

## STANDARD OPERATING PROCEDURE FOR TUBE "B2-Ox-Alloy" furnace in TRL.

### INTRODUCTION

Tube "B2-Ox\_Alloy" is an Atmospheric furnace designed to grow thermal SiO<sub>2</sub> in the temperature range of 800- 1050C, on Silicon wafers up to 6" inch in diameter. Other thermal processes can also be run. The system is operated in manual mode. Three Eurotherm temperature controllers provide a 20 inch long, flat profile in the Center Zone; they are arranged in a master/slave configuration and the temperature profile is set up in manual mode. The gases are introduced through a Hydrogen injector, located at the Source Zone and specially designed to allow the generation of water vapors by Pyrogenic reaction. The gas control is provided by the Argus 581 Gas Control Module, which allows to set up and monitor the Mass Flow Controller flow for each gas, and also manages the safety hardware interlocks. The gas control could be manual or in a programmed sequence by using the Argus 771 Sequencer. The system has 4 MFCs with the following maximum flow ranges:

Nitrogen 10 SLPM  
Oxygen 10 SLPM  
Hydrogen 0.5 SLPM  
Oxygen 0.5 SLPM

The Hydrogen MFC has three safety hardware interlocks for wet oxidation processes:

- master/slave interlock configuration with Oxygen MFC, in a specific ratio range (< 2:1);
- Pyrogenic thermocouple temperature value interlock (> 600 C);
- Nitrogen flow interlock (> 50%, >10 minutes, alone), to clear the furnace of Oxygen.

The wafer handling is manual: the quartz boat is introduced in the flat zone and extracted from the furnace with the help of quartz rods.

The system can be used for wet or dry thermal oxidation, anneal, film densification, wafer bonding, etc.

### SAFETY.

The system has hardware safety interlocks, to prevent any Hydrogen related hazard.

High temperature: many furnace parts can be hot. Use the special heat resistant gloves to handle those parts

### PROCEDURE.

- 1) "ENGAGE" the machine in CORAL for TRL tube "B2-Ox-Alloy" machine, before you start.  
Tube B2 was designated to run wafers that have been exposed to CMOS metals processing.  
Your wafers must be free of photoresist and other organic materials and cleaned according to PTC approved procedures.
- 2) Load the wafers into the tube:
  - place the wafers into the assigned quartz boat for tubeA1, with the flat up and front side to face the clean room side, when introduced into the furnace. Place the boat on the quartz half shell handler.
  - check if the tube temperature is bellow 600C and remove the furnace end cap using the heat resistant gloves; place it face down on the SS wafer transfer table.
  - transport the quartz boat with the boat handler to the tube opening, and push the boat with the short quartz rod into the tube.
  - using the long quartz rod push the boat to the Center Zone of the flat temperature profile; the quartz has a mark that should be aligned to the edge of the tube scavenger, when the boat is in the Center Zone.
  - replace the end cap: take care not to push it too hard, and align its exhaust to the scavenger opening.
  - set the Nitrogen flow to 50%:
    - \* select channel 1 using the Channel toggle switch on the Argus GCM, in MAN mode.
    - \* increase the MFC set point to 50% by moving upward the Set Point toggle switch.
    - \* push twice the Set Point button located bellow the display, to activate the set point, and the actual flow value will be displayed.

- 3) Set the process temperature profile:
- on the Central Zone Eurotherm controller, adjust the set point to the process temperature value by using the arrow keys. The set point is for the heater thermocouples located outside the quartz tube and should be lower than 1065C. Adjust the set point for the Load and Source zone controllers to a value between 10 and 20; these set points are relative to the Central zone controller set point .
  - on the main Omega DSP display, select channel # 17 that correspond to the Central Zone profile Tc located inside the quartz tube, and wait for the temperature ramp up and stabilization.
  - on the Omega display check the Load zone (channel 16) and Source zone (channe 18) temperature values and manually adjust the respective controllers set points to get a flat temperature profile; repeat these adjustments until all temperature values are within 2 degrees.

4) Edit the process recipe on the 771 Sequencer:

a) Wet oxidation example:

- on the 771 Sequencer turn the key into the program position, and push the MAN button, you are in program edit mode now.
- push the PROG SELECT button, and use the toggle switch to select the program number address (up to 5 programs) that you want to program. Use the TIME SELECT switch to set the time base, and push RESET button to reset to program step # 1.

Bellow is a program example.

Lets assume that you want to grow a 1 um thermal SiO2 film on a <100> Si substrate, with the electrical resistivity value in the 0.1 - 50 Ohm-cm range, at 1050 C, using the following gas flow sequence: (each step will be explained bellow)

1 min N2 + 20 min O2 + 11 min N2 + 200 min( H2O & O2) + 20 min O2 + 20 min N2 / end,  
then on the 771 Sequencer set the time values and push the active buttons specified bellow

STEP #	TIME (MIN)	DESCRIPTION	ACTIVE BUTTONS	COMMENTS
1	1.0	N2 FLOW 51%	1,10,LOAD,STEP	RECIPE START
2	20.0	O2 FLOW 60%	3,10,LOAD,STEP	DRY OXIDATION
3	11.0	N2 FLOW 51%	1,10,LOAD,STEP	SAFETY INTERLOCK FOR H2 FLOW ENABLE.
4	99.9	H2 40 % & O2	2,3,10,LOAD,STEP	WET OXIDATION USING PYROGENIC REACTION
5	99.9	H2 40% & O2	2,3,10,LOAD,STEP	H2 MFC SETS THE O2 MFC SET POINT
6	20.0	O2 FLOW 60%	3,10,LOAD,STEP	DRY OXIDATION
7	20.0	N2 FLOW 51%	1,,10,LOAD,STEP	ANNEAL
8	0.0	N2 FLOW 51%	1,10,HALT,LOAD,RESET	RECIPE END.

Explanations:

The buttons 1,2,3,10 on the 771 Sequencer correspond respectively to the N2, H2 , O2 and N2 Bypass channels on the Argus 581 Gas Box , LOAD button stores the step settings into the memory, STEP button moves the program edit control to the next step and the RESET button brings the control to the first step. HALT stops the program control movement to the next step. The timer allows maximum 99.9 minutes per step; more identical step are needed for longer process steps. The 771 Sequencer controls the on/off time sequence of the gas "objects" with their attributes (set points) already defined and set up, on the corresponding Argus 781 Gas Box. Check and adjust the following channels: N2 =51%, H2=40%, O2= 60%, H2:O2 Ratio = 1.5, Pyro TC = 610C, on the Argus 581 Gas Box.

- when you finish the program, turn the key to LOCK and push the MAN button to exit the edit mode, and check each program step.

5) Start the program

Check if the system temperature profile is the one you need, and if it is stable.  
There is no programmable connection between the gas flow sequence and the temperature time variation.

- on the 771 Sequencer push the ENABLE button
  - on the 581 Argus Gas Box push the AUTO button
  - on the 771 Sequencer push the RUN button ( be sure the program was reset in step 1)
- The program starts and the timer display will show the time remaining in each step.

\* You have to wait until the program goes into step 4, to be sure that H2 and O2 flows are OK  
Push RESET button on the Argus 781 Gas Box if it was a H2 alarm, and call the staff if the alarm didn't clear.

6) To unload the wafers do the following:

When the program ends, the system will remain at the process temperature with Nitrogen flow at 51%, and a buzzer will be on signaling the end of the run.

You must ramp down the temperature below 600 C before unloading the wafers, and you must put the system controller in manual mode, and finally let the tube in idle state at 600C with 20 % N2 flow.

- push the following buttons quickly on after other, to silence the buzzer and reset to manual mode:

ENABLE on 771 Sequencer  
MAN on Argus 781 box  
Channel 1 on Argus 781 box  
Channel 10 on Argus 781 box

after these steps the buzzer went off and the controller was switched from auto to manual mode.

- on the Eurotherm Central zone controller push the down arrow key to bring the tube temperature set point to 600C; wait aprox 1 hour for the temperature to reach that level.
- check if the tube temperature is below 600C and remove the furnace end cap using the heat resistant gloves; place it face down on the SS wafer transfer table.
- using the long quartz rod bring the quartz boat to the tube edge, then using the short quartz rod pull the quartz boat onto the boat handler and move them to the transfer table.
- install back the end cap with its exhaust aligned to the scavenger opening, and take care not to push it too hard as it may get stuck and difficult to remove later.
- set the N2 flow to 20 %.

7) End your session in CORAL, by "DISENGAGE" the machine after you input the measurement data in the comments section.

Bernard Alamariu MTL Research Engineer

Brian McKenna MTL Research Specialist