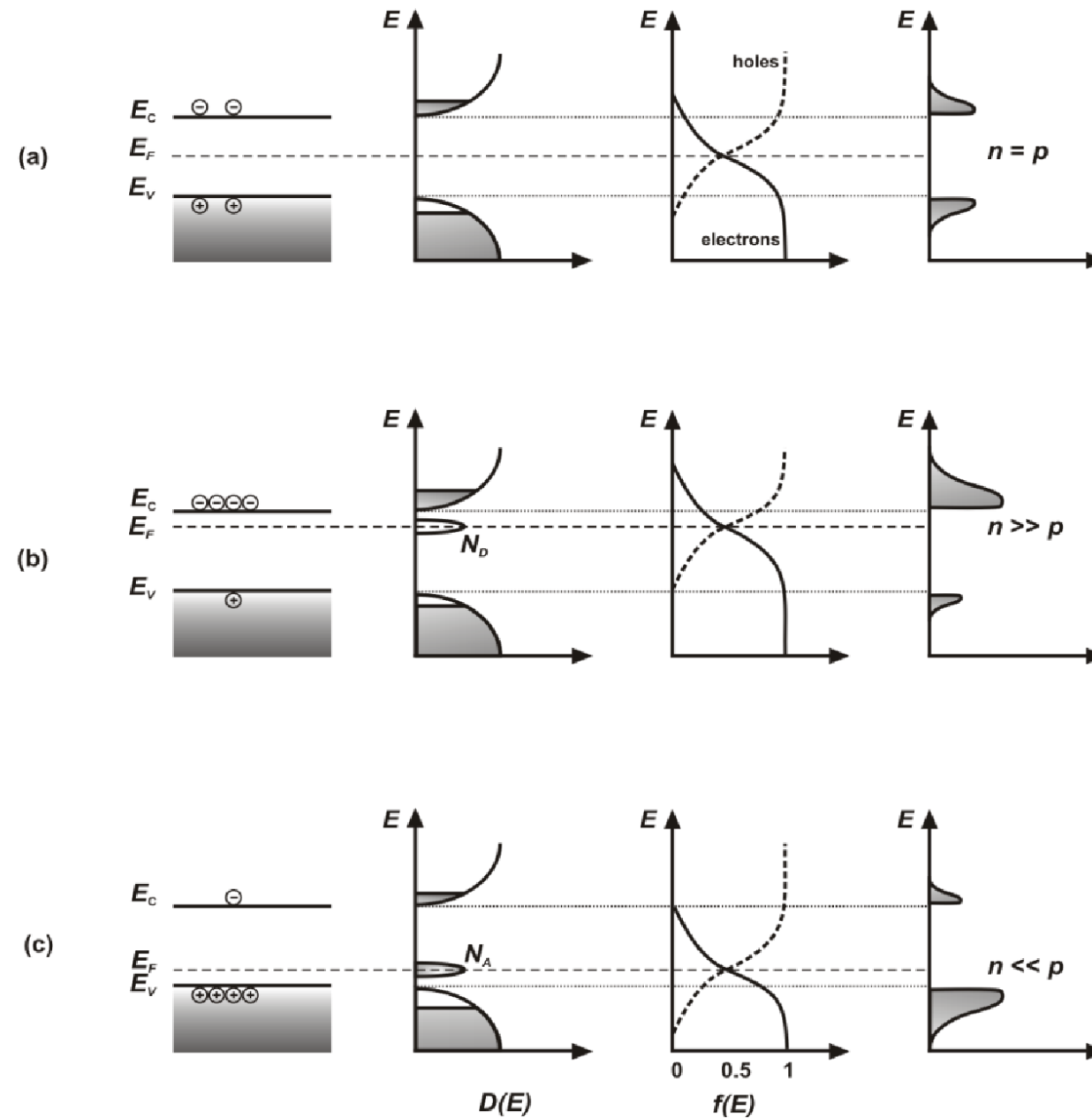
E_c : conduction band energy, E_F : Fermi energy, E_V : Valence band energy

<https://i.sstatic.net/72aOy.jpg>

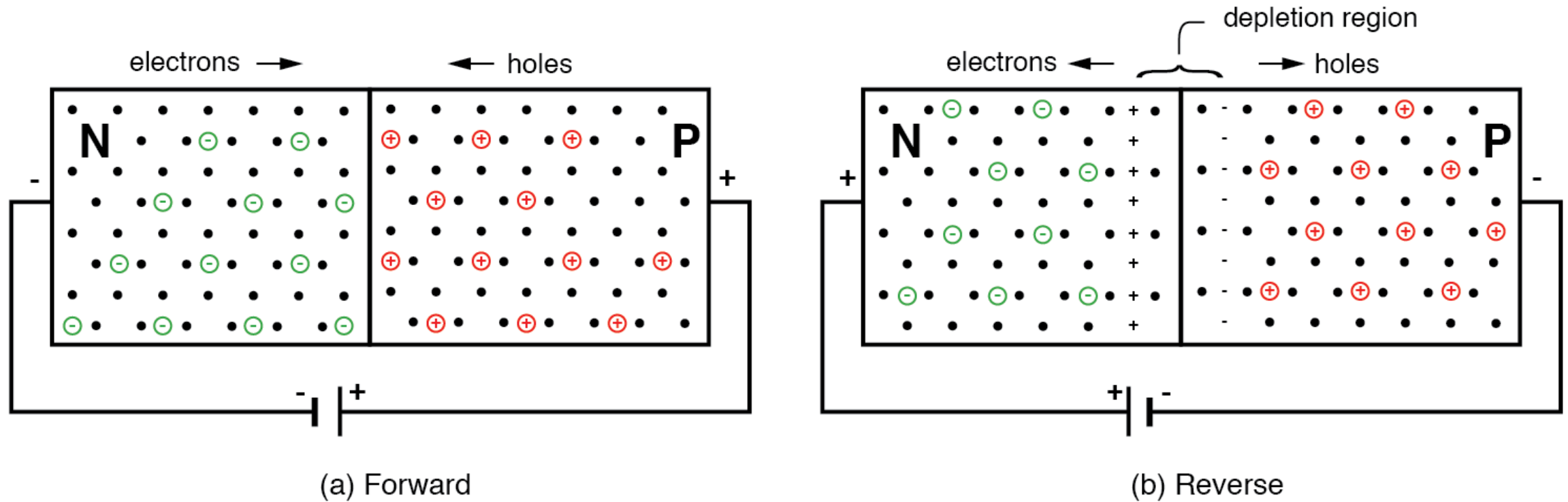
For Intrinsic Si (i.e., without dopants)



<https://i.sstatic.net/k5RID.png>

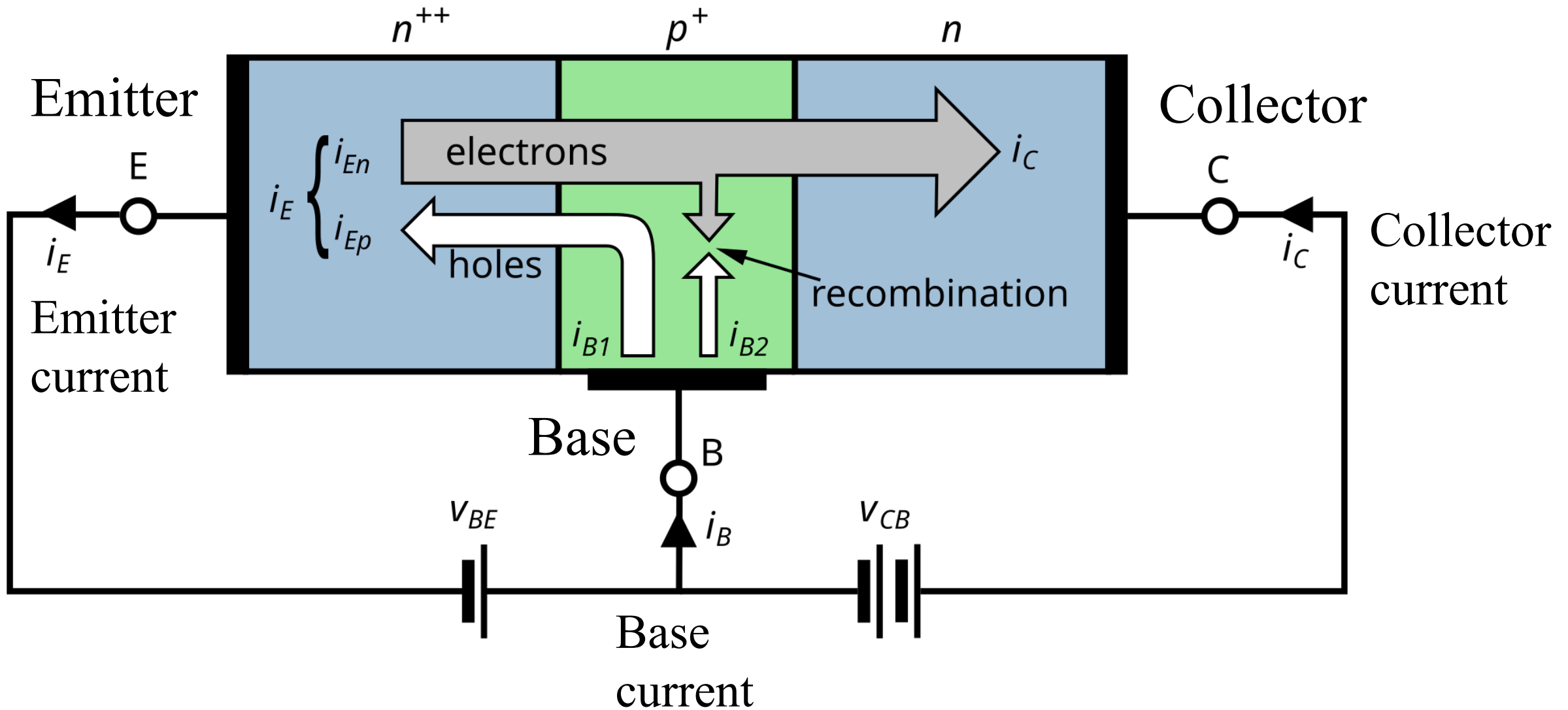


PN junction diode

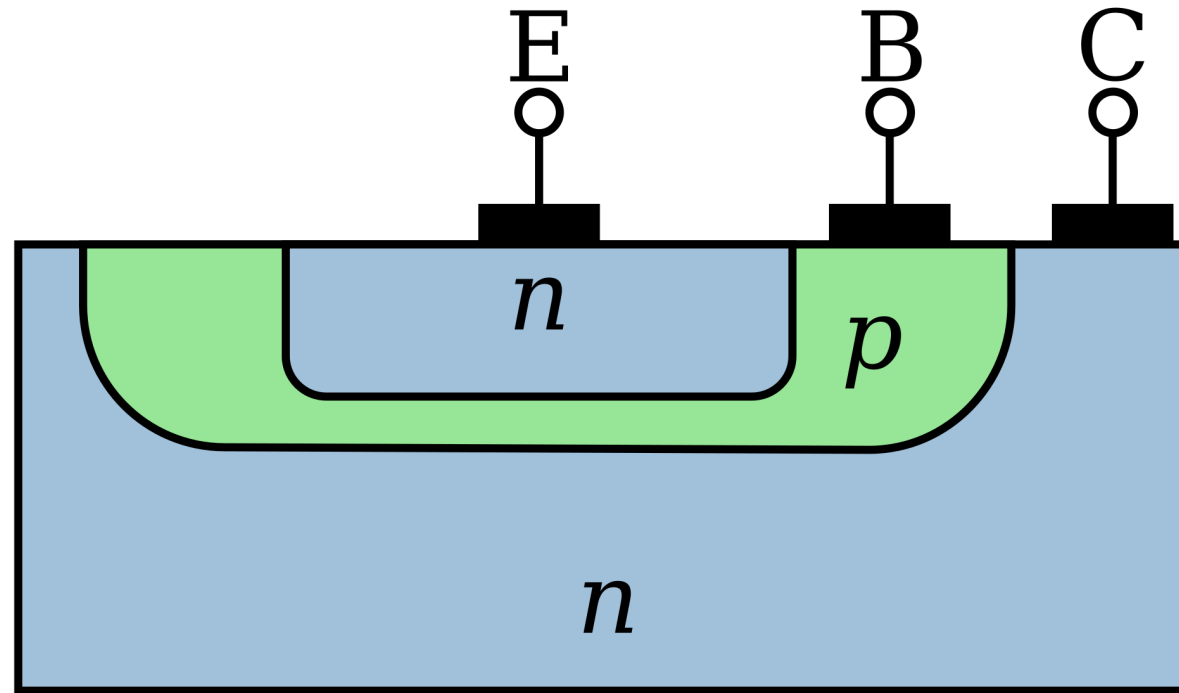


<https://www.allaboutcircuits.com/uploads/articles/pn-junction-bias.png>

Bipolar Junction Transistor (BJT) : NPN transistor

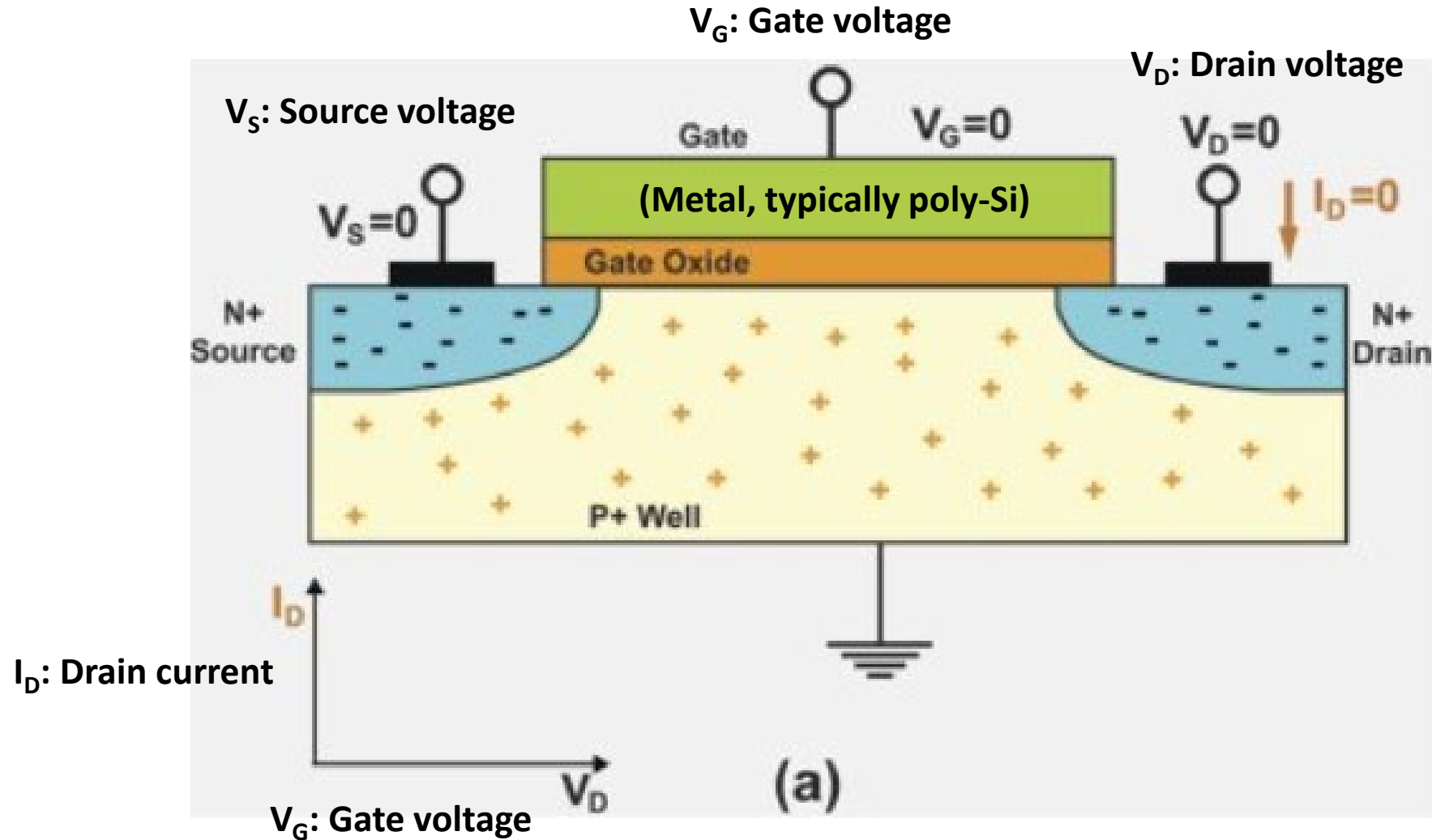


Bipolar Junction Transistor (BJT) : NPN transistor

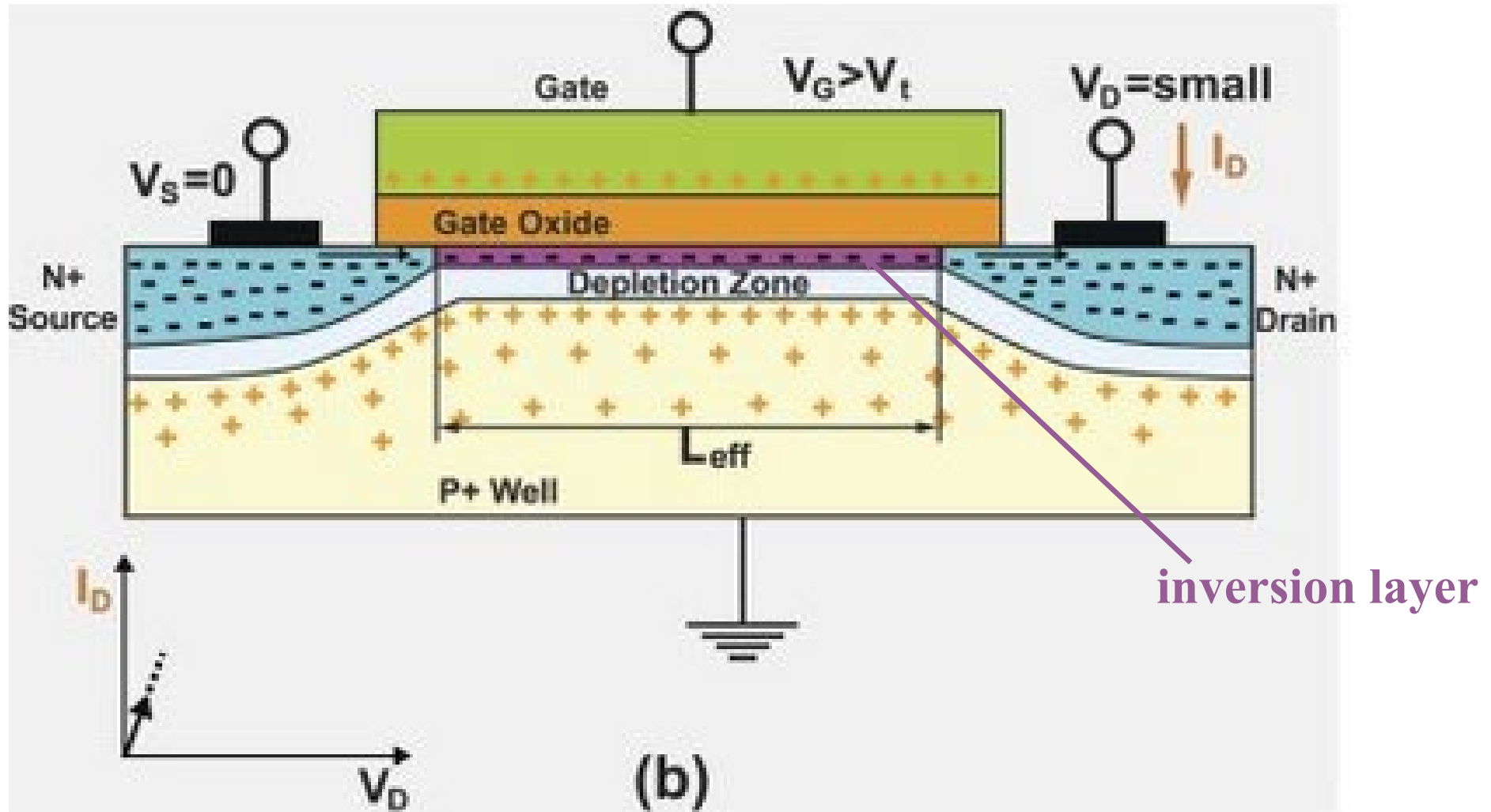


Simplified cross section of a planar *NPN* bipolar junction transistor

Metal–Oxide–Semiconductor Field-Effect Transistor (MOS FET)

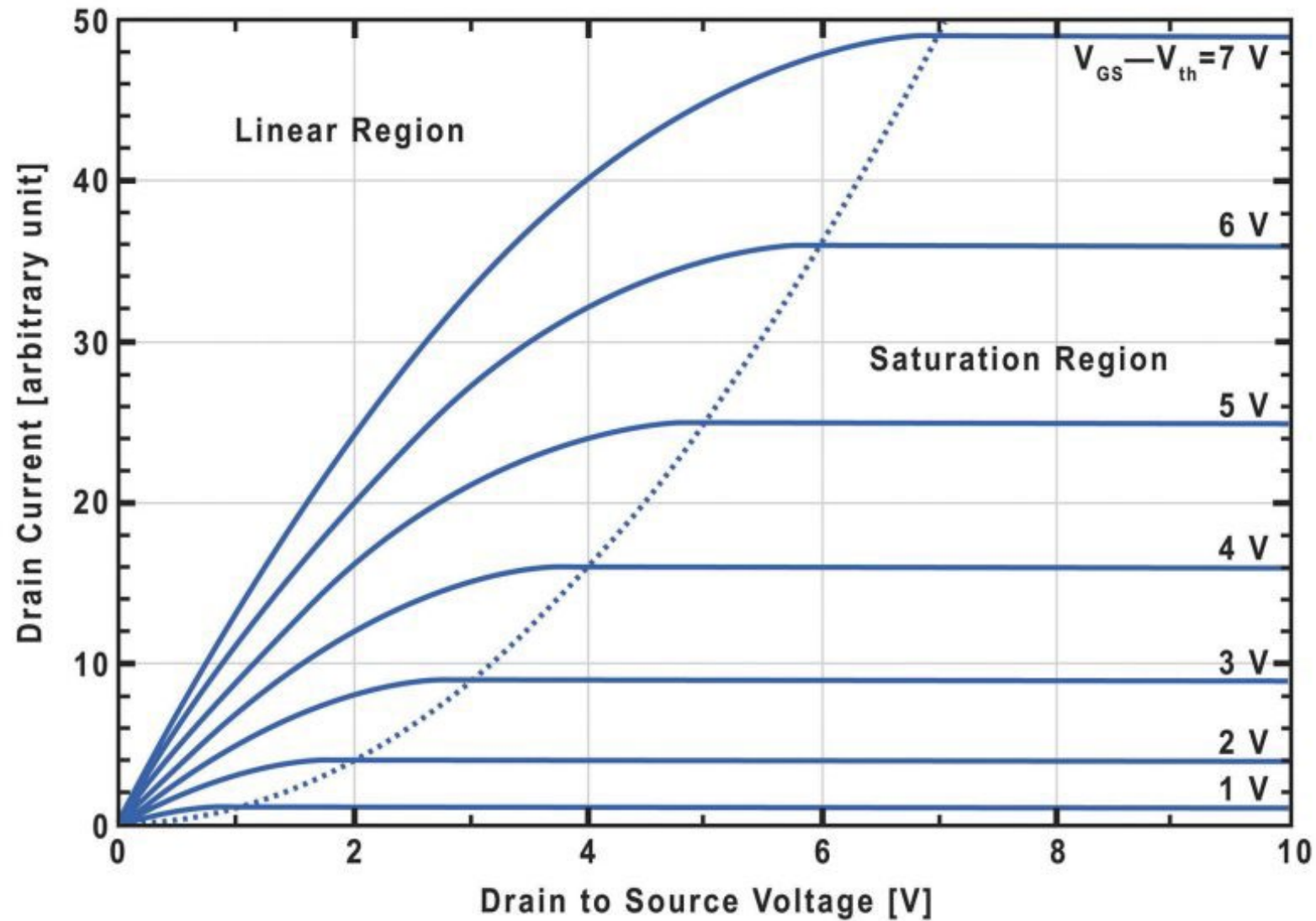


Metal–Oxide–Semiconductor Field-Effect Transistor (MOS FET)

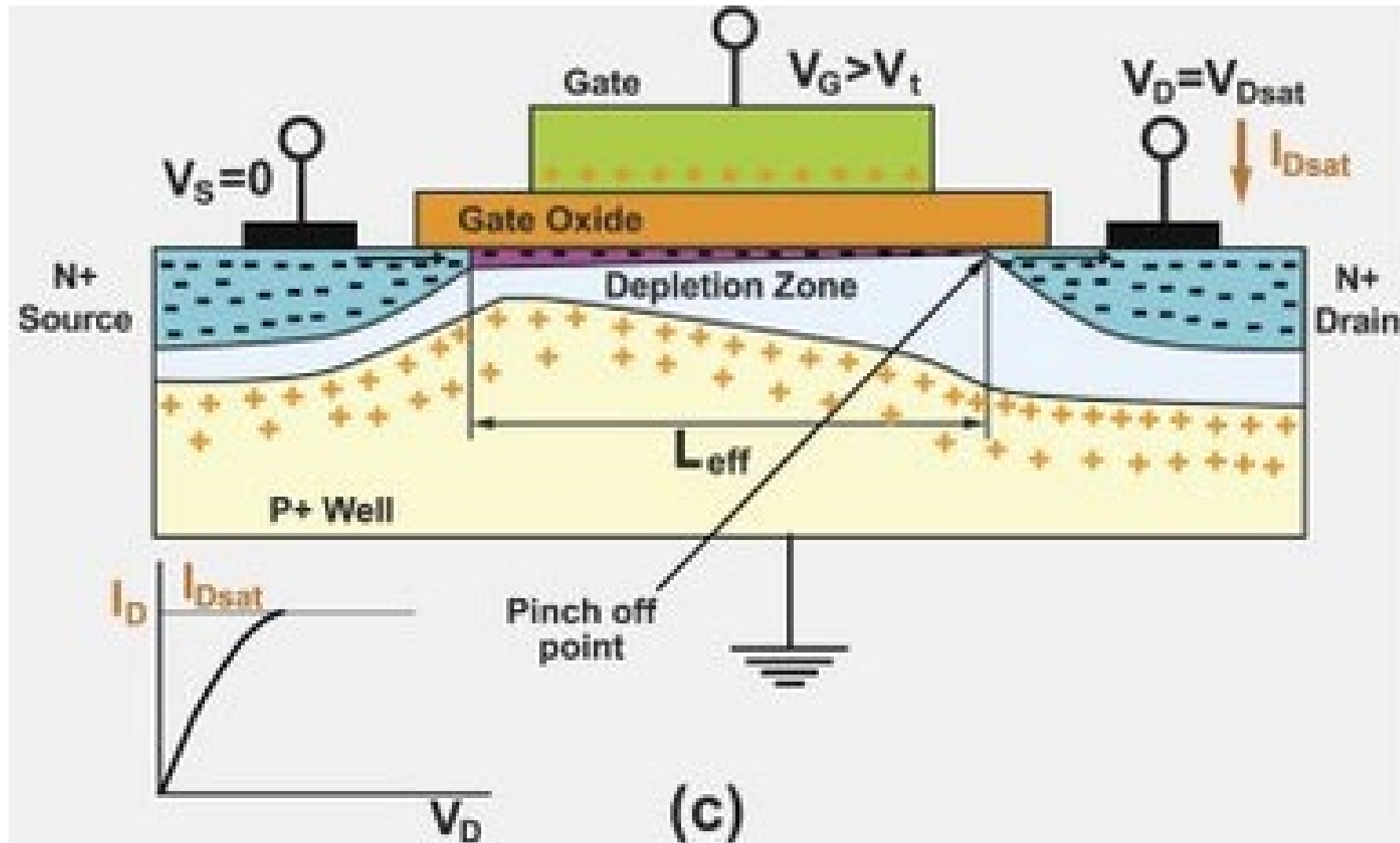


V_{GS} : gate voltage – source voltage

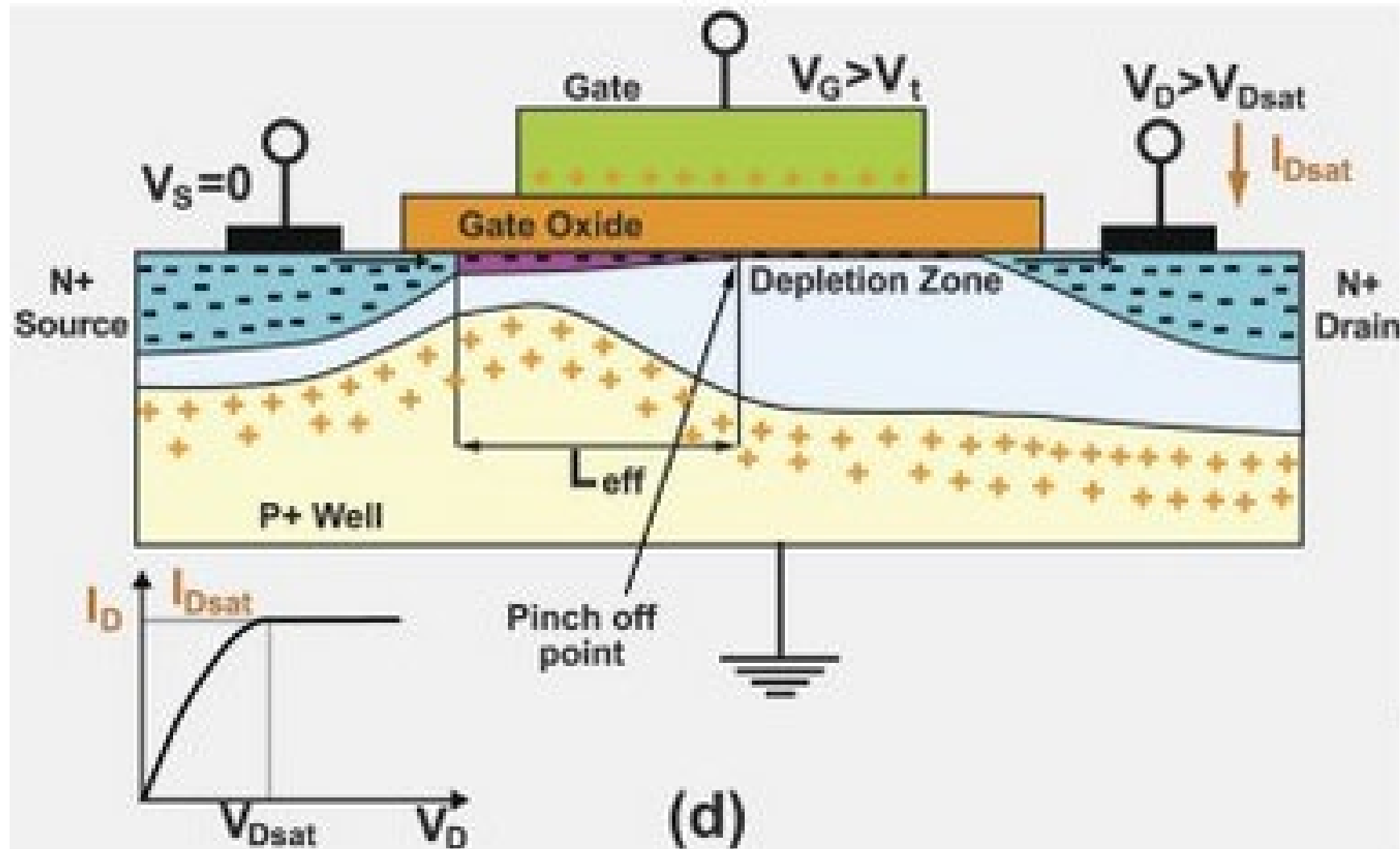
V_{th} : Threshold voltage



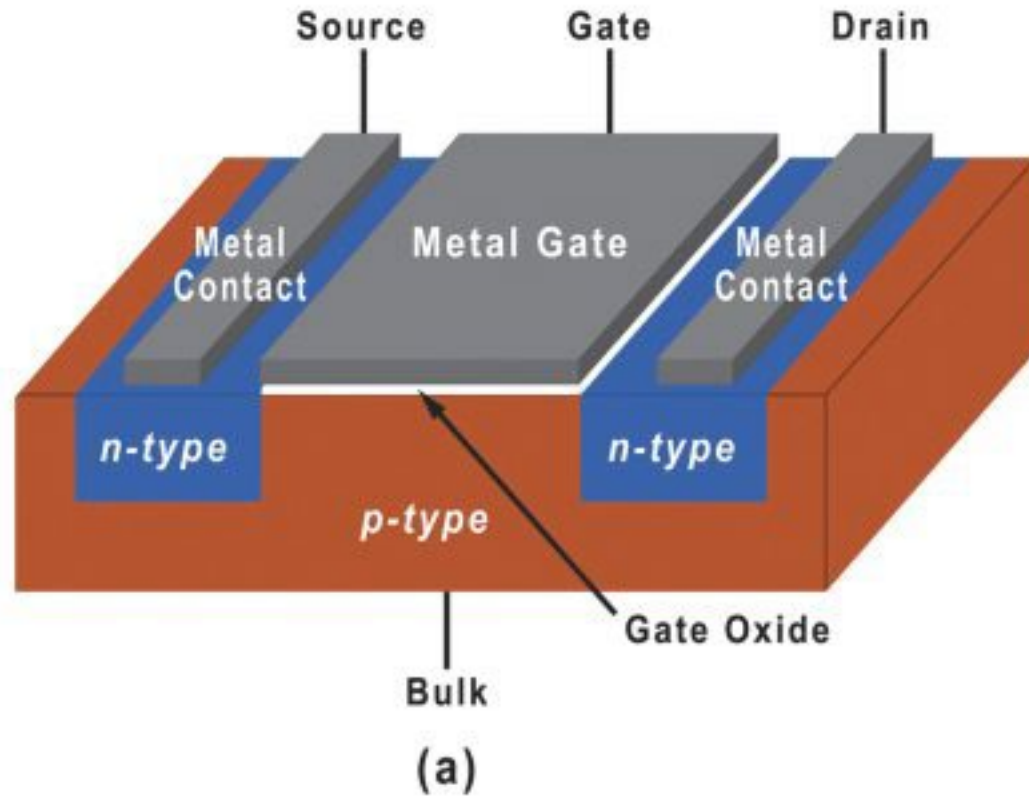
Metal–Oxide–Semiconductor Field-Effect Transistor (MOS FET)



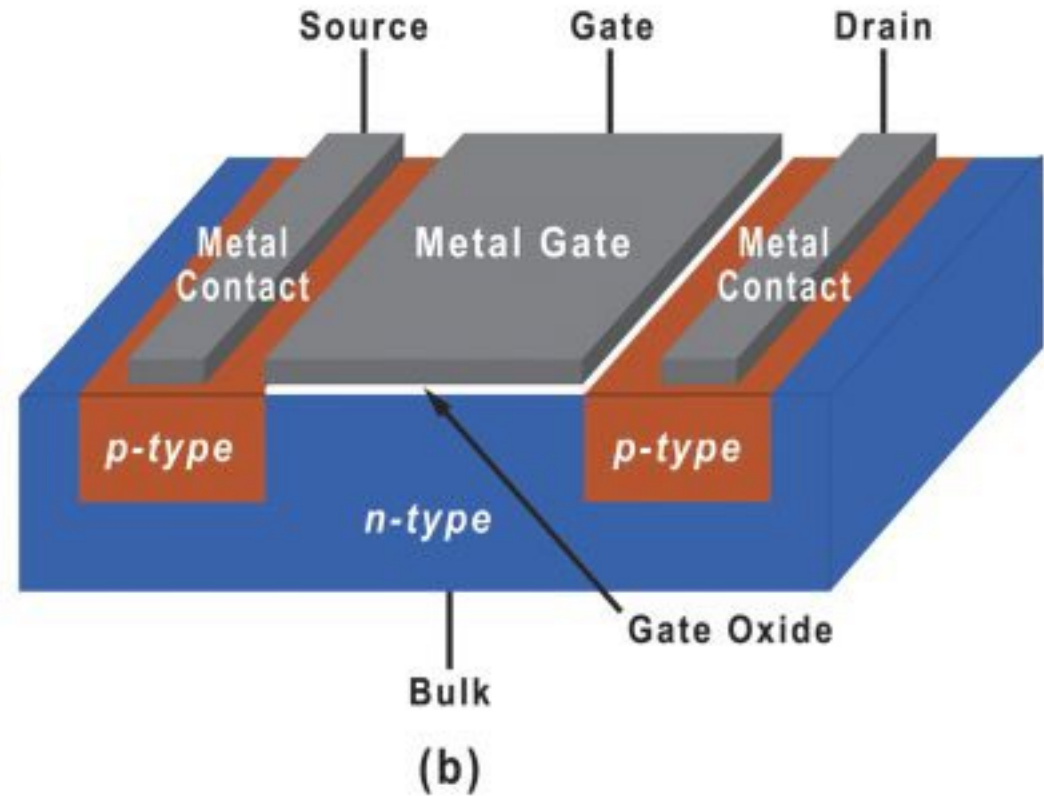
Metal–Oxide–Semiconductor Field-Effect Transistor (MOS FET)



NMOS



PMOS



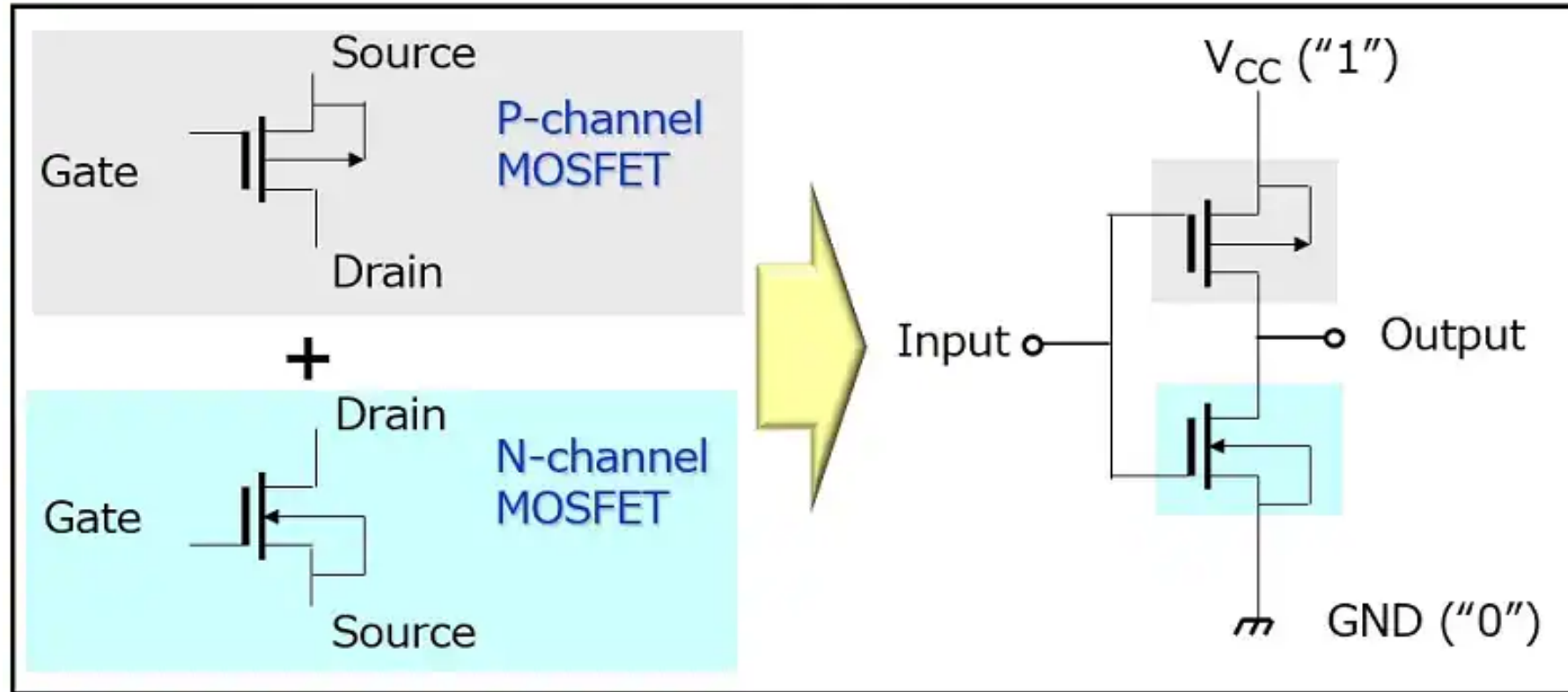
MOS consumes much less power than BJT

Complementary MOS FET (CMOS)

Inverter

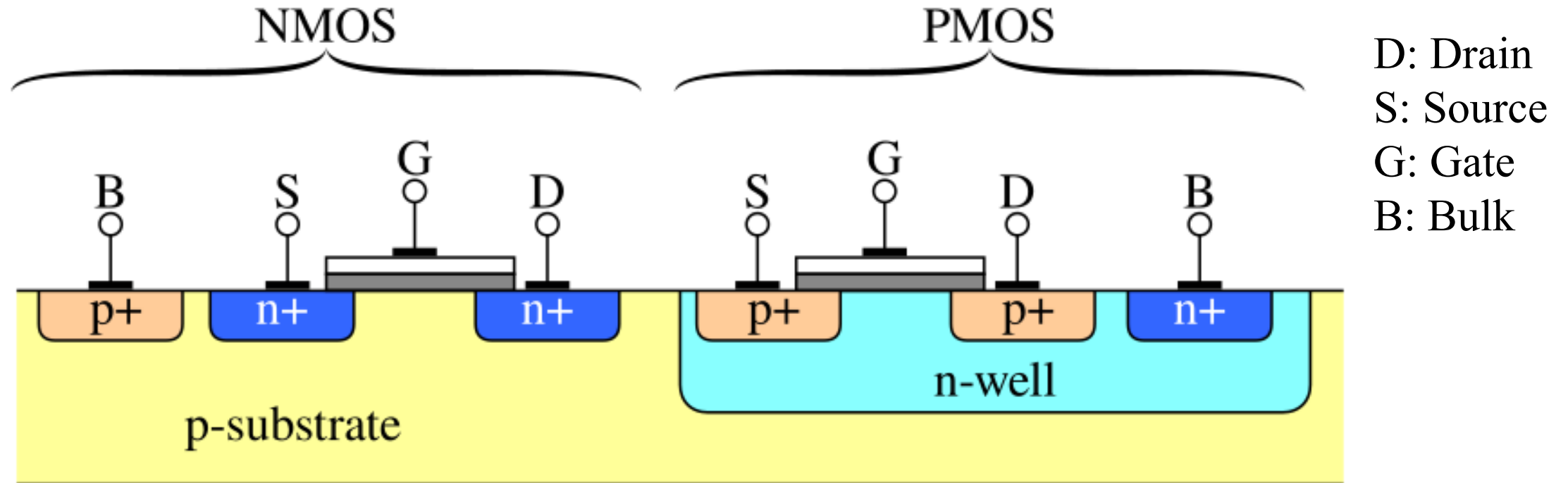


Logic symbol

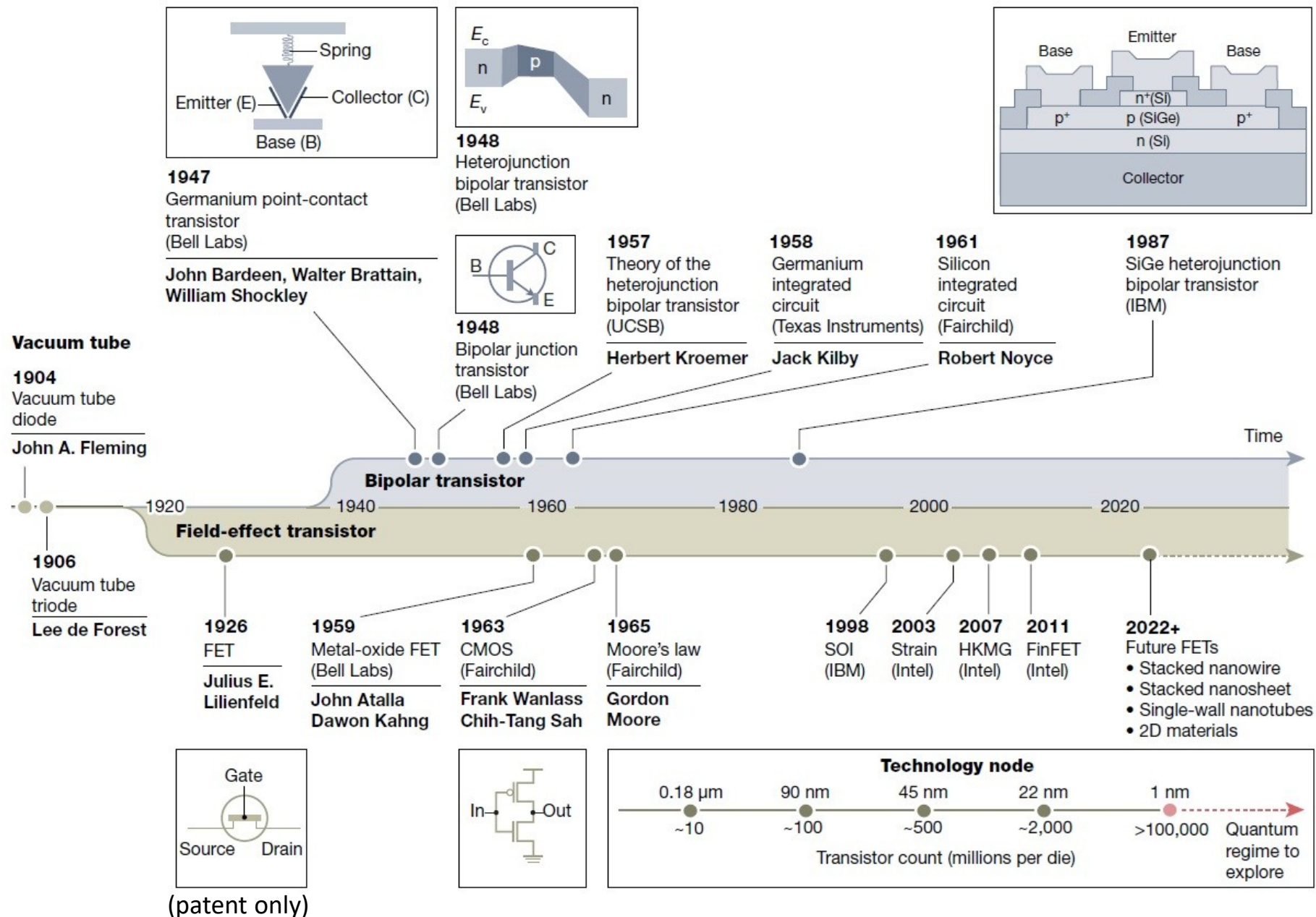


https://toshiba.semicon-storage.com/content/dam/toshiba-ss-v3/master/en/semiconductor/knowledge/e-learning/cmos-logic-basics/chap2-1_en.jpg

Complementary MOS FET (CMOS)



The advantages of CMOS over NMOS or PMOS are lower power consumption, less prone to noise, and therefore, allow higher integration.



Outline

1. The semiconductor industry
 - overview
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3. Fundamentals of device physics
4. Fundamentals of Chip Manufacturing
 - Front-end processes (FEOL & BEOL)
 - Back-end processes
5. Summary

Outline of semiconductor manufacturing

Cross-section of a chip \Rightarrow

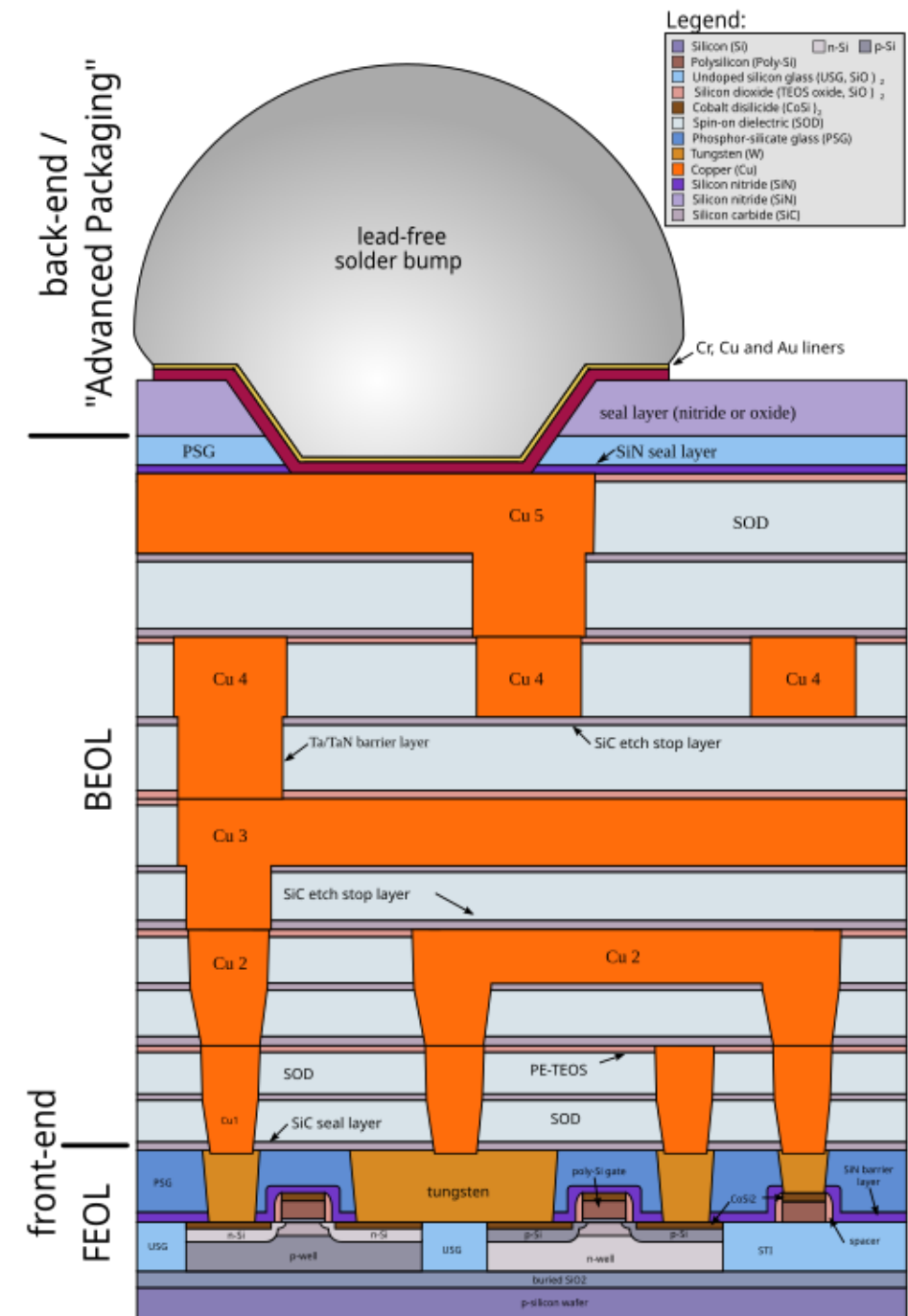
front-end processes

front end of line (FEOL)

back end of line (BEOL)

back-end processes

https://upload.wikimedia.org/wikipedia/commons/thumb/e/ee/Cmos-chip_structure_in_2000s_%28en%29.svg/500px-Cmos-chip_structure_in_2000s_%28en%29.svg.png



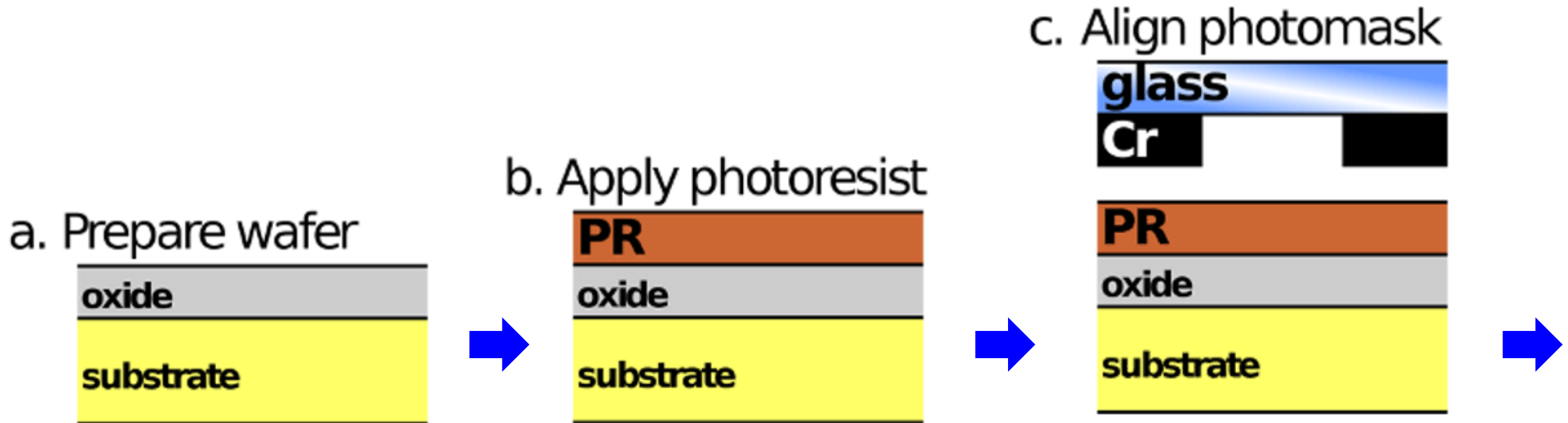
FOEL processes

FEOL processes: the first portion of IC fabrication where the individual components (transistors, capacitors, resistors, etc.) are patterned in a semiconductor substrate. FEOL generally covers everything up to (but not including) the deposition of metal interconnect layers.

(https://en.wikipedia.org/wiki/Front_end_of_line)

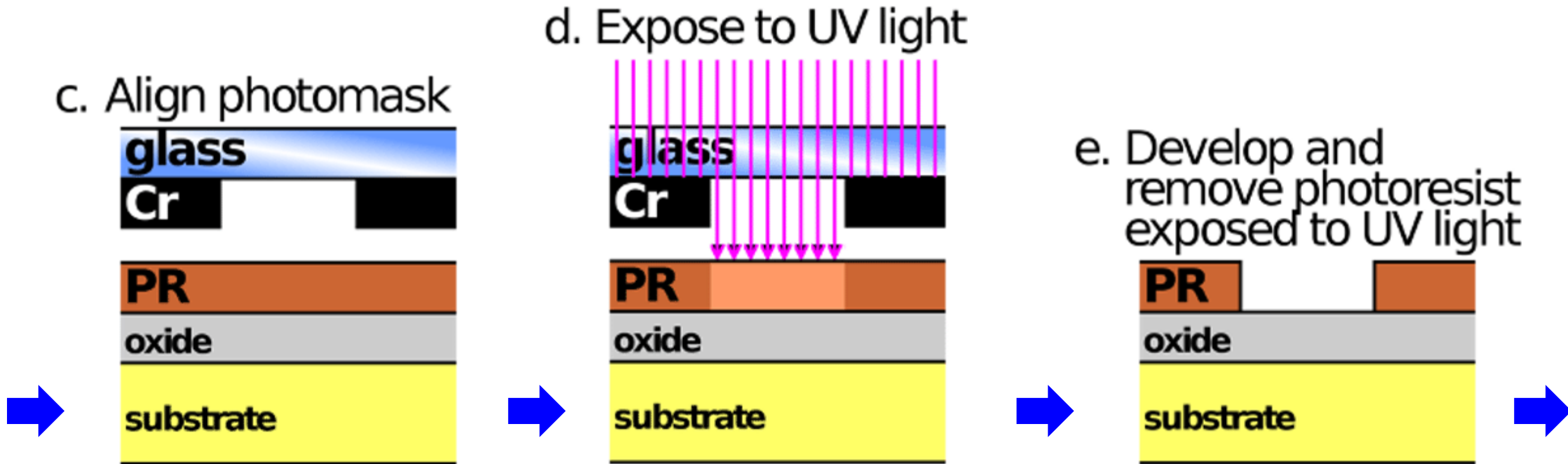
Basic Pattern Formation Process

How to form a mask for plasma etching



Basic Pattern Formation Process

How to form a mask for plasma etching

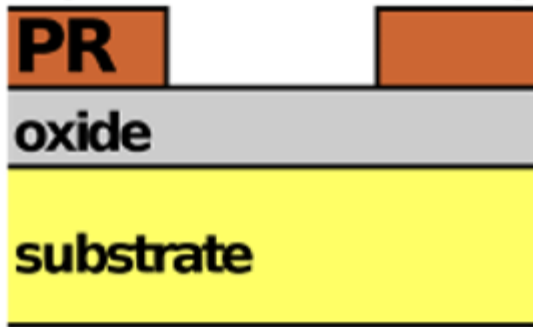


Lithography process

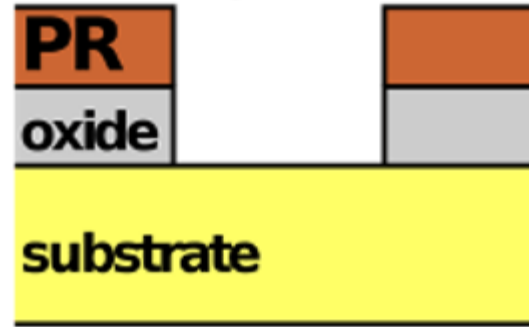
Basic Pattern Formation Process

How to form a mask for plasma etching

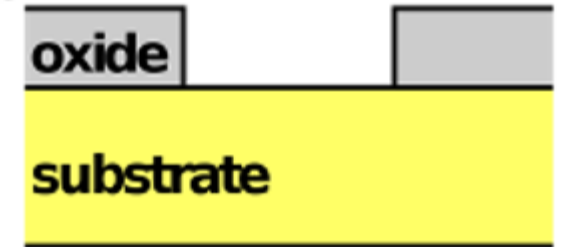
e. Develop and remove photoresist exposed to UV light



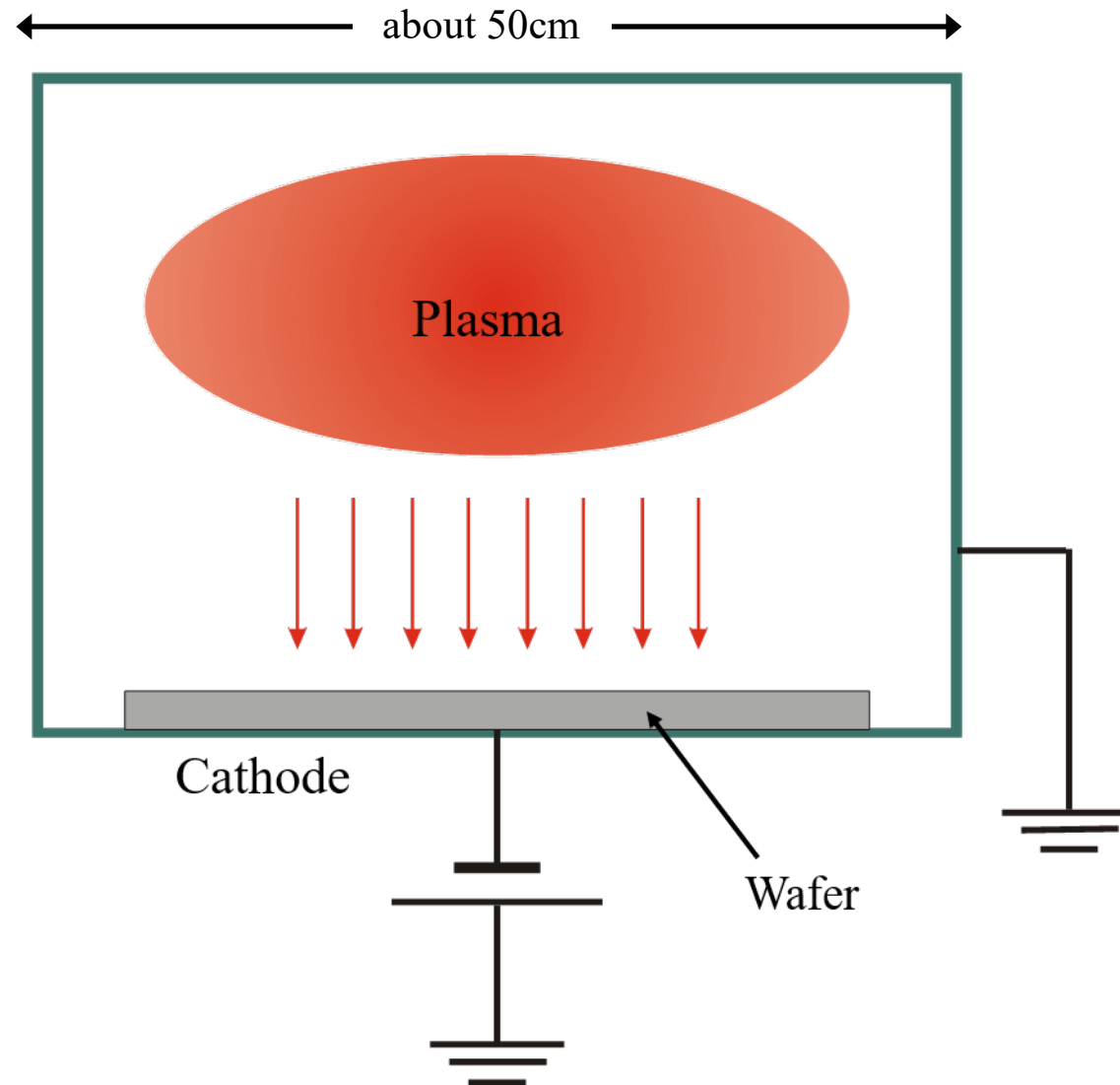
f. Etch exposed oxide



g. Remove remaining photoresist

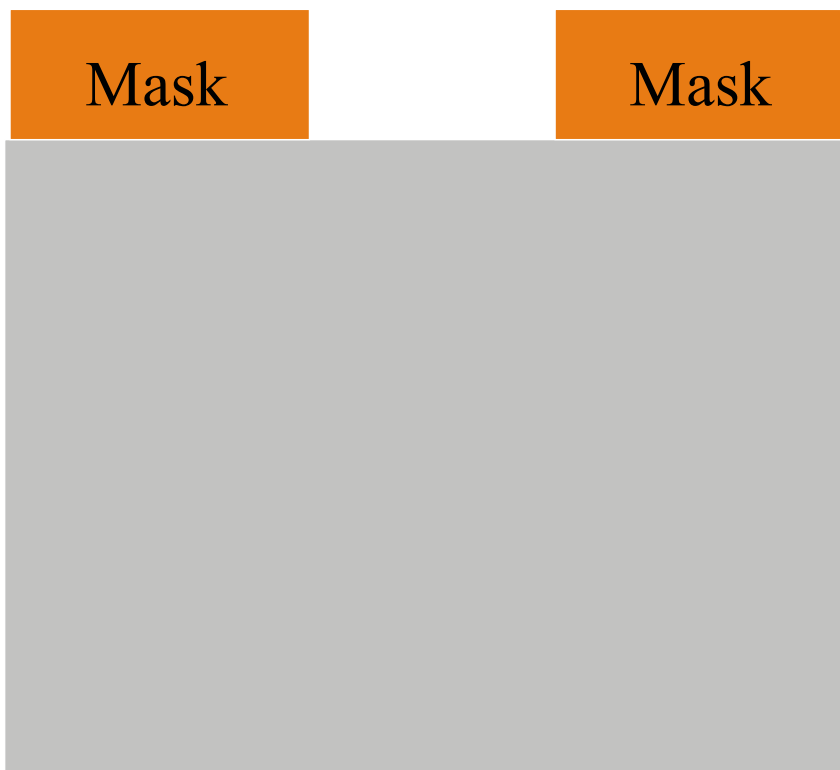


Typical Plasma Processing Equipment

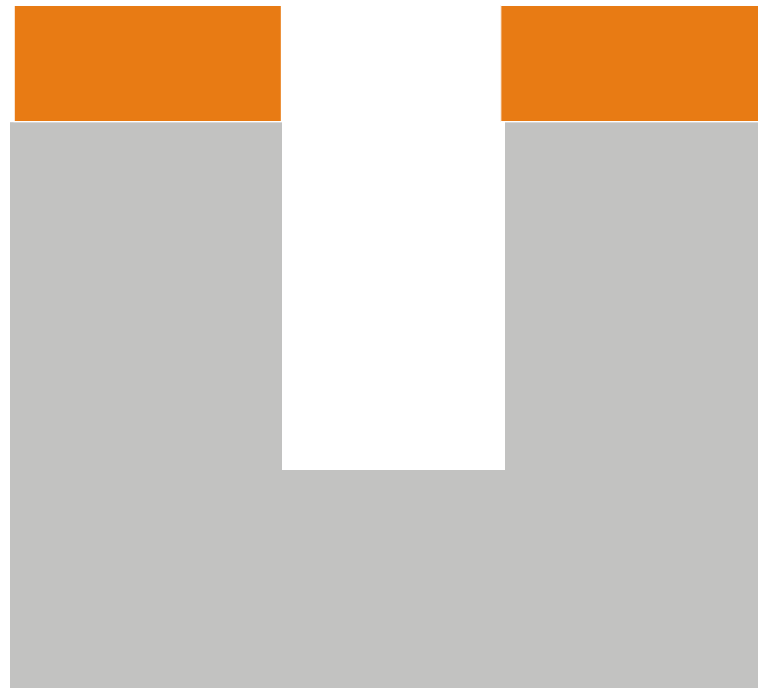
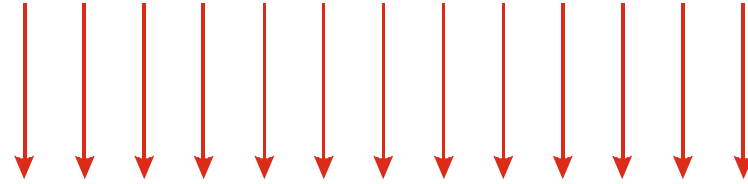


Chip Surface

For example, about 100 nm



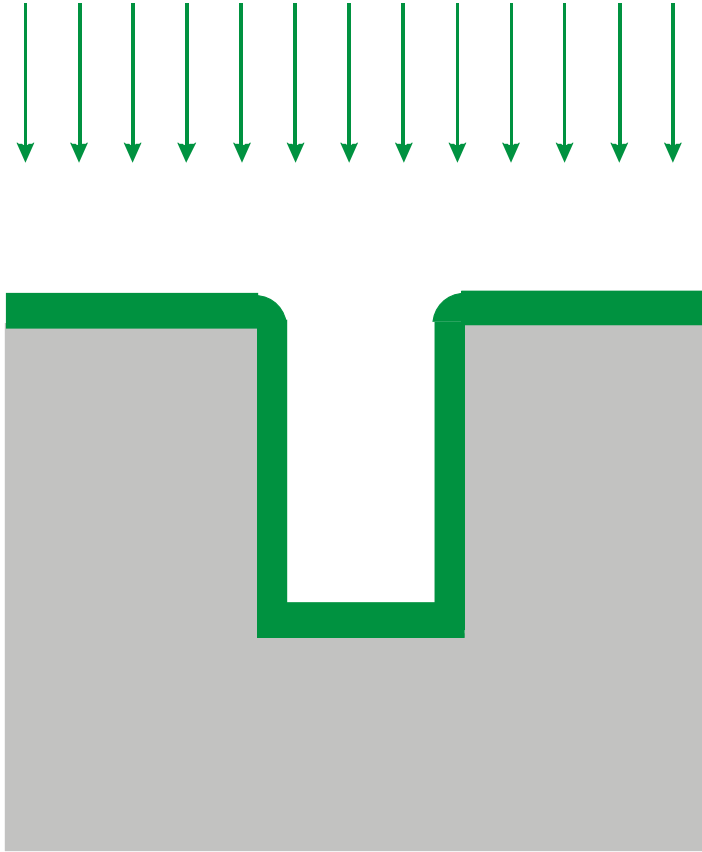
Dig a hole or Trench



Remove the masks

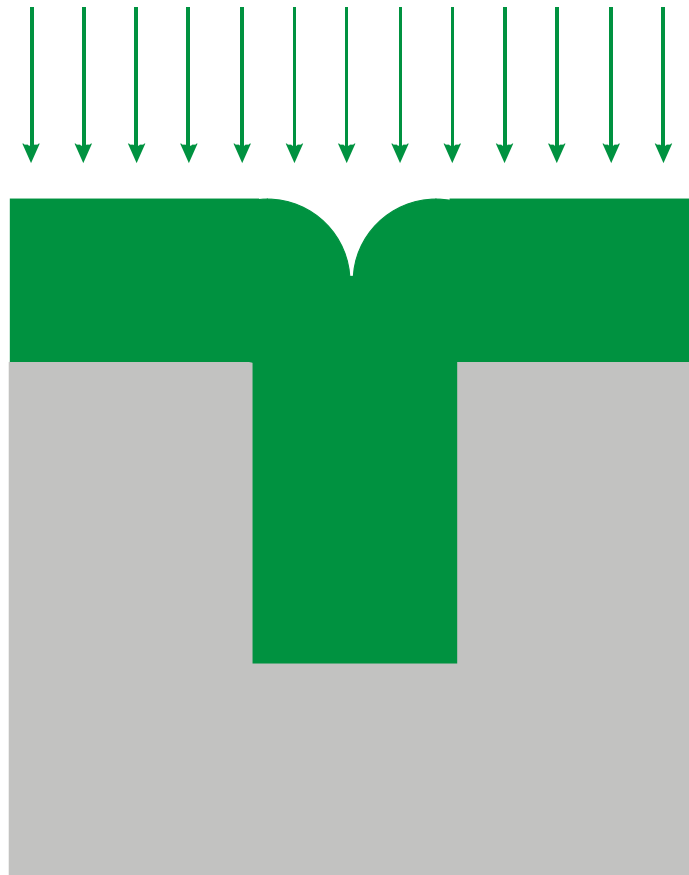


Fill the Hole or Trench

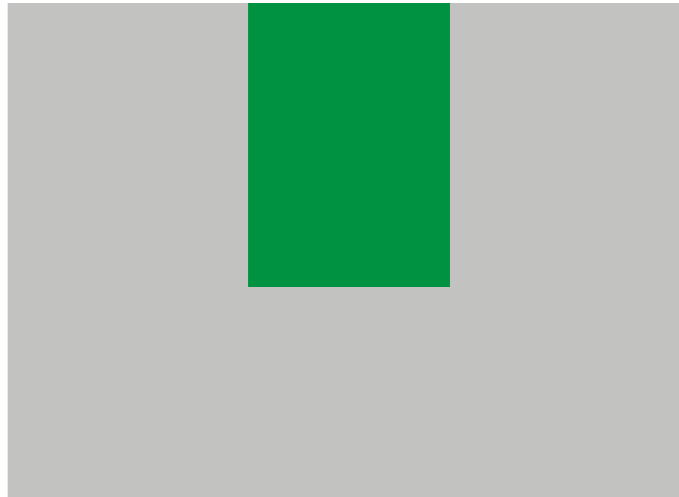


by Chemical Vapor Deposition (CVD)
or Sputtering Deposition (Physical Vapor Deposition: PVD)

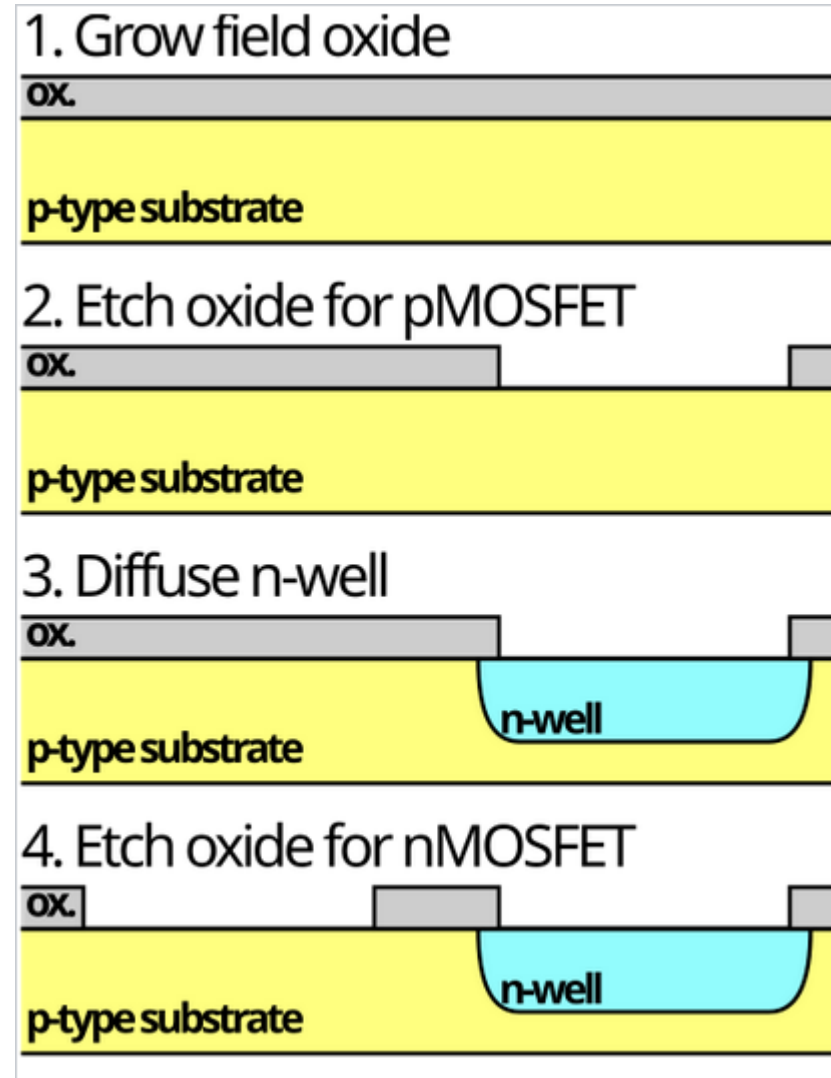
Fill the Hole or Trench



Planarize by Chemical Mechanical Polish (CMP)

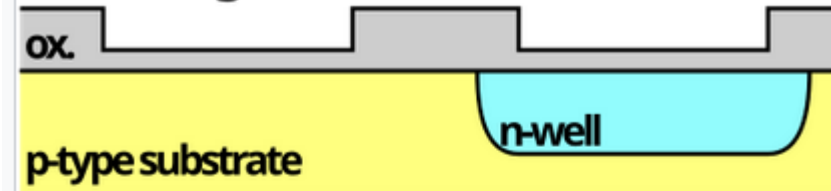


Typical CMOS fabrication process

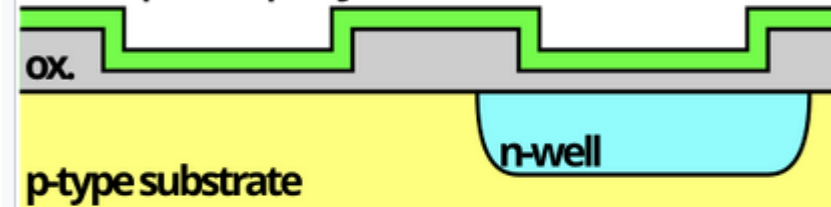


⇐ ion implantation

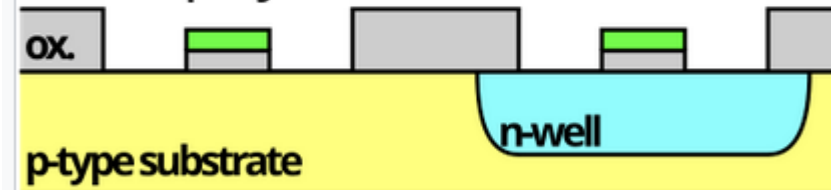
5. Grow gate oxide



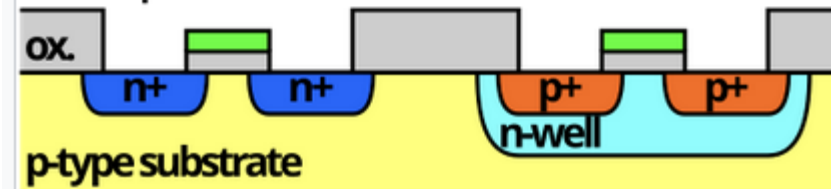
6. Deposit polysilicon



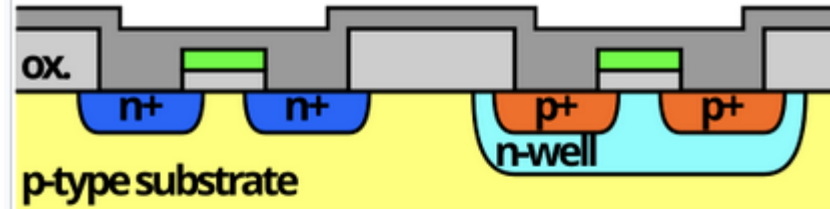
7. Etch polysilicon and oxide



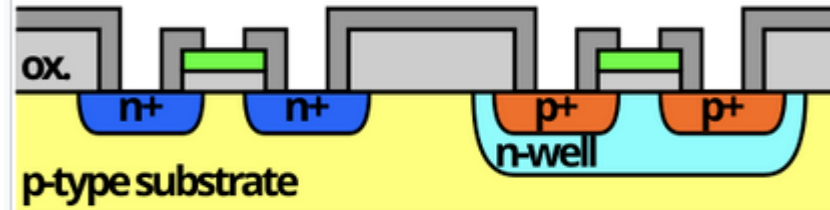
8. Implant sources and drains



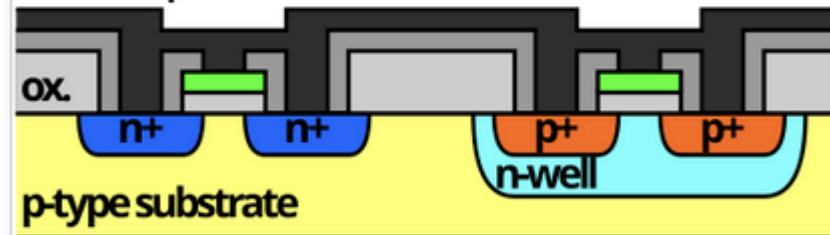
9. Grow nitride



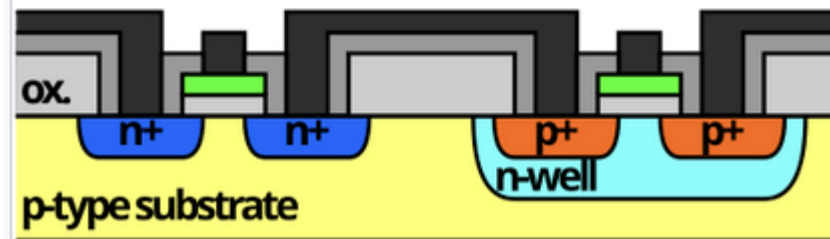
10. Etch nitride



11. Deposit metal



12. Etch metal



⇐ W deposition: CVD
(for higher layers, Cu is used
via electrochemical deposition;
damascene process)

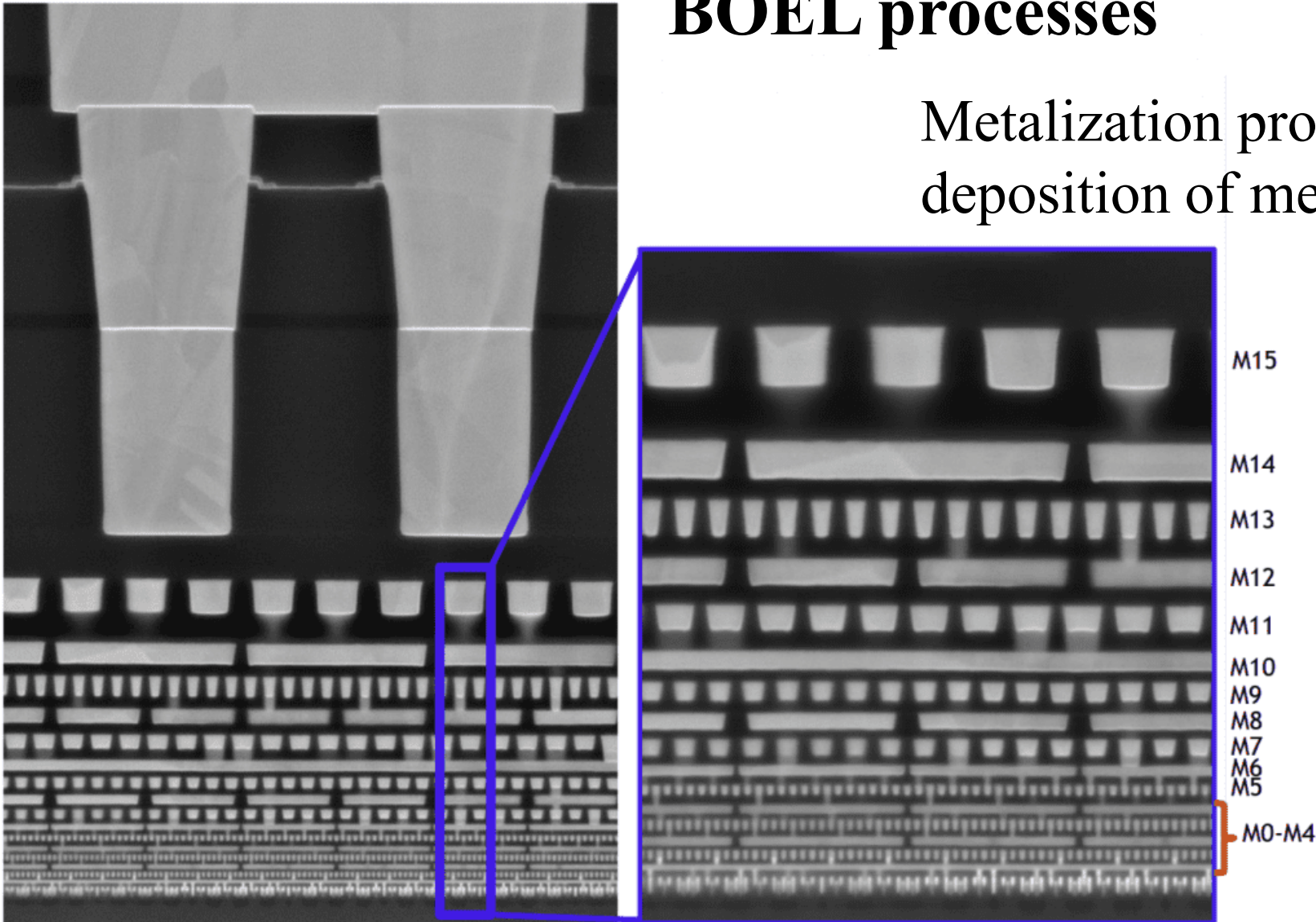
BOEL processes

BEOL processes: the process in semiconductor device fabrication that consists of depositing metal interconnect layers onto a wafer already patterned with devices. It is the second part of IC fabrication, after FEOL. In BEOL, the individual devices (transistors, capacitors, resistors, etc.) are connected to each other according to how the metal wiring is deposited. (https://en.wikipedia.org/wiki/Back_end_of_line)

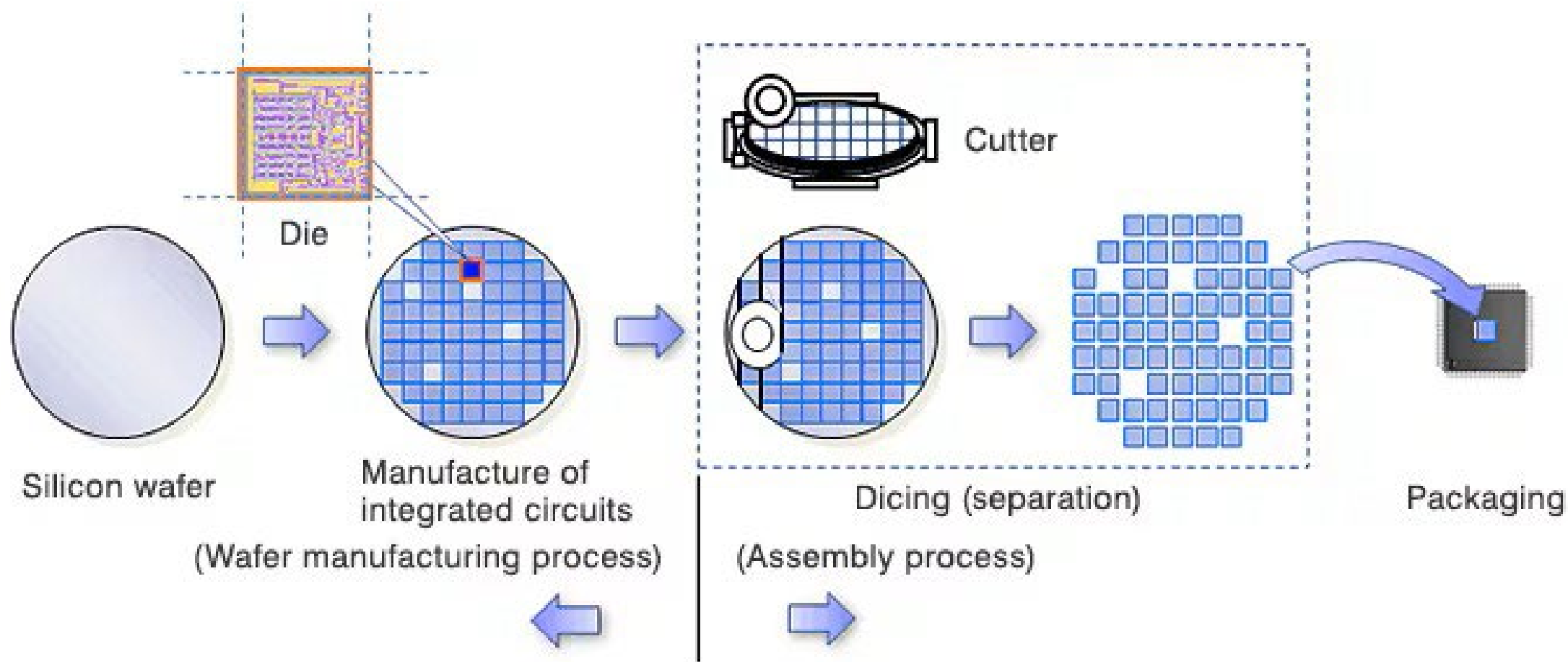
⇒ mostly Metalization processes

BOEL processes

Metalization processes:
deposition of metal wires and insulators



RC delay: the main factor that determines the chip's operation speed

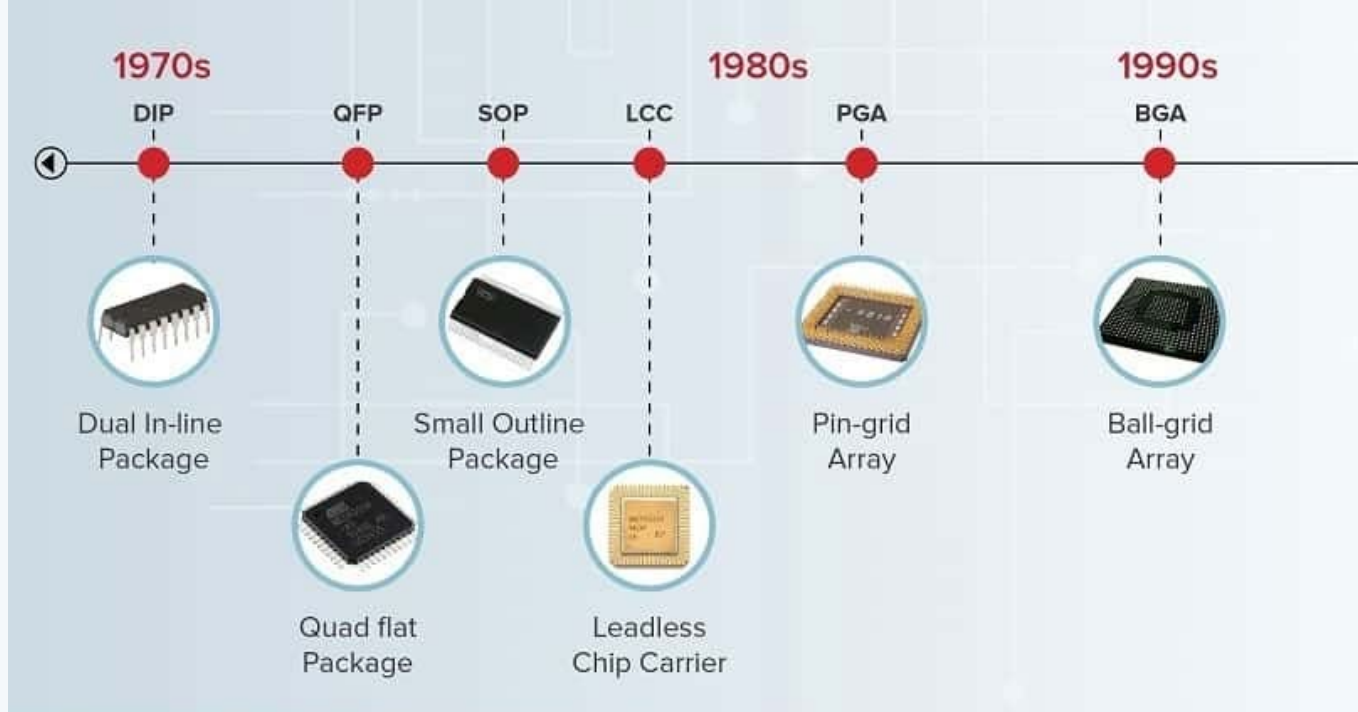


https://www.hitachi-hightech.com/global/en/media/02_il04_gif_tcm27-70428.gif

Backend processes = Assembly, Testing, Packaging (ATP)

ATP = The last production stage of semiconductor chips, where individual chips are cut from the wafers, tested, assembled, packaged, and connected with wires that can be attached to the printed circuit board (PCB). This process is often outsourced to different companies.

(<https://www.semiconductors.org/wp-content/uploads/2018/09/Assembly-Packaging.pdf>)



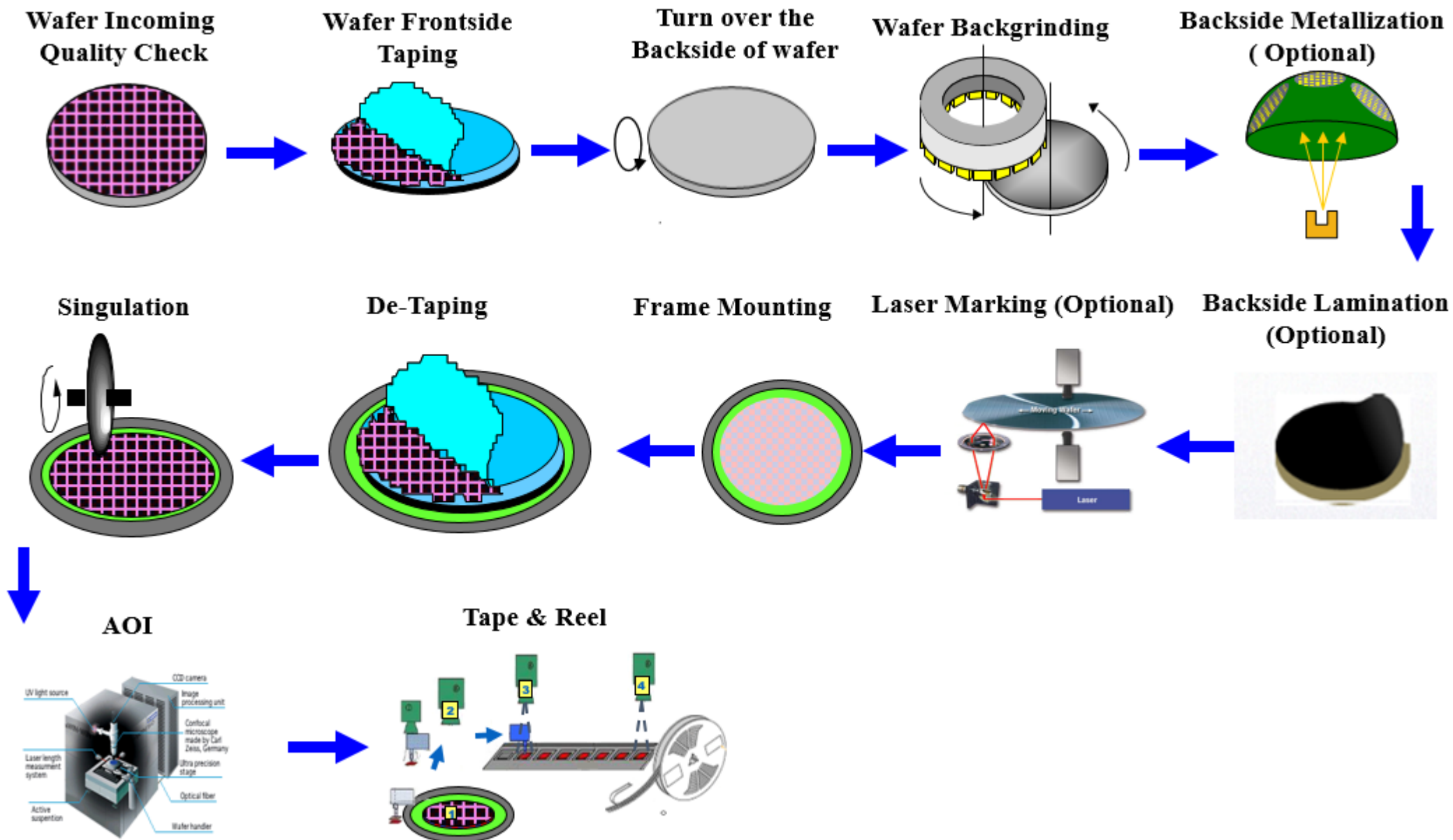
Summary of ATP

- Inspection
- Backgrinding
- Dicing
- Die bonding (die: a chip cut from a large wafer)
- Wire bonding or flip chip bonding
- molding
- Final Test

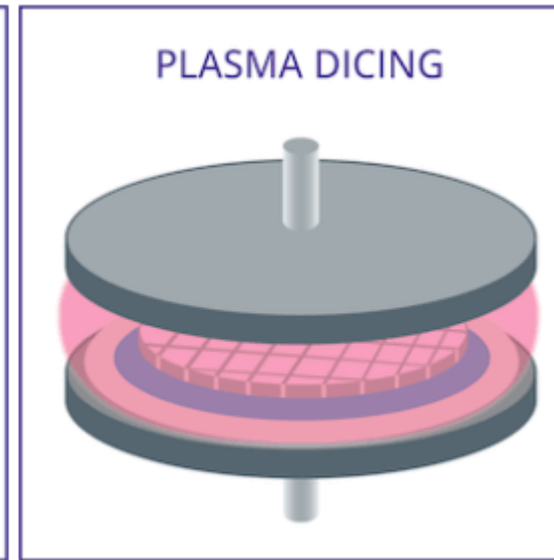
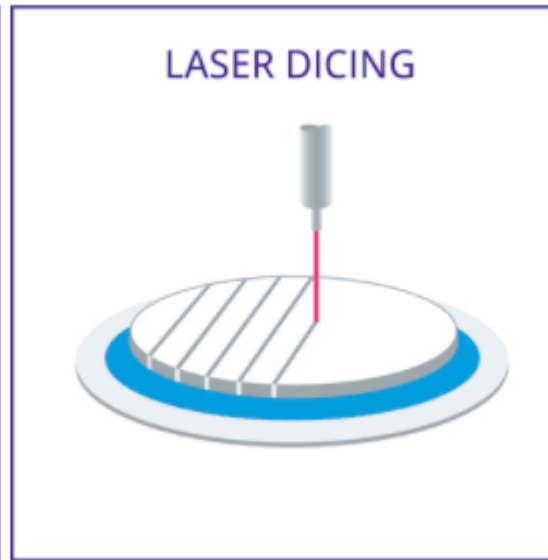
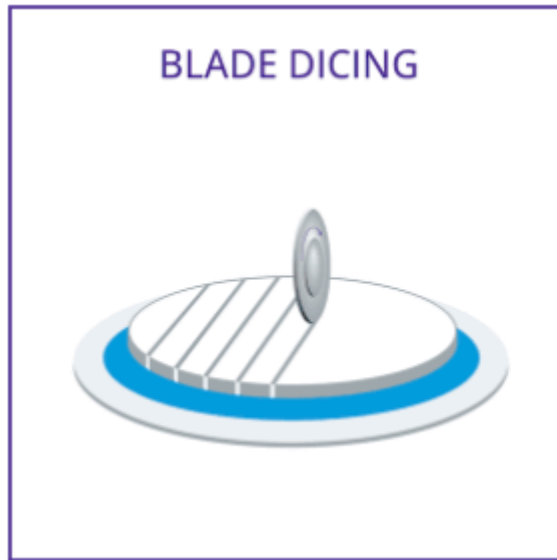
inspection

Automated inspection of a diced wafer

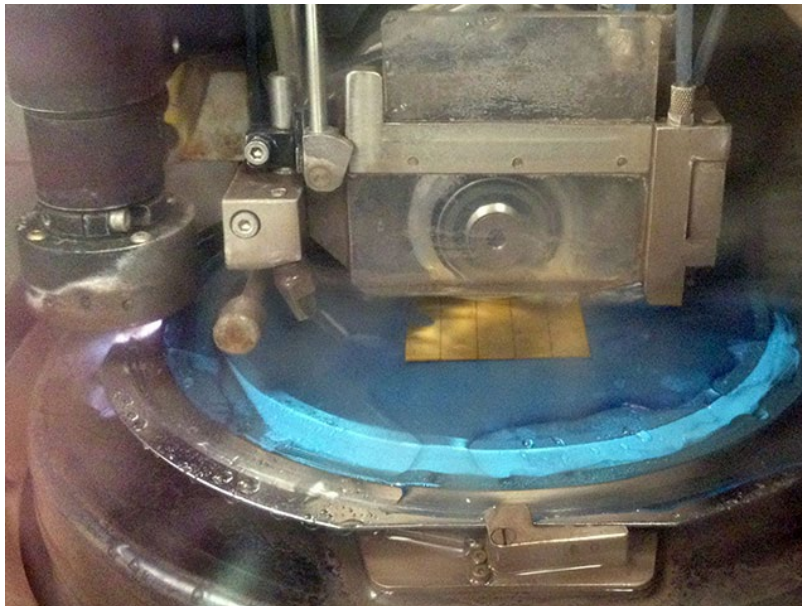




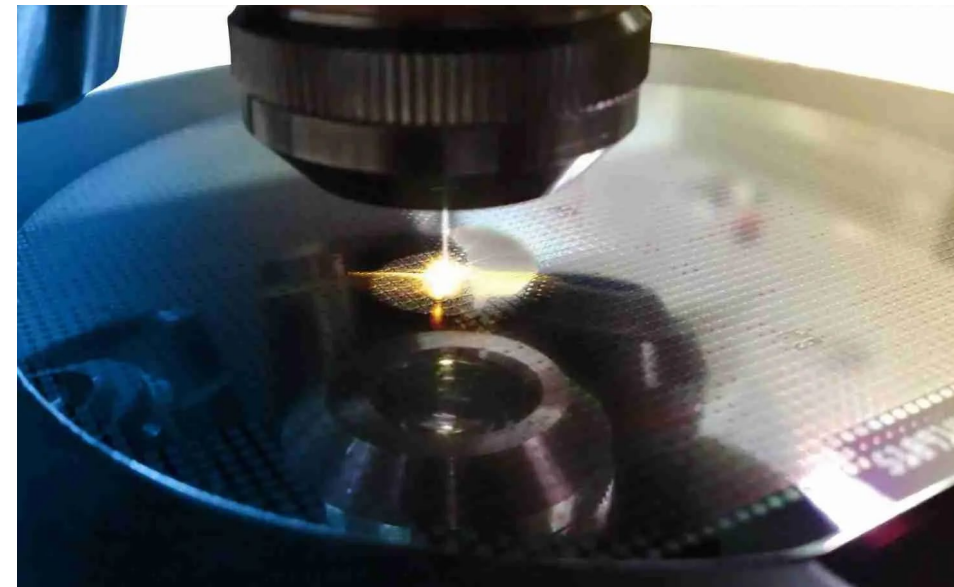
AOI: automated optical inspection



<https://www.kla.com/advance/innovation/plasma-dicing-101-the-basics>

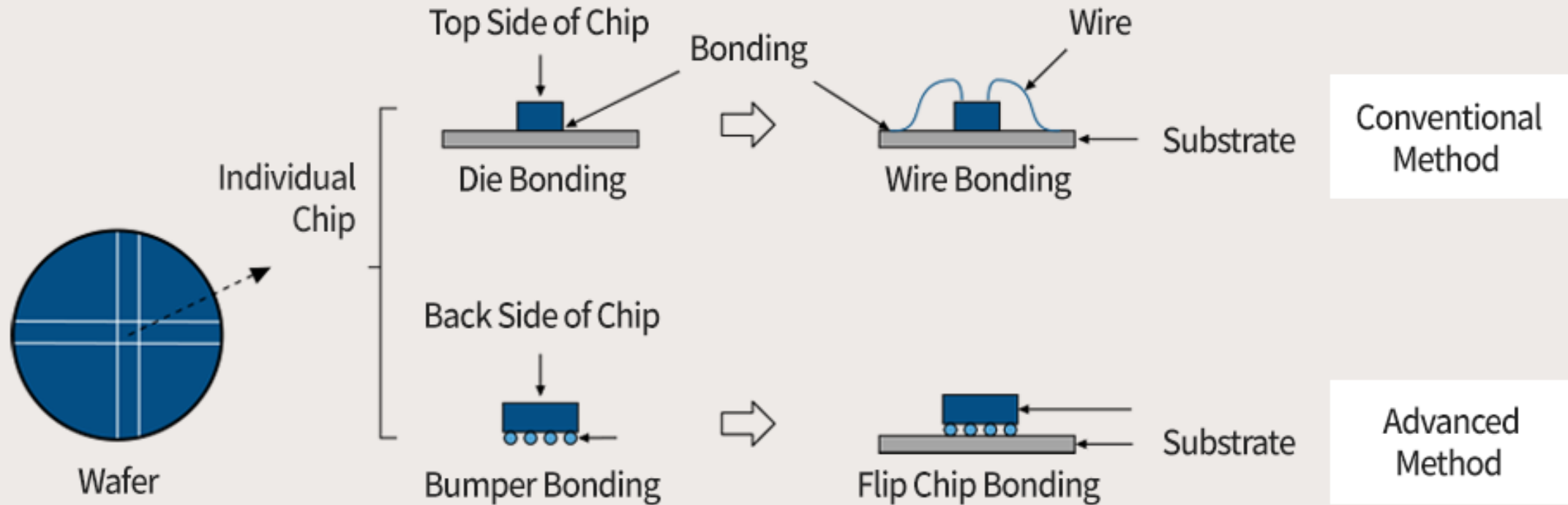


<https://Inf-wiki.eecs.umich.edu/wiki/Dicing>

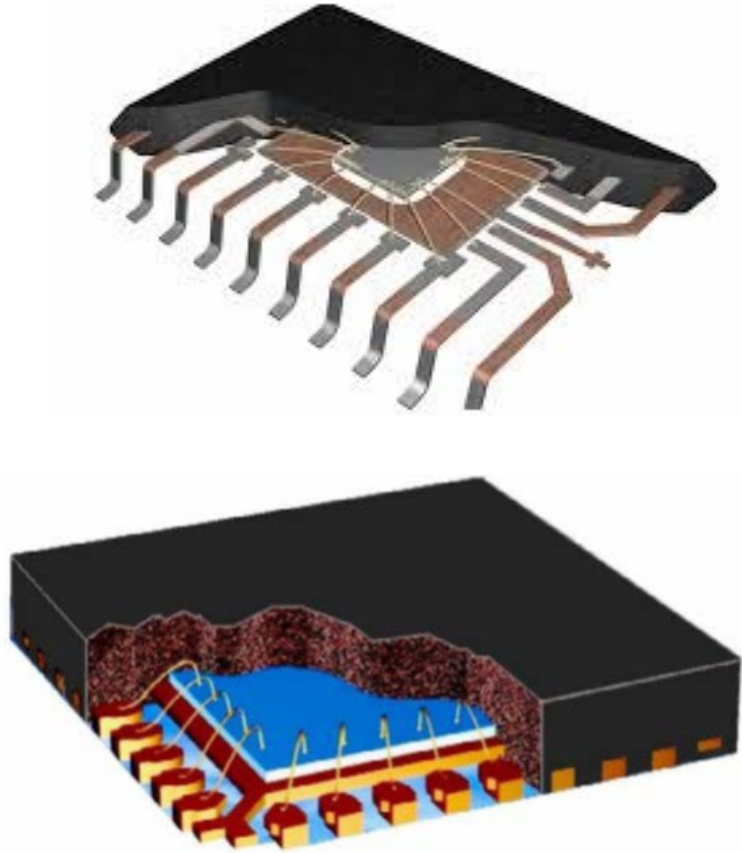


<https://intech-technologies.com/introduction-to-wafer-dicing-techniques-2/>

Die bonding



molding



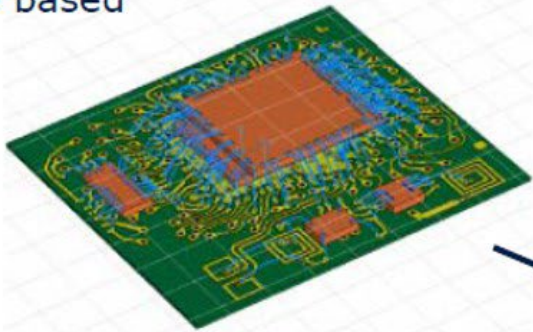
<https://prostech.vn/chip-molding-in-semiconductor/>
<https://polymerinnovationblog.com/polymers-electronic-packaging-part-one-introduction-mold-compounds/>



<https://elimold.com/industries/semiconductor-injection-molding/>

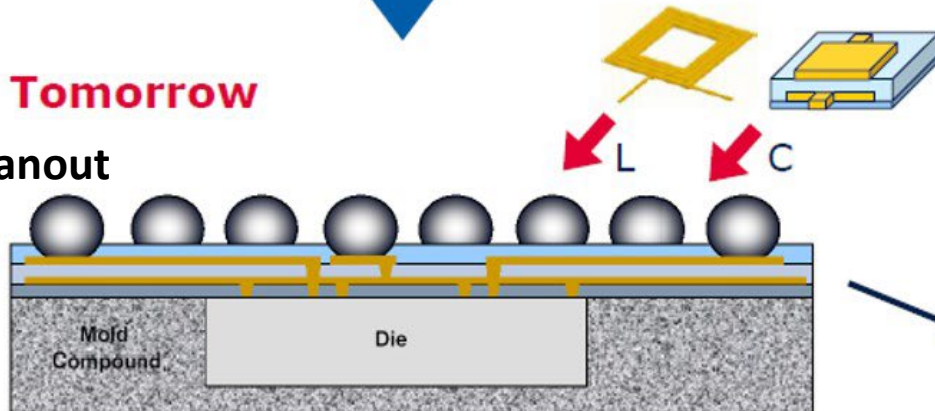
Laminate based
BGA

Today



Tomorrow

wafer level fanout



Embedded Wafer Level BGA

leadframe

**Form Factor
Interconnect Size, Cost**

BGA

Flip Chip

EWLB

Source: Infineon

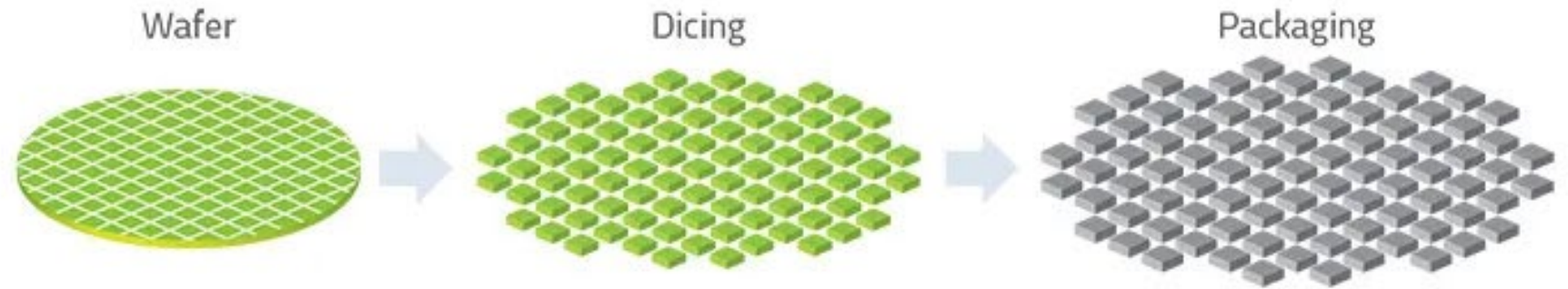
BGA: ball grid array

EWLB: embedded wafer level BGA

PBGA: plastic ball grid array

<https://polymerinnovationblog.com/polymers-electronic-packaging-part-one-introduction-mold-compounds/>

Traditional Packaging Process Flow



Wafer-Level Packaging Process Flow



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