

(51) International Patent Classification:
H01L 29/872 (2006.01)(21) International Application Number:
PCT/US2012/035262(22) International Filing Date:
26 April 2012 (26.04.2012)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:

13/095,652	27 April 2011 (27.04.2011)	US
13/095,664	27 April 2011 (27.04.2011)	US
13/095,670	27 April 2011 (27.04.2011)	US
13/095,678	27 April 2011 (27.04.2011)	US
13/095,690	27 April 2011 (27.04.2011)	US

(63) Related by continuation (CON) or continuation-in-part (CIP) to earlier application:
US 13/095,652 (CON)
Filed on 27 April 2011 (27.04.2011)

(71) Applicant (for all designated States except US):
FAIRCHILD SEMICONDUCTOR CORPORATION
[US/US]; 3030 Orchard Parkway, San Jose, California 95134 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **YEDINAK, Josph A.** [US/US]; 114 Ash Lane, Mountain Top, Pennsylvania, Pennsylvania 18707 (US). **REXER, Christopher L.** [US/US]; 374 White Birch Lane, Mountain Top, Pennsylvania 18707 (US). **RINEHIMER, Mark L.** [US/US]; 85 Fieldstone Way, Mountain Top, Pennsylvania

18707 (US). **SHENOY, Praveen Muraleedharan** [US/IN]; F-803, Cosmos, Magarpatta, Hadapsar, Pune 411013 (IN). **LEE, Jaegil** [KR/KR]; 2128-804, Keumkang KCC Apt., Sang3-dong, Wonmi-ku, Puchon-si, Kyounggi-do (KR). **YILMAZ, Hamza** [US/US]; 20755 Trinity Avenue, Saratoga, California 95070 (US). **YUN, Chongman** [KR/KR]; 110-101, Ichon APT, Dongbuichon-dong, Yongsan-ku, Seoul (KR). **REICHL, Dwayne S.** [US/US]; 7-35-7 Owassa Drive, Pocono Lake, Pennsylvania 18347 (US). **PAN, James** [US/US]; 9300 Redwood Road, #1923, West Jordan, Utah 84088 (US). **RIDLEY, Rodney S.** [US/US]; 322 Holmes Road, Scarborough, Maine 04074 (US). **HEIDENREICH, Harold** [US/US]; 39 Public Square, Wilkes Barre, Pennsylvania 18701 (US).

(74) Agent: **BENNETT, Daniel M.**; Brake Hughes Bellermann LLP, c/o CPA Global, P.O. Box 52050, Minneapolis, Minnesota 55402 (US).

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ,

[Continued on next page]

(54) Title: SUPERJUNCTION STRUCTURES FOR POWER DEVICES AND METHODS OF MANUFACTURE

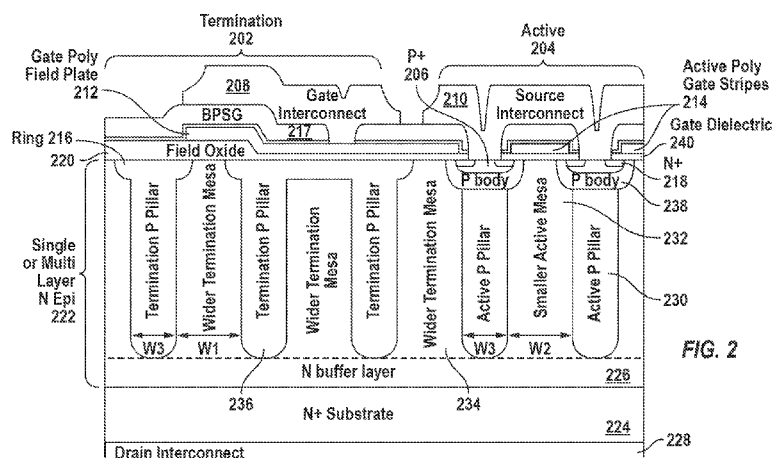


FIG. 2

(57) Abstract: A power device includes a semiconductor region which in turn includes a plurality of alternately arranged pillars of first and second conductivity type. Each of the plurality of pillars of second conductivity type further includes a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant regions of second conductivity type.



TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

- *with international search report (Art. 21(3))*
- *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments (Rule 48.2(h))*

SUPERJUNCTION STRUCTURES FOR POWER DEVICES AND METHODS OF MANUFACTURE

RELATED APPLICATIONS

[0001] The present application claims priority to, the benefit of, and is a continuation of U.S.

5 Non-Provisional Patent Application Serial No. 13/095,652, filed on April 27, 2011, entitled, “Superjunction Structures for Power Devices and Methods of Manufacture,” which is incorporated herein by reference in its entirety.

[0002] The present application also claims priority to and the benefit of U.S. Non-Provisional Patent Application Serial No. 13/095,664, filed on April 27, 2011, entitled,

10 “Superjunction Structures for Power Devices and Methods of Manufacture,” which is incorporated herein by reference in its entirety.

[0003] The present application also claims priority to and the benefit of U.S. Non-Provisional Patent Application Serial No. 13/095,670, filed on April 27, 2011, entitled,

15 “Superjunction Structures for Power Devices and Methods of Manufacture,” which is incorporated herein by reference in its entirety.

[0004] The present application also claims priority to and the benefit of U.S. Non-Provisional Patent Application Serial No. 13/095,678, filed on April 27, 2011, entitled,

“Superjunction Structures for Power Devices and Methods of Manufacture,” which is incorporated herein by reference in its entirety.

20 **[0005]** The present application also claims priority to and the benefit of U.S. Non-Provisional Patent Application Serial No. 13/095,690, filed on April 27, 2011, entitled,

“Superjunction Structures for Power Devices and Methods of Manufacture,” which is incorporated herein by reference in its entirety.

[0006] The present disclosure incorporates by reference the commonly assigned U.S. Patent

25 Application No. 12/234,549 filed September 19, 2008, entitled “Superjunction Structures for Power Devices and Methods of Manufacture,” as if set forth in full in this document, for all purposes.

BACKGROUND

[0007] The present invention relates in general to semiconductor technology and in particular to power semiconductor devices such as transistors and diodes and their methods of manufacture.

[0008] The key component in power electronic applications is the solid-state switch. From
5 ignition control in automotive applications to battery-operated consumer electronic devices, to power converters in industrial applications, there is a need for a power switch that optimally meets the demands of the particular application. Solid-state switches including, for example, the power metal-oxide-semiconductor field effect transistor (power MOSFET), the insulated-gate bipolar transistor (IGBT) and various types of thyristors and rectifiers have continued to evolve to
10 meet this demand. In the case of the power MOSFET, for example, double-diffused structures (DMOS) with lateral channel (e.g., U.S. Pat. No. 4,682,405 to Blanchard et al.), trench gate structures (e.g., U.S. Pat. No. 6,429,481 to Mo et al.), and various techniques for charge balancing in the transistor drift region (e.g., U.S. Pat. No. 4,941,026 to Temple, U.S. Pat. No. 5,216,275 to Chen, and U.S. Pat. No. 6,081,009 to Neilson) have been developed, among many other
15 technologies, to address the differing and often competing performance requirements.

[0009] Some of the defining performance characteristics for the power switch are its on-resistance, breakdown voltage and switching speed. Depending on the requirements of a particular application, a different emphasis is placed on each of these performance criteria. For example, for power applications greater than about 300-400 volts, the IGBT exhibits an
20 inherently lower on-resistance as compared to the power MOSFET, but its switching speed is lower due to its slower turn off characteristics. Therefore, for applications greater than 400 volts with low switching frequencies requiring low on-resistance, the IGBT is the preferred switch while the power MOSFET is often the device of choice for relatively higher frequency applications. If the frequency requirements of a given application dictate the type of switch that
25 is used, the voltage requirements determine the structural makeup of the particular switch. For example, in the case of the power MOSFET, because of the proportional relationship between the drain-to-source on-resistance R_{ds-on} and the breakdown voltage, improving the voltage performance of the transistor while maintaining a low R_{ds-on} poses a challenge. Various charge balancing structures in the transistor drift region have been developed to address this challenge
30 with differing degrees of success.

[0010] Device performance parameters are also impacted by the fabrication process.

Attempts have been made to address some of these challenges by developing a variety of improved processing techniques.

[0011] Whether it is in ultra-portable consumer electronic devices or routers and hubs in communication systems, the varieties of applications for the power switch continue to grow with the expansion of the electronic industry. The power switch therefore remains a semiconductor device with high development potential.

BRIEF SUMMARY

[0012] In accordance with one aspect of the invention, a power device includes a semiconductor region which in turn includes a plurality of alternately arranged pillars of first and second conductivity type. Each of the plurality of pillars of second conductivity type further includes a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant regions of second conductivity type.

[0013] In accordance with another aspect of the invention, a power device includes: an active region and a termination region surrounding the active region, and a plurality of pillars of first and second conductivity type alternately arranged in each of the active and termination regions, each of the plurality of pillars of second conductivity type in the active and termination regions further including a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of the pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant regions of second conductivity type.

[0014] In accordance with another aspect of the invention, a method for forming pillars of alternating conductivity type in a power device includes: forming a plurality of epitaxial layers of a first conductivity type over a substrate; forming a plurality of implant regions of a second conductivity type in each of a predetermined number of the plurality of epitaxial layers; forming trenches extending into the upper-most one of the plurality of epitaxial layers; and filling the trenches with semiconductor material of the second conductivity type, wherein the plurality of implant regions of second conductivity type in the predetermined number of the plurality of epitaxial layers are vertically aligned with corresponding ones of the trenches so that the

semiconductor material filling the trenches together with the plurality of implant regions of second conductivity type in the predetermined number of the plurality of epitaxial layers form a plurality of pillars of second conductivity type, and those portions of the plurality of epitaxial layers separating the plurality of pillars of second conductivity type from one another form a plurality of pillars of first conductivity type.

[0015] In accordance with another aspect of the invention, a method for forming pillars of alternating conductivity type in a power device includes: forming a first epitaxial layer of a first conductivity type over a substrate; forming a lower portion of a plurality of deep trenches in the first epitaxial layer; filling the lower portion of the plurality of deep trenches with semiconductor material of a second conductivity type; forming a second epitaxial layer of first conductivity type over the first epitaxial layer; forming an upper portion of the plurality of deep trenches in the second epitaxial layer directly over the lower portion of the plurality of deep trenches so that each lower portion and a corresponding upper portion of the plurality of deep trenches together form one of the plurality of deep trenches; and filling the upper portion of the plurality of deep trenches with semiconductor material of second conductivity type, wherein the semiconductor material filling the lower and upper portions of the plurality of deep trenches form a plurality of pillars of second conductivity type, and those portions of the first and second epitaxial layers separating the plurality of pillars of second conductivity type from one another form a plurality of pillars of first conductivity type.

[0016] In accordance with another aspect of the invention, a method for forming a power field effect transistor includes: forming an N-type epitaxial layer over a substrate; forming one or more P-type epitaxial layers over the N-type epitaxial layer; forming a plurality of trenches extending through the one or more P-type epitaxial layers; filling the plurality of trenches with N-type semiconductor material; forming P-type body regions in the one or more P-type epitaxial layers; forming N-type source regions in the P-type body regions; and forming gate electrodes adjacent to but insulated from the P-type body regions and the N-type semiconductor material, the gate electrodes overlapping with the N-type source regions, wherein the plurality of trenches filled with N-type semiconductor material form N-pillars, and those portions of the one or more P-type epitaxial layers separating the N-pillars form P-pillars.

[0017] In accordance with another aspect of the invention, a power field effect transistor (FET) includes: an N-type epitaxial layer over a substrate; one or more P-type epitaxial layers

over the N-type epitaxial layer; a plurality of trenches extending through the one or more P-type epitaxial layers, the plurality of trenches being filled with N-type semiconductor material; P-type body regions in the one or more P-type epitaxial layers; N-type source regions in the P-type body regions; and gate electrodes adjacent to but insulated from the P-type body regions and the N-type semiconductor material, the gate electrodes overlapping with the N-type source regions, wherein the plurality of trenches filled with N-type semiconductor material form N-pillars, and those portions of the one or more P-type epitaxial layers separating the N-pillars form P-pillars.

[0018] In accordance with another aspect of the invention, a method for forming a power field effect transistor includes: forming one or more epitaxial layers of a first conductivity type

over a substrate; forming a plurality of lower trenches extending through the one or more epitaxial layers; filling the plurality of lower trenches with semiconductor material of a second conductivity type; forming one or more epitaxial layers of the second conductivity type over the one or more epitaxial layers of first conductivity type; forming a plurality of upper trenches extending through the one or more epitaxial layers of the second conductivity type; filling the plurality of upper trenches with semiconductor material of the second conductivity type, wherein the plurality of lower trenches and the plurality of upper trenches are off-set from one another along the lateral dimension.

[0019] In accordance with another aspect of the invention, a power field effect transistor (FET) includes a semiconductor region including a plurality of alternately arranged pillars of first and second conductivity type, wherein each of the pillars of the first conductivity type has a middle section that is wider than its upper and lower sections, and each of the pillars of the second conductivity type has a middle section that is narrower than its upper and lower sections.

[0020] In accordance with another aspect of the invention, a method for forming a super-junction structure in a power device includes: forming one or more epitaxial layers of a first conductivity type over a substrate; forming a plurality of trenches extending in the one or more epitaxial layers; lining the sidewalls and bottom of the trenches with a an epitaxial layer of a second conductivity type; forming a dielectric layer in the plurality of trenches over the epitaxial layer of second conductivity type; and filling the plurality of trenches with conformal material.

[0021] In accordance with another aspect of the invention, a method for forming a super-junction structure in a power device includes: forming one or more epitaxial layers of a first conductivity type over a substrate; forming a plurality of trenches extending in the one or more

epitaxial layers; filling each trench with an epitaxial layer of a second conductivity type such that only a center portion of each trench along the top of the trench remains unfilled; and filling the center portion of each trench along the top of the trench with a dielectric material.

[0022] In accordance with another aspect of the invention, a method for forming a super-

5 junction structure in a power device includes: forming one or more epitaxial layers of a first conductivity type over a substrate; forming a plurality of trenches extending in the one or more epitaxial layers; lining sidewalls and bottom of the plurality of trenches with a first epitaxial layer of a second conductivity type; filling each trench with a second epitaxial layer of the second conductivity type such that only a center portion of each trench along the top of the trench
10 remains unfilled; and filling the center portion of each trench along the top of the trench with a dielectric material.

[0023] In accordance with another aspect of the invention, a power device includes a

plurality of trenches extending in one or more epitaxial layers of a first conductivity type, the plurality of trenches being filled with a first epitaxial layer of a second conductivity type, a
15 second epitaxial layer of the second conductivity type, and a layer of insulating material, the first epitaxial layer lining the trench sidewalls and bottom, the second epitaxial layer extending over and being in direct contact with the first epitaxial layer, and the layer of insulating material extending over and being in direct contact with the second epitaxial layer, the first epitaxial layer, the second epitaxial layer, and the third layer of insulating material in each trench forming a pillar
20 of second conductivity type, and those portions of the one or more epitaxial layers separating the pillars of second conductivity type forming pillars of first conductivity type such that the pillars of first and second conductivity type form pillars of alternating conductivity type.

[0024] In accordance with another aspect of the invention, a power device includes at least

first and second N-type epitaxial layers extending over a substrate, and a plurality of trenches
25 extending in the second N-type epitaxial layer, the plurality of trenches being filled with a first epitaxial layer, a second P-type epitaxial layer, and a third layer of conductive material, the first epitaxial layer lining the trench sidewalls and bottom, the second P-type epitaxial layer extending over and being in direct contact with the first epitaxial layer, and the third layer of conductive material extending over and being in direct contact with the second P-type epitaxial layer, the first
30 epitaxial layer, the second P-type epitaxial layer, and the third layer of conductivity type in each trench forming a P-pillar, and those portions of the at least first and second N-type epitaxial layers

separating the P-pillars forming N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

[0025] In accordance with another aspect of the invention, a method for forming pillars of alternating conductivity type in a power device includes: forming at least first and second N-type epitaxial layers over a substrate; forming a plurality of trenches extending in the second epitaxial layer; and filling the plurality of trenches with a first epitaxial layer, second P-type epitaxial layer, and a third layer of conductive material, the first epitaxial layer lining the trench sidewalls and bottom, the second P-type epitaxial layer extending over and being in direct contact with the first epitaxial layer, and the third layer of conductive material extending over and being in direct contact with the second P-type epitaxial layer, the first epitaxial layer, the second P-type epitaxial layer and the third layer of conductive material in each trench forming a P-pillar, those portions of the at least first and second N-type epitaxial layers separating the P-pillars forming N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

[0026] In accordance with another aspect of the invention, a power device includes: one or more N-type epitaxial layers extending over a substrate; a plurality of trenches extending into the one or more N-type epitaxial layers, the plurality of trenches being filled with P-type silicon material, the P-type silicon material in the plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N-pillars; and an active region and a termination region surrounding the active region, wherein the alternating P-N-pillars are disposed in both the active region and the termination region, the termination region includes a predetermined number of floating P-pillars, and each N-pillar located between two adjacent ones of the predetermined number of floating P-pillars includes a N-type surface region along its upper surface, the N-type surface region having a lower doping concentration than the rest of the N-pillar in which it is formed.

[0027] In accordance with another aspect of the invention, a power device includes: one or more N-type epitaxial layers extending over a substrate; a plurality of trenches extending into the one or more N-type epitaxial layers, the plurality of trenches being filled with P-type silicon material, the P-type silicon material in the plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N-pillars; an active region and a termination region

surrounding the active region, wherein the alternating P-N-pillars are disposed in both the active region and the termination region, the alternating P-N-pillars in the termination region surround the active region in a concentric fashion and include a predetermined number of floating P-pillars, each floating P-pillar includes a P-type ring along its top; a plurality of field plates disposed in the termination region over but insulated from the one or more N-type epitaxial layers, the plurality of field plates surround the active region in a concentric fashion; and a plurality of contacts configured so that each of the plurality of contacts makes contact between one of the plurality of field plates and one or more of the P-type rings, the plurality of contacts being disposed directly above a corresponding one of the predetermined number of floating P-pillars.

10 [0028] In accordance with another aspect of the invention, a power device includes an active region surrounded by a termination region, and a plurality of trenches extending into one or more epitaxial layers of a first conductivity type, the plurality of trenches being filled with silicon material of a second conductivity type, the silicon material of a second conductivity type in the plurality of trenches together with portions of the one or more epitaxial layers separating the plurality of trenches from one another forming a plurality of concentric octagon-shaped pillars of alternating conductivity type extending through the active region and the termination region, wherein four of the eight legs of each of the plurality of concentric octagon-shaped pillars have a different length than the other four legs, and sidewalls of the plurality of trenches along all eight legs of the plurality of concentric octagon-shaped pillars have the same plane direction.

20 [0029] In accordance with another aspect of the invention, a method of forming a power device having an active region surrounded by a termination region, the method comprising: forming a plurality of trenches in one or more epitaxial layers of a first conductivity type; and filling the plurality of trenches with silicon material of a second conductivity type, the silicon material of a second conductivity type in the plurality of trenches together with portions of the one or more epitaxial layers separating the plurality of trenches from one another forming a plurality of concentric octagon-shaped pillars of alternating conductivity type extending through the active region and the termination region, wherein four of the eight legs of each of the plurality of concentric octagon-shaped pillars have a different length than the other four legs, and sidewalls of the plurality of trenches along all eight legs of the plurality of concentric octagon-shaped pillars have the same plane direction.

30 [0030] In accordance with another aspect of the invention, a power device includes an active

region surrounded by a termination region, a plurality of stripe-shaped pillars of alternating conductivity type extending through the active region, and a plurality of octagon-shaped pillars of alternating conductivity type extending through the termination region in a concentric fashion, surrounding the active region.

5 [0031] In accordance with another aspect of the invention, a power device includes: an active region surrounded by a termination region; a plurality of pillars of alternating conductivity type arranged in a concentric fashion in the active and termination regions; a plurality of polysilicon gates arranged in concentric fashion in the active region; an outer metal gate runner extending along an outer perimeter of the termination region in a concentric fashion, the outer metal gate
10 runner being connected to a gate pad; and a plurality of supplementary metal gate runners directly connected to the outer metal gate runner, and extending from the outer metal gate runner toward a center of the active region but terminating before reaching the center of the active region, wherein a first group of the plurality of the polysilicon gates directly connects to all of the plurality of supplementary metal gate runners, and a second group of the plurality of the polysilicon gates
15 directly contact only two of the plurality of supplementary metal gate runners.

[0032] In accordance with another aspect of the invention, a power device includes: an active region and a termination region surrounding the active region; a plurality of pillars of alternating conductivity type arranged in a concentric fashion in both the active and the termination regions; a plurality of polysilicon gate stripes extending through the active and termination regions; and a
20 gate runner metal extending along an outer perimeter of the termination region, the plurality of polysilicon stripes connecting to the gate runner metal along their opposite ends.

[0033] In accordance with another aspect of the invention, a method for forming pillars of alternating conductivity type in a power device, the method comprising: forming one or more N-type epitaxial layers over a substrate; forming P-type body regions in the one or more N-type
25 epitaxial layers; forming gate electrodes extending adjacent to but being insulated from the one or more N-type epitaxial layers by a gate dielectric; after forming the P-type body regions and the gate electrodes, forming a plurality of deep trenches extending in the one or more N-type epitaxial layers; and filling the plurality of deep trenches with P-type silicon to form a plurality of P-pillars, those portions of the one or more N-type epitaxial layers separating the plurality of P-
30 pillars forming N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

[0034] In accordance with another aspect of the invention, a high voltage device includes: one or more N-type epitaxial layers extending over a substrate; a plurality of trenches extending into the one or more N-type epitaxial layers, the plurality of trenches being filled with P-type silicon material, the P-type silicon material in the plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N-pillars; a plurality of P-wells each formed in an upper portion of one of the P-pillars; and an anode terminal comprising a Schottky barrier metal directly contacting a top surface of the N-pillars to form a Schottky contact therebetween, the Schottky barrier metal further directly contacting the P-wells.

[0035] In accordance with another aspect of the invention, a high voltage device includes: one or more N-type epitaxial layers extending over a substrate; a plurality of trenches extending into the one or more N-type epitaxial layers, the plurality of trenches being filled with P-type silicon material, the P-type silicon material in the plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N pillars; an N-type epitaxial layer extending over the alternating P-N Pillars; and an anode terminal comprising a Schottky barrier metal directly contacting a top surface of the N-type epitaxial layer to form a Schottky contact therebetween, the N-type epitaxial layer separating the Schottky barrier metal from the P-pillars so that the P-pillars float.

BRIEF DESCRIPTION OF THE DRAWINGS

[0036] Figs. 1A-1C show three different layout configurations for a superjunction power devices;

[0037] Fig. 2 shows a simplified cross section view of a superjunction FET;

[0038] Fig. 3 shows a simplified cross section view along a portion of a die where the active region transitions to termination region through transition region, in accordance with an embodiment of the invention;

[0039] Figs. 4A-4H are simplified cross section views depicting various steps in an exemplary process for forming the pillar structure shown in Fig. 3;

[0040] Figs. 5A-5G are simplified cross section views showing various embodiments in which the flexibility provided by combining the trench-fill process with the multiple Epi and

implant process is advantageously exploited to obtain performance improvements;

[0041] Figs. 6A-6B are simplified cross section views showing a process for forming P-pillars using a two-step pillar process;

5 [0042] Figs. 7A-7D, 8A-8D, 9A-9B and 10A-10B are simulation results illustrating the impact of various process parameters on the degree of electric field concentration along the trench depth;

[0043] Figs. 11A and 11B show a simplified cross section view where N-enrichment regions are formed at the bottom of N-filled trenches to create a local charge imbalance, and the corresponding electric field curve, respectively;

10 [0044] Figs. 12A and 12B show another simplified cross section view with N-enrichment regions at the bottom of N-pillars to create a local charge imbalance, and the corresponding electric field curve, respectively;

[0045] Figs. 13A-13B are simplified cross section views showing a three step trench fill process used in forming a super-junction device that is free of voids;

15 [0046] Figs. 14 and 15 show simplified cross section views of superjunction power devices which minimizes formation of voids in the trench fill process;

[0047] Figs. 16A-16C, 17 and 18 are simplified cross section views showing various embodiments of super-junction devices with pillars of alternating conductivity type;

20 [0048] Figs. 19A-19L are simplified cross section views showing various stages of a process for forming a super-junction trench-gate MOSFET;

[0049] Fig. 20 is simplified cross section view used to illustrate the process for forming the planar-gate variation of the trench-gate MOSFET in Figs. 19A-19L;

[0050] Figs. 21 and 22 are simplified cross section views along a portion of the die where the active region transitions into the termination region;

25 [0051] Fig. 23 is a simplified cross section view of a superjunction power device where field plates are electrically connected to their corresponding floating P-pillars;

[0052] Fig. 24A is a top layout view of a corner region of a super-junction power device;

[0053] Fig. 24B is an expanded view of the corner of the termination region of the top layout view in Fig. 24A;

30 [0054] Figs. 25A-25D are simplified cross section views showing various embodiments of super-junction high voltage merged PiN Schottky rectifiers;

[0055] Figs. 26A-26B are simplified cross section views showing two additional embodiments of super-junction high voltage Schottky rectifiers;

[0056] Figs. 27A and 27B are respectively top view of a die layout diagram and top view of a wafer where the wafer flat extends parallel to the laterally extending pillars in Fig. 27A;

5 [0057] Fig. 28 is a top view of a die layout diagram illustrating rotation of the die for the purpose of eliminating the non-uniform epi filling due to variations in plane direction;

[0058] Fig. 29 is a top layout view of a corner of a super-junction power MOSFET with striped active P-pillars surrounded by concentric termination P-pillars;

10 [0059] Fig. 30 is a top view of a fully concentric layout design where a supplementary metal gate runner is bussed through a center portion of the die to provide metal connection to the concentric polysilicon gates;

[0060] Fig. 31A shows a top layout view of a fully concentric design with a gate runner design that provides a more balanced gate propagation delay throughout the die;

[0061] Fig. 31B is an expanded view of an inner portion of the top view in Fig. 31A;

15 [0062] Fig. 31C is an expanded view of the upper right quadrant of the die shown in Fig. 31A; and

[0063] Fig. 32 shows a top layout view of a fully concentric pillar design with stripe polysilicon gates.

20 DETAILED DESCRIPTION

[0064] The power switch can be implemented by any one of power MOSFET, IGBT, various types of thyristors and rectifiers and the like. Many of the novel techniques presented herein are described in the context of the power MOSFET and Schottky rectifiers for illustrative purposes.

It is to be understood however that the various embodiments of the invention described herein are
25 not limited to the power MOSFET and Schottky rectifiers and can apply to many of the other types of power switch technologies, including but no limited to, for example, IGBTs and other types of bipolar switches and various types of thyristors and rectifiers. Further, for the purposes of illustration, the various embodiments of the invention are shown to include specific P and N type regions (e.g., for an n-channel MOSFET). It is understood by those skilled in the art that the
30 teachings herein are equally applicable to devices in which the conductivities of the various regions are reversed.

[0065] In the super-junction technology, the alternating P/N-pillars in the active and termination regions may be arranged in a number of different layout configurations. Figs. 1A-1C show three such layout configurations. In Fig. 1A, P/N-pillars 102 and 104 in both active region 108 and termination region 106 are arranged in a concentric configuration (hereinafter referred to as "full concentric" configuration); in Fig. 1B, P/N-pillars 112 and 114 in both active region 118 and termination region 116 are arranged in a parallel (or striped) configuration (hereinafter referred to as "full parallel" configuration); and in Fig. 1C, P/N-pillars 122 and 124 in active region 128 are arranged in a parallel (or striped) configuration, and P/N-pillars 122 and 124 in termination region 126 are arranged in a concentric configuration (hereinafter referred to as "parallel-concentric" configuration). Each of these layout configurations has its own merits and drawbacks. Some of the inventions and embodiments described herein address various drawbacks of these layout configurations.

[0066] The full concentric configuration in Fig. 1A enjoys uniform charge balance throughout active region 108 and termination region 106, but the active channel area may be reduced because the gate feeds must extend into the interior of active area 108 to feed the concentric active polysilicon gates. The channel may need to be removed at the corners to eliminate areas of lower threshold voltage and prevent parasitic NPN turn-on. Thus, as the die size is reduced, the penalty in on-resistance (R_{ds-on}) attributed to these corners in the active area may become greater.

[0067] The full parallel configuration in Fig. 1B also enjoys uniform charge balance throughout the active and termination regions but without the R_{ds-on} penalty of the full concentric configuration. However, the P/N-pillar design in the full parallel configuration may be limited to an N-rich balance condition to insure that the P-pillars extending out into termination area 116 from active area 118 become fully depleted somewhere along their length. By using concentric pillars for the termination, as in Fig. 1C, the electric field can be distributed across the termination region without full pillar depletion.

[0068] In the design where pillars (e.g., P-pillars) are formed using a trench etch and fill process, corners of the concentric pillars may be difficult to etch and fill resulting in voids in the epi fill that cause charge imbalance. These corners may thus become areas of high electric field stress. If they are shorted to source potential, either of the Fig. 1A and Fig. 1C layout configurations may have a lower breakdown voltage at these corners. In the parallel-concentric

configuration shown in Fig. 1C, these corners may be moved outside active area 128 where they can float and are thus not fixed at source potential thereby minimizing or eliminating them as a source of localized lower breakdown voltage. Also, the active channel area can be maximized and gate feeds used that are more conventional only requiring a perimeter gate runner to make connection to the active polysilicon gates.

[0069] In order to achieve good Unclamped Inductive Switching (UIS) characteristics, it is desirable to design the device so that breakdown first occurs in the active region as opposed to any other region of the device including the termination region. One way to achieve this is to make sure that all regions of the device have sufficiently higher breakdown voltage than the active area by locally modifying the charge balance in these regions. Fig. 2 shows an embodiment where this is achieved. In Fig. 2, P-pillars 230, 236 in both active region 204 and termination region 202 may have the same width W3 and similar doping profiles. N-type mesa regions 232, 234 (alternatively referred to as N-pillars in this disclosure) in active region 204 and termination region 202 may be grown with the same epitaxial layer or layers.

[0070] Using known techniques, mesa width W1 and P-pillar width W3 as well as the doping profiles in P-pillars 230, 236 and N-type mesas 232, 234 may be designed to achieve a charge balance condition resulting in termination region 202 having a higher breakdown voltage than active region 204. In contrast, mesa width W2 in active region 204 may be adjusted to obtain a different charge balance condition that results in a lower breakdown voltage than other areas of the device including termination region 202. In one embodiment, mesa width W2 in active region 204 may be made smaller than mesa width W1 in termination region 202 so that active region 204 is more P-rich. In another embodiment, mesa width W2 in active region 204 may be made greater than mesa width W1 in termination region 202 so that active region 204 is more N-rich. These techniques ensure that breakdown occurs in active region 204 first thus resulting in a more stable breakdown characteristic and a more uniformly distributed current flow during a UIS event. Accordingly, both the breakdown and UIS characteristics of the device are improved. Note that an N-rich active region may result in a improved (lower) Rds-on at the expense of UIS performance, and a P-rich active region may provide a better UIS performance at the expense of Rds-on. Depending on the design goals, one approach may be preferred to the other. A number of techniques for achieving various performance improvements are described next.

[0071] Fig. 3 shows a cross section view along a portion of a die where active region 301

transitions to termination region 302 through transition region 304. In this exemplary embodiment, transition P-pillars 329A are bridged to the first contacted P-pillar 329B in active region 301 through a diffusion region 342 marked as P_{iso}. This bridging diffusion may extend over N-type mesa regions 333A. In this and other embodiments disclosed herein, the N-type mesa regions separating the P-pillars may also be referred to as “N-pillars.” When N-type mesa regions 333A in transition region 304 have the same or smaller width than active N-pillars 333B, an increase in P charge in transition region 304 occurs. This increase in P charge can reduce the breakdown voltage below that of active area 301. To compensate for this increase in P charge, the width of N-pillars 333A in transition region 304 may be made greater than the width of N-pillars 333B in the active region. This can ensure that the breakdown voltage in transition region 304 remains higher than in active area 301. In the embodiment shown in Fig. 3, transition region 304 is defined by the span of the bridging diffusion 342.

[0072] As with the Fig. 2 embodiment, the width of all P-type pillars 329A, 329B, 329C in all regions (the termination, transition and active regions) may be substantially the same, and the width of termination mesa regions 333C may be greater than the width of the active mesa regions 333B. However, the width of termination mesa regions 333C may be greater than, the same as, or smaller than the width of transition mesa regions 333A. In active region 301, in one embodiment, P-pillars 329B may have the same width and may be spaced from one another by the same distance. However, in another embodiment, the width of P-pillars 329B in active region 301 may be smaller than the spacing between them, thus providing a N-rich condition in the active region. In one embodiment, the active and transition N-pillars and P-pillars may be stripe-shaped with termination N-pillars and P-pillars surrounding the active and transition regions in a concentric fashion similar to the layout configuration shown in Fig. 1C. In yet another embodiment, the active, transition, and termination N-pillars may be concentric similar to the layout configuration shown in Fig. 1A.

[0073] In the designs where the pillars (e.g., P-pillars) are formed by etching deep trenches and filling them with silicon, as for example in high voltage super-junctions designs, process reliability may be directly related to the trench depth to width ratio (i.e., the trench aspect ratio). For higher trench aspect ratios, epi filling of the trenches becomes more difficult. Fig. 3 shows a technique whereby P-pillars that extend deep into the drift region are formed without requiring deep trenches.

[0074] In Fig. 3, a multi-epi process with multiple aligned implantations is combined with a trench process to form all P-pillars 329A, 329B, 329C. As can be seen, each P-pillar includes three P-implant regions 335A, 335B, 335C stacked on top of each other, as well as a trench-filled portion 337 along the upper portion of the P-pillar. Along each P-pillar, the three P-implant regions 335A, 335B, 335C and the upper trench-filled portion 337 correspond to separate N-epi layers. That is, in the exemplary embodiment shown in Fig. 3, four N-epi layers are used to form the P-pillars. More or fewer than four epi layers may be used depending on the design goals.

[0075] The technique exemplified by the Fig. 3 embodiment provides a number of advantages. First, the trench etch depth is substantially reduced thus allowing for reduced trench CD and easier trench filling. Also, the cell pitch can be reduced due to the trench etch angle. That is, the trenches are etched with a taper from bottom to top, thus resulting in a wider trench width at the top. This allows the trenches to be fully filled without the risk of pinch off at the top creating voids in the pillar. Having a shallower trench etch reduces the width of the trench at the top which is a function of the tangent of the etch angle. Consequently, the width of the pillar at the top is smaller and the shallower trenches can be made with a smaller etch CD because they are easier to fill. Thus a smaller cell pitch and a lower Rds-on can be obtained. Further, as is described more fully in connection with Figs. 5A through 5G below, this technique advantageously: (1) allows use of different P implant CDs for active and termination P-pillars to insure that break down occurs in the active area first, and (2) allows adjusting the P implant CDs in the active region to insure that the avalanche breakdown occurs well below the junction formed by the P-type body regions and the N-type drift region.

[0076] Before turning to Figs. 5-A to 5-G, an exemplary process for forming the pillar structure shown in Fig. 3 will be described with references to Figs. 4A to 4H. Fig. 4A shows N+ starting substrate 404. In Fig. 4B, a first N-epi layer 407A may be grown using conventional techniques. In Fig. 4C, a P-implant may be carried out to form P-implant regions 401A. A conventional masking and implant process may be used to form P-implant regions 401. In Fig. 4D, the steps corresponding to Fig. 4C are repeated two more times to form second and third N-epi layers 407B, 407C and the corresponding P-implant regions 401B, 401C, followed by formation of a fourth and thicker N-epi layer 407D. The second to fourth N-epi layers may be formed using conventional techniques. The second to fourth N-epi layers may be formed with a uniform, stepped, or graded doping concentration. As will be discussed further below, different

implant doping concentration and/or energy may be selected in forming each P-implant region 401A, 401B, 401C in order to obtain the desired charged imbalance condition along the pillar length and/or depth.

[0077] In Fig. 4E, trenches 403 may be patterned and etched deep enough to reach the uppermost P-implant regions 401C. Backside alignment techniques may be used to ensure alignment of trenches 403 with P-implant regions 401C. In Fig. 4F, trenches 403 may be filled with P-epi 405 using known techniques. In Fig. 4G, P-epi 405 may be planarized using, for example, a conventional chemical mechanical polishing (CMP) process. In Fig. 4H, P-type body region 438, N⁺ source regions 418, the P⁺ heavy body regions as well as the gate structure and its overlying layers may be formed using known techniques. While in the process depicted by Figs. 4A-4G, a separate N-type buffer layer is not incorporated between the substrate and the first N-epi layer 407A (as is done in Fig. 3), such buffer layer can be incorporated by forming a suitable N-epi layer before forming N-epi layer 407A in Fig. 4C. Alternatively, N-epi layer 407A can be made thicker to account for the buffer layer.

[0078] As can be seen, this process yields a super-junction device with P-pillars that are formed from a combination of multiple P-implant regions 401A, 401B, 401C and a relatively shallow trench-filled portion 403. Accordingly, the trench etch depth is substantially reduced thus allowing for reduced trench CD and easier trench filling. This technique also provides a number of other advantages over conventional techniques, some of which will be discussed with reference to the embodiments shown in Figs. 5A-5G.

[0079] Figs. 5A-5G show various embodiments in which the flexibility provided by combining the trench-fill process with the multiple Epi and implant process is advantageously exploited to obtain performance improvements. Fig. 5A is a cross section view that is similar to Fig. 3 except that a larger P-implant CD is used in forming the bottom-most P-implant region 535A of active P-pillars 529B than that used in forming the bottom-most P-implant regions of transition P-pillars 529A and termination P-pillars 529C. In this manner, the charge imbalance at the bottom of the active P-pillars is made greater than the charge imbalance at the bottom of the termination and transition P-pillars, thus ensuring that the break down first occurs in the active region.

[0080] Fig. 5B shows a variation of the Fig. 3 embodiment where P-implant regions 555A, 555B along P-pillars in the active, transition and termination regions are floating (i.e., P-implant

regions 555A, 555B do not merge). This can be achieved by carefully controlling the P-implant dose and energy in the process steps corresponding to Figs. 4C and 4D. Floating the pillar regions allows for reduced charge balance sensitivity because these regions can assume a potential similar to the floating pillar regions in the termination. Fig. 5C shows another embodiment that is similar to that in Fig. 5B except that a larger P-implant CD is used in forming the bottom-most P-implant regions 555A in the active P-pillars as compared to that used in forming the bottom-most P-implant regions 555A in the transition and termination P-pillars. Similar to the Fig. 5A embodiment, the greater charge imbalance in the active region due to the larger P-implant regions 502 forces the break down to occur in the active region.

[0081] In the Figs. 5A and 5C embodiments, the larger P-implant regions may be formed for every other active P-pillar as opposed to all active P-pillars. This technique is advantageous in that the impact of the larger P-implant regions on current flow (e.g., pinching off the current path at the bottom of the P-pillars) is reduced thus improving Rds-on. The larger P-implant regions could also be formed at the bottom of every third active P-pillar or every fourth active P-pillar or some other pattern depending on the avalanche current and as long as breakdown occurs in a uniform manner in the active region.

[0082] Fig. 5D shows a cross section view of yet another embodiment which is similar to that shown in Fig. 3 except that multiple N-implant regions 572A, 572B, 572C are formed in between the P-implant regions 535A, 535B, 535C. These N-implant regions enable better control of charge balance and imbalance as well as make the pillars N rich at the bottom. Having the N rich imbalance at the bottom is another method of moving the avalanche location deeper in the silicon without penalizing Rds-on as a result of pillar pinch off. Referring to Figs. 4C and 4D, N-implant regions 572A, 572B, and 572C can be formed immediately before or immediately after forming the corresponding P-implant regions using known techniques. Referring back to Fig. 5D, while the N-implant regions 572A, 572B, 572C and the P-implant regions 535A, 535B, 535C are formed in a manner that provides similar charge balance characteristics in the active, transition and termination regions, in the embodiment shown in the Fig. 5E, a smaller N-implant CD is used in forming the lower-most N-implant regions 572A in the active region as compared to the lower-most N-implant regions 572A in the transition and termination regions, thereby forcing break down in the active region. The smaller N-implant regions 572A in the active region may alternatively be formed at the bottom of every other active N-pillar (instead of each and every

active N-pillar as shown in Fig. 5E). In yet another embodiment shown in Fig. 5F, the bottom-most N-implant region may be eliminated altogether in the active region by blocking the N-implant in the active region only. Alternatively, the bottom-most N-implant region may be eliminated from every other active N-pillar.

5 [0083] Fig. 5G shows yet another embodiment in which a larger P-implant CD is used for the lower-most P-implant regions 535A in the active P-pillars than that used in the termination and transition regions, and the bottom-most N-implant regions are eliminated only in the active region. Of the various embodiments, this embodiment provides the most P-rich condition at the bottom of the active P-pillars. Other permutations can be envisioned in view of the various
10 embodiments disclosed herein. For example, the larger P-implant regions in Fig. 5G can be formed at the bottom of every other active P-pillar to obtain better Rds-on, or in Fig. 5G, instead of fully eliminating the bottom-most N-implant region, smaller N-implant regions (such as regions 572A in 5E) can be used to improve Rds-on. Further, the P-implant regions and/or N-implant regions, or select groups of them, shown in the various embodiments may be formed so
15 that they do not extend along the full length of the P-pillar (e.g., into the page). Also, while the cross section views in Figs. 3 and 5A-5G show the mesa widths in the active region to be different than the mesa widths in the transition and termination regions, in one embodiment, all mesa widths in the active, transition and termination regions are the same, and the bottom-most P-implant regions in the active region and/or the bottom-most N-implant regions in the active
20 region are manipulated as outlined in the various embodiments described above to insure that the active region has a lower break down voltage than the termination region. It is also noted that the various embodiments described above may be implemented using any of the three layout configurations shown in Figs. 1A-1C.

[0084] While the embodiments described with reference to Figs. 3, 4A-4H and 5A-5G
25 disclose techniques whereby the trench etch depth is substantially reduced thus allowing for easier trench filling, another technique for achieving the same is shown in Figs. 6A-6B.

[0085] Figs. 6A-6B are cross section views showing a process for forming P-pillars using a two-step pillar process. In Fig. 6A, a first N-epi layer 604 is grown over a highly doped substrate 602 using known techniques. A bottom portion 606A of a deep trench 606 is formed in first epi
30 layer 604, and then filled with P-type silicon material 608A using conventional methods. A planarization process (e.g., chemical mechanical polish) may be carried out to planarize the top

surface of the silicon before the next process step of forming the second N-epi layer 609 is carried out. Second epi layer 609 is formed over first epitaxial layer 604 using conventional techniques. A top portion 606B of deep trench 606 is then formed in second epi layer 609, and then filled with P-type silicon material 608B using conventional methods. Back-side alignment techniques
5 may be used to ensure that top and bottom trenches 606A, 606B are properly aligned.

[0086] Next, A planarization process may be carried out to planarize the top surface of the silicon before the subsequent steps. A post bake (e.g., at temperature of 1200 degree C and 60 minutes) may be carried out to anneal out the defects in the two epi layers. Further processing may be carried out next to form the surface structures. For example, in the case of a MOSFET, as
10 shown in Fig. 6B, P-type body region 610, N+ source regions 614, P+ heavy body regions 612 as well as the gate structure and its overlying layers may be formed using known techniques. The two-step pillar process depicted by Figs. 6A-6B may be expanded to include additional epi, trench etch and trench fill steps, for example, for higher voltage devices in which the trenched pillars extend even deeper.

[0087] This technique provides a number of advantages. By forming and filling the deep trench in multiple steps, filling the deep trench is made easier. Also, this technique can easily be scaled to accommodate higher voltage devices. That is, depending on the target breakdown voltage and the corresponding trench depth, the number of epi layers and corresponding trench etch and fill steps can be increased. Additionally, this technique provides significant flexibility by
20 allowing independent selection of thicknesses and doping profiles for the two N-epi layers, as well as independent selection of doping profiles for the two trench fills. This flexibility enables more precise control of the electric field characteristics along the depth of deep trenches 600. For example, the degree of field concentration, as well as the electric field profile (e.g., flat or double peak) and the position of the peak electric field, can be controlled by adjusting the thicknesses of
25 the epi layers and the doping profiles of the epi layers and the trench fill material.

[0088] For example, the simulation results in Figs. 7A-7D illustrate the impact of the doping concentration of the trench fills on the degree of electric field concentration along the trench depth (in these simulations, the thicknesses and doping concentration of the two N-epi layers are not changed). In these figures, t1 and t2 indicate the thicknesses of the bottom epi 604 (Fig. 6A) and top epi 609 (Fig. 6), respectively; N1 and N2 indicate the doping concentrations of the
30 bottom epi 604 and top epi 609, respectively; and P1 and P2 indicate the doping concentration of

the P-type silicon material 608A in the bottom portion 606A of deep trench 606 and the P-type silicon material 608B in the top portion 606B of deep trench 606, respectively. As another example, the simulation results in Figs 8A-8D illustrate the impact of the doping concentration of the trench fills on the location of the peak electric field (in these simulations, similar to those in Figs. 7A-7D, the thicknesses and doping concentration of the two N-epi layers are not changed). The simulation results in Figs. 9A-9B illustrate yet another example where the various parameters and physical dimensions are manipulated to create a double peak in the electric field, thus increasing the break down voltage. The simulation results in Figs. 10A-10B illustrate still another example where an even higher breakdown voltage can be obtained by using the appropriate thicknesses for the epi layers and doping concentrations for the trench fill material (it is noted that this particular simulation result shows that, as compared to standard 900V MOSFETs, the parameters and dimensions identified in the table in Fig. 10B yield a substantially lower Rds-on -- a factor of 10 -- for the same break down voltage). Thus, the location of peak impact ionization and the avalanche point along the depth of the pillar can be controlled so as to be below the body junction.

[0089] As discussed above, it is advantageous to induce the onset of avalanche breakdown along the bottom half the pillars away from the body-drift junction. Fig. 11A shows a cross section view in accordance with an exemplary embodiment of the invention where N-enrichment regions 1105 may be formed at the bottom of N-filled trenches 1107 to create a local charge imbalance thereby inducing the onset of avalanche breakdown at the pillar bottoms. This characteristic of the Fig. 11A structure can be seen from the electric field curve shown in Fig. 11B. The electric field curve shows the electric field profile along the depth of the cross section view in Fig. 11A. As can be seen, N-enrichment regions 1105 cause the electric field peak to occur near the bottom of the pillars. N-enrichment regions 1105 preferably have a higher doping concentration than N-pillars 1108 to create the charge imbalance. Since the electric field profile and thus the breakdown voltage is a function of the total N-type and P-type charge in both pillars, the N-pillars can be more heavily doped and made narrower thus reducing the pitch. This benefit is realized because the impact of the lateral diffused compensation from the P-pillar doping into the N-pillar is minimized.

[0090] The structure in Fig. 11A may be formed as follows. An N-epi layer 1104 may be grown over N+ substrate 1102 using conventional techniques. An N-enrichment implant may be

carried out to form N-enrichment regions 1105 where bottoms of N-pillars 1108 will terminate. A conventional masking and implant process may be used to form N-enrichment regions 1105. The implant doping concentration and energy may be set in accordance with the target charge imbalance condition at the pillar bottoms. An alternate method for forming N enrichment regions 1105 is to grow an N-type epi layer, etch the pillar trenches and then implant the bottom of the trenches with N enrichment dopants.

[0091] One or more P-epi layers 1106 may be grown over N-epi layer 1104 using conventional techniques. The one or more P-epi layers 1106 may be formed with a uniform, stepped, or graded doping concentration. Trenches 1107 may be patterned and etched deep enough to reach N-enrichment regions 1105. Backside alignment techniques may be used to ensure alignment of trenches 1107 with N-enrichment regions 1105. Trenches 1107 may be filled with N-epi using known techniques. The N-epi used to fill the trenches need not be fully planarized since any portions of N-epi remaining over the P-epi 1106 can be used in forming the top structure of the power device. Alternatively, the N-epi used to fill the trenches may be planarized using, for example, a conventional chemical mechanical polishing (CMP) process. P-body regions 1110, N+ source regions 1114, P+ heavy body regions 1112 as well as gate structure 1116 and its overlying layers (not shown) may be formed using known techniques. In one implementation, P-body regions 1110, source regions 1114 and heavy body regions 1112 are all formed after gate structure 1116 is formed.

[0092] In another embodiment shown in Fig 12A, one or more P-epi layers 1206a may be grown over N-epi layer 1204 using convention techniques. The one or more P-epi layers 1206a may have a uniform, stepped, or graded doping concentration. Lower trenches 1207 maybe patterned and etched deep enough to reach N-enrichment regions 1205. Lower trenches 1207 may be filled with N-epi 1208a using know techniques. One or more N-epi layers 1208b is then grown over the one or more P-epi layers 1206a and the N-epi filled lower trenches 1207, using conventional techniques. The one or more N-epi layers 1208b may have a uniform, stepped, or graded doping concentration. Upper trenches 1209 maybe patterned and etched deep enough to reach the one or more P-epi layers 1206a. Upper trenches 1209 may be filled with P-epi 1206b using know techniques. The upper trenches may be aligned to the lower trenches using backside alignment techniques or can be run perpendicular to the lower trenches.

[0093] As can be seen, N-pillars 1208 have a reverse taper along their upper half. P-epi

1206b used to fill upper trenches 1209 may be planarized using, for example, a conventional CMP process. P-body regions 1210, N+ source regions 1214, P+ heavy body regions 1212 as well as gate structure 1216 and its overlying layers (not shown) may be formed using known techniques. In one implementation, P-body regions 1210, source regions 1214 and heavy body regions 1212 are all formed after gate structure 1216 is formed. An advantage of this structure is that the wider P-pillar at the surface pushes the avalanche point down so that avalanche occurs below the surface P-body region and the increased electric field at the bottom due the N-enrichment causes the peak electric field to occur at the bottom. This characteristic of the Fig. 12A structure can be seen from the electric field curve shown in Fig. 12B. The electric field curve shows the electric field profile along the depth of the cross section view in Fig. 12A. The Wider N-Pillar with the N-enrichment at the bottom increases the peak current at which pinch-off occurs due to JFET effects and lowers Rds-on.

[0094] The N-enrichment regions 1105 in Fig. 11A and 1205 in Fig. 12A advantageously induce avalanche breakdown at the bottom of the pillars and thus result in a device with improved UIS capability. The N-enrichments may be used in other advantageous ways as well.

[0095] As discussed above, device ruggedness can be improved in trench epi fill charge balance devices by initiating breakdown in the active area and having the breakdown voltage be substantially lower than other areas, such as termination regions, gate runner areas, and other areas that are likely to be a potential source of charge imbalance. In one embodiment, N-enrichment regions may be formed at the bottom of N-pillars in the active region only. In another embodiment, N-enrichment regions may be formed at the bottom of every other active N-pillar. In other embodiments, N-enrichment regions may be wider than or narrower than the active N-pillars or distributed along length of a N-pillar in an uniform or non-uniform pattern. In yet another variation, the distribution of N-enrichment may not need to be the same for every P-pillar. In yet another embodiment, the N-enrichment regions may be formed in a blanket manner (i.e., adjacent N-enrichment regions merge together) in the active region. Alternatively, the N-enrichment regions may be formed in a blanket manner across both the active and termination regions.

[0096] In accordance with other variations of the Figs. 11A and 12A technique, regions of P-enrichment (not shown) are formed at the bottom of the P-pillars or at the bottom of the N-pillars to disrupt charge balance and thereby create a location of lower breakdown voltage so that

avalanche initiates at this localized area. The P-enrichment regions may be implemented in both the active and termination regions, thus ensuring that breakdown occurs near the bottom of the pillars and is far from the silicon surface. Alternatively, the P-enrichment regions may be implemented in the active region only, so that the charge balance is disrupted in the active region to ensure breakdown in the active region. The P-enrichment regions may be wider or narrower than the P-pillars or distributed along length of a P-pillar in a uniform or non-uniform pattern. In another variation, the P-enrichment regions may be formed at the bottom of every other P-pillar in the active region. In yet another variation, the distribution of P-enrichment may not need to be the same for every P-pillar.

[0097] The technique depicted in Figs. 11A, 12A and its various embodiments described above may be implemented using any of the three layout configurations shown in Figs. 1A-1C.

[0098] In the super-junction approach where P-pillars are formed using deep trenches, it is difficult to prevent formation of voids in the epi material that is typically used to fill the deep trenches. Such voids are undesirable because they can lead to reliability and leakage problems.

Figs. 13A-13B are cross section views showing a three step trench fill process used in forming a super-junction device that is free of voids.

[0099] In Fig. 13A, one or more N-type epitaxial layers, marked in the figure as N epi 1302, is (are) formed over a suitable substrate (not shown). Trenches 1304 are etched in N epi 1302 using known techniques. P-type epitaxial layer 1306 lining the trench sidewalls and bottom is formed using conventional methods. Next, dielectric layer 1308 (e.g., grown or deposited oxide) is formed over P-epi layer 1306 in trenches 1304 using known methods. Finally, the central remaining portion of trenches 1304 is filled with a conformal material such as amorphous silicon or polysilicon that is doped or undoped using known methods. This technique eliminates formation of voids since epi is used to only partially fill the trench, and a conformal material, such as polysilicon, is used to fill the difficult-to-fill central portion of deep trenches. The void-free filling of deep trenches is achieved while preserving the ability to carefully set the P-charge for charge balance purposes via P-liner 1306. That is, using conformal material 1310 to fill the central portion of the trenches eliminates formation of voids while P epi liner 1306 enables accurate control of the P-charge. Dielectric layer 1308 in turn, advantageously, serves as a cap layer preventing out-diffusion of P-dopants from P-epi liner 1306 to poly fill 1310. Thus charge balance becomes independent of trench width.

[00100] In Fig. 13B, the surface structure of the device, in this case a planar gate MOSFET, is formed. Incorporating the three step trench fill process in other MOSFET structures (e.g., trench gate variation) or other types of super-junction devices (e.g., planar gate or trench gate IGBTs) would be obvious in view of this disclosure. In Fig. 13B, P-type body regions 1312, N+ source regions 1314 and P+ heavy body regions 1316 are formed in N epi 1302 using conventional techniques. The gate structure, including gate dielectric 1318 and gate electrodes 1320 are formed using known processes. Source metal 1322, contacting source regions 1314, heavy body regions 1316 and poly fill 1310, is formed using known techniques. A back-side drain metal (not shown) contacting the substrate (not shown) is formed in accordance with conventional methods.

[00101] As stated earlier, it is difficult to fill deep trenches with epi without formation of voids. Voids can lead to reliability and leakage issues and are thus undesirable. Fig. 14 shows a simplified cross section view of a superjunction power device which minimizes formation of voids in the trench fill process. Trenches 1408 (one of which is shown in Fig. 14) are formed in one or more layers of N-epi 1402. Those portions of the one or more N-epi layers 1402 that separate adjacent trenches 1408 from one another, form N-pillars. A thick P-epi liner 1404 is grown in trenches 1408. P-epi liner 1404 sets the P charge for the P-pillars. Most of trench 1408 is filled by P-epi liner 1404, and its thickness is selected so that the top of trenches 1408 remain open after the epi growth process. A dielectric material 1406 is then used to fill the rest of the trench. In one embodiment, dielectric material 1406 comprises high quality thermal oxide. The thermal oxide fill helps improve reliability. Also, the P charge can be easily controlled by P-epi liner 1404. The remaining structural details of the power device (not shown), and the manner of forming them, may be similar to those shown in Fig. 13B.

[00102] Another embodiment directed to eliminating formation of voids in deep trenches is shown in Fig. 15. This embodiment is similar to the Fig. 14 embodiment except that the fill process includes forming an additional epi layer in the trenches. In Fig. 15, trenches 1508 (one of which is shown in Fig. 15) are formed in one or more layers of N-epi 1502. Those portions of the one or more N-epi layers 1502 that separate adjacent trenches 1508 from one another, form N-pillars. A first P-epi liner 1510 lining the trench sidewalls and bottom is formed in trenches 1508. Trenches 1508 are then mostly filled by another lighter doped P-epi layer 1504. The thicknesses of P-epi layers 1510 and 1504 are selected so that the top of trenches 1508 remain open after the epi fill process. A dielectric material 1506 is then used to fill the rest of the trench. In one

embodiment, dielectric material 1506 comprises high quality thermal oxide. The remaining structural details of the power device (not shown), and the manner of forming them, may be similar to those shown in Fig. 13B.

[00103] Fig. 16A shows a cross section view of yet another super-junction device with pillars

5 of alternating conductivity type. In this embodiment, the P-pillars include 2 differently doped P epi layers: an outer P- epi layer 1610A, and a center P epi layer 1610C. These two epi layers may be formed by successively filling the trench with P epi layers of increasing doping concentration. An advantage of such P-pillar structure is that the width of the N-pillars is kept intact since the outer P epi layer 1610A is lightly doped and thus the lateral diffusion of P-type dopant into
10 adjacent N-pillars has minimal or no impact on the increase in the N-pillar resistivity. Keeping the width and resistivity of the N-pillars intact improves Rds-on.

[00104] The Fig. 16A structure further includes a retro-graded N-pillar. As can be seen, the N-pillar includes, from bottom to top, N⁺ region 1618, N epi layer 1606 and N- epi layer 1608.

Such retro-graded N-pillar advantageously reduces the peak electric at the P-N junction formed
15 by the P-body and N-drift regions, and lowers the Rds-on. The N⁺ region 1618 of the N-pillar can be formed as follows. Prior to forming N- epi layer 1604 over substrate 1602, a heavy dose of arsenic is implanted into region 1604 of substrate 1602 using a mask. During subsequent heat cycles, the arsenic in heavily implanted region 1604 up-diffuses into N- epi layer 1604, thus forming N⁺ region 1618.

20 **[00105]** The remaining portions of the Fig. 16A structure may be formed as follows. N epi layer 1606 and N- epi layer 1608 are formed over N- epi layer 1604 using conventional techniques. Deep trenches extending into N- epi layer 1608 and N epi layer 1606 are formed using known methods. The deep trenches terminate in or prior to reaching N- epi layer 1604.

The deep trenches are then filled with P epi layers 1610A and 1610C using conventional epi
25 processes. The remaining surface structures of the super-junction device, in this case a trench gate MOSFET, are formed using known techniques. The gate trenches housing gate electrodes 1612 are formed in N- epi 1608, followed by forming a thick bottom oxide along the trench bottom. Gate dielectric 1616 is formed along the trench sidewalls followed by forming recessed gate electrodes 1612 in the gate trenches. Source regions 1614 are formed adjacent the gate
30 trenches, and a source metal contacting source regions 1614 and P epi layers 1610A, and 1610C is formed along the top surface of the structure. A drain metal (not shown) contacting substrate

1602 is formed along the backside.

[00106] Fig. 16B shows a cross section view of another super-junction device with pillars of alternating conductivity type. In this embodiment, the P-pillars include 2 differently doped epi layers: an outer P+ epi layer 1611A and a center P- epi layer 1611C. An advantage of such P-pillar structure is that the P-pillar charge is set by the outer P+ epi layer 1611A which lines the trench. Thus, the effect of the charge variation of the P-pillar at the top and the bottom remains consistent and is independent of the trench angle which makes the trench wider at the top. Keeping the P-pillar charge the same from top to bottom of the trench reduces the variation in charge imbalance resulting from the trench angle, which in turn results in less variation of breakdown voltage.

[00107] Fig. 16C shows a cross section view of yet another super-junction device with pillars of alternating conductivity type. In this embodiment, the P-pillars include 3 differently doped P epi layers: outer P- epi layer 1613A, center P- epi layer 1613C and middle P epi layer 1613B sandwiched by outer epi layer 1613A and center epi layer 1613C. These three epi layers may be formed by successively filling the trench with P epi layers of different doping concentrations. Such P-pillar structure provides a compromise between Figs. 16A and 16B. This structure offers the advantage of the Fig. 16A structure, namely, the lateral diffusion of P-type dopants into the N-pillars is substantially reduced thus minimizing or eliminating the impact on the N-pillar resistivity. The Fig. 16C structure also offers the advantage of the Fig. 16B structure in that the effect of the charge variation of the P-pillar at the top and the bottom remains consistent and is independent of the trench angle because the P-pillar charge is set by the middle P+ epi layer 1613B. Thus, the Fig. 16C structure has the advantages of reduced breakdown voltage variation and reduced Rds-on.

[00108] Fig. 17 shows a cross section view of yet another super-junction device with pillars of alternating conductivity type. In this embodiment, the P-pillars include 3 differently doped P epi layers: outer P- epi layer 1710A, center P+ epi layer 1710C and middle P epi layer 1710B sandwiched by outer epi layer 1710A and center epi layer 1710C. These three epi layers may be formed by successively filling the trench with P epi layers of increasing doping concentration. An advantage of such P-pillar structure is that the width of the N-pillars is kept intact since the outermost P epi layer 1710A is lightly doped and thus out-diffuses minimally. Keeping the width of the N-pillars intact improves Rds-on.

[00109] In another embodiment shown in Fig. 18, P-enrichment region 1822 is formed at the bottom of each P-pillar using similar techniques to those described above for forming N-enrichment regions 1105 in Fig. 11. Such P-enrichment regions advantageously compensate up-diffusion of dopants from N-epi layer 1604. Many of the same variations discussed above in connection with N-enrichment regions 1105 in Fig. 11 may be applied to the Fig. 18 embodiment. Also, enrichment region 1822 can be formed along the bottom of the P pillars in the embodiments shown in Figs. 16A-16C and 17.

[00110] Although epi layer 1610A in Fig. 16A, epi layer 1611C in Fig. 16B, epi layers 1613A, 1613C in Fig. 16C, epi layer 1710A in Fig. 17, and epi layers 1810A and 1810C in Fig. 18 are all shown as P-epi, they could be lightly doped N- or intrinsic epi silicon. Further, center layer 1611C in Fig. 16B, center layer 1613C in Fig. 16C and center layer 1810C in Fig. 18 embodiments need not be from epi, and can instead be from another material such as polysilicon.

[00111] Figs. 19A-19L are cross section views showing various stages of a process for forming a super-junction trench-gate MOSFET. These figures show a portion of the die where active region 1903 transitions into termination region 1905. In Fig. 19A, N-epi 1902 is formed over a suitable substrate (not shown) using conventional techniques. N-epi 1902 may comprise multiple epi layers with different doping concentrations, or may be a single epi layer with graded or uniform doping concentration. Using masking layer 1904 (e.g., comprising photoresist), a boron implant process 1904 is then carried out to form P-Iso region 1906 in N-epi layer 1902. P-Iso region 1908 extends in the transition and termination regions, and is incorporated for reasons stated above in connection with Fig. 3, and is formed in a similar manner to that in Fig. 3.

[00112] In Fig. 19B, P-Iso drive and trench hard mask oxidation are carried out in one process step. Hard mask 1910 (comprising oxide) is then formed over the top surface. Trenches 1912 are defined using photoresist 1910. In Fig. 19C, trenches 1912 are formed in N-epi layer 1902 using known techniques. Gate dielectric 1914 is then formed along trench sidewalls and bottom using conventional techniques (e.g., gate oxidation). Prior to forming gate dielectric 1914, a thick bottom dielectric may optionally be formed along trench bottoms to reduce the gate to drain capacitance. In Fig. 19D, conventional polysilicon deposition and etch back steps are carried out to form recessed gate electrodes 1916 in trenches 1914.

[00113] In Fig. 19E, P-type body regions 1918 are formed in N-epi 1902 using conventional implant and drive processes. In Fig. 19F, source regions 1920 are formed in the active region

adjacent active trenches using conventional implant and drive processes. In Fig. 19G, an oxide-nitride-oxide (ONO) composite layer 1922 is formed using known techniques. In one embodiment, the ONO comprises from bottom to top: pad oxide 1922A, nitride 1922B, and thick LTO 1922C. Pad oxide 1922A serves as a nitride etch stop in a later process step. In Fig. 19H, deep trenches 1924 are defined and etched into N-epi 1902 using techniques described in this disclosure, or using known techniques.

[00114] In Fig. 19I, known techniques are used to fill trenches 1924 with P-type silicon 1926. As can be seen, vertically extending portions 1902A of N-epi 1902 between adjacent P-filled pillars 1926, form N-pillars. N-pillars 1902A and P-pillars 1926 thus form the super-junction structure, namely, the alternating pillars of opposite conductivity type. In Fig. 19J, the top oxide layer in ONO composite layer 1922 is removed, defining edge LTO 1922A, and BPSG 1930 is formed over the surface of the device using conventional processes and then annealed. In Fig. 19K, BPSG 1930 is defined and etched using masking layer 1932 (e.g., comprising photoresist) to form contact openings in BPSG 1930. The remaining portions of BPSG 1930 cover the gate electrodes and extend over source regions 1920. A conventional heavy body implant is carried out to form P+ heavy body regions 1934 through the contact openings. Alternatively, dimples may be etched in body regions 1918, and P-type dopants may then be implanted along the bottom of the dimples to form P+ heavy body regions in body regions 1918. The dimples also expose sidewalls of the source regions to which contact can be made by the later formed source metal. In Fig. 19L, a conventional BPSG reflow is carried out to round the corners of the dielectric, followed by formation of the various metal layers (e.g., source metal layer 1936 and gate metal layer 19368). A backside metal (e.g., drain metal, not shown) contacting the substrate on the backside of the die is formed using known techniques.

[00115] In termination region 1905, the P-Iso region 1908, which is electrically connected to source metal 1936, connects a number of the P-pillars together and thus biases these P-pillars along their tops to the source potential. All termination P-pillars located to the right of P-Iso region 1908 float, and are marked in Fig. 19L as “floating P-pillars 1940.”

[00116] As can be seen, P-pillars 1926 are formed relatively late in the process as compared to conventional trenched pillar processes where the P-pillars are formed early in the process.

Because the P-pillars are formed late in the process after most of the thermal budget has been completed, the out-diffusion of the P-pillar dopants is advantageously minimized. This enables

use of tighter pitch for P-pillars and results in lower Rds-on without compromising breakdown voltage.

[00117] The process embodiment depicted by Figs. 19A-19L is directed to a trench gate MOSFET however, this process can be modified to implement a planar gate MOSFET with the same advantages, as described next. This process will be described with reference to Fig. 20, which is a cross section view of a planar gate MOSFET that is formed using the process that is described next. One or more N-type epitaxial layers 2027A, 2027B are formed over a suitable substrate 2024 using known techniques. P-type enrichment regions 2021 may optionally be formed in epi layer 2027A prior to forming epi layer 2027B. As described in connection with other embodiments, P-enrichment regions 1921 advantageously creates more of a charge imbalance at the bottom of the P-pillars, thereby inducing the onset of avalanche breakdown at the bottom of the P-pillars and away from the body-drift junction.

[00118] The gate dielectric and the overlying planar gate electrodes 2014 are defined and formed over N-epi 2027B using known techniques. P-type dopants are then implanted with planar gate electrodes 2014 serving as a blocking layer, followed by a drive step, thus forming P-type body regions 2038 in N-epi 2027B. After the drive step, the P-type body regions laterally extend under the gate electrodes. Using known techniques, source regions 2018 are then defined and formed in body regions 2038 adjacent each edge of gate electrodes 2014. A conformal layer, e.g., a nitride layer, (not shown) extending over the gate electrodes and stepping down between adjacent gate electrodes over the body and source regions is formed using known techniques. A thick layer of LTO (not shown) is then formed over the nitride layer. The LTO is then defined and etched to expose silicon surfaces between adjacent gate electrodes where deep trenches 2003 are to be formed. The LTO would cover the source regions 2018. A conventional silicon etch is then carried out to form deep trenches 2003.

[00119] Next, the trenches are filled with P-type silicon using conventional techniques. The LTO is removed using the conformal (e.g., nitride) layer as an etch stop. The conformal layer may then be removed or may be left intact and used as a self alignment spacer to space off a high energy P+ implant from the poly gate edges. Dielectric cap 2051 (e.g., comprising BPSG) covering gate electrodes 2014 is formed using conventional techniques. Dielectric cap 2051 forms contact openings between adjacent gate electrodes. A heavy body implant is carried out through the contact openings to form the P+ heavy body regions in body regions 2038 between adjacent

source regions 2018. The remaining process steps would be similar to those shown in Fig. 18L and thus will not be described. As can be seen, in this planar gate process, as in the trench gate process of Figs. 18A-18L, the P-pillars are formed late in the process after much of the thermal budget is used, thus minimizing out-diffusion of P-pillar dopants.

5 [00120] In the process technology where pillars are formed by etching trenches and filling them with silicon (rather than using the multi-epi process), varying the mesa width is undesirable as it results in non-uniform trench etch and filling. Therefore, center-to-center pillar spacing needs to be maintained constant to the extent possible. However, with a constant pillar spacing other provisions need to be made to obtain the desired surface electric field profile. Figs. 21 and
10 22 are cross section views showing exemplary embodiments where the desired surface electric profile is obtained using surface N regions and/or surface P regions.

[00121] Fig. 21 shows a cross section view along a portion of the die where the active region transitions into the termination region. The cross section view in Fig. 21 is similar to that shown in Fig. 19L except N- surface regions 2142 are formed along the top of those N-pillars 2102A
15 located between floating P-pillars 2140 in termination region 2105. N- surface regions 2142 advantageously serve to spread the surface electric field thus improving the break down voltage in the termination region. All other structural features in the Fig. 21 cross section view are similar to those in Fig. 19L and thus will not be described.

[00122] The process steps for forming N- surface regions 2142 can be incorporated in the
20 process sequence depicted by Figs. 19A-19L as follows. In Fig. 19A, prior to forming any of the regions along the top surface, N- surface region 2142 may be formed by growing a lightly doped N- epitaxial layer over N-epi 1902. The N- epitaxial layer 2142 would have a lower doping concentration than N-epi 1902. Alternatively, N- surface region 2142 may be formed by performing a blanket compensation P-implant into N-epi 1902 so that a top layer of N-epi 1902 is
25 converted to a lighter doped N- layer. The process sequence as depicted in Figs. 19A-19L would then be carried out to form the MOSFET.

[00123] In Fig. 21, the top regions of floating P-pillars 2140 in termination region 2105 together with their adjacent N- surface regions 2142 make an already P-rich condition along the pillar tops even more P-rich, thus potentially lowering the break down voltage in termination
30 region 2105. The surface regions of floating P-pillars 2140 can be compensated to improve the charge balance along the pillar tops. In one embodiment, after forming the P-pillars as depicted

by the process steps corresponding to Fig. 19I, and before the process steps corresponding to Fig. 19J (i.e., while the top surfaces of all P-pillars are exposed), a blanket compensation N implant is carried out to compensate the top regions of all P-pillars in the active and termination regions. Thus, the blanket compensation N implant into the top regions of all P-pillars ensures that the termination region has a higher break down voltage than the active region.

[00124] While Fig. 21 shows implementation of the N- surface regions in a trench gate MOSFET, the N- surface regions may also be incorporated in the planar gate variation. In the planar gate embodiment however, a JFET implant carried out only in the active region may be necessary to increase the doping concentration in the JFET regions which would otherwise be made up of the lightly doped N- surface region. The JFET implant enhances the transistor Rds-on which would otherwise be adversely impacted by the N- surface region. In the process described above in connection with the planar gate embodiment shown in Fig. 20, the JFET implant may be incorporated after forming the N- surface region but before forming the gate structure.

[00125] In the Fig. 22 embodiment, surface P-enrichment regions 2244 are formed along top surfaces of the P-pillars in termination region 2205. The active P-body regions 2218 may extend deeper than P-enrichment regions 2244, and may have a higher doping concentration than P-enrichment regions 2205. The doping and depth of P-enrichment regions 2244 as well as the doping and depth of N- surface regions 2242 may be designed to obtain a charge balance state resulting in a high breakdown voltage with a low peak electric field and substantially evenly distributed electric field across the termination region. In one embodiment, it is desirable to have the charge of P-enrichment regions 2244 higher than the charge of the N surface regions to minimize the peak surface electric field.

[00126] In any of the above embodiments, the P-pillars in both the active and termination regions may be equally spaced from one another so that all P-pillars have the same width.

[00127] Conductive field plates are used to spread the electric field more uniformly in the termination region. It is desirable to electrically connect the field plates to the underlying pillars so that they can assume the potential of their corresponding pillar. Fig. 23 shows a cross section view of a super-junction power device where field plates 2330 are electrically connected to their corresponding floating P-pillars 2304 through surface well regions (also referred to as "P rings") formed along tops of P-pillars 2304. These electrical connections are made by forming contacts between field plates 2330 and corresponding well regions through one or more dielectric layers

2332. However, as cell pitch is reduced, forming a contact between the field plates and their underlying pillars becomes more difficult. Fig. 24A is a top layout view of a corner region of a super-junction power device showing a technique for contacting field plates to the underlying pillars for small cell pitches. Fig. 24B is an expanded view of the corner the termination region of the top layout view in Fig. 24A.

[00128] In Fig. 24A, active region 2404 and termination region 2402 are delineated. The pillar configuration is similar to the parallel-concentric configuration shown in Fig. 1C. That is, the P-pillars in active region 2404 extend parallel to each other, while the P-pillars in termination region 2402 extend in a concentric fashion around the active region. As shown, contact structures 2406 for electrically connecting the field plates to the underlying floating P-pillars are advantageously located directly over the P-pillars where the P-pillars make a 90 degrees turn. Fig. 24B will be used to show and describe contact structures 2406 in more detail.

[00129] In Fig. 24B, P-pillars 2412 are spaced equally from one another in the active and termination regions. P-rings 2408 are formed along the tops of corresponding P-pillars, and extend in a concentric fashion around the active region similar to the floating P-pillars in which they are formed. In one embodiment, the width of P-rings 2408 gradually decreases in the direction away from the active region. Field plates 2410 (e.g., comprising polysilicon) extend over but are off-set relative to corresponding P-pillars and P-rings so that each of them extends partially over a corresponding P-pillar and partially over an adjacent mesa region (or N-pillar). Field plates 2410 surround the active region in a concentric fashion similar to P-rings 2408. While the P-rings are shown in Figs. 23, 24A and 24B to be centered about the corresponding P-pillars, the P-rings may be off-set to the right or the left relative to the corresponding P-pillar. The offset P-rings can be advantageously used to merge two adjacent P-pillars along the surface.

[00130] Contacts 2406 are formed directly above corresponding P-pillars 2412 in the corner regions where the P-pillars make a 90 degree turn. The corner regions provide additional space in which contacts 2406 can be formed. A conductive or semiconductive material 2414 (e.g., a metal) is used to make the connection between each P-pillar 2412 and the corresponding polysilicon field plate 2410 through contacts 2406.

[00131] In one embodiment, two or more P-rings 2408 physically touch thereby merging the corresponding P-pillars at the surface. This advantageously provides a larger surface area for forming the contacts. This technique is particularly useful in designs with tighter cell pitches

where forming one contact per P-pillar can be difficult. In another embodiment, the termination N-pillars located between the floating P-pillars include a lightly doped N- region along their tops similar to those shown in Figs. 21 and 22. In yet another embodiment, highly doped P+ regions are formed in the P-rings to ensure a more robust contact between the field plates and the
5 corresponding P-rings. The P+ regions may be formed at the same time the P+ heavy body regions are formed in the active area of device.

[00132] The technique described in connection with Figs. 23 and 24A, 24B may be used in the design of edge termination for any superjunction or non-superjunction power semiconductor device (e.g., MOSFET, IGBT, diode).

10 **[00133]** Figs. 25A-25D are cross section views showing various embodiments of superjunction high voltage merged PiN Schottky rectifiers. These figures show a portion of the die where the active region transitions to the termination region. In Fig. 25A, active region 2501 includes alternating P-N pillars 2530, 2532. P-pillars 2530 are trench-filled pillars, similar to various other embodiments described herein. P-wells 2538 extend along a top side of
15 corresponding P-pillars 2530. P-wells 2538 are wider than P-pillars 2530 and extend to a predetermined depth from the top silicon surface. A Schottky barrier metal 2571 together with an overlying metal layer 2572 (e.g., comprising aluminum) extend along the top surface of the top epitaxial layer. Schottky barrier metal 2571 and metal layer 2572 together form the anode terminal of the Schottky rectifier. As can be seen, the anode terminal contacts both the top
20 surface of N-pillars 2532 and the top surface of P-wells 2538. Where the anode terminal makes contact with N-pillars 2532, Schottky contacts are formed.

[00134] During operation, the alternating P-N pillar structure keeps the high electric field away from the Schottky surface area, thus reducing the reverse leakage. Additionally, the P-N pillars can support high voltages thus allowing use of low resistivity N pillars (where the current
25 flows), thereby reducing the series resistance component of the diode forward voltage. Moreover, P-wells 2538 serve to pinch off the active N-pillars near the surface at a lower voltage, which helps to further reduce the reverse leakage current. Thus, a high voltage Schottky rectifier with low forward voltage and low reverse leakage is obtained.

[00135] In one embodiment, the active and transition P-N pillars may be stripe-shaped with
30 termination P-N pillars surrounding the active and transition regions in a concentric fashion similar to the layout configuration shown in Fig. 1C. In yet another embodiment, the active,

transition, and termination P-N pillars may be concentric similar to the layout configuration shown in Fig. 1A. In the latter layout configuration, the gate feed issues associated with MOSFETs is not present since there are no gate structures in the Schottky rectifier.

[00136] Fig. 25B shows a variation of the Fig. 25A embodiment in which P+ contact regions 5 2506 are formed in P-wells 2538. The anode terminal forms an ohmic contact with P-wells 2538 through P+ contact regions 2506. This allows the diode to operate at high current density with lower conduction voltage due to the parallel conduction of the PN diode when the forward voltage exceeds the built in potential.

[00137] Fig. 25C shows a variation of the Fig. 25B embodiment where P-wells 2538 are not 10 included, but P+ contact regions 2506 are included so that the anode terminal makes ohmic contact with P-pillars 2530 along their tops through the P+ contact regions 2538. This variant trades off lower forward voltage for increased leakage resulting from the higher electric field at the barrier.

[00138] Fig. 25D shows a variation of the Fig. 25A embodiment where P-wells 2538A have 15 approximately the same width as the P-pillars in which they are formed. With the width of P-well regions reduced as compared to the Fig. 25A embodiment, the mesa width (N-pillar width) near the surface is increased thus lowering the forward voltage of the Schottky rectifier.

[00139] The MOSFET process described above can be modified in simple ways to form the Schottky rectifiers in Figs. 25A-25D. For example, the Fig. 25A embodiment may be obtained by 20 eliminating the source implant from the MOSFET process. The P+ regions in Figs. 25B and 25C correspond to the heavy body region of the MOSFET. Because of the compatibility between the processes for the MOSFET and the Schottky rectifier, MOSFET (e.g., Fig. 3) and Schottky rectifier (e.g., Fig. 25A) can be easily integrated in a single die to thereby obtain a SynchFET.

[00140] Figs. 26A and 26B are cross section views showing two additional embodiments of 25 super-junction high voltage Schottky rectifier. In Fig. 26A, after trench-filled P-pillars 2630 are formed, an N-type epitaxial layer 2682 is formed over the P-N pillar structure, after which the anode terminal comprising Schottky barrier metal 2671 and an overlying metal layer 2672 (e.g., comprising aluminum) is formed over and directly contacts N-type epitaxial layer 2682. In this embodiment, P-pillars 2630 are not connected to the anode terminal and thus float. This 30 embodiment advantageously lowers the forward voltage of the Schottky rectifier by increasing the Schottky contact area, and reduces leakage current by using the floating pillars to deplete the

active N-pillars at a low voltage.

[00141] Fig. 26B shows a variation of the Fig. 26A embodiment where instead of N-epi layer 2682, an N-implant is carried to thereby form N-implant region 2684 along the top surface of the P-N pillars. As shown, the anode terminal comprising Schottky barrier metal 2671 and an
5 overlying metal layer 2672 (e.g., comprising aluminum) directly contacts N-implant region 2684.

[00142] In Figs. 25A-25D and 26A-26B, while the P pillars are shown as being of the trench filled variety, the pillars can have a lower portion that is made up of multiple bubble-shaped P-regions, and an upper portion that is trench filled, similar to P-pillars 3xx shown in Fig. 3.

Furthermore, the transition region 2504, 2604 and termination regions 2502, 2602 in Figs. 25A-
10 25D and 26A-26B are similar to the corresponding regions in Fig. 3, and thus will not be described. The same advantages obtained in integrating these regions with the active region of the MOSFET in Fig. 3 are realized with the Schottky structure of Figs. 25A-25D and 26A-26B.

[00143] A challenge in filling trenches having a high aspect ratio is avoiding formation of
15 voids in the trench or preventing premature epi closure along the top of the trench due to localized growth near the top corners of the trench. In superjunction layout configurations where trench sidewalls have different plane directions, filling trenches with epi becomes even more difficult because the epi filling process is sensitive to silicon crystal plane direction. For example, the rate at which epitaxial silicon grows along the $\langle 100 \rangle$ plane direction is different than the rate at which epitaxial silicon grows along the $\langle 110 \rangle$ plane direction. This is more clearly illustrated in Figs.
20 27A and 27B. Fig. 27A shows a top view of a die layout diagram, and Fig. 27B shows a top view of a wafer where the wafer flat extends parallel to the laterally extending pillars in Fig. 27A.

[00144] Fig. 27A shows a full concentric octagon layout configuration. That is, P-pillars 2710 and N-pillars 2706 in both active region 2712 and termination region 2714 are concentric octagons. P-pillars 2710 are formed in trenches using techniques disclosed herein. While the
25 sidewalls of vertically and horizontally extending trenches have the same plane direction, namely, $\langle 110 \rangle$, the diagonally extending trenches have the $\langle 100 \rangle$ plane (this assumes that the die shown in Fig. 27A is positioned on the wafer so that the horizontally extending trenches run parallel to the wafer flat, as depicted in Figs. 27A and 27B). This variation in plane direction will result in non-uniform filling of the trenches.

[00145] In accordance with one embodiment, the non-uniform epi filling due to variations in
30 plane direction can be eliminated by rotating the wafer 22.5 degrees. This is illustrated in Fig. 28.

As can be seen, by rotating the wafer and thus the dies on the wafer during photolithography processing, the dies can all be oriented so that all trench sidewalls line up along the $\langle \tan 22.5^\circ \rangle_{10}$ plane direction. In Fig. 28, similar to Fig. 27A, P-pillars 2810 and N-pillars 2806 in both active region 2812 and termination region 2814 are concentric octagons, and P-pillars 2810 are formed in trenches using techniques disclosed herein. Alternatively, N-pillars 2806 may be formed in trenches using techniques disclosed herein. In one embodiment, the wafer is maintained in the 22.5 degree rotated position throughout the process sequence. The structural details of the power device (e.g., MOSFET, IGBT or rectifier) housed in the die shown in Fig. 28 are not shown, but such details can be found in other embodiments disclosed herein.

[00146] In the Fig. 1C layout design where the striped active P-pillars are surrounded by termination P-pillars, the sharp corners of the concentric rectangular or square shaped termination pillars are difficult to etch and fill and may result in formation of voids in the epi fill. Such voids can cause charge imbalance resulting in localized breakdown voltage. These voids can also result in areas in the termination region having high electric field stress that become a source of electron injection into the oxide and a magnet for positive charges, resulting in reliability failures.

[00147] Fig. 29 is a top layout view of a corner of a super-junction power MOSFET with striped active P-pillars 2904 surrounded by concentric termination P-pillars 2904. In this layout design the sharp corners of the concentric termination P-pillars in Fig. 1C are eliminated by forming octagon shaped termination P-pillars. By eliminating the sharp corners, the concentric termination trenches can be filled without formation of voids in the fill material. As can be seen, the corner edges of the octagon shaped termination P-pillars gradually increase in length in the direction away from the active region. Also, as compared to the fully concentric octagon design with equal length legs, the Fig. 29 layout configuration provides better packing and thus a more efficient use of silicon.

[00148] In Fig. 29, gap region 2908 is formed between an end of active P-pillars 2904 and the first concentric P-pillar in termination region 2910. Two full floating mesa regions (or N-pillars) 2914 are inserted to provide isolation between gap 2708 and corner areas and termination 2910. These features reduce the sensitivity to breakdown voltage due to charge imbalance in this area. In one embodiment, the trench fill process described in connection with the Fig. 28 embodiment is used to further eliminate the possibility of void formation due to non-uniform epi filling caused by differing plane directions along the termination trench sidewalls. That is, prior to filling the

trenches, the wafer is rotated 22.5 degrees so that all trench sidewalls line up along the $\langle \tan 22.5 \rangle_{10}$ plane direction. In one embodiment, the wafer is maintained in the 22.5 degree rotated position (relative to wafer flat) throughout the process sequence. The structural details of the power device (e.g., MOSFET, IGBT or rectifier) housed in the die shown in Fig. 28 are not shown, but such details can be found in other embodiments disclosed herein

[00149] Fig. 30 is a top view of a fully concentric layout design where a supplementary metal gate runner 3002 is bussed through a center portion of the die to provide metal connection to all the concentric polysilicon gates 3008. A cross section view along line A-A' is also included in Fig. 30. Metal gate runner 3004 extends around the perimeter of the die and connects to a gate pad (not shown), and to supplementary metal gate runner 3002. P-pillars 3010, N-pillars 3006 and planar polysilicon gates 3008 all extend in a concentric fashion in active region 3012 and termination region 3014.

[00150] Supplementary metal gate runner 3002 extends far enough inside the die to contact the inner most concentric polysilicon gate. A drawback of this gate runner design is that it does not provide a balanced gate propagation delay. As can be seen, the inner most concentric polysilicon gates travel a shorter distance before contacting supplementary metal gate runner 3002 than do the outer most concentric polysilicon gates. The inner concentric polysilicon gates thus exhibit a lower propagation delay than the outer concentric polysilicon gates. This imbalance in propagation delays makes it difficult to obtain good switching speeds without dynamic failure of the device.

[00151] Fig. 31A shows a top layout view of a fully concentric design with a gate runner design that provides a more balanced gate propagation delay throughout the die. While Fig. 31A does not show the concentric P and N pillars and the concentric polysilicon gates, these regions of the die in Fig. 31A are similar to those in Fig. 30. Outer metal gate bus 3114 extends around the outer perimeter of the die and contacts gate pad 3116. Four supplementary metal gate runners 3118A, 3118B, 3118C and 3118D extend from outer metal gate bus 3114 toward the center of the die, but terminate before reaching the die center. In this design, while a number of the outer concentric polysilicon gates directly tie into the four supplementary metal gate runners, a number of the inner-most concentric polysilicon gates are not directly connected to all of the supplementary metal gate runners. This can be seen more clearly in Fig. 31B which is an expanded view of an inner portion of the top view in Fig. 31A.

[00152] In Fig. 31B, the concentric poly gates 3108 as well as the end portions of supplementary metal gate runners 3118A and 3118B in the active region can be seen. Concentric polysilicon gates 3108 encircle a center portion of the die through which polysilicon feed 3120 extends. Polysilicon feed 3120 extends laterally to make electrical contact with supplementary metal gate runner 3118A to the left of the die center, and to supplementary metal gate runner 3118C (not shown in Fig. 31B) to the right of the die center. As can be seen, none of the supplementary metal gate runners extend all the way to the center of the die. Instead, the lengths to which these four supplementary metal gate runners extend are carefully selected in order to obtain a more balanced gate propagation delay among the concentric poly gates 3108. As a result, a number of the inner-most concentric polysilicon gates do not directly tie into all of the supplementary metal gate runners.

[00153] Fig. 31C is an expanded view of the upper right quadrant of the die shown in Fig. 31A. Fig. 31C will be used to illustrate how the particular lengths selected for the supplementary metal gate runners for this embodiment result in a more balanced propagation delay through the concentric poly gates. Two measurements are shown. The inner measurement, marked by reference numeral 3122, measures one half the length of a concentric gate poly that extends between two supplementary metal gate runner 3118C to just below the bottom end of supplementary metal gate runner 3118B (i.e., does not tie into gate runner 3118B), ties into supplementary metal gate runner 3118A (not shown in Fig. 31C), and circles back around to tie into metal gate runner 3118C. That is, the measured concentric gate poly ties into gate runners 3118A and 3118C, but not 3118B and 3118D. On the other hand, the outer measurement, marked by reference numeral 3124, measures a length of the outermost concentric gate poly connected between two supplementary gate runners as it circles around the die. The measurements illustrate that the portion of the measured inner poly gate that extends between supplementary gate runner 3118C and 3118A (i.e., the closest two gate runner to which it is directly connected) is substantially equal to the portion of the measured outer poly gate that extends between supplementary gate runners 3118B and 3118C (i.e., the closest two gate runners to which it is directly connected). Also, those concentric poly gates closer to the center of the die that do not contact any of the four supplementary metal gate runners have short enough length that the propagation delay through them would not be very different from the outer concentric poly gates that are tied to two or all four of the supplementary gate runners.

[00154] As can be seen, while this technique does not obtain perfectly equal propagations delays through all concentric poly gates, it significantly improves the imbalance in the gate poly propagation delay that is present in the Fig. 30 gate runner design. As Fig. 31A illustrates, while supplementary metal gate runners 3118A, 3118B, 3118C, 3118D extend into the middle of the die, ample surface area remains for bonding to the source metal. The technique illustrated in Figs. 31A-31C can be implemented in the planar gate variation or the trench gate variation.

[00155] Fig. 32 shows a top layout view of a fully concentric pillar design with stripe polysilicon gates. Metal gate runner 3204 extends around the perimeter of the die and connects to a gate pad (not shown). P-pillars 3210 and N-pillars 3206 extend in a concentric fashion in active region 3212 and in termination region 3214. Polysilicon gates 3208 (which can be of the planar gate or trench gate varieties) are stripe shaped and extend through both active and termination regions, and contact metal gate runner 3204 along their opposite ends.

[00156] This configuration advantageously eliminates the need for the supplementary gate runner(s) that is needed in the concentric gate poly design, thus resulting in area savings. While some channel area is lost where gate poly stripes 3208 cross over P-pillars 3210, the impact on R_{ds-on} due to channel resistance increase is small in high voltage devices.

[00157] In one general aspect, a power device can include a semiconductor region including a plurality of alternately arranged pillars of first and second conductivity type where each of the plurality of pillars of second conductivity type can include a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant regions of second conductivity type.

[00158] In some embodiments, a stack of a plurality of epitaxial layers of the first conductivity type over a substrate where each of the plurality of implant regions of second conductivity type extend into two adjacent ones of the plurality of epitaxial layers. In some embodiments, the trench portion of the plurality of pillars of second conductivity type extends into and terminates within the upper-most one of the plurality of epitaxial layers.

[00159] In some embodiments, the plurality of pillars of second conductivity type terminate prior to reaching the substrate, and the plurality of epitaxial layers have a lower doping concentration than the substrate. In some embodiments, the plurality of implant regions of second conductivity type and the semiconductor material filling the trench portion of the plurality

of pillars of second conductivity type have the same doping concentration. In some embodiments, at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type has a different doping concentration than the remaining ones of the plurality of implant regions of second conductivity type.

5 [00160] In some embodiments, at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type has a different shape than the remaining ones of the plurality of implant regions of second conductivity type. In some embodiments, adjacent ones of the plurality of implant regions of second conductivity type in each of the plurality of pillars of second conductivity type directly contact each other. In some
10 embodiments, the plurality of implant regions of the second conductivity type in each of the plurality of pillars of second conductivity type are spaced apart from one another. In some embodiments, the plurality of pillars of first conductivity type comprise a plurality of implant regions of the first conductivity type arranged on top of one another along the depth of pillars of first conductivity type.

15 [00161] In some embodiments, at least one of the plurality of implant regions of first conductivity type in the plurality of pillars of first conductivity type has a different shape than the remaining ones of the plurality of implant regions of first conductivity type.

[00162] In some embodiments, the power device also includes body regions of the second conductivity type extending in the semiconductor region and forming part of the pillars of second
20 conductivity type, source regions of the first conductivity type extending in the body regions, and gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlap corresponding source regions

[00163] In another general aspect, a power device can include an active region and a termination region surrounding the active region, and a plurality of pillars of first and second
25 conductivity type alternately arranged in each of the active and termination regions where each of the plurality of pillars of second conductivity type in the active and termination regions include a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of the pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant
30 regions of second conductivity type.

[00164] In some embodiments, the power device also includes a stack of a plurality of

epitaxial layers of the first conductivity type over a substrate where each of the plurality of implant regions of second conductivity type in the active and termination regions extending into two adjacent ones of the plurality of epitaxial layers. In some embodiments, the trench portion of the plurality of pillars of second conductivity type in the active and termination regions extends
5 into and terminates within the upper-most one of the plurality of epitaxial layers.

[00165] In some embodiments, at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the active region have a different shape than at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the termination region. In some
10 embodiments, at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the active region are laterally wider than at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the termination region.

[00166] In some embodiments, the plurality of pillars of first conductivity type in the active
15 region have fewer number of implant regions of first conductivity type than do the plurality of pillars of first conductivity type in the termination region. In some embodiments, the plurality of pillars of first conductivity type in the active and termination regions comprise a plurality of implant regions of the first conductivity type arranged on top of one another along the depth of pillars of first conductivity type.

[00167] In some embodiments, at least one of the plurality of implant regions of first
20 conductivity type in the plurality of pillars of first conductivity type in the active region has a different shape than at least one of the plurality of implant regions of first conductivity type in the plurality of pillars of first conductivity type in the termination region. In some embodiments, the plurality of pillars of first conductivity type in the active region have fewer number of implant
25 regions of first conductivity type than do the plurality of pillars of first conductivity type in the termination region.

[00168] In another general aspect, a method for forming pillars of alternating conductivity type in a power device can include forming a plurality of epitaxial layers of a first conductivity type over a substrate, and forming a plurality of implant regions of a second conductivity type in
30 each of a predetermined number of the plurality of epitaxial layers. The method can include forming trenches extending into the upper-most one of the plurality of epitaxial layers, and filling

the trenches with semiconductor material of the second conductivity type. The plurality of implant regions of second conductivity type in the predetermined number of the plurality of epitaxial layers are vertically aligned with corresponding ones of the trenches so that the semiconductor material filling the trenches together with the plurality of implant regions of second conductivity type in the predetermined number of the plurality of epitaxial layers form a plurality of pillars of second conductivity type, and those portions of the plurality of epitaxial layers separating the plurality of pillars of second conductivity type from one another form a plurality of pillars of first conductivity type.

[00169] In some embodiments, each of the plurality of implant regions of second conductivity type extends into two adjacent ones of the predetermined number of the plurality of epitaxial layers due to processing heat cycles. In some embodiments, the power device includes an active region and a termination region surrounding the active region, and the plurality of pillars of first and second conductivity type are formed in both the active and termination regions and at least one of the epitaxial layers containing the plurality of implants is of second conductivity type

[00170] In some embodiments, at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the active region have a different shape than at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the termination region. In some embodiments, the at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the active region are laterally wider than at least one of the plurality of implant regions of second conductivity type in the plurality of pillars of second conductivity type in the termination region

[00171] In some embodiments, the plurality of pillars of first conductivity type in the active region have fewer number of implant regions of first conductivity type than do the plurality of pillars of first conductivity type in the termination region. In some embodiments, the plurality of pillars of first conductivity type in the active and termination regions comprise a plurality of implant regions of the first conductivity type arranged on top of one another along the depth of pillars of first conductivity type

[00172] In some embodiments, at least one of the plurality of implant regions of first conductivity type in the plurality of pillars of first conductivity type in the active region has a different shape than at least one of the plurality of implant regions of first conductivity type in the

plurality of pillars of first conductivity type in the termination region. In some embodiments, the plurality of pillars of first conductivity type in the active region have fewer number of implant regions of first conductivity type than do the plurality of pillars of first conductivity type in the termination region.

5 **[00173]** In another general aspect, a method for forming pillars of alternating conductivity type in a power device can include forming a first epitaxial layer of a first conductivity type over a substrate, and forming a lower portion of a plurality of deep trenches in the first epitaxial layer. The method can also include filling the lower portion of the plurality of deep trenches with semiconductor material of a second conductivity type, forming a second epitaxial layer of first
10 conductivity type over the first epitaxial layer, and forming an upper portion of the plurality of deep trenches in the second epitaxial layer directly over the lower portion of the plurality of deep trenches so that each lower portion and a corresponding upper portion of the plurality of deep trenches together form one of the plurality of deep trenches. The method can also include filling the upper portion of the plurality of deep trenches with semiconductor material of second
15 conductivity type where the semiconductor material filling the lower and upper portions of the plurality of deep trenches form a plurality of pillars of second conductivity type, and those portions of the first and second epitaxial layers separating the plurality of pillars of second conductivity type from one another form a plurality of pillars of first conductivity type.

[00174] In some embodiments, the semiconductor material filling the lower portion of the
20 plurality of deep trenches has a different doping concentration than the semiconductor material filling the upper portion of the plurality of deep trenches. In some embodiments, the semiconductor material filling the lower portion of the plurality of deep trenches has a different doping profile than the semiconductor material filling the upper portion of the plurality of deep trenches.

25 **[00175]** In some embodiments, the first and second epitaxial layers have the same doping profile. In some embodiments, the first and second epitaxial layers have different doping profiles. In some embodiments, the first and second epitaxial layers have different thicknesses. In some embodiments, the method can include prior to forming the second epitaxial layer, planarizing the surface of the first epitaxial layer and the surface of the semiconductor material filling the lower
30 portion of the plurality of deep trenches.

[00176] In some embodiments, the method can include after forming the second epitaxial

layer, planarizing the surface of the second epitaxial layer and the surface of the semiconductor material filling the upper portion of the plurality of deep trenches. In some embodiments, the lower portion of the plurality of deep trenches terminates within the first epitaxial layer prior to reaching the substrate. In some embodiments, the method can include forming body regions of second conductivity type in the second epitaxial layer where the body regions forming part of the plurality of pillars of second conductivity type, forming source regions of the first conductivity type in the body regions, and forming gate electrodes extending adjacent to but being insulated from the body regions, the gate electrodes overlapping corresponding source regions.

[00177] In another general aspect, a method for forming a power field effect transistor can include forming an N-type epitaxial layer over a substrate, forming one or more P-type epitaxial layers over the N-type epitaxial layer, and forming a plurality of trenches extending through the one or more P-type epitaxial layers. The method can also include filling the plurality of trenches with N-type semiconductor material, forming P-type body regions in the one or more P-type epitaxial layers, and forming N-type source regions in the P-type body regions. The method can also include forming gate electrodes adjacent to but insulated from the P-type body regions and the N-type semiconductor material, the gate electrodes overlapping with the N-type source regions where the plurality of trenches filled with N-type semiconductor material form N-pillars, and those portions of the one or more P-type epitaxial layers separating the N-pillars form P-pillars.

[00178] In some embodiments, the method can also include prior to filling the plurality of trenches, implanting N-type dopants along the bottom of the plurality of trenches. In some embodiments, the method can include prior to forming the P-type epitaxial layer, implanting N-type dopants to form N-enrichment regions in an upper portion of the N-type epitaxial layer where the plurality of trenches are formed in the P-type epitaxial layer directly over corresponding ones of N-enrichment regions such that during one or more temperature cycles, and the N-type enrichment regions up-diffuse into the N-type semiconductor material filling the plurality of trenches and down-diffuse into the N-type epitaxial layer.

[00179] In some embodiments, the N-enrichment regions create a N-rich imbalance condition along the bottom of the N and P-pillars. In some embodiments, the power device includes an active region and a termination region surrounding the active region, and each of the active and termination regions including a plurality of alternating N and P-pillars where the N-enrichment

regions are formed along the bottom of the N-pillars in both the active and termination regions.

[00180] In some embodiments, the power device includes an active region and a termination region surrounding the active region, and each of the active and termination regions including a plurality of alternating N and P-pillars where the N-enrichment regions are formed along the bottom of the N-pillars in the active region only. In some embodiments, the plurality of trenches have tapered sidewalls so that the plurality of trenches are wider along the top of the plurality of trenches than along their bottom. In some embodiments, the gate electrodes laterally extend directly over the plurality of trenches.

[00181] In another general aspect, a power field effect transistor (FET) can include an N-type epitaxial layer over a substrate, one or more P-type epitaxial layers over the N-type epitaxial layer, and a plurality of trenches extending through the one or more P-type epitaxial layers where the plurality of trenches are filled with N-type semiconductor material. The power FET CAN INCLUDE P-type body regions in the one or more P-type epitaxial layers, N-type source regions in the P-type body regions, and gate electrodes adjacent to but insulated from the P-type body regions and the N-type semiconductor material, the gate electrodes overlapping with the N-type source regions where the plurality of trenches filled with N-type semiconductor material form N-pillars, and those portions of the one or more P-type epitaxial layers separating the N-pillars form P-pillars.

[00182] In some embodiments, power FET can include N-enrichment regions at the bottom of the N-pillars, the N-enrichment regions extending into the N-type semiconductor material filling the plurality of trenches and into the N-type epitaxial layer. In some embodiments, the N-enrichment regions create a N-rich imbalance condition along the bottom of the N and P-pillars. In some embodiments, the power FET includes an active region and a termination region surrounding the active region, each of the active and termination regions including a plurality of alternating N and P-pillars, wherein the N-enrichment regions are formed along the bottom of the N-pillars in both the active and termination regions.

[00183] In some embodiments, the power device includes an active region and a termination region surrounding the active region, each of the active and termination regions including a plurality of alternating N and P-pillars, wherein the N-enrichment regions are formed along the bottom of the N-pillars in the active region only. In some embodiments, the plurality of trenches have tapered sidewalls so that the plurality of trenches are wider along the top of the plurality of

trenches than along their bottom. In some embodiments, the gate electrodes laterally extend directly over the plurality of trenches.

[00184] In another general aspect, a method for forming a power field effect transistor can include forming one or more epitaxial layers of a first conductivity type over a substrate, forming
5 a plurality of lower trenches extending through the one or more epitaxial layers, and filling the plurality of lower trenches with semiconductor material of a second conductivity type. The method can also include forming one or more epitaxial layers of the second conductivity type over the one or more epitaxial layers of first conductivity type, forming a plurality of upper
10 trenches extending through the one or more epitaxial layers of the second conductivity type, and filling the plurality of upper trenches with semiconductor material of the second conductivity type where the plurality of lower trenches and the plurality of upper trenches are off-set from one another along the lateral dimension.

[00185] In some embodiments, the semiconductor material of the second conductivity type in the plurality of upper trenches together with underlying portions of the one or more epitaxial
15 layers of the second conductivity type form pillars of the second conductivity type, and the semiconductor material of the first conductivity type in the plurality of lower trenches together with overlying portions of the one or more epitaxial layers of the first conductivity type form pillars of the first conductivity type, so that the pillars of first and second conductivity type form
pillars of alternating conductivity type. In some embodiments, the method can include prior to
20 forming the one or more epitaxial layers of the first conductivity type, forming a first epitaxial layer of the second conductivity type over the substrate.

[00186] In some embodiments, the method can include forming enrichment regions of the second conductivity type along the bottom of the plurality of lower trenches, where the
enrichment regions of the second conductivity type extending into the semiconductor material of
25 the second conductivity type and further extending into the first epitaxial layer of the second conductivity type.

[00187] In some embodiments, the step of forming the enrichment regions can include prior to forming the one or more epitaxial layers of the first conductivity type, implanting dopants of the second conductivity type to form enrichment regions of the second conductivity type in an upper
30 portion of the a first epitaxial layer of the second conductivity type where the plurality of lower trenches are formed in the one or more epitaxial layers of a first conductivity type directly over

corresponding ones of enrichment regions of the second conductivity type such that during one or more temperature cycles, the enrichment regions of the second conductivity type up-diffuse into the semiconductor material of the second conductivity type and down-diffuse into the first epitaxial layer of the second conductivity type.

5 [00188] In some embodiments, the enrichment regions of the second conductivity type create a charge imbalance condition along the bottom of the pillars of alternating conductivity type. In some embodiments, the step of forming the enrichment regions can include prior to filling the plurality of lower trenches, implanting dopants of the second conductivity type along the bottom of the plurality of lower trenches into the first epitaxial layer of the second conductivity type.

10 [00189] In some embodiments, the field effect transistor includes an active region and a termination region surrounding the active region. Each of the active and termination regions includes alternating pillars of first and second conductivity type where the enrichment regions are formed along the bottom of the pillars of the second conductivity type in both the active and termination regions. In some embodiments, the field effect transistor includes an active region
15 and a termination region surrounding the active region. Each of the active and termination regions includes a plurality of alternating pillars of first and second conductivity type where the enrichment regions are formed along the bottom of the pillars the second conductivity type in the active region only.

[00190] In some embodiments, the plurality of lower and upper trenches have tapered
20 sidewalls so that each of the plurality of lower and upper trenches is wider along its top than along its bottom. In some embodiments, the method can also include forming body regions of the first conductivity type in the one or more epitaxial layers of the first conductivity type, forming source regions of the second conductivity type in the body regions, and forming gate electrodes adjacent to but insulated from the body regions, the gate electrodes overlapping with the source
25 regions.

[00191] In another general aspect a power field effect transistor (FET) can include a semiconductor region including a plurality of alternately arranged pillars of first and second conductivity type where each of the pillars of the first conductivity type has a middle section that is wider than its upper and lower sections, and each of the pillars of the second conductivity type
30 has a middle section that is narrower than its upper and lower sections. In some embodiments, each of the pillars of the first conductivity type includes a lower section that is trench filled, and

each of the pillars of the second conductivity type includes an upper section that is trench filled.

[00192] In some embodiments, the power FET can include an N-type epitaxial layer over a substrate, one or more P-type epitaxial layers over the N-type epitaxial layer, and a plurality of trenches extending through the one or more P-type epitaxial layers where the plurality of trenches are filled with N-type semiconductor material. Power FET can include one or more N-type epitaxial layers over the one or more P-type epitaxial layers, and a plurality of trenches extending through the one or more N-type epitaxial layers where the plurality of trenches are filled with P-type semiconductor material. The P-type semiconductor material together with portions of the one or more P-type epitaxial layers form the pillars of the second conductivity type, and the N-type semiconductor material together with portions of the one or more N-type epitaxial layers form the pillars of the first conductivity type.

[00193] In some embodiments, power FET can include P-type body regions extending into the P-type semiconductor material, N-type source regions in the P-type body regions, and gate electrodes adjacent to but insulated from the P-type body regions where the gate electrodes overlapping with the N-type source regions.

[00194] In some embodiments, further comprising enrichment regions of the first conductivity type at the bottom of the pillars of the first conductivity type. In some embodiments, the power device includes an active region and a termination region surrounding the active region, each of the active and termination regions including a plurality of alternating pillars of first and second conductivity type, wherein the enrichment regions are formed along the bottom of the pillars of the first conductivity type in both the active and termination regions. In some embodiments, the power device includes an active region and a termination region surrounding the active region. Each of the active and termination regions includes a plurality of alternating pillars of first and second conductivity type where the enrichment regions are formed along the bottom of the pillars of the first conductivity type in the active region only.

[00195] In another general aspect, a method for forming a super-junction structure in a power device can include forming one or more epitaxial layers of a first conductivity type over a substrate, forming a plurality of trenches extending in the one or more epitaxial layers, and lining the sidewalls and bottom of the trenches with a an epitaxial layer of a second conductivity type. The method can include forming a dielectric layer in the plurality of trenches over the epitaxial layer of second conductivity type, and filling the plurality of trenches with conformal material.

[00196] In some embodiments, the dielectric layer is in direct contact with the epitaxial layer of second conductivity type. In some embodiments, the conformal material is in direct contact with the dielectric layer. In some embodiments, the conformal material comprises polysilicon. In some embodiments, the conformal material comprises amorphous silicon. In some embodiments, the dielectric layer comprises oxide. In some embodiments, the method can include forming body regions of second conductivity type in the one or more epitaxial layers, and forming source regions of the first conductivity type in the body regions. The method can also include forming gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlapping corresponding source regions, and forming a source metal directly contacting the source regions. In some embodiments, the source metal directly contacts the conformal material.

[00197] In another general aspect a method for forming a super-junction structure in a power device can include forming one or more epitaxial layers of a first conductivity type over a substrate, forming a plurality of trenches extending in the one or more epitaxial layers, and filling each trench with an epitaxial layer of a second conductivity type such that only a center portion of each trench along the top of the trench remains unfilled. The method can also include filling the center portion of each trench along the top of the trench with a dielectric material.

[00198] In some embodiments, the dielectric material comprises thermal oxide. In some embodiments, the method can also include forming body regions of the second conductivity type in the one or more epitaxial layers, and forming source regions of the first conductivity type in the body regions. The method can also include forming gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlapping corresponding source regions, and forming a source metal directly contacting the source regions.

[00199] In another general aspect, a method for forming a super-junction structure in a power device can include forming one or more epitaxial layers of a first conductivity type over a substrate, and forming a plurality of trenches extending in the one or more epitaxial layers. The method can include lining sidewalls and bottom of the plurality of trenches with a first epitaxial layer of a second conductivity type, filling each trench with a second epitaxial layer of the second conductivity type such that only a center portion of each trench along the top of the trench remains unfilled, and filling the center portion of each trench along the top of the trench with a dielectric material.

[00200] In some embodiments, the dielectric material comprises thermal oxide. In some embodiments, the second epitaxial layer has a lower doping concentration than the first epitaxial layer. In some embodiments the method can include forming body regions of the second conductivity type in the one or more epitaxial layers, and forming source regions of the first conductivity type in the body regions. The method can also include forming gate electrodes extending adjacent to but being insulated from the body regions, the gate electrodes overlapping corresponding source regions, and forming a source metal directly contacting the source regions.

[00201] In another general aspect, a power device can include a plurality of trenches extending in one or more epitaxial layers of a first conductivity type. The plurality of trenches can be filled with a first epitaxial layer of a second conductivity type, a second epitaxial layer of the second conductivity type, and a layer of insulating material where the first epitaxial layer lines the trench sidewalls and bottom. The second epitaxial layer can extend over and be in direct contact with the first epitaxial layer, and the layer of insulating material can extend over and be in direct contact with the second epitaxial layer. The first epitaxial layer, the second epitaxial layer, and the third layer of insulating material in each trench can form a pillar of second conductivity type, and those portions of the one or more epitaxial layers can separate the pillars of second conductivity type forming pillars of first conductivity type such that the pillars of first and second conductivity type form pillars of alternating conductivity type.

[00202] In some embodiments, the layer of dielectric material comprises thermal oxide. In some embodiments, the second epitaxial layer has a lower doping concentration than the first epitaxial layer. In some embodiments, forming a power device can include forming body regions of the second conductivity type in the one or more epitaxial layers, forming source regions of the first conductivity type in the body regions. Forming the power device can also include forming gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlapping corresponding source regions, and forming a source metal directly contacting the source regions.

[00203] In another general aspect, a power device can include at least first and second N-type epitaxial layers extending over a substrate, and a plurality of trenches extending in the second N-type epitaxial layer. The plurality of trenches can be filled with a first epitaxial layer, a second P-type epitaxial layer, and a third layer of conductive material. The first epitaxial layer can line the trench sidewalls and bottom. The second P-type epitaxial layer can extend over and be in direct

contact with the first epitaxial layer, and the third layer of conductive material can extend over and be in direct contact with the second P-type epitaxial layer. The first epitaxial layer, the second P-type epitaxial layer, and the third layer of conductivity type in each trench forming a P-pillar, and those portions of the at least first and second N-type epitaxial layers can separate the P-pillars forming N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

[00204] In some embodiments, the second P-type epitaxial layer has a higher doping concentration than the first epitaxial layer, and the third layer of conductive material has a higher doping concentration than the second P-type epitaxial layer. In some embodiments, the first epitaxial layer is N-type and has a lower doping concentration than the second P-type epitaxial layer. In some embodiments, the first epitaxial layer comprises intrinsic silicon. In some embodiments, the third layer of conductive material is N-type and has a lower doping than the second P-type epitaxial layer. In some embodiments, the third layer of conductive material comprises an intrinsic epitaxial layer. In some embodiments, the third layer of conductive material comprises polysilicon. In some embodiments, the power device can include a P-enrichment region at the bottom of each P-pillar.

[00205] In some embodiments, each N-pillar has an upper N-region, a middle N region and a lower N region, the upper N region having a lower doping concentration than the middle N region, and the middle N region having a lower doping concentration than the lower N region. In some embodiments, the power device can include P-type body regions in the second N-type epitaxial layer, and source regions of the first conductivity type in the body regions. The power device can include gate electrodes extending adjacent to but being insulated from the body regions, the gate electrodes overlapping corresponding source regions, and a source metal directly contacting the source regions. In some embodiments, the source metal directly contacts the third layer of conductive material.

[00206] In another general aspect, a method for forming pillars of alternating conductivity type in a power device can include forming at least first and second N-type epitaxial layers over a substrate, and forming a plurality of trenches extending in the second epitaxial layer. The method can also include filling the plurality of trenches with a first epitaxial layer, second P-type epitaxial layer, and a third layer of conductive material. The first epitaxial layer can line the trench sidewalls and bottom, and the second P-type epitaxial layer can extend over and be in direct

contact with the first epitaxial layer. The third layer of conductive material can extend over and be in direct contact with the second P-type epitaxial layer. The first epitaxial layer, the second P-type epitaxial layer and the third layer of conductive material in each trench can form a P-pillar. Those portions of the at least first and second N-type epitaxial layers separating the P-pillars can
5 form N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

[00207] In some embodiments, the second P-type epitaxial layer has a higher doping concentration than the first epitaxial layer, and the third layer of conductive material has a higher doping concentration than the second P-type epitaxial layer. In some embodiments, the second P-
10 type epitaxial layer has a higher doping concentration than the first epitaxial layer and the third layer of conductive material. In some embodiments, the first epitaxial layer is N-type and has a lower doping concentration than the second P-type epitaxial layer. In some embodiments, the first epitaxial layer comprises intrinsic silicon. In some embodiments, the third layer of conductive material is an N-type doped epitaxial layer having a lower doping concentration than
15 the second P-type epitaxial layer.

[00208] In some embodiments, the method can include prior to filling the plurality of trenches, implanting P-type dopants along the bottom of the plurality of trenches. In some embodiments, the method can include prior to forming the second N-type epitaxial layer, implanting P-type dopants to form P-enrichment regions in an upper portion of the first N-type
20 epitaxial layer where the plurality of trenches are formed in the second N-type epitaxial layer directly over corresponding ones of the P-enrichment regions such that during one or more temperature cycles, the P-type enrichment regions up-diffuse into corresponding P-pillars. In some embodiments, each N-pillar has an upper N-region, a middle N region and a lower N region. The upper N region can have a lower doping concentration than the middle N region, and
25 the middle N region can have a lower doping concentration than the lower N region.

[00209] In some embodiments, the method can also include forming P-type body regions in the second N-type epitaxial layer, and forming N-type source regions in the P-type body regions. The method can also include forming gate electrodes extending adjacent to but being insulated from the P-type body regions where the gate electrodes overlap corresponding source regions,
30 and forming a source metal directly contacting the source regions. In some embodiments, the source metal directly contacts the third layer of conductive material.

[00210] In yet another general aspect, a power device can include one or more N-type epitaxial layers extending over a substrate, and a plurality of trenches extending into the one or more N-type epitaxial layers. The plurality of trenches can be filled with P-type silicon material. The P-type silicon material in the plurality of trenches forming P-pillars where those portions of the one or more N-type epitaxial layers separate the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N-pillars. The power device can also include an active region and a termination region surrounding the active region where the alternating P-N-pillars are disposed in both the active region and the termination region. The termination region can include a predetermined number of floating P-pillars, and each N-pillar located between two adjacent ones of the predetermined number of floating P-pillars includes a N-type surface region along its upper surface. The N-type surface region can have a lower doping concentration than the rest of the N-pillar in which it is formed.

[00211] In some embodiments, the power device can include P-type body regions in the one or more N-type epitaxial layer, gate electrodes adjacent to but insulated from the P-type body regions, and N-type source regions in the P-type body regions. The power device can also include a source metal electrically contacting the source regions, and a P-Iso region extending along a surface of the one or more N-type epitaxial layer where two or more of the P-pillars in the termination region are electrically connected to the source metal through the P-Iso region.

[00212] In some embodiments, the power device can include shallow trenches extending into the one or more N-type epitaxial layers, and a gate dielectric layer lining the sidewalls of the shallow trenches where the gate electrodes are disposed in each shallow trench. In some embodiments, the gate electrodes are in the form of planar gates extending over but being insulated from the one or more N-type epitaxial layer by a gate dielectric layer. The planar gate electrodes can be laterally spaced from one another, and the plurality of deep trenches can be disposed between the planar gate electrodes. In some embodiments, each of two or more of the P-pillars in the termination region includes a P-type enrichment region along its upper surface, and the P-type enrichment region can have a higher doping concentration than the rest of the P-pillar in which it is formed.

[00213] In some embodiments, the power device can include P-type body regions in the one or more N-type epitaxial layer, gate electrodes adjacent to but insulated from the P-type body regions, and N-type source regions in the P-type body regions. The power device can also

include a source metal electrically contacting the source regions, and a P-Iso region extending along a surface of the one or more N-type epitaxial layer where two or more of the P-pillars in the termination region are electrically connected to the source metal through the P-Iso region.

[00214] In yet another general aspect, a power device can include one or more N-type

5 epitaxial layers extending over a substrate, and a plurality of trenches extending into the one or more N-type epitaxial layers. The plurality of trenches can be filled with P-type silicon material.

The P-type silicon material in the plurality of trenches can form P-pillars where those portions of the one or more N-type epitaxial layers separate the P-pillars forming N-pillars such that the N-

10 pillars and the P-pillars form alternating P-N-pillars. The power device can include an active region and a termination region surrounding the active region where the alternating P-N-pillars are disposed in both the active region and the termination region. The alternating P-N-pillars in the termination region surround the active region in a concentric fashion and include a

predetermined number of floating P-pillars where each floating P-pillar includes a P-type ring along its top. The power device can include a plurality of field plates disposed in the termination

15 region over but insulated from the one or more N-type epitaxial layers where the plurality of field plates surround the active region in a concentric fashion. The power device can also include a plurality of contacts configured so that each of the plurality of contacts makes contact between one of the plurality of field plates and one or more of the P-type rings, the plurality of contacts

being disposed directly above a corresponding one of the predetermined number of floating P-

20 pillars.

[00215] In some embodiments, the predetermined number of floating P-pillars are contacted

where the predetermined number of floating P-pillars make a sharp turn. In some embodiments, a width of the P-type rings gradually decreases in the direction away from the active region. In

some embodiments, each of the plurality of field plates extends directly above a corresponding

25 one of the predetermined number of floating P-pillars and directly above an adjacent N-pillar. In

some embodiments, the plurality of contacts are formed through one or more insulating layers that extend between the plurality of contacts and the one or more N-type epitaxial layers.

[00216] In some embodiments, the P-pillars in the active and termination regions are equally spaced apart. In some embodiments, the P-type rings are centered about a corresponding one of

30 the predetermined number of floating P-pillars. In some embodiments, each P-type ring includes a highly doped P+ region for forming a robust contact between the plurality of field plates and

corresponding P-type rings.

[00217] In yet another general aspect, a power device can include an active region surrounded by a termination region, and a plurality of trenches extending into one or more epitaxial layers of a first conductivity type. The plurality of trenches can be filled with silicon material of a second conductivity type where the silicon material of a second conductivity type in the plurality of trenches together with portions of the one or more epitaxial layers separating the plurality of trenches from one another forming a plurality of concentric octagon-shaped pillars of alternating conductivity type extending through the active region and the termination region. Four of the eight legs of each of the plurality of concentric octagon-shaped pillars have a different length than the other four legs, and sidewalls of the plurality of trenches along all eight legs of the plurality of concentric octagon-shaped pillars have the same plane direction.

[00218] In some embodiments, corner edges of the plurality of octagon-shaped pillars of alternating conductivity type gradually increase in length in the direction away from a center of the plurality of concentric octagon-shaped pillars. In some embodiments, the power device can include body regions of the second conductivity type extending in the one or more epitaxial layers, source regions of the first conductivity type extending in the body regions, and gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlapping corresponding source regions.

[00219] In yet another general aspect, a method of forming a power device having an active region surrounded by a termination region can include forming a plurality of trenches in one or more epitaxial layers of a first conductivity type, and filling the plurality of trenches with silicon material of a second conductivity type. The silicon material of a second conductivity type in the plurality of trenches together with portions of the one or more epitaxial layers separate the plurality of trenches from one another form a plurality of concentric octagon-shaped pillars of alternating conductivity type extending through the active region and the termination region. Four of the eight legs of each of the plurality of concentric octagon-shaped pillars have a different length than the other four legs, and sidewalls of the plurality of trenches along all eight legs of the plurality of concentric octagon-shaped pillars have the same plane direction.

[00220] In some embodiments, methods can include prior to filling the trenches, rotating a wafer in which the power device is housed by 22.5 degrees. In some embodiments, corner edges of the plurality of octagon-shaped pillars of alternating conductivity type gradually increase in

length in the direction away from a center of the plurality of concentric octagon-shaped pillars.

[00221] In some embodiments, the method can also include forming body regions of the second conductivity type in the one or more epitaxial layers, forming source regions of the first conductivity type extending in the body regions, and forming gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlap corresponding source regions.

[00222] In yet another general aspect, a power device can include an active region surrounded by a termination region, a plurality of stripe-shaped pillars of alternating conductivity type extending through the active region, and a plurality of octagon-shaped pillars of alternating conductivity type extending through the termination region in a concentric fashion, surrounding the active region.

[00223] In some embodiments, corner edges of the plurality of octagon-shaped pillars of alternating conductivity type gradually increase in length in the direction away from the active region. In some embodiments, the plurality of stripe-shaped pillars include P-pillars, and the plurality of octagon-shaped pillars include P-pillars where the ends of the plurality of stripe-shaped P-pillars are spaced from the plurality of octagon-shaped P-pillars by a gap region that floats.

[00224] In some embodiments, four of the eight legs of each of the plurality of octagon-shaped pillars have a different length than the other four legs. In some embodiments, further comprising a plurality of trenches extending into one or more epitaxial layers of a first conductivity type where the plurality of trenches can be filled with silicon material of a second conductivity type. The silicon material of a second conductivity type in the plurality of trenches together with portions of the one or more epitaxial layers separate the plurality of trenches from one another forming the plurality of octagon-shaped pillars of alternating conductivity type. The sidewalls of the plurality of trenches along all eight legs of the plurality of octagon-shaped pillars have the same plane direction.

[00225] In some embodiments, the power device can include body regions of the second conductivity type extending in the one or more epitaxial layers, source regions of the first conductivity type extending in the body regions, and gate electrodes extending adjacent to but being insulated from the body regions where the gate electrodes overlap corresponding source regions.

[00226] In another general aspect, a power device can include an active region surrounded by a termination region, a plurality of pillars of alternating conductivity type arranged in a concentric fashion in the active and termination regions, and a plurality of polysilicon gates arranged in concentric fashion in the active region. The power device can include an outer metal gate runner
5 extending along an outer perimeter of the termination region in a concentric fashion where the outer metal gate runner being connected to a gate pad. The power device can also include a plurality of supplementary metal gate runners directly connected to the outer metal gate runner, and extending from the outer metal gate runner toward a center of the active region but terminating before reaching the center of the active region. A first group of the plurality of the
10 polysilicon gates directly connects to all of the plurality of supplementary metal gate runners, and a second group of the plurality of the polysilicon gates directly contact only two of the plurality of supplementary metal gate runners.

[00227] In some embodiments, a third group of the plurality of the polysilicon gates do not directly contact any of the plurality of supplementary metal gate runners. In some embodiments,
15 further comprising a polysilicon feed extending through a center portion of the active region and directly connects on two ends to two of the plurality of supplementary metal gate runners. In some embodiments, a length of a portion of an inner one of the plurality of polysilicon gates that extends between and directly contact two of the plurality of supplementary metal gate runners is substantially equal to a length of a portion of an outer one of the plurality of polysilicon gates that
20 extends between and directly contact two of the plurality of supplementary metal gate runners.

[00228] In some embodiments, the plurality of polysilicon gates are of the planar gate variety. In some embodiments, the plurality of polysilicon gates are of the trench gate variety.

[00229] In another general aspect, power device can include an active region and a termination region surrounding the active region, a plurality of pillars of alternating conductivity
25 type arranged in a concentric fashion in both the active and the termination regions, and a plurality of polysilicon gate stripes extending through the active and termination regions. Power device can include a gate runner metal extending along an outer perimeter of the termination region. The plurality of polysilicon stripes can connect to the gate runner metal along their opposite ends.

[00230] In some embodiments, the plurality of polysilicon gates are of the planar gate variety. In some embodiments, the plurality of polysilicon gates are of the trench gate variety.

[00231] In yet another general aspect, a method for forming pillars of alternating conductivity type in a power device can include forming one or more N-type epitaxial layers over a substrate, forming P-type body regions in the one or more N-type epitaxial layers, and forming gate electrodes extending adjacent to but being insulated from the one or more N-type epitaxial layers by a gate dielectric. The method can also include after forming the P-type body regions and the gate electrodes, forming a plurality of deep trenches extending in the one or more N-type epitaxial layers, and filling the plurality of deep trenches with P-type silicon to form a plurality of P-pillars. Those portions of the one or more N-type epitaxial layers separating the plurality of P-pillars forming N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

[00232] In some embodiments, a composite layer of oxide-nitride-oxide (ONO) is used in defining and etching the plurality of deep trenches in the N-type epitaxial layer. In some embodiments, the method also includes forming N-type source regions in the P-type body regions, wherein the plurality of deep trenches are formed after forming the source regions. In some embodiments, the method also includes after forming the plurality of deep trenches, forming a dielectric cap over each gate electrode, the dielectric caps defining contact openings between adjacent trenches.

[00233] In some embodiments, the method also includes implanting P-type dopants into the P-type body regions through the contact openings to form P+ heavy body regions in the P-type body regions. In some embodiments, the method also includes prior to forming the dielectric cap, forming a conformal layer that extends adjacent the gate electrodes such that the conformal layer spaces the P-type dopants implanted into the P-type body regions from the edges of the gate electrodes. In some embodiments, the method also includes etching a dimple in each P-type body region, and implanting P-type dopants into the bottom of each dimple to form heavy body regions in the P-type body regions.

[00234] In some embodiments, the method also includes forming a source metal layer electrically contacting the N-type source regions and the P+ heavy body regions through the contact openings. In some embodiments, the power device includes an active region and a termination regions surrounding the active region, both the active and termination regions include a plurality of P-pillars. The method can also include prior to forming the P-type body regions, forming a P-type Iso region in the one or more N-type epitaxial layers in the termination region

such that after the plurality of P-pillars are formed. The P-type Iso region connects a predetermined number of the P-pillars in the termination region together.

[00235] In some embodiments, the method also includes forming a source metal layer electrically contacting the P-type Iso region. In some embodiments, the step of forming gate electrodes can include forming shallow trenches extending into the one or more N-type epitaxial layers, forming a gate dielectric layer lining the sidewalls of the shallow trenches, and forming recessed gate electrodes in the shallow trenches. In some embodiments, the step of forming gate electrodes can include forming a gate dielectric layer over the one or more N-type epitaxial layers, and forming planar gate electrodes over the gate dielectric layer where the planar gate electrodes can be laterally spaced from one another, and the plurality of deep trenches are formed between the planar gate electrodes.

[00236] In yet another general aspect, a high voltage device can include one or more N-type epitaxial layers extending over a substrate, and a plurality of trenches extending into the one or more N-type epitaxial layers where the plurality of trenches are filled with P-type silicon material. The P-type silicon material in the plurality of trenches can form P-pillars where those portions of the one or more N-type epitaxial layers separate the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N-pillars. The high-voltage device can include a plurality of P-wells each formed in an upper portion of one of the P-pillars, and an anode terminal including a Schottky barrier metal directly contacting a top surface of the N-pillars to form a Schottky contact therebetween. The Schottky barrier metal can further directly contact the P-wells.

[00237] In some embodiments, each P-well has a width greater than a width of the P-pillars. In some embodiments, each P-well has a width substantially equal to a width of the P-pillars. In some embodiments, each P-well includes a highly doped P+ region, and the Schottky barrier metal direction can contact a top surface of the P+ regions to form ohmic contact therebetween. In some embodiments, the Schottky contacts are formed in a Schottky region of the high voltage device, and the high voltage device also include a MOSFET region configured to include a MOSFET.

[00238] In yet another general aspect, a high voltage device can include one or more N-type epitaxial layers extending over a substrate, and a plurality of trenches extending into the one or more N-type epitaxial layers. The plurality of trenches can be filled with P-type silicon material,

and the P-type silicon material in the plurality of trenches can form P-pillars where those portions of the one or more N-type epitaxial layers separate the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N pillars. The high-voltage device can include an N-type epitaxial layer extending over the alternating P-N Pillars, and an anode terminal including a Schottky barrier metal directly contacting a top surface of the N-type epitaxial layer to form a Schottky contact therebetween. The N-type epitaxial layer can separate the Schottky barrier metal from the P-pillars so that the P-pillars float. In some embodiments, the Schottky contact is formed in a Schottky region of the high voltage device, the high voltage device further comprising a MOSFET region configured to include a MOSFET.

[00239] In yet another general aspect, a high voltage device can include one or more N-type epitaxial layers extending over a substrate, and a plurality of trenches extending into the one or more N-type epitaxial layers. The plurality of trenches can be filled with P-type silicon material. The P-type silicon material in the plurality of trenches can form P-pillars where those portions of the one or more N-type epitaxial layers separate the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N pillars. The high-voltage device can include an N-type implant region extending through an upper portion of the alternating P-N pillars, and an anode terminal including a Schottky barrier metal directly contacting a top surface of the N-type implant region to form a Schottky contact therebetween. The N-type implant region can separate the Schottky barrier metal from the P-pillars so that the P-pillars float. In some embodiments, the Schottky contact is formed in a Schottky region of the high voltage device, and the high voltage device can also include a MOSFET region configured to include a MOSFET.

[00240] While the above provides a complete description of specific embodiments of the present invention, various modifications, alternatives and equivalents are possible. For example, while some embodiments of the invention are illustrated in the context of planar gate MOSFETs, the same techniques could easily be applied to other planar-gate structures such as planar gate IGBTs by merely reversing the polarity of the substrate from those shown in the figures. Similarly, some of the structures and process sequences are described in the context of N-channel FETs, however, modifying these structures and process sequences to form P-channel FETs would be obvious to one skilled in the art in view of this disclosure. Further, the various techniques disclosed herein are not limited to planar gate structures and may be implemented in trench gate MOSFETs, trench gate IGBTs (which have trench gates), shielded gate MOSFETs or IGBTs

(which have trenched gates with underlying shield electrode(s)), and rectifiers (including Schottky rectifiers, TMBS rectifiers, etc.).

[00241] Additionally, while not specifically called out for each embodiment, the various embodiments including many of the termination designs and charge balance techniques may be implemented in any of the three layout configurations shown in Figs. 1A-1C. Similarly, many of the embodiments disclosed herein including many of the termination designs and charge balance techniques are not limited in implementation to the trench epi fill charge balance process technology, and may also be implemented in the multi-epi layer pillar process technology. For this and other reasons, therefore, the above description should not be taken as limiting the scope of the invention, which is defined by the appended claims.

WHAT IS CLAIMED IS:

- 1 1. A power device comprising:
2 a semiconductor region including a plurality of alternately arranged pillars of first
3 and second conductivity type, each of the plurality of pillars of second conductivity type
4 comprising: a plurality of implant regions of the second conductivity type arranged on top of one
5 another along the depth of pillars of second conductivity type, and a trench portion filled with
6 semiconductor material of the second conductivity type directly above the plurality of implant
7 regions of second conductivity type.
- 1 2. The power device of claim 1 further comprising:
2 a stack of a plurality of epitaxial layers of the first conductivity type over a
3 substrate, each of the plurality of implant regions of second conductivity type extending into two
4 adjacent ones of the plurality of epitaxial layers.
- 1 3. The power device of claim 2 wherein the trench portion of the plurality of
2 pillars of second conductivity type extends into and terminates within the upper-most one of the
3 plurality of epitaxial layers.
- 1 4. The power device of claim 2 wherein:
2 the plurality of pillars of second conductivity type terminate prior to reaching the
3 substrate, and
4 the plurality of epitaxial layers have a lower doping concentration than the
5 substrate.
- 1 5. The power device of claim 1 wherein the plurality of implant regions of
2 second conductivity type and the semiconductor material filling the trench portion of the
3 plurality of pillars of second conductivity type have the same doping concentration.
- 1 6. The power device of claim 1 wherein at least one of the plurality of
2 implant regions of second conductivity type in the plurality of pillars of second conductivity type
3 has a different doping concentration than the remaining ones of the plurality of implant regions
4 of second conductivity type.

1 7. The power device of claim 1 wherein at least one of the plurality of
2 implant regions of second conductivity type in the plurality of pillars of second conductivity type
3 has a different shape than the remaining ones of the plurality of implant regions of second
4 conductivity type.

1 8. The power device of claim 1 wherein adjacent ones of the plurality of
2 implant regions of second conductivity type in each of the plurality of pillars of second
3 conductivity type directly contact each other.

1 9. The power device of claim 1 wherein the plurality of implant regions of
2 the second conductivity type in each of the plurality of pillars of second conductivity type are
3 spaced apart from one another.

1 10. The power device of claim 1 wherein the plurality of pillars of first
2 conductivity type comprise a plurality of implant regions of the first conductivity type arranged
3 on top of one another along the depth of pillars of first conductivity type.

1 11. The power device of claim 10 wherein at least one of the plurality of
2 implant regions of first conductivity type in the plurality of pillars of first conductivity type has a
3 different shape than the remaining ones of the plurality of implant regions of first conductivity
4 type.

1 12. The power device of claim 1 further comprising:
2 body regions of the second conductivity type extending in the semiconductor
3 region and forming part of the pillars of second conductivity type;
4 source regions of the first conductivity type extending in the body regions; and
5 gate electrodes extending adjacent to but being insulated from the body regions,
6 the gate electrodes overlapping corresponding source regions.

1 13. A power device comprising:
2 an active region and a termination region surrounding the active region; and
3 a plurality of pillars of first and second conductivity type alternately arranged in
4 each of the active and termination regions, each of the plurality of pillars of second conductivity
5 type in the active and termination regions comprising: a plurality of implant regions of the

6 second conductivity type arranged on top of one another along the depth of the pillars of second
7 conductivity type, and a trench portion filled with semiconductor material of the second
8 conductivity type directly above the plurality of implant regions of second conductivity type.

1 14. The power device of claim 13 further comprising:
2 a stack of a plurality of epitaxial layers of the first conductivity type over a
3 substrate, each of the plurality of implant regions of second conductivity type in the active and
4 termination regions extending into two adjacent ones of the plurality of epitaxial layers.

1 15. The power device of claim 14 wherein the trench portion of the plurality
2 of pillars of second conductivity type in the active and termination regions extends into and
3 terminates within the upper-most one of the plurality of epitaxial layers.

1 16. The power device of claim 13 wherein at least one of the plurality of
2 implant regions of second conductivity type in the plurality of pillars of second conductivity type
3 in the active region have a different shape than at least one of the plurality of implant regions of
4 second conductivity type in the plurality of pillars of second conductivity type in the termination
5 region.

1 17. The power device of claim 13 wherein at least one of the plurality of
2 implant regions of second conductivity type in the plurality of pillars of second conductivity type
3 in the active region are laterally wider than at least one of the plurality of implant regions of
4 second conductivity type in the plurality of pillars of second conductivity type in the termination
5 region.

1 18. The power device of claim 17 wherein the plurality of pillars of first
2 conductivity type in the active region have fewer number of implant regions of first conductivity
3 type than do the plurality of pillars of first conductivity type in the termination region.

1 19. The power device of claim 13 wherein the plurality of pillars of first
2 conductivity type in the active and termination regions comprise a plurality of implant regions of
3 the first conductivity type arranged on top of one another along the depth of pillars of first
4 conductivity type.

1 20. The power device of claim 19 wherein at least one of the plurality of
2 implant regions of first conductivity type in the plurality of pillars of first conductivity type in
3 the active region has a different shape than at least one of the plurality of implant regions of first
4 conductivity type in the plurality of pillars of first conductivity type in the termination region.

1 21. The power device of claim 19 wherein the plurality of pillars of first
2 conductivity type in the active region have fewer number of implant regions of first conductivity
3 type than do the plurality of pillars of first conductivity type in the termination region.

1 22. A method for forming pillars of alternating conductivity type in a power
2 device, the method comprising:
3 forming a plurality of epitaxial layers of a first conductivity type over a substrate;
4 forming a plurality of implant regions of a second conductivity type in each of a
5 predetermined number of the plurality of epitaxial layers;
6 forming trenches extending into the upper-most one of the plurality of epitaxial
7 layers; and
8 filling the trenches with semiconductor material of the second conductivity type,
9 wherein, the plurality of implant regions of second conductivity type in the
10 predetermined number of the plurality of epitaxial layers are vertically aligned with
11 corresponding ones of the trenches so that the semiconductor material filling the trenches
12 together with the plurality of implant regions of second conductivity type in the predetermined
13 number of the plurality of epitaxial layers form a plurality of pillars of second conductivity type,
14 and those portions of the plurality of epitaxial layers separating the plurality of pillars of second
15 conductivity type from one another form a plurality of pillars of first conductivity type.

1 23. The method of claim 22 wherein each of the plurality of implant regions
2 of second conductivity type extends into two adjacent ones of the predetermined number of the
3 plurality of epitaxial layers due to processing heat cycles.

1 24. The method of claim 22 wherein the power device includes an active
2 region and a termination region surrounding the active region, and the plurality of pillars of first
3 and second conductivity type are formed in both the active and termination regions and at least
4 one of the epitaxial layers containing the plurality of implants is of second conductivity type.

1 25. The method of claim 24 wherein at least one of the plurality of implant
2 regions of second conductivity type in the plurality of pillars of second conductivity type in the
3 active region have a different shape than at least one of the plurality of implant regions of second
4 conductivity type in the plurality of pillars of second conductivity type in the termination region.

1 26. The method of claim 24 wherein the at least one of the plurality of implant
2 regions of second conductivity type in the plurality of pillars of second conductivity type in the
3 active region are laterally wider than at least one of the plurality of implant regions of second
4 conductivity type in the plurality of pillars of second conductivity type in the termination region.

1 27. The method of claim 26 wherein the plurality of pillars of first
2 conductivity type in the active region have fewer number of implant regions of first conductivity
3 type than do the plurality of pillars of first conductivity type in the termination region.

1 28. The method of claim 24 wherein the plurality of pillars of first
2 conductivity type in the active and termination regions comprise a plurality of implant regions of
3 the first conductivity type arranged on top of one another along the depth of pillars of first
4 conductivity type.

1 29. The method of claim 28 wherein at least one of the plurality of implant
2 regions of first conductivity type in the plurality of pillars of first conductivity type in the active
3 region has a different shape than at least one of the plurality of implant regions of first
4 conductivity type in the plurality of pillars of first conductivity type in the termination region.

1 30. The method of claim 28 wherein the plurality of pillars of first
2 conductivity type in the active region have fewer number of implant regions of first conductivity
3 type than do the plurality of pillars of first conductivity type in the termination region.

1 31. A method for forming pillars of alternating conductivity type in a power
2 device, the method comprising:
3 forming a first epitaxial layer of a first conductivity type over a substrate;
4 forming a lower portion of a plurality of deep trenches in the first epitaxial layer;
5 filling the lower portion of the plurality of deep trenches with semiconductor
6 material of a second conductivity type;

7 forming a second epitaxial layer of first conductivity type over the first epitaxial
8 layer;

9 forming an upper portion of the plurality of deep trenches in the second epitaxial
10 layer directly over the lower portion of the plurality of deep trenches so that each lower portion
11 and a corresponding upper portion of the plurality of deep trenches together form one of the
12 plurality of deep trenches; and

13 filling the upper portion of the plurality of deep trenches with semiconductor
14 material of second conductivity type,

15 wherein, the semiconductor material filling the lower and upper portions of the
16 plurality of deep trenches form a plurality of pillars of second conductivity type, and those
17 portions of the first and second epitaxial layers separating the plurality of pillars of second
18 conductivity type from one another form a plurality of pillars of first conductivity type.

1 32. The method of claim 31 wherein the semiconductor material filling the
2 lower portion of the plurality of deep trenches has a different doping concentration than the
3 semiconductor material filling the upper portion of the plurality of deep trenches.

1 33. The method of claim 31 wherein the semiconductor material filling the
2 lower portion of the plurality of deep trenches has a different doping profile than the
3 semiconductor material filling the upper portion of the plurality of deep trenches.

1 34. The method of claim 31 wherein the first and second epitaxial layers have
2 the same doping profile.

1 35. The method of claim 31 wherein the first and second epitaxial layers have
2 different doping profiles.

1 36. The method of claim 31 wherein the first and second epitaxial layers have
2 different thicknesses.

1 37. The method of claim 31 further comprising:
2 prior to forming the second epitaxial layer, planarizing the surface of the first
3 epitaxial layer and the surface of the semiconductor material filling the lower portion of the
4 plurality of deep trenches.

1 38. The method of claim 31 further comprising:
2 after forming the second epitaxial layer, planarizing the surface of the second
3 epitaxial layer and the surface of the semiconductor material filling the upper portion of the
4 plurality of deep trenches.

1 39. The method of claim 31 wherein the lower portion of the plurality of deep
2 trenches terminates within the first epitaxial layer prior to reaching the substrate.

1 40. The method of claim 31 further comprising:
2 forming body regions of second conductivity type in the second epitaxial layer,
3 the body regions forming part of the plurality of pillars of second conductivity type;
4 forming source regions of the first conductivity type in the body regions; and
5 forming gate electrodes extending adjacent to but being insulated from the body
6 regions, the gate electrodes overlapping corresponding source regions.

1 41. A method for forming a power field effect transistor, the method
2 comprising:
3 forming an N-type epitaxial layer over a substrate;
4 forming one or more P-type epitaxial layers over the N-type epitaxial layer;
5 forming a plurality of trenches extending through the one or more P-type epitaxial
6 layers;
7 filling the plurality of trenches with N-type semiconductor material;
8 forming P-type body regions in the one or more P-type epitaxial layers;
9 forming N-type source regions in the P-type body regions; and
10 forming gate electrodes adjacent to but insulated from the P-type body regions
11 and the N-type semiconductor material, the gate electrodes overlapping with the N-type source
12 regions,
13 wherein the plurality of trenches filled with N-type semiconductor material form
14 N-pillars, and those portions of the one or more P-type epitaxial layers separating the N-pillars
15 form P-pillars.

1 42. The method of claim 41 further comprising:
2 prior to filling the plurality of trenches, implanting N-type dopants along the
3 bottom of the plurality of trenches.

1 43. The method of claim 41 further comprising:
2 prior to forming the P-type epitaxial layer, implanting N-type dopants to form N-
3 enrichment regions in an upper portion of the N-type epitaxial layer, wherein the plurality of
4 trenches are formed in the P-type epitaxial layer directly over corresponding ones of N-
5 enrichment regions such that during one or more temperature cycles, the N-type enrichment
6 regions up-diffuse into the N-type semiconductor material filling the plurality of trenches and
7 down-diffuse into the N-type epitaxial layer.

1 44. The method of claim 43 wherein the N-enrichment regions create a N-rich
2 imbalance condition along the bottom of the N and P-pillars.

1 45. The method of claim 43 wherein the power device includes an active
2 region and a termination region surrounding the active region, each of the active and termination
3 regions including a plurality of alternating N and P-pillars, wherein the N-enrichment regions are
4 formed along the bottom of the N-pillars in both the active and termination regions.

1 46. The method of claim 43 wherein the power device includes an active
2 region and a termination region surrounding the active region, each of the active and termination
3 regions including a plurality of alternating N and P-pillars, wherein the N-enrichment regions are
4 formed along the bottom of the N-pillars in the active region only.

1 47. The method of claim 41 wherein the plurality of trenches have tapered
2 sidewalls so that the plurality of trenches are wider along the top of the plurality of trenches than
3 along their bottom.

1 48. The method of claim 41 wherein the gate electrodes laterally extend
2 directly over the plurality of trenches.

1 49. A power field effect transistor (FET) comprising:
2 an N-type epitaxial layer over a substrate;
3 one or more P-type epitaxial layers over the N-type epitaxial layer;

4 a plurality of trenches extending through the one or more P-type epitaxial layers,
5 the plurality of trenches being filled with N-type semiconductor material;
6 P-type body regions in the one or more P-type epitaxial layers;
7 N-type source regions in the P-type body regions; and
8 gate electrodes adjacent to but insulated from the P-type body regions and the N-
9 type semiconductor material, the gate electrodes overlapping with the N-type source regions,
10 wherein the plurality of trenches filled with N-type semiconductor material form
11 N-pillars, and those portions of the one or more P-type epitaxial layers separating the N-pillars
12 form P-pillars.

1 50. The power FET of claim 49 further comprising N-enrichment regions at
2 the bottom of the N-pillars, the N-enrichment regions extending into the N-type semiconductor
3 material filling the plurality of trenches and into the N-type epitaxial layer.

1 51. The power FET of claim 50 wherein the N-enrichment regions create a N-
2 rich imbalance condition along the bottom of the N and P-pillars.

1 52. The power FET of claim 50 wherein the power device includes an active
2 region and a termination region surrounding the active region, each of the active and termination
3 regions including a plurality of alternating N and P-pillars, wherein the N-enrichment regions are
4 formed along the bottom of the N-pillars in both the active and termination regions.

1 53. The power FET of claim 50 wherein the power device includes an active
2 region and a termination region surrounding the active region, each of the active and termination
3 regions including a plurality of alternating N and P-pillars, wherein the N-enrichment regions are
4 formed along the bottom of the N-pillars in the active region only.

1 54. The power FET of claim 49 wherein the plurality of trenches have tapered
2 sidewalls so that the plurality of trenches are wider along the top of the plurality of trenches than
3 along their bottom.

1 55. The power FET of claim 49 wherein the gate electrodes laterally extend
2 directly over the plurality of trenches.

1 56. A method for forming a power field effect transistor, the method
2 comprising:
3 forming one or more epitaxial layers of a first conductivity type over a substrate;
4 forming a plurality of lower trenches extending through the one or more epitaxial
5 layers;
6 filling the plurality of lower trenches with semiconductor material of a second
7 conductivity type;
8 forming one or more epitaxial layers of the second conductivity type over the one
9 or more epitaxial layers of first conductivity type;
10 forming a plurality of upper trenches extending through the one or more epitaxial
11 layers of the second conductivity type;
12 filling the plurality of upper trenches with semiconductor material of the second
13 conductivity type,
14 wherein the plurality of lower trenches and the plurality of upper trenches are off-
15 set from one another along the lateral dimension.

1 57. The method of claim 56 wherein the semiconductor material of the second
2 conductivity type in the plurality of upper trenches together with underlying portions of the one
3 or more epitaxial layers of the second conductivity type form pillars of the second conductivity
4 type, and the semiconductor material of the first conductivity type in the plurality of lower
5 trenches together with overlying portions of the one or more epitaxial layers of the first
6 conductivity type form pillars of the first conductivity type, so that the pillars of first and second
7 conductivity type form pillars of alternating conductivity type.

1 58. The method of claim 57 further comprising:
2 prior to forming the one or more epitaxial layers of the first conductivity type,
3 forming a first epitaxial layer of the second conductivity type over the substrate.

1 59. The method of claim 58 further comprising:
2 forming enrichment regions of the second conductivity type along the bottom of
3 the plurality of lower trenches, the enrichment regions of the second conductivity type extending
4 into the semiconductor material of the second conductivity type and further extending into the
5 first epitaxial layer of the second conductivity type.

1 60. The method of claim 59 wherein the step of forming the enrichment
2 regions comprises:

3 prior to forming the one or more epitaxial layers of the first conductivity type,
4 implanting dopants of the second conductivity type to form enrichment regions of the second
5 conductivity type in an upper portion of the a first epitaxial layer of the second conductivity type,
6 wherein the plurality of lower trenches are formed in the one or more epitaxial layers of a first
7 conductivity type directly over corresponding ones of enrichment regions of the second
8 conductivity type such that during one or more temperature cycles, the enrichment regions of the
9 second conductivity type up-diffuse into the semiconductor material of the second conductivity
10 type and down-diffuse into the first epitaxial layer of the second conductivity type.

1 61. The method of claim 60 wherein the enrichment regions of the second
2 conductivity type create a charge imbalance condition along the bottom of the pillars of
3 alternating conductivity type.

1 62. The method of claim 59 wherein the step of forming the enrichment
2 regions comprises:
3 prior to filling the plurality of lower trenches, implanting dopants of the second
4 conductivity type along the bottom of the plurality of lower trenches into the first epitaxial layer
5 of the second conductivity type.

1 63. The method of claim 59 wherein the field effect transistor includes an
2 active region and a termination region surrounding the active region, each of the active and
3 termination regions including alternating pillars of first and second conductivity type, wherein
4 the enrichment regions are formed along the bottom of the pillars of the second conductivity type
5 in both the active and termination regions.

1 64. The method of claim 59 wherein the field effect transistor includes an
2 active region and a termination region surrounding the active region, each of the active and
3 termination regions including a plurality of alternating pillars of first and second conductivity
4 type, wherein the enrichment regions are formed along the bottom of the pillars the second
5 conductivity type in the active region only.

1 65. The method of claim 56 wherein the plurality of lower and upper trenches
2 have tapered sidewalls so that each of the plurality of lower and upper trenches is wider along its
3 top than along its bottom.

1 66. The method of claim 56 further comprising:
2 forming body regions of the first conductivity type in the one or more epitaxial
3 layers of the first conductivity type;
4 forming source regions of the second conductivity type in the body regions; and
5 forming gate electrodes adjacent to but insulated from the body regions, the gate
6 electrodes overlapping with the source regions.

1 67. A power field effect transistor (FET) comprising:
2 a semiconductor region including a plurality of alternately arranged pillars of first
3 and second conductivity type, wherein each of the pillars of the first conductivity type has a
4 middle section that is wider than its upper and lower sections, and each of the pillars of the
5 second conductivity type has a middle section that is narrower than its upper and lower sections.

1 68. The power FET of claim 67 wherein each of the pillars of the first
2 conductivity type includes a lower section that is trench filled, and each of the pillars of the
3 second conductivity type includes an upper section that is trench filled.

1 69. The power FET of claim 67 further comprising:
2 an N-type epitaxial layer over a substrate;
3 one or more P-type epitaxial layers over the N-type epitaxial layer;
4 a plurality of trenches extending through the one or more P-type epitaxial layers,
5 the plurality of trenches being filled with N-type semiconductor material;
6 one or more N-type epitaxial layers over the one or more P-type epitaxial layers;
7 a plurality of trenches extending through the one or more N-type epitaxial layers,
8 the plurality of trenches being filled with P-type semiconductor material, wherein the P-type
9 semiconductor material together with portions of the one or more P-type epitaxial layers form the
10 pillars of the second conductivity type, and the N-type semiconductor material together with
11 portions of the one or more N-type epitaxial layers form the pillars of the first conductivity type,

1 70. The power FET of claim 69 further comprising:
2 P-type body regions extending into the P-type semiconductor material;
3 N-type source regions in the P-type body regions; and
4 gate electrodes adjacent to but insulated from the P-type body regions, the gate
5 electrodes overlapping with the N-type source regions.

1 71. The power FET of claim 67 further comprising enrichment regions of the
2 first conductivity type at the bottom of the pillars of the first conductivity type.

1 72. The power FET of claim 71 wherein the power device includes an active
2 region and a termination region surrounding the active region, each of the active and termination
3 regions including a plurality of alternating pillars of first and second conductivity type, wherein
4 the enrichment regions are formed along the bottom of the pillars of the first conductivity type in
5 both the active and termination regions.

1 73. The power FET of claim 71 wherein the power device includes an active
2 region and a termination region surrounding the active region, each of the active and termination
3 regions including a plurality of alternating pillars of first and second conductivity type, wherein
4 the enrichment regions are formed along the bottom of the pillars of the first conductivity type in
5 the active region only.

1 74. A method for forming a super-junction structure in a power device, the
2 method comprising:
3 forming one or more epitaxial layers of a first conductivity type over a substrate;
4 forming a plurality of trenches extending in the one or more epitaxial layers;
5 lining the sidewalls and bottom of the trenches with a an epitaxial layer of a
6 second conductivity type;
7 forming a dielectric layer in the plurality of trenches over the epitaxial layer of
8 second conductivity type; and
9 filling the plurality of trenches with conformal material.

1 75. The method of claim 74 wherein the dielectric layer is in direct contact
2 with the epitaxial layer of second conductivity type.

1 76. The method of claim 74 wherein the conformal material is in direct
2 contact with the dielectric layer.

1 77. The method of claim 74 wherein the conformal material comprises
2 polysilicon.

1 78. The method of claim 74 wherein the conformal material comprises
2 amorphous silicon.

1 79. The method of claim 74 wherein the dielectric layer comprises oxide.

1 80. The method of claim 74 further comprising:
2 forming body regions of second conductivity type in the one or more epitaxial
3 layers;
4 forming source regions of the first conductivity type in the body regions;
5 forming gate electrodes extending adjacent to but being insulated from the body
6 regions, the gate electrodes overlapping corresponding source regions; and
7 forming a source metal directly contacting the source regions.

1 81. The method of claim 80 wherein the source metal directly contacts the
2 conformal material.

1 82. A method for forming a super-junction structure in a power device, the
2 method comprising:
3 forming one or more epitaxial layers of a first conductivity type over a substrate;
4 forming a plurality of trenches extending in the one or more epitaxial layers;
5 filling each trench with an epitaxial layer of a second conductivity type such that
6 only a center portion of each trench along the top of the trench remains unfilled; and
7 filling the center portion of each trench along the top of the trench with a
8 dielectric material.

1 83. The method of claim 82 wherein the dielectric material comprises thermal
2 oxide.

1 84. The method of claim 82 further comprising:
2 forming body regions of the second conductivity type in the one or more epitaxial
3 layers;
4 forming source regions of the first conductivity type in the body regions;
5 forming gate electrodes extending adjacent to but being insulated from the body
6 regions, the gate electrodes overlapping corresponding source regions; and
7 forming a source metal directly contacting the source regions.

1 85. A method for forming a super-junction structure in a power device, the
2 method comprising:
3 forming one or more epitaxial layers of a first conductivity type over a substrate;
4 forming a plurality of trenches extending in the one or more epitaxial layers;
5 lining sidewalls and bottom of the plurality of trenches with a first epitaxial layer
6 of a second conductivity type;
7 filling each trench with a second epitaxial layer of the second conductivity type
8 such that only a center portion of each trench along the top of the trench remains unfilled; and
9 filling the center portion of each trench along the top of the trench with a
10 dielectric material.

1 86. The method of claim 85 wherein the dielectric material comprises thermal
2 oxide.

1 87. The method of claim 85 wherein the second epitaxial layer has a lower
2 doping concentration than the first epitaxial layer.

1 88. The method of claim 85 further comprising:
2 forming body regions of the second conductivity type in the one or more epitaxial
3 layers;
4 forming source regions of the first conductivity type in the body regions;
5 forming gate electrodes extending adjacent to but being insulated from the body
6 regions, the gate electrodes overlapping corresponding source regions; and
7 forming a source metal directly contacting the source regions.

1 89. A power device comprising:

2 a plurality of trenches extending in one or more epitaxial layers of a first
3 conductivity type, the plurality of trenches being filled with a first epitaxial layer of a second
4 conductivity type, a second epitaxial layer of the second conductivity type, and a layer of
5 insulating material, the first epitaxial layer lining the trench sidewalls and bottom, the second
6 epitaxial layer extending over and being in direct contact with the first epitaxial layer, and the
7 layer of insulating material extending over and being in direct contact with the second epitaxial
8 layer, the first epitaxial layer, the second epitaxial layer, and the third layer of insulating material
9 in each trench forming a pillar of second conductivity type, and those portions of the one or more
10 epitaxial layers separating the pillars of second conductivity type forming pillars of first
11 conductivity type such that the pillars of first and second conductivity type form pillars of
12 alternating conductivity type.

1 90. The power device of claim 89 wherein the layer of dielectric material
2 comprises thermal oxide.

1 91. The power device of claim 89 wherein the second epitaxial layer has a
2 lower doping concentration than the first epitaxial layer.

1 92. The power device of claim 89 further comprising:
2 forming body regions of the second conductivity type in the one or more epitaxial
3 layers;
4 forming source regions of the first conductivity type in the body regions;
5 forming gate electrodes extending adjacent to but being insulated from the body
6 regions, the gate electrodes overlapping corresponding source regions; and
7 forming a source metal directly contacting the source regions.

1 93. A power device comprising:
2 at least first and second N-type epitaxial layers extending over a substrate; and
3 a plurality of trenches extending in the second N-type epitaxial layer, the plurality
4 of trenches being filled with a first epitaxial layer, a second P-type epitaxial layer, and a third
5 layer of conductive material, the first epitaxial layer lining the trench sidewalls and bottom, the
6 second P-type epitaxial layer extending over and being in direct contact with the first epitaxial

7 layer, and the third layer of conductive material extending over and being in direct contact with
8 the second P-type epitaxial layer, the first epitaxial layer, the second P-type epitaxial layer, and
9 the third layer of conductivity type in each trench forming a P-pillar, and those portions of the at
10 least first and second N-type epitaxial layers separating the P-pillars forming N-pillars such that
11 the P-pillars and the N-pillars form pillars of alternating conductivity type.

1 94. The power device of claim 93 wherein the second P-type epitaxial layer
2 has a higher doping concentration than the first epitaxial layer, and the third layer of conductive
3 material has a higher doping concentration than the second P-type epitaxial layer.

1 95. The power device of claim 93 wherein the first epitaxial layer is N-type
2 and has a lower doping concentration than the second P-type epitaxial layer.

1 96. The power device of claim 93 wherein the first epitaxial layer comprises
2 intrinsic silicon.

1 97. The power device of claim 93 wherein the third layer of conductive
2 material is N-type and has a lower doping than the second P-type epitaxial layer.

1 98. The power device of claim 93 wherein the third layer of conductive
2 material comprises an intrinsic epitaxial layer.

1 99. The power device of claim 93 wherein the third layer of conductive
2 material comprises polysilicon.

1 100. The power device of claim 93 further comprising a P-enrichment region at
2 the bottom of each P-pillar.

1 101. The power device of claim 93 wherein each N-pillar has an upper N-
2 region, a middle N region and a lower N region, the upper N region having a lower doping
3 concentration than the middle N region, and the middle N region having a lower doping
4 concentration than the lower N region.

1 102. The power device of claim 93 further comprising:
2 P-type body regions in the second N-type epitaxial layer;
3 source regions of the first conductivity type in the body regions;
4 gate electrodes extending adjacent to but being insulated from the body regions,
5 the gate electrodes overlapping corresponding source regions; and
6 a source metal directly contacting the source regions.

1 103. The power device of claim 97 wherein the source metal directly contacts
2 the third layer of conductive material.

1 104. A method for forming pillars of alternating conductivity type in a power
2 device, the method comprising:
3 forming at least first and second N-type epitaxial layers over a substrate;
4 forming a plurality of trenches extending in the second epitaxial layer; and
5 filling the plurality of trenches with a first epitaxial layer, second P-type epitaxial
6 layer, and a third layer of conductive material, the first epitaxial layer lining the trench sidewalls
7 and bottom, the second P-type epitaxial layer extending over and being in direct contact with the
8 first epitaxial layer, and the third layer of conductive material extending over and being in direct
9 contact with the second P-type epitaxial layer, the first epitaxial layer, the second P-type
10 epitaxial layer and the third layer of conductive material in each trench forming a P-pillar, those
11 portions of the at least first and second N-type epitaxial layers separating the P-pillars forming
12 N-pillars such that the P-pillars and the N-pillars form pillars of alternating conductivity type.

1 105. The method of claim 104 wherein the second P-type epitaxial layer has a
2 higher doping concentration than the first epitaxial layer, and the third layer of conductive
3 material has a higher doping concentration than the second P-type epitaxial layer.

1 106. The method of claim 104 wherein the second P-type epitaxial layer has a
2 higher doping concentration than the first epitaxial layer and the third layer of conductive
3 material.

1 107. The method of claim 104 wherein the first epitaxial layer is N-type and
2 has a lower doping concentration than the second P-type epitaxial layer.

1 108. The method of claim 104 wherein the first epitaxial layer comprises
2 intrinsic silicon.

1 109. The method of claim 104 wherein the third layer of conductive material is
2 an N-type doped epitaxial layer having a lower doping concentration than the second P-type
3 epitaxial layer.

1 110. The method of claim 104 further comprising:
2 prior to filling the plurality of trenches, implanting P-type dopants along the
3 bottom of the plurality of trenches.

1 111. The method of claim 104 further comprising:
2 prior to forming the second N-type epitaxial layer, implanting P-type dopants to
3 form P-enrichment regions in an upper portion of the first N-type epitaxial layer, wherein the
4 plurality of trenches are formed in the second N-type epitaxial layer directly over corresponding
5 ones of the P-enrichment regions such that during one or more temperature cycles, the P-type
6 enrichment regions up-diffuse into corresponding P-pillars.

1 112. The method of claim 104 wherein each N-pillar has an upper N-region, a
2 middle N region and a lower N region, the upper N region having a lower doping concentration
3 than the middle N region, and the middle N region having a lower doping concentration than the
4 lower N region.

1 113. The method of claim 104 further comprising:
2 forming P-type body regions in the second N-type epitaxial layer;
3 forming N-type source regions in the P-type body regions;
4 forming gate electrodes extending adjacent to but being insulated from the P-type
5 body regions, the gate electrodes overlapping corresponding source regions; and
6 forming a source metal directly contacting the source regions.

1 114. The method of claim 113 wherein the source metal directly contacts the
2 third layer of conductive material.

1 115. A power device comprising:
2 one or more N-type epitaxial layers extending over a substrate;
3 a plurality of trenches extending into the one or more N-type epitaxial layers, the
4 plurality of trenches being filled with P-type silicon material, the P-type silicon material in the
5 plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers
6 separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form
7 alternating P-N-pillars; and
8 an active region and a termination region surrounding the active region, wherein
9 the alternating P-N-pillars are disposed in both the active region and the termination region, the
10 termination region includes a predetermined number of floating P-pillars, and each N-pillar
11 located between two adjacent ones of the predetermined number of floating P-pillars includes a
12 N-type surface region along its upper surface, the N-type surface region having a lower doping
13 concentration than the rest of the N-pillar in which it is formed.

1 116. The power device of claim 115 further comprising:
2 P-type body regions in the one or more N-type epitaxial layer;
3 gate electrodes adjacent to but insulated from the P-type body regions;
4 N-type source regions in the P-type body regions;
5 a source metal electrically contacting the source regions; and
6 a P-Iso region extending along a surface of the one or more N-type epitaxial layer,
7 wherein two or more of the P-pillars in the termination region are electrically connected to the
8 source metal through the P-Iso region.

1 117. The power device of claim 116 further comprising:
2 shallow trenches extending into the one or more N-type epitaxial layers;
3 a gate dielectric layer lining the sidewalls of the shallow trenches, wherein the
4 gate electrodes are disposed in each shallow trench.

1 118. The power device of claim 116 wherein the gate electrodes are in the form
2 of planar gates extending over but being insulated from the one or more N-type epitaxial layer by
3 a gate dielectric layer, the planar gate electrodes being laterally spaced from one another, and the
4 plurality of deep trenches being disposed between the planar gate electrodes.

119. The power device of claim 115 wherein each of two or more of the P-pillars in the termination region includes a P-type enrichment region along its upper surface, the P-type enrichment region having a higher doping concentration than the rest of the P-pillar in which it is formed.

120. The power device of claim 119 further comprising:
P-type body regions in the one or more N-type epitaxial layer;
gate electrodes adjacent to but insulated from the P-type body regions;
N-type source regions in the P-type body regions;
a source metal electrically contacting the source regions; and
a P-Iso region extending along a surface of the one or more N-type epitaxial layer,
wherein two or more of the P-pillars in the termination region are electrically connected to the source metal through the P-Iso region.

121. A power device comprising:
one or more N-type epitaxial layers extending over a substrate;
a plurality of trenches extending into the one or more N-type epitaxial layers, the plurality of trenches being filled with P-type silicon material, the P-type silicon material in the plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form alternating P-N-pillars;
an active region and a termination region surrounding the active region, wherein the alternating P-N-pillars are disposed in both the active region and the termination region, the alternating P-N-pillars in the termination region surround the active region in a concentric fashion and include a predetermined number of floating P-pillars, each floating P-pillar includes a P-type ring along its top;
a plurality of field plates disposed in the termination region over but insulated from the one or more N-type epitaxial layers, the plurality of field plates surround the active region in a concentric fashion; and
a plurality of contacts configured so that each of the plurality of contacts makes contact between one of the plurality of field plates and one or more of the P-type rings, the plurality of contacts being disposed directly above a corresponding one of the predetermined number of floating P-pillars.

1 122. The power device of claim 121 wherein the predetermined number of
2 floating P-pillars are contacted where the predetermined number of floating P-pillars make a
3 sharp turn.

1 123. The power device of claim 121 wherein a width of the P-type rings
2 gradually decreases in the direction away from the active region.

1 124. The power device of claim 121 wherein each of the plurality of field plates
2 extends directly above a corresponding one of the predetermined number of floating P-pillars
3 and directly above an adjacent N-pillar.

1 125. The power device of claim 121 wherein the plurality of contacts are
2 formed through one or more insulating layers that extend between the plurality of contacts and
3 the one or more N-type epitaxial layers.

1 126. The power device of claim 121 wherein the P-pillars in the active and
2 termination regions are equally spaced apart.

1 127. The power device of claim 121 wherein the P-type rings are centered
2 about a corresponding one of the predetermined number of floating P-pillars.

1 128. The power device of claim 121 wherein each P-type ring includes a highly
2 doped P+ region for forming a robust contact between the plurality of field plates and
3 corresponding P-type rings.

1 129. A power device comprising:
2 an active region surrounded by a termination region; and
3 a plurality of trenches extending into one or more epitaxial layers of a first
4 conductivity type, the plurality of trenches being filled with silicon material of a second
5 conductivity type, the silicon material of a second conductivity type in the plurality of trenches
6 together with portions of the one or more epitaxial layers separating the plurality of trenches
7 from one another forming a plurality of concentric octagon-shaped pillars of alternating
8 conductivity type extending through the active region and the termination region,
9 wherein four of the eight legs of each of the plurality of concentric octagon-
10 shaped pillars have a different length than the other four legs, and sidewalls of the plurality of

11 trenches along all eight legs of the plurality of concentric octagon-shaped pillars have the same
12 plane direction.

1 130. The power device of claim 129 wherein corner edges of the plurality of
2 octagon-shaped pillars of alternating conductivity type gradually increase in length in the
3 direction away from a center of the plurality of concentric octagon-shaped pillars.

1 131. The power device of claim 129 further comprising:
2 body regions of the second conductivity type extending in the one or more
3 epitaxial layers;
4 source regions of the first conductivity type extending in the body regions; and
5 gate electrodes extending adjacent to but being insulated from the body regions,
6 the gate electrodes overlapping corresponding source regions.

1 132. A method of forming a power device having an active region surrounded
2 by a termination region, the method comprising:
3 forming a plurality of trenches in one or more epitaxial layers of a first
4 conductivity type; and
5 filling the plurality of trenches with silicon material of a second conductivity type,
6 the silicon material of a second conductivity type in the plurality of trenches together with
7 portions of the one or more epitaxial layers separating the plurality of trenches from one another
8 forming a plurality of concentric octagon-shaped pillars of alternating conductivity type
9 extending through the active region and the termination region,
10 wherein four of the eight legs of each of the plurality of concentric octagon-
11 shaped pillars have a different length than the other four legs, and sidewalls of the plurality of
12 trenches along all eight legs of the plurality of concentric octagon-shaped pillars have the same
13 plane direction.

1 133. The method of claim 132 further comprising:
2 prior to filling the trenches, rotating a wafer in which the power device is housed
3 by 22.5 degrees.

1 134. The method of claim 132 wherein corner edges of the plurality of octagon-
2 shaped pillars of alternating conductivity type gradually increase in length in the direction away
3 from a center of the plurality of concentric octagon-shaped pillars.

1 135. The method of claim 132 further comprising:
2 forming body regions of the second conductivity type in the one or more epitaxial
3 layers;
4 forming source regions of the first conductivity type extending in the body
5 regions; and
6 forming gate electrodes extending adjacent to but being insulated from the body
7 regions, the gate electrodes overlapping corresponding source regions.

1 136. A power device comprising:
2 an active region surrounded by a termination region;
3 a plurality of stripe-shaped pillars of alternating conductivity type extending
4 through the active region; and
5 a plurality of octagon-shaped pillars of alternating conductivity type extending
6 through the termination region in a concentric fashion, surrounding the active region.

1 137. The power device of claim 136 wherein corner edges of the plurality of
2 octagon-shaped pillars of alternating conductivity type gradually increase in length in the
3 direction away from the active region.

1 138. The power device of claim 136 wherein the plurality of stripe-shaped
2 pillars include P-pillars, and the plurality of octagon-shaped pillars include P-pillars, wherein the
3 ends of the plurality of stripe-shaped P-pillars are spaced from the plurality of octagon-shaped P-
4 pillars by a gap region that floats.

1 139. The power device of claim 136 wherein four of the eight legs of each of
2 the plurality of octagon-shaped pillars have a different length than the other four legs.

1 140. The power device of claim 136 further comprising a plurality of trenches
2 extending into one or more epitaxial layers of a first conductivity type, the plurality of trenches
3 being filled with silicon material of a second conductivity type, the silicon material of a second

conductivity type in the plurality of trenches together with portions of the one or more epitaxial layers separating the plurality of trenches from one another forming the plurality of octagon-shaped pillars of alternating conductivity type, the sidewalls of the plurality of trenches along all eight legs of the plurality of octagon-shaped pillars have the same plane direction.

141. The power device of claim 136 further comprising:
body regions of the second conductivity type extending in the one or more epitaxial layers;
source regions of the first conductivity type extending in the body regions; and
gate electrodes extending adjacent to but being insulated from the body regions, the gate electrodes overlapping corresponding source regions.

142. A power device comprising:
an active region surrounded by a termination region;
a plurality of pillars of alternating conductivity type arranged in a concentric fashion in the active and termination regions;
a plurality of polysilicon gates arranged in concentric fashion in the active region;
an outer metal gate runner extending along an outer perimeter of the termination region in a concentric fashion, the outer metal gate runner being connected to a gate pad; and
a plurality of supplementary metal gate runners directly connected to the outer metal gate runner, and extending from the outer metal gate runner toward a center of the active region but terminating before reaching the center of the active region,
wherein a first group of the plurality of the polysilicon gates directly connects to all of the plurality of supplementary metal gate runners, and a second group of the plurality of the polysilicon gates directly contact only two of the plurality of supplementary metal gate runners.

143. The power device of claim 142 wherein a third group of the plurality of the polysilicon gates do not directly contact any of the plurality of supplementary metal gate runners.

144. The power device of claim 142 further comprising a polysilicon feed extending through a center portion of the active region and directly connects on two ends to two of the plurality of supplementary metal gate runners.

1 145. The power device of claim 142 wherein a length of a portion of an inner
2 one of the plurality of polysilicon gates that extends between and directly contact two of the
3 plurality of supplementary metal gate runners is substantially equal to a length of a portion of an
4 outer one of the plurality of polysilicon gates that extends between and directly contact two of
5 the plurality of supplementary metal gate runners.

1 146. The power device of claim 142 wherein the plurality of polysilicon gates
2 are of the planar gate variety.

1 147. The power device of claim 142 wherein the plurality of polysilicon gates
2 are of the trench gate variety.

1 148. A power device comprising:
2 an active region and a termination region surrounding the active region;
3 a plurality of pillars of alternating conductivity type arranged in a concentric
4 fashion in both the active and the termination regions;
5 a plurality of polysilicon gate stripes extending through the active and termination
6 regions; and
7 a gate runner metal extending along an outer perimeter of the termination region,
8 the plurality of polysilicon stripes connecting to the gate runner metal along their opposite ends.

1 149. The power device of claim 148 wherein the plurality of polysilicon gates
2 are of the planar gate variety.

1 150. The power device of claim 148 wherein the plurality of polysilicon gates
2 are of the trench gate variety.

1 151. A method for forming pillars of alternating conductivity type in a power
2 device, the method comprising:
3 forming one or more N-type epitaxial layers over a substrate;
4 forming P-type body regions in the one or more N-type epitaxial layers;
5 forming gate electrodes extending adjacent to but being insulated from the one or
6 more N-type epitaxial layers by a gate dielectric;

7 after forming the P-type body regions and the gate electrodes, forming a plurality
8 of deep trenches extending in the one or more N-type epitaxial layers; and
9 filling the plurality of deep trenches with P-type silicon to form a plurality of P-
10 pillars, those portions of the one or more N-type epitaxial layers separating the plurality of P-
11 pillars forming N-pillars such that the P-pillars and the N-pillars form pillars of alternating
12 conductivity type.

1 152. The method of claim 151 wherein a composite layer of oxide-nitride-oxide
2 (ONO) is used in defining and etching the plurality of deep trenches in the N-type epitaxial layer.

1 153. The method of claim 151 further comprising:
2 forming N-type source regions in the P-type body regions, wherein the plurality
3 of deep trenches are formed after forming the source regions.

1 154. The method of claim 153 further comprising:
2 after forming the plurality of deep trenches, forming a dielectric cap over each
3 gate electrode, the dielectric caps defining contact openings between adjacent trenches.

1 155. The method of claim 154 further comprising:
2 implanting P-type dopants into the P-type body regions through the contact
3 openings to form P+ heavy body regions in the P-type body regions.

1 156. The method of claim 155 further comprising:
2 prior to forming the dielectric cap, forming a conformal layer that extends
3 adjacent the gate electrodes such that the conformal layer spaces the P-type dopants implanted
4 into the P-type body regions from the edges of the gate electrodes.

1 157. The method of claim 154 comprising:
2 etching a dimple in each P-type body region; and
3 implanting P-type dopants into the bottom of each dimple to form heavy body
4 regions in the P-type body regions.

1 158. The method of claim 154 further comprising:
2 forming a source metal layer electrically contacting the N-type source regions and
3 the P+ heavy body regions through the contact openings.

1 159. The method of claim 151 wherein the power device includes an active
2 region and a termination regions surrounding the active region, both the active and termination
3 regions include a plurality of P-pillars, the method further comprising:

4 prior to forming the P-type body regions, forming a P-type Iso region in the one
5 or more N-type epitaxial layers in the termination region such that after the plurality of P-pillars
6 are formed, the P-type Iso region connects a predetermined number of the P-pillars in the
7 termination region together.

1 160. The method of claim 159 further comprising:

2 forming a source metal layer electrically contacting the P-type Iso region.

1 161. The method of claim 151 wherein the step of forming gate electrodes
2 further comprises:

3 forming shallow trenches extending into the one or more N-type epitaxial layers;
4 forming a gate dielectric layer lining the sidewalls of the shallow trenches; and
5 forming recessed gate electrodes in the shallow trenches.

1 162. The method of claim 151 wherein the step of forming gate electrodes
2 further comprises:

3 forming a gate dielectric layer over the one or more N-type epitaxial layers; and
4 forming planar gate electrodes over the gate dielectric layer, the planar gate
5 electrodes being laterally spaced from one another, and the plurality of deep trenches are formed
6 between the planar gate electrodes.

1 163. A high voltage device comprising:

2 one or more N-type epitaxial layers extending over a substrate;
3 a plurality of trenches extending into the one or more N-type epitaxial layers, the
4 plurality of trenches being filled with P-type silicon material, the P-type silicon material in the
5 plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers
6 separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form
7 alternating P-N-pillars;
8 a plurality of P-wells each formed in an upper portion of one of the P-pillars; and

9 an anode terminal comprising a Schottky barrier metal directly contacting a top
10 surface of the N-pillars to form a Schottky contact therebetween, the Schottky barrier metal
11 further directly contacting the P-wells.

1 164. The high voltage device of claim 163 wherein each P-well has a width
2 greater than a width of the P-pillars.

1 165. The high voltage device of claim 163 wherein each P-well has a width
2 substantially equal to a width of the P-pillars.

1 166. The high voltage device of claim 163 wherein each P-well includes a
2 highly doped P+ region, the Schottky barrier metal direction contacting a top surface of the P+
3 regions to form ohmic contact therebetween.

1 167. The high voltage device of claim 163 wherein the Schottky contacts are
2 formed in a Schottky region of the high voltage device, the high voltage device further
3 comprising a MOSFET region configured to include a MOSFET.

1 168. A high voltage device comprising:
2 one or more N-type epitaxial layers extending over a substrate;
3 a plurality of trenches extending into the one or more N-type epitaxial layers, the
4 plurality of trenches being filled with P-type silicon material, the P-type silicon material in the
5 plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers
6 separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form
7 alternating P-N pillars;

8 an N-type epitaxial layer extending over the alternating P-N Pillars; and

9 an anode terminal comprising a Schottky barrier metal directly contacting a top
10 surface of the N-type epitaxial layer to form a Schottky contact therebetween, the N-type
11 epitaxial layer separating the Schottky barrier metal from the P-pillars so that the P-pillars float.

1 169. The high voltage device of claim 168 wherein the Schottky contact is
2 formed in a Schottky region of the high voltage device, the high voltage device further
3 comprising a MOSFET region configured to include a MOSFET.

1 170. A high voltage device comprising:
2 one or more N-type epitaxial layers extending over a substrate;
3 a plurality of trenches extending into the one or more N-type epitaxial layers, the
4 plurality of trenches being filled with P-type silicon material, the P-type silicon material in the
5 plurality of trenches forming P-pillars, those portions of the one or more N-type epitaxial layers
6 separating the P-pillars forming N-pillars such that the N-pillars and the P-pillars form
7 alternating P-N pillars;
8 an N-type implant region extending through an upper portion of the alternating P-
9 N pillars; and
10 an anode terminal comprising a Schottky barrier metal directly contacting a top
11 surface of the N-type implant region to form a Schottky contact therebetween, the N-type
12 implant region separating the Schottky barrier metal from the P-pillars so that the P-pillars float.

1 171. The high voltage device of claim 170 wherein the Schottky contact is
2 formed in a Schottky region of the high voltage device, the high voltage device further
3 comprising a MOSFET region configured to include a MOSFET.

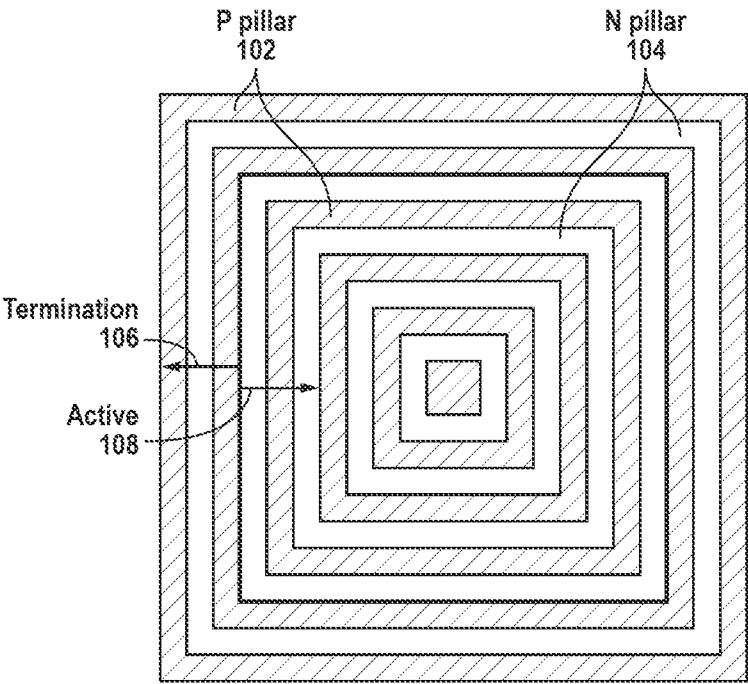


FIG. 1A

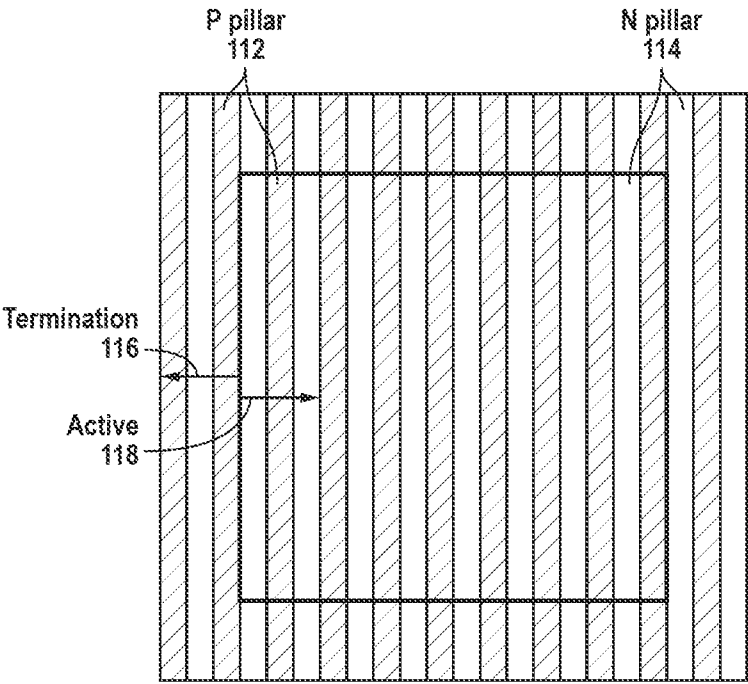


FIG. 1B

2/54

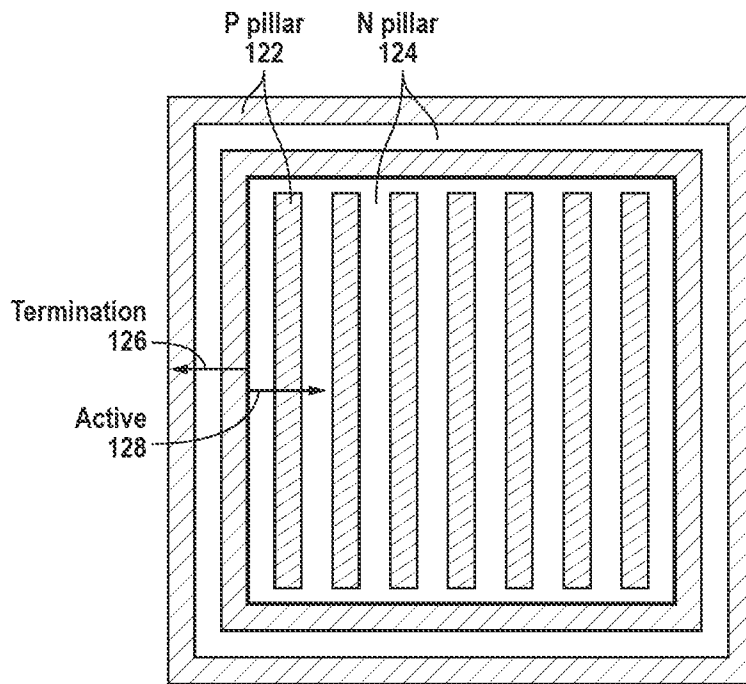


FIG. 1C

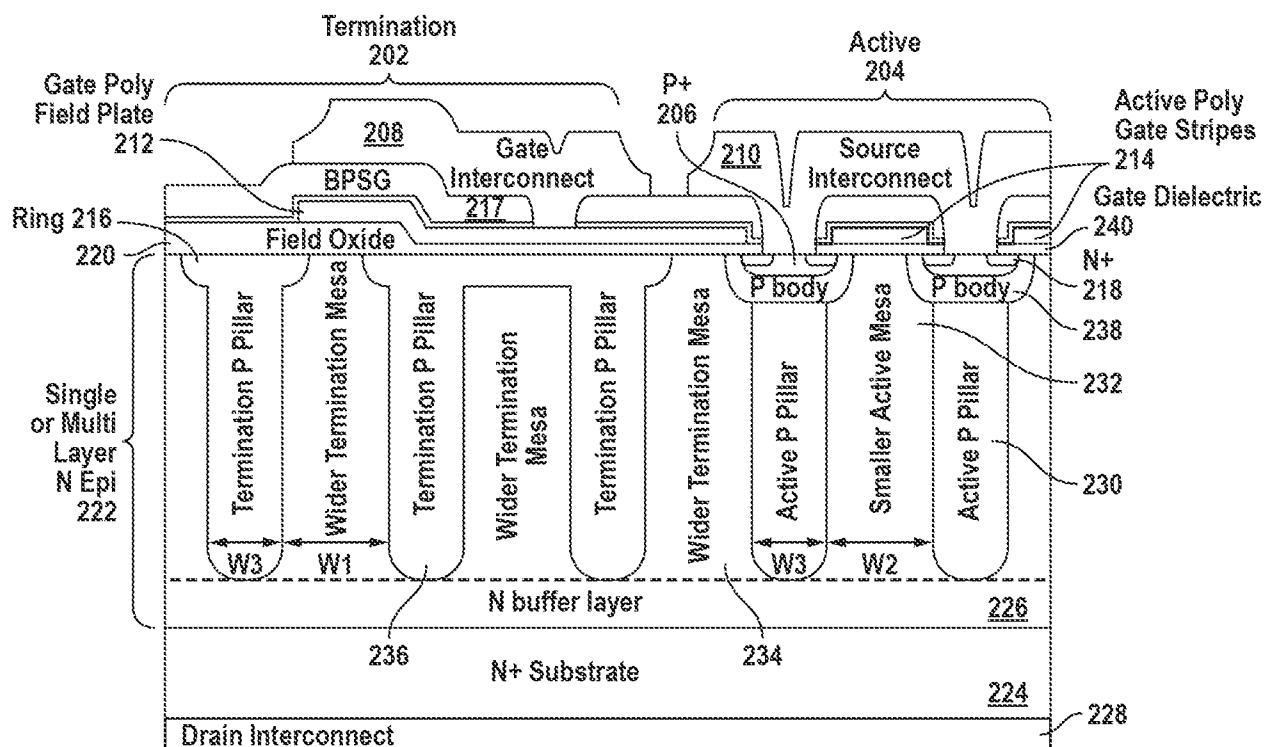
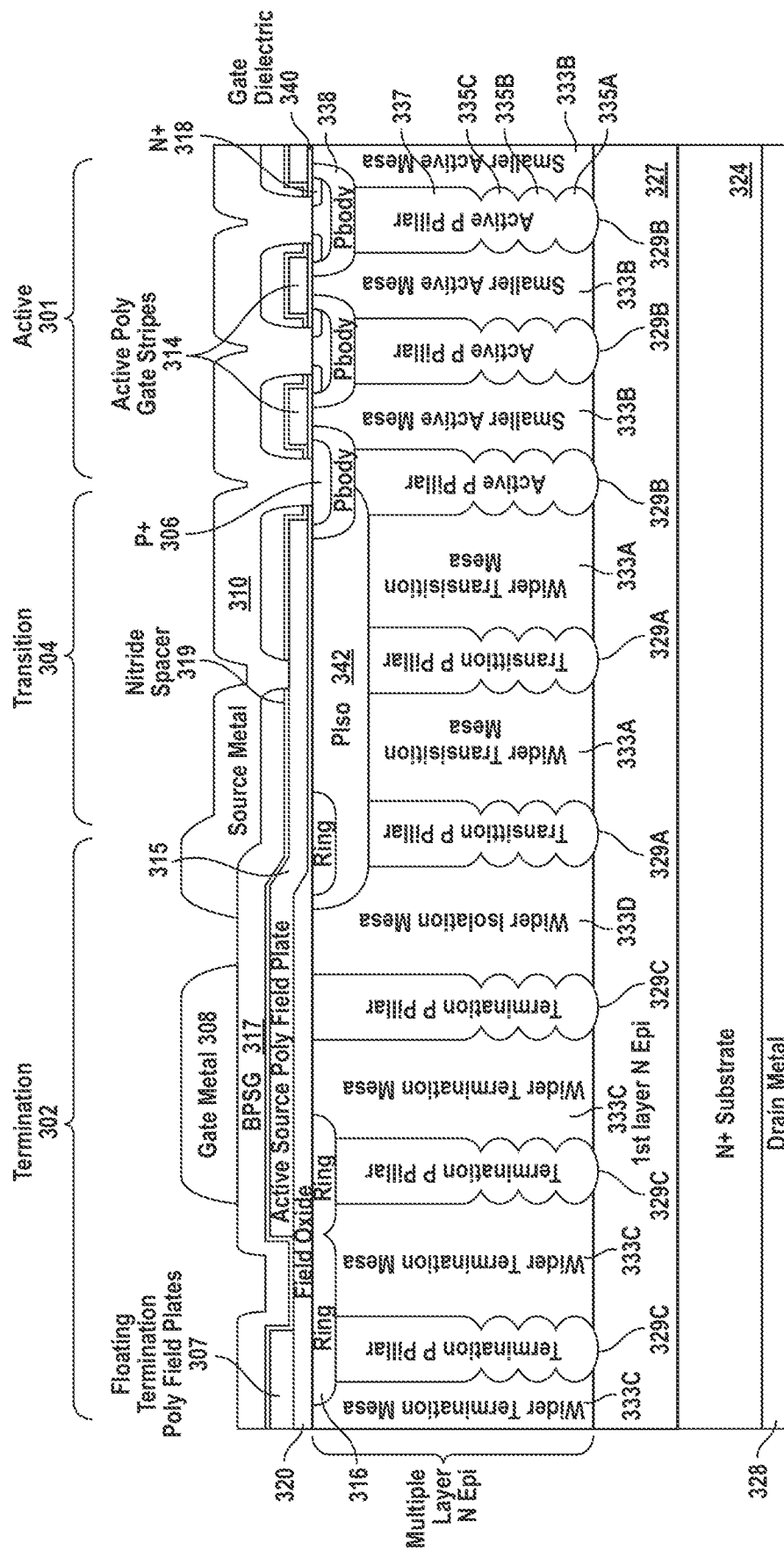


FIG. 2



364

+

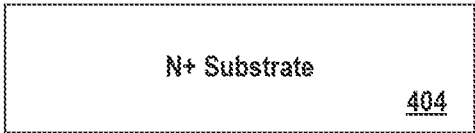


FIG. 4A

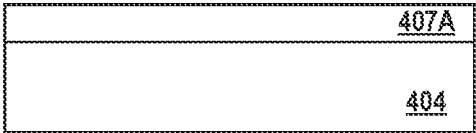


FIG. 4B

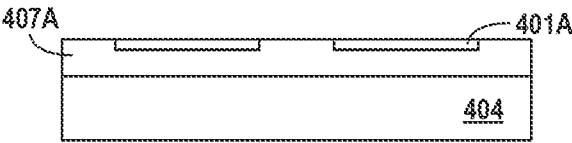


FIG. 4C

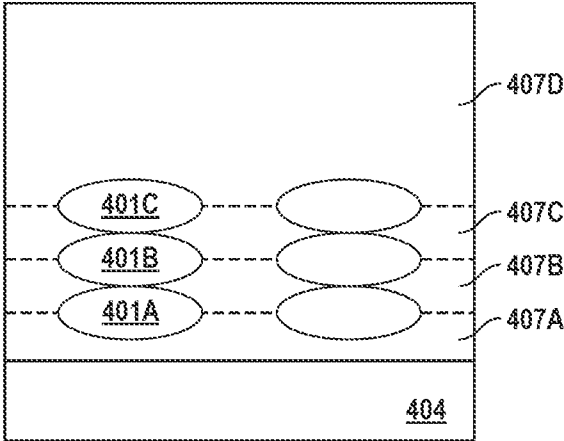


FIG. 4D

+

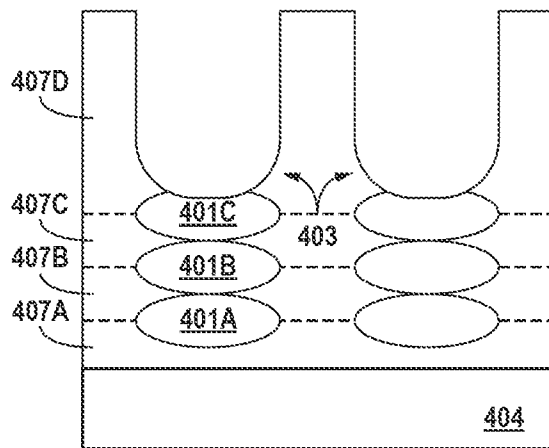


FIG. 4E

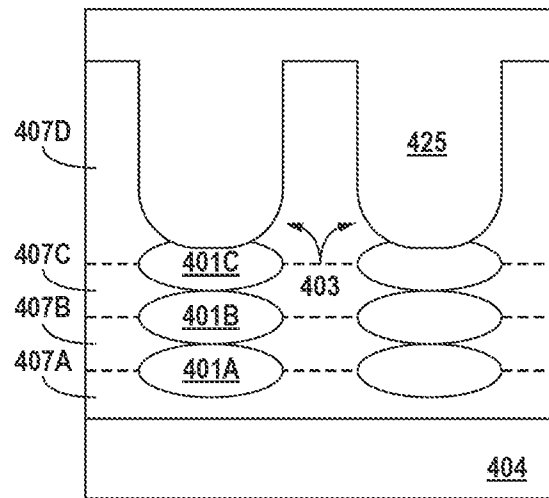


FIG. 4F

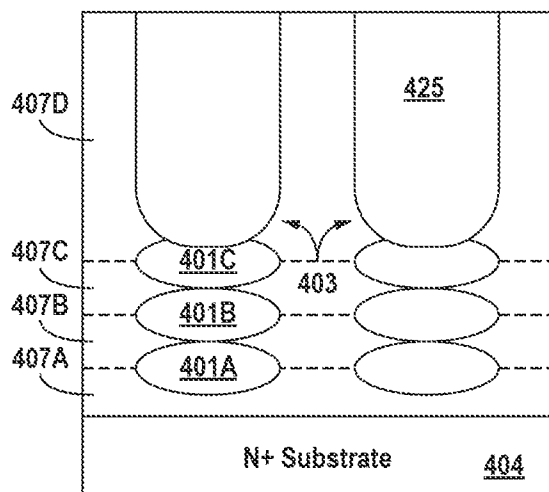


FIG. 4G

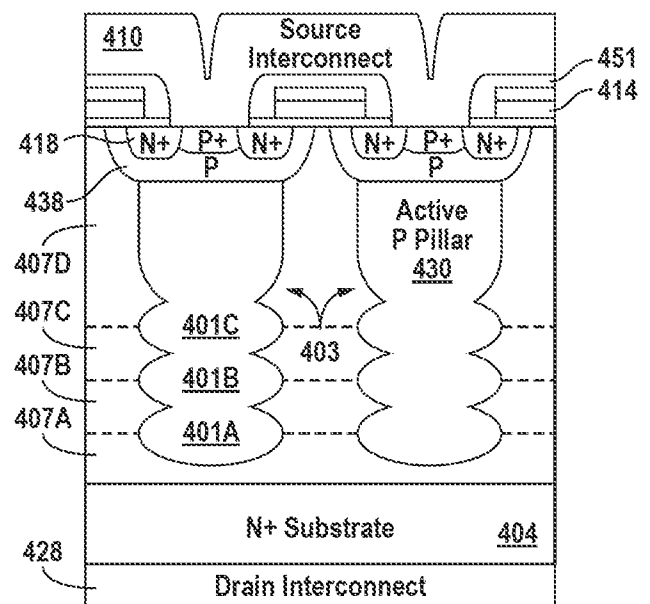


FIG. 4H

6/54

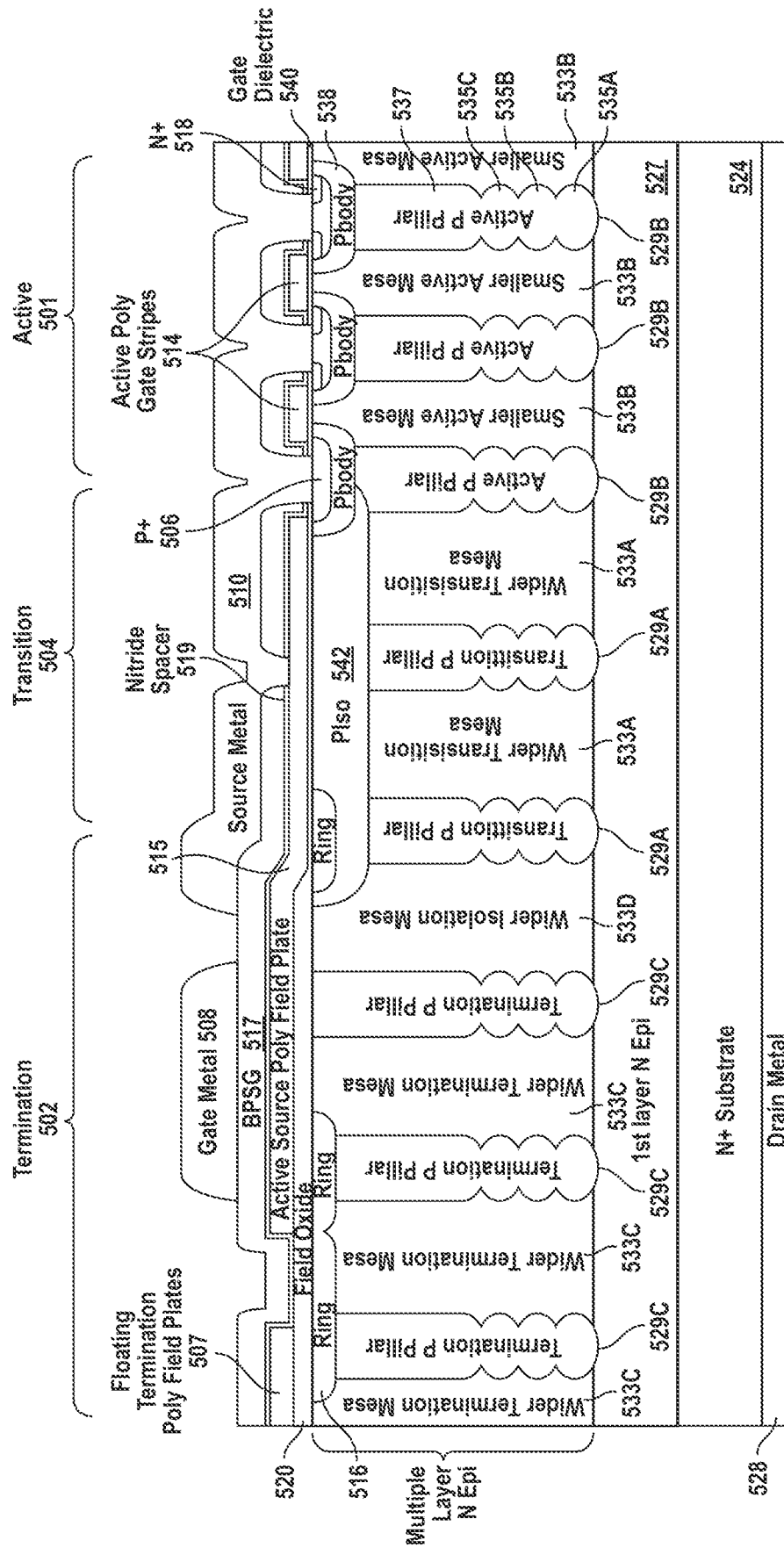


FIG. 5A

7/54

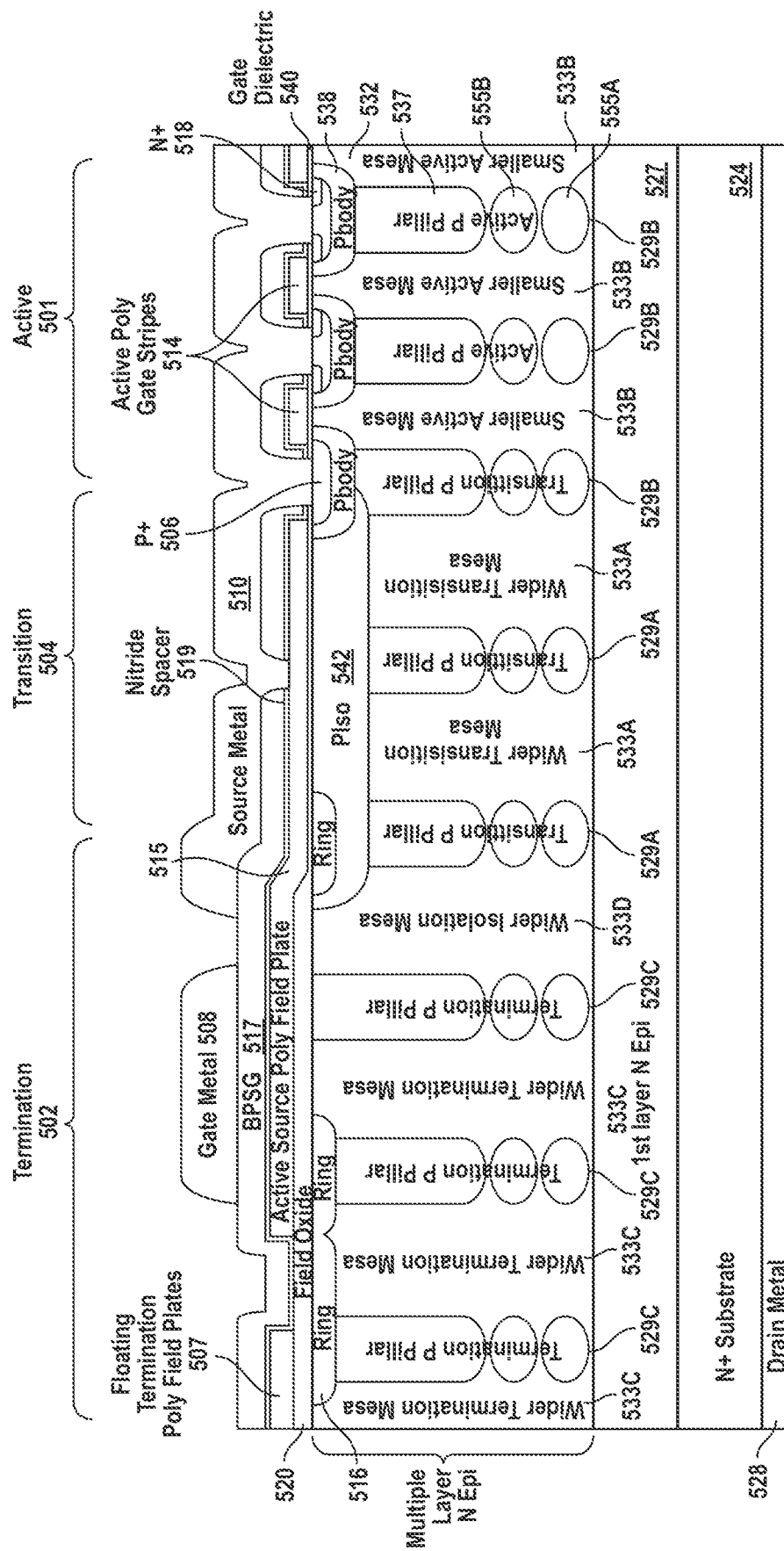


FIG. 5B

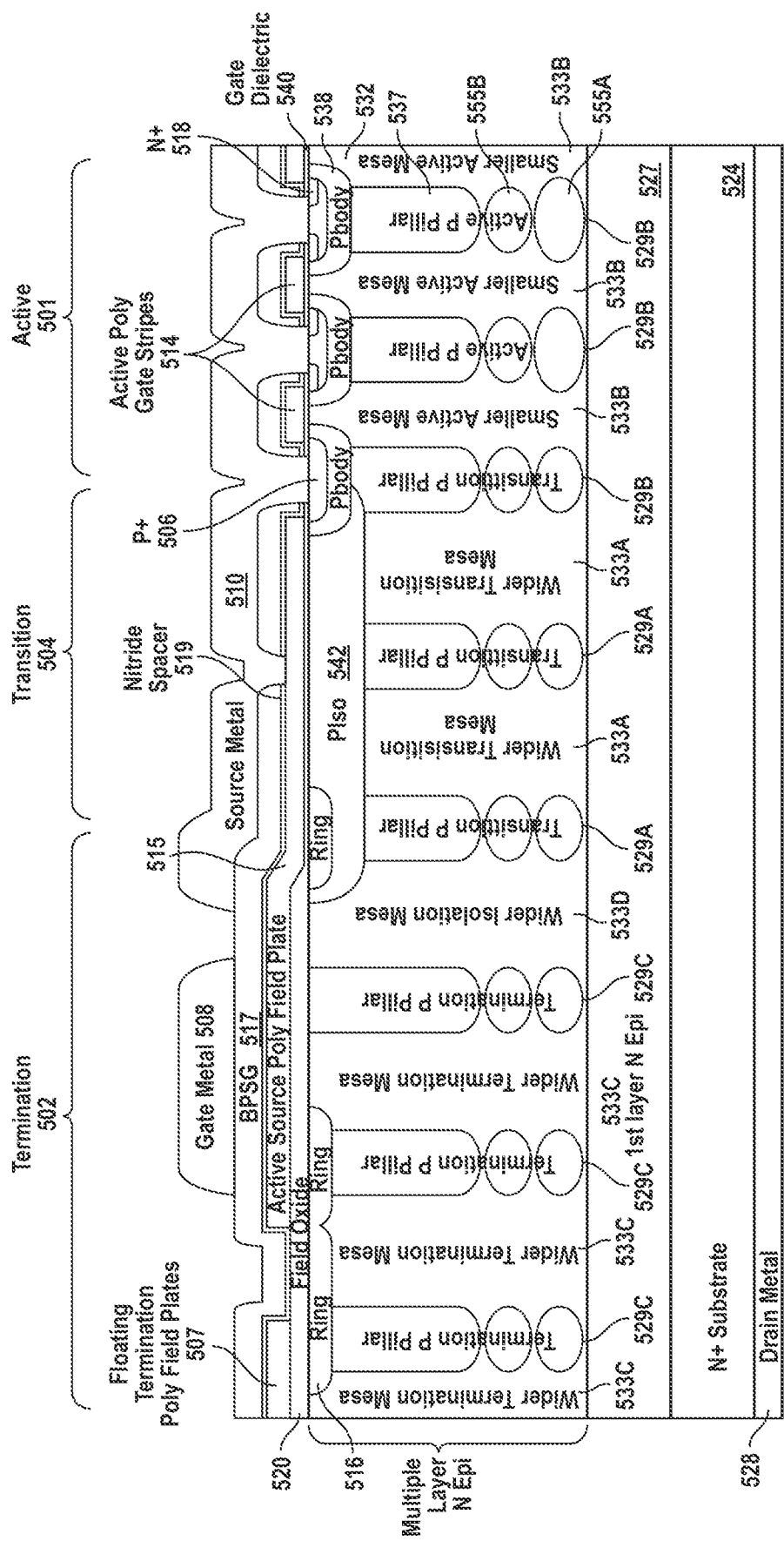


FIG. 5C

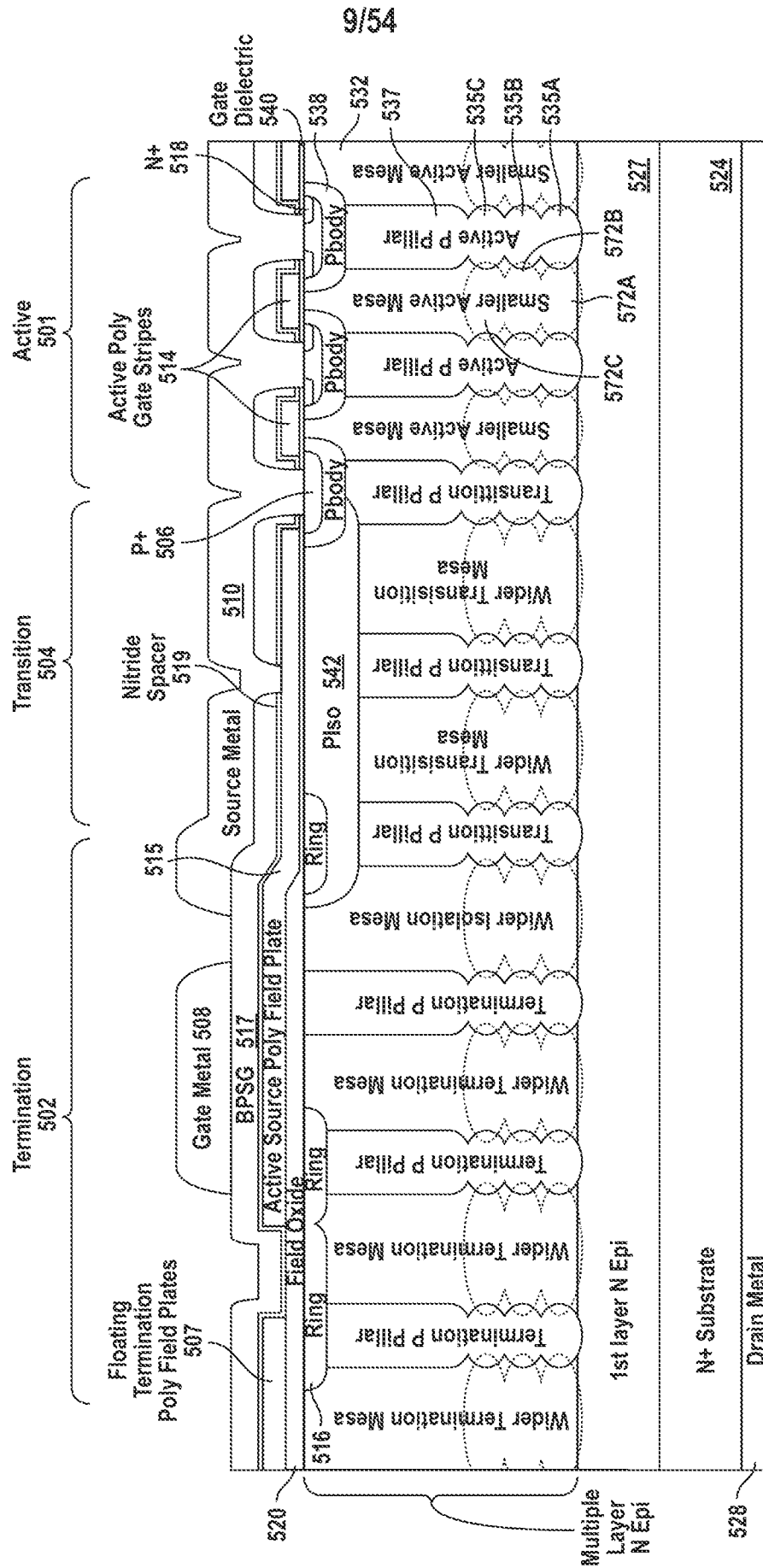


FIG. 5D

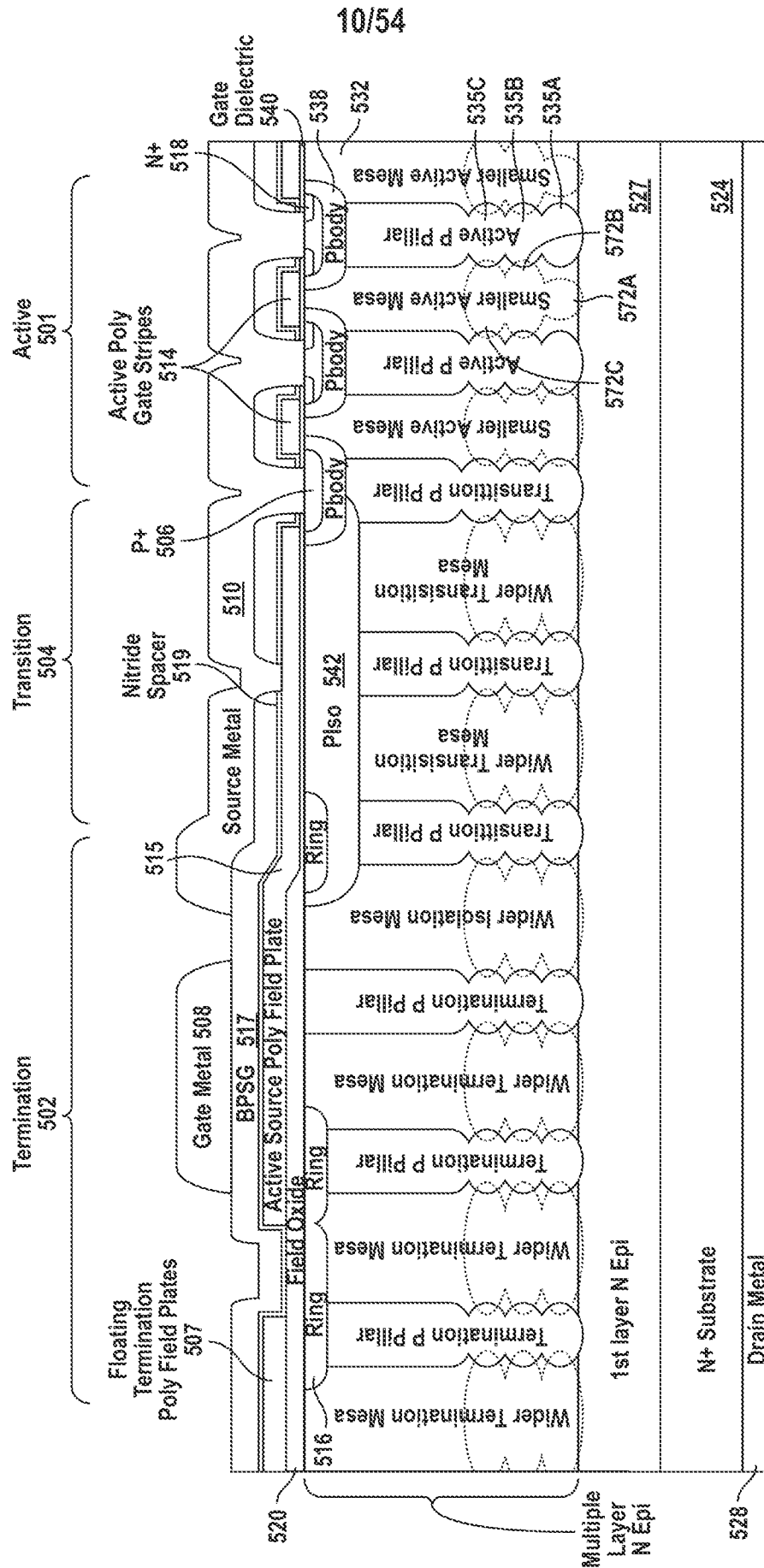


FIG. 5E

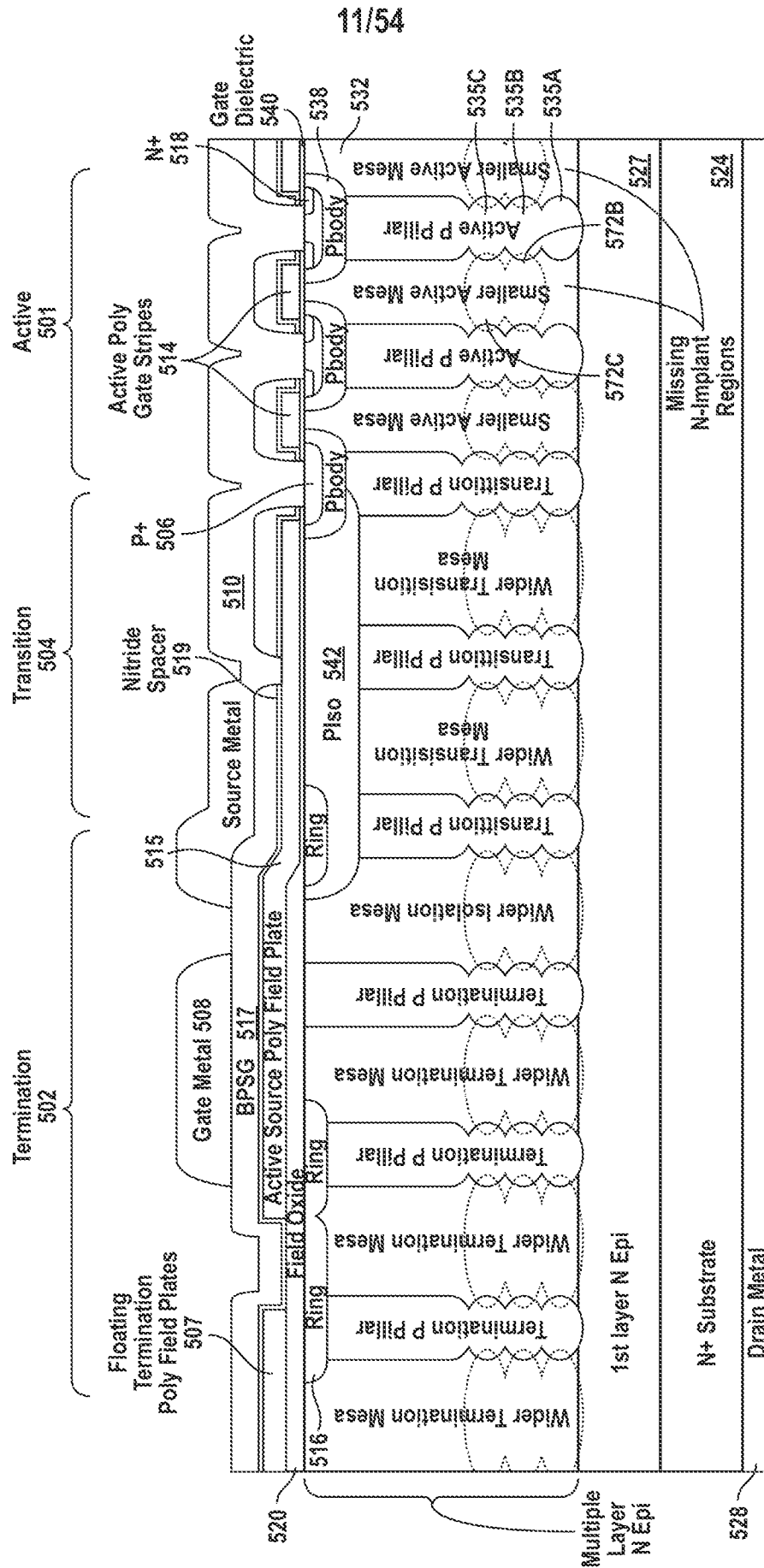
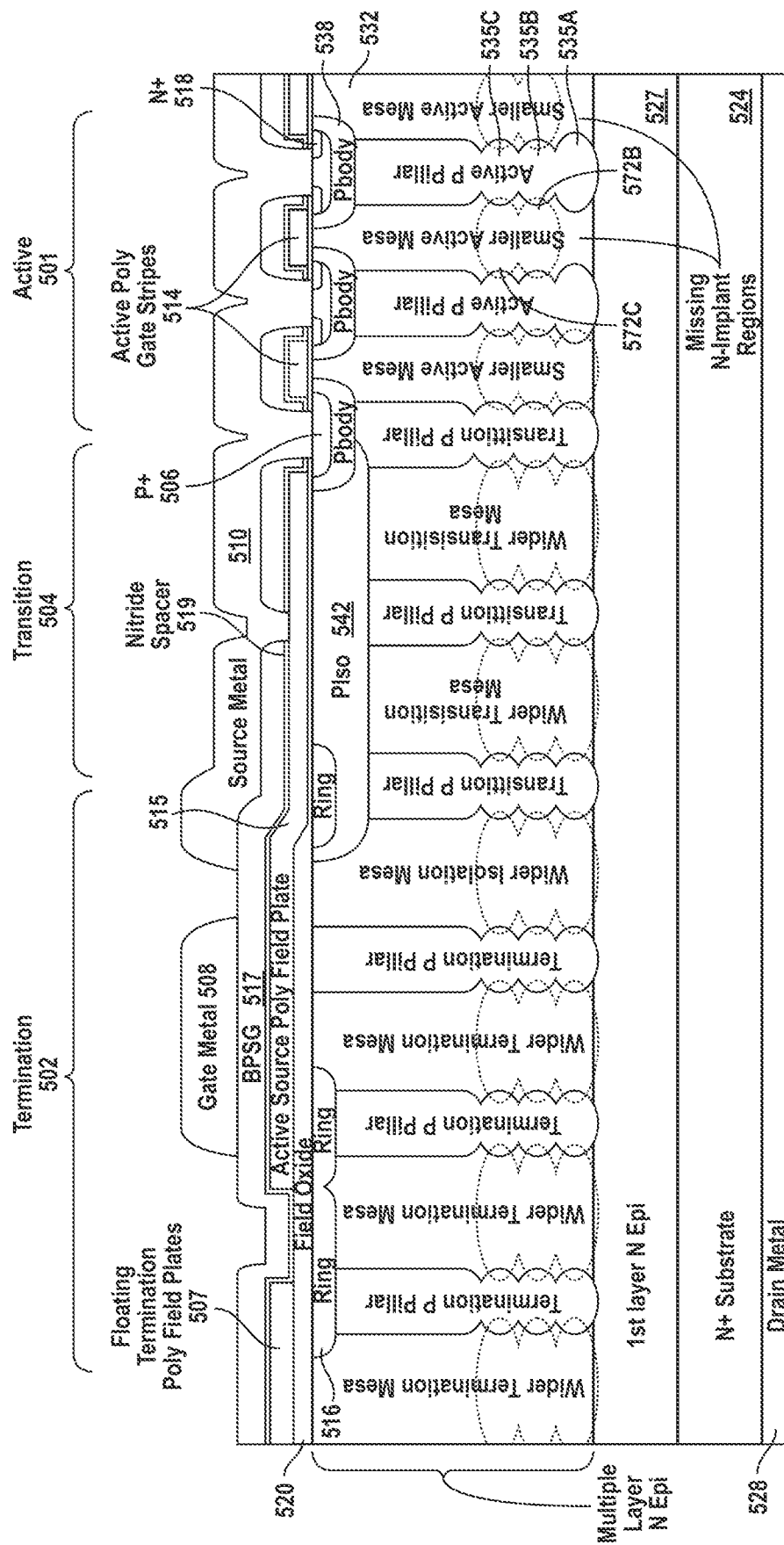
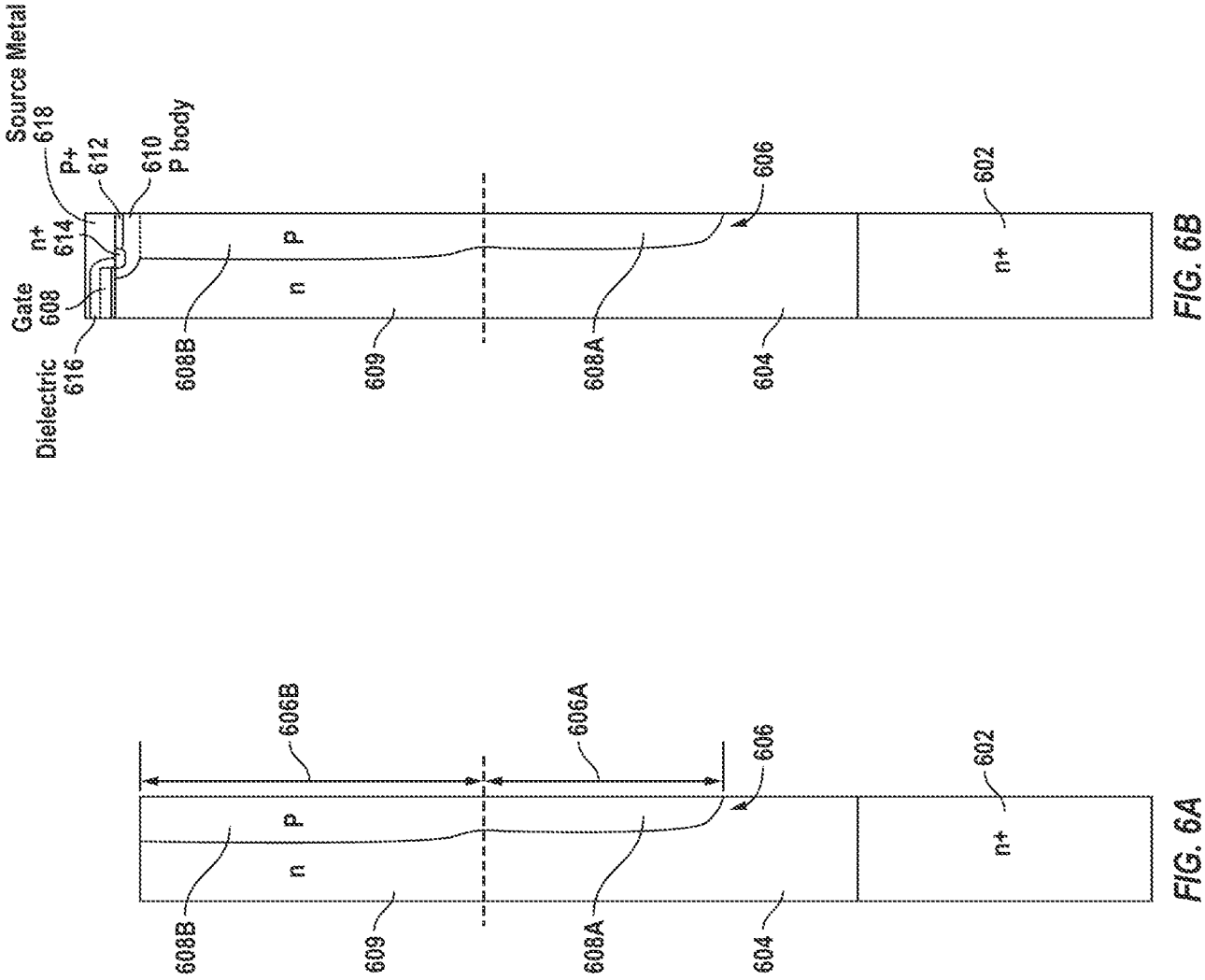


Fig. 5



55



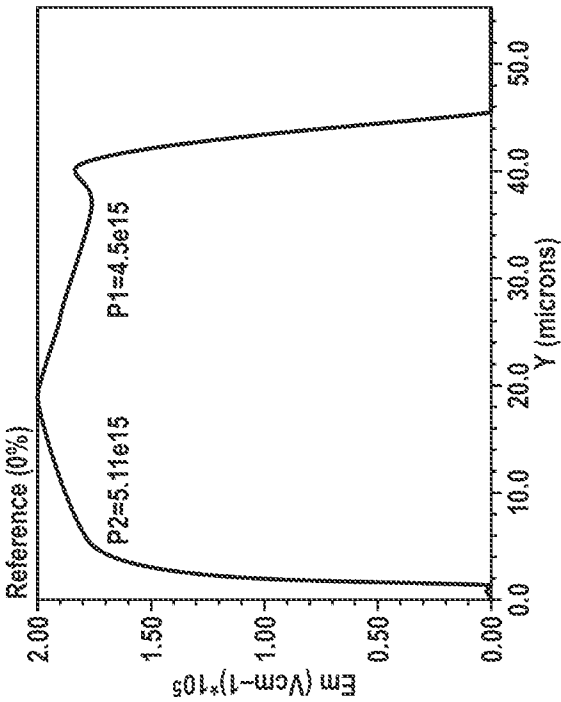


FIG. 7A

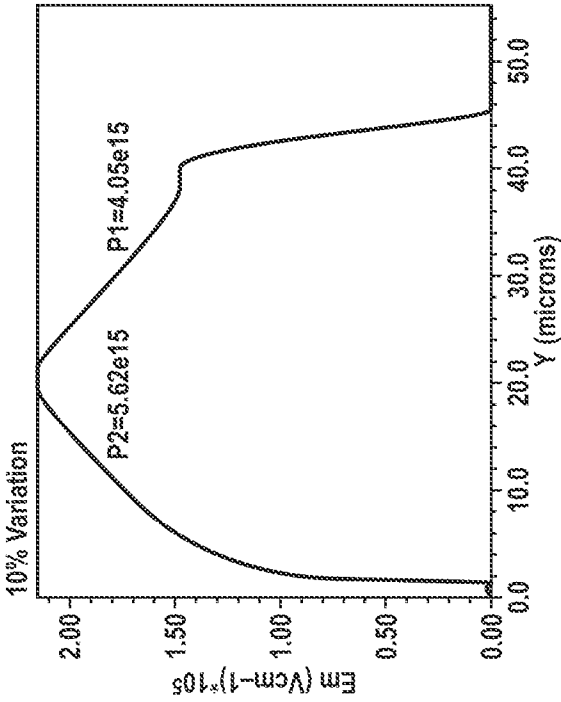


FIG. 7B

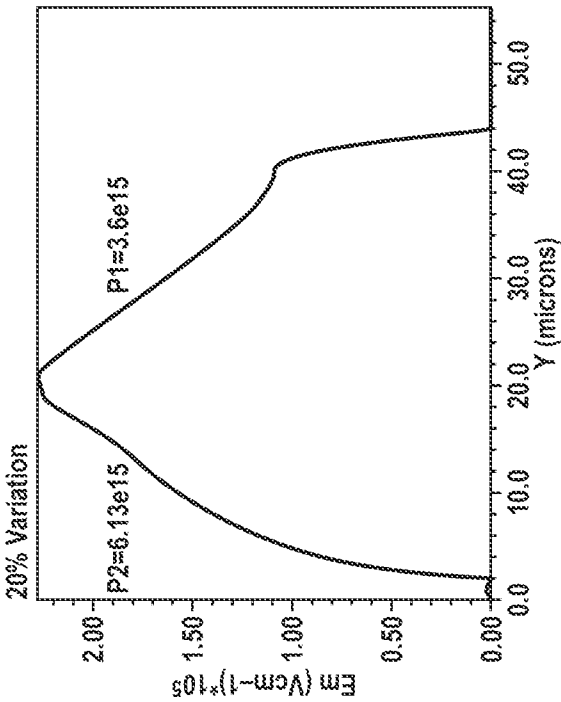


FIG. 7C

Control degree of E field concentration:
• t1 (epi 1 thickness) = t2 (epi 2 thickness) = 25 um
• N1 (epi 1 concentration) = N2 (epi 2 concentration) = 3.03e15cm⁻³

	Bottom Pillar		Top Pillar		BV	Rsp
	N-Mesa	P-Fill	N-Mesa	P-Fill		
0%		4.50E+15		5.11E+15	772	20.6
10% var.	3.03E+15	4.05E+15	3.03E+15	5.62E+15	715	20.6
20% var.		3.60E+15		6.13E+15	639	20.5

FIG. 7D

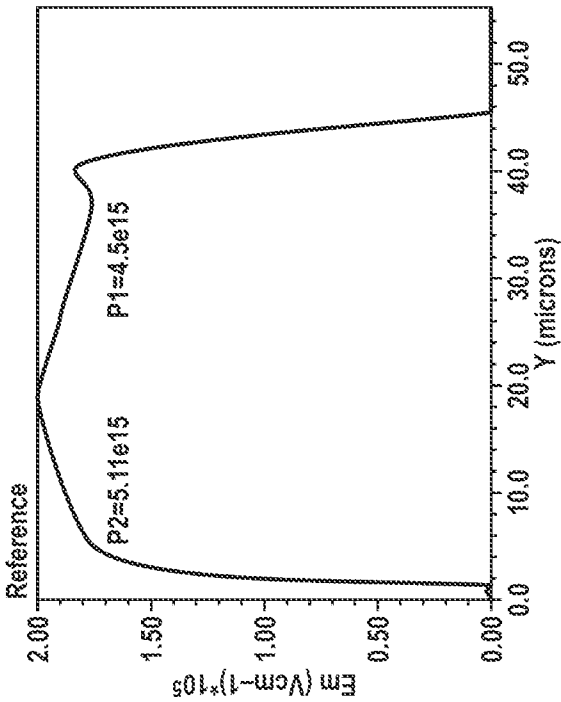


FIG. 8A

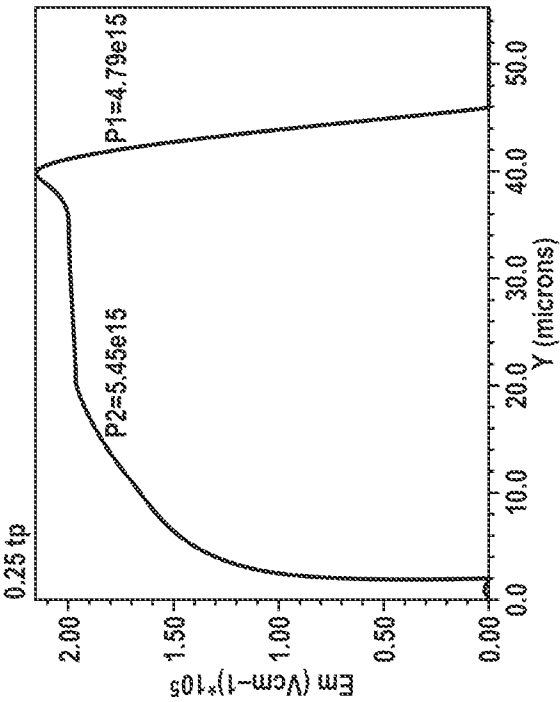


FIG. 8C

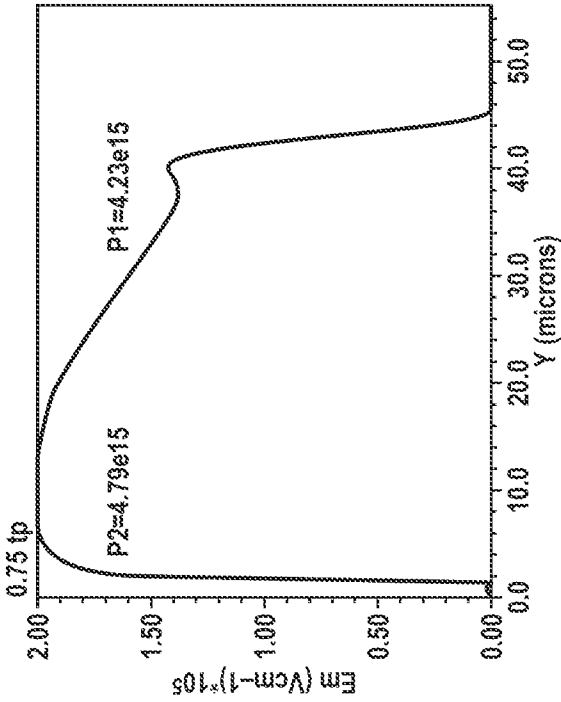


FIG. 8B

Peak field position control

- t1 (epi 1 thickness) = t2 (epi 2 thickness) = 25 um
- N1 (epi 1 concentration) = N2 (epi 2 concentration) = 3.03e15cm⁻³

	Bottom Pillar		Top Pillar		BV	Rsp
	N-Mesa	P-Fill	N-Mesa	P-Fill		
Center						
0.75 tp	3.03E+15	4.23E+15	3.03E+15	4.79E+15	725	20.3
0.25 tp		4.79E+15		5.45E+15	773	21.0

FIG. 8D

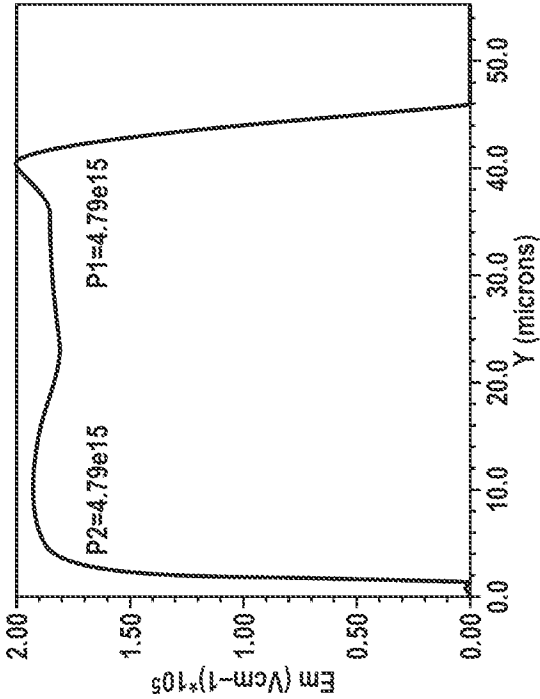


FIG. 9A

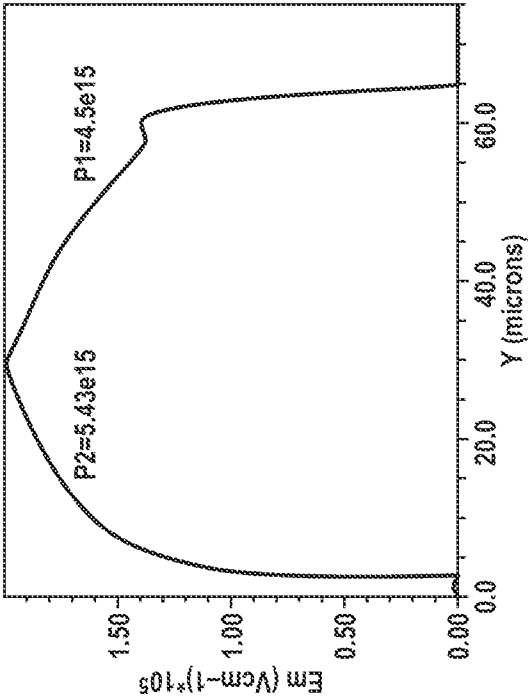


FIG. 10A

Double peak

- t1 = t2 = 25um
- N1 = N2 = 3.03e15cm⁻³

	Bottom Pillar		Top Pillar		BV	Rsp
	N-Mesa	P-Fill	N-Mesa	P-Fill		
Center	3.03E+15	4.79E+15	3.03E+15	4.79E+15	790	20.7

FIG. 9B

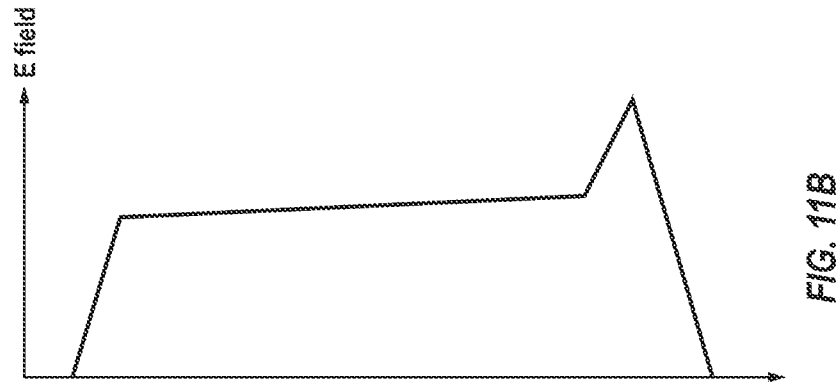
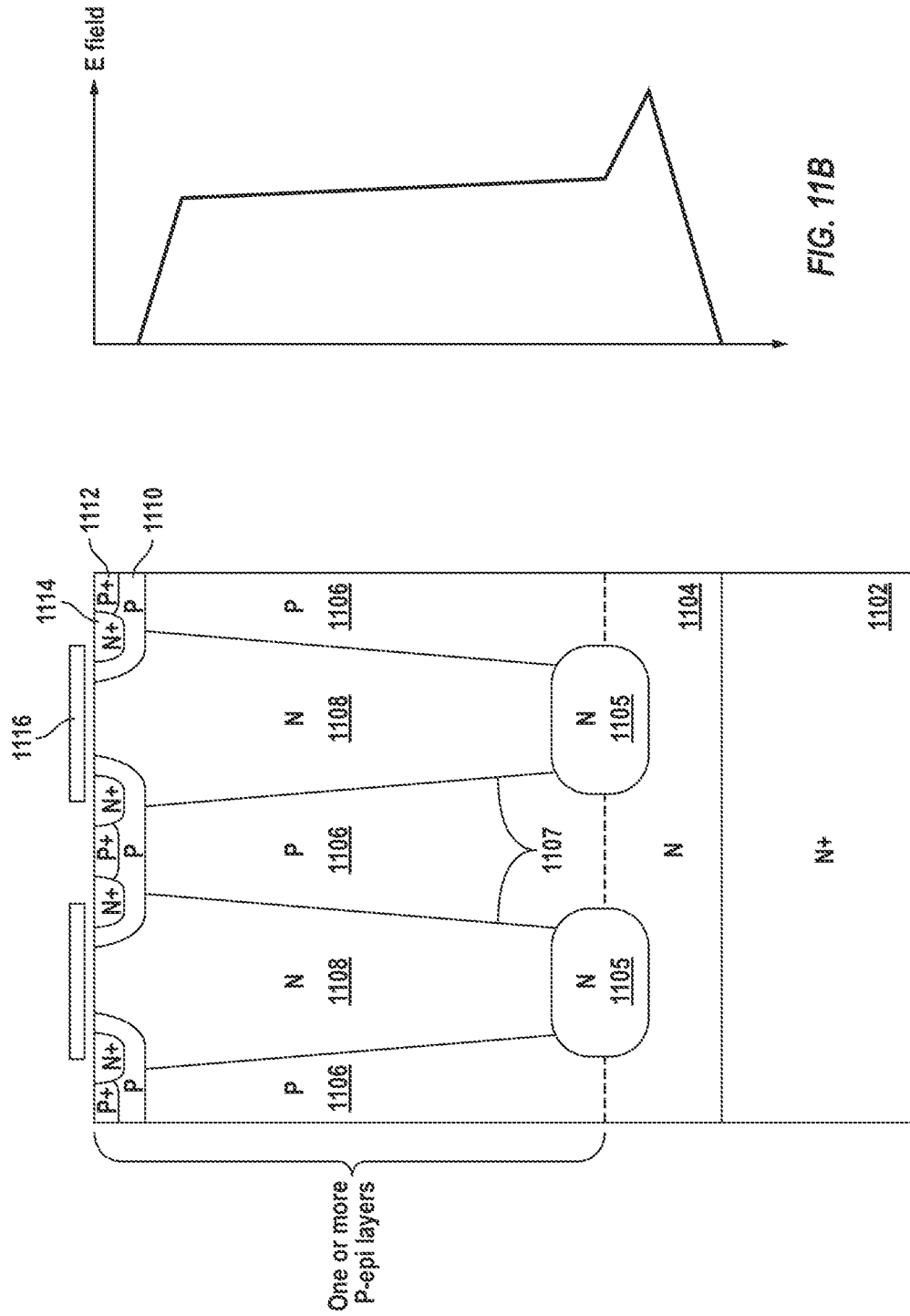
Can easily increase breakdown voltage

- t1 = t2 = 35um
- N1 = N2 = 3.03e15cm⁻³

	Bottom Pillar		Top Pillar		BV	Rsp
	N-Mesa	P-Fill	N-Mesa	P-Fill		
Center	3.03E+15	4.50E+15	3.03E+15	5.43E+15	1021	29.7

cf) QFET 900V
Rsp=260mΩ-cm²

FIG. 10B



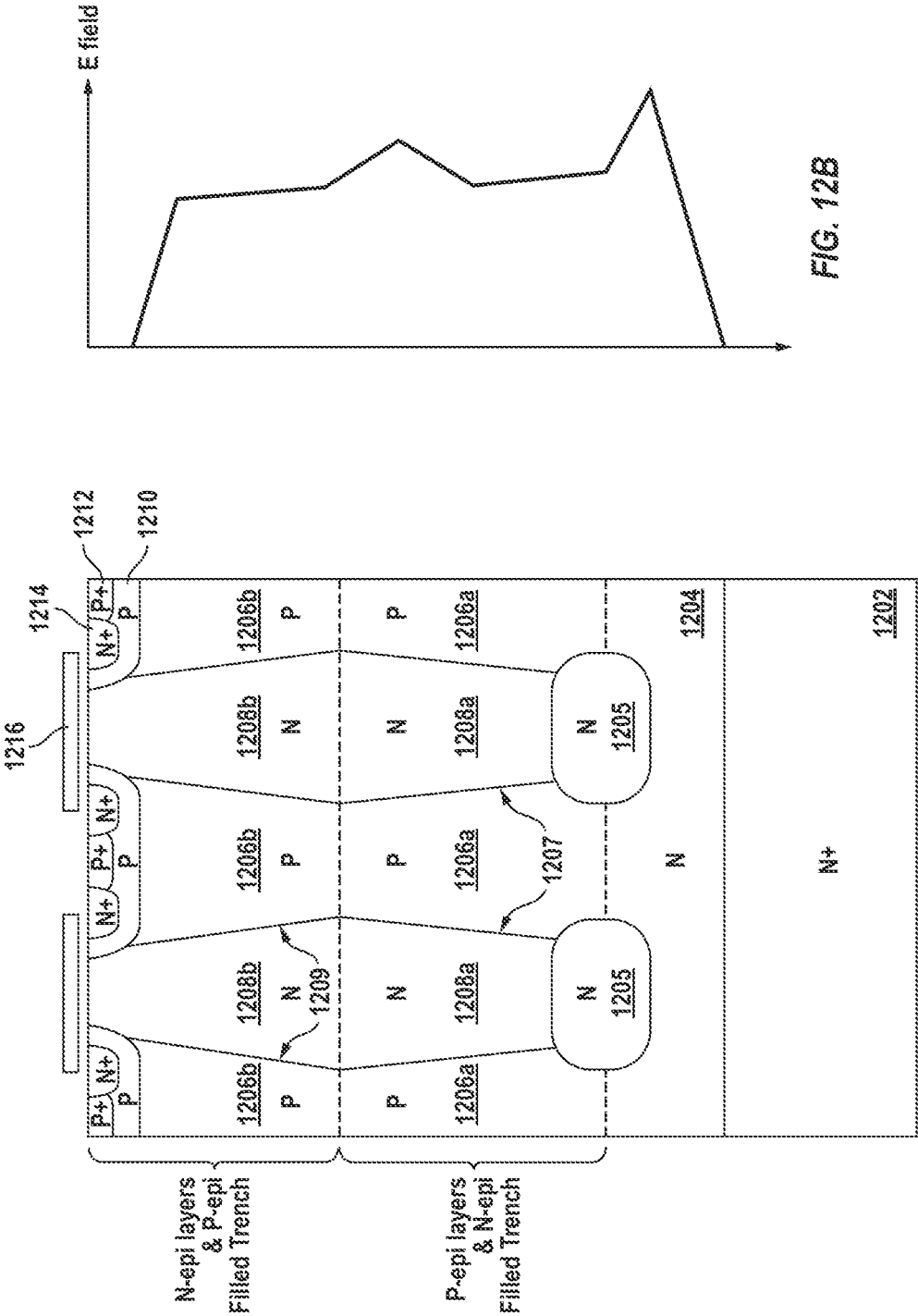


FIG. 12A

FIG. 12B

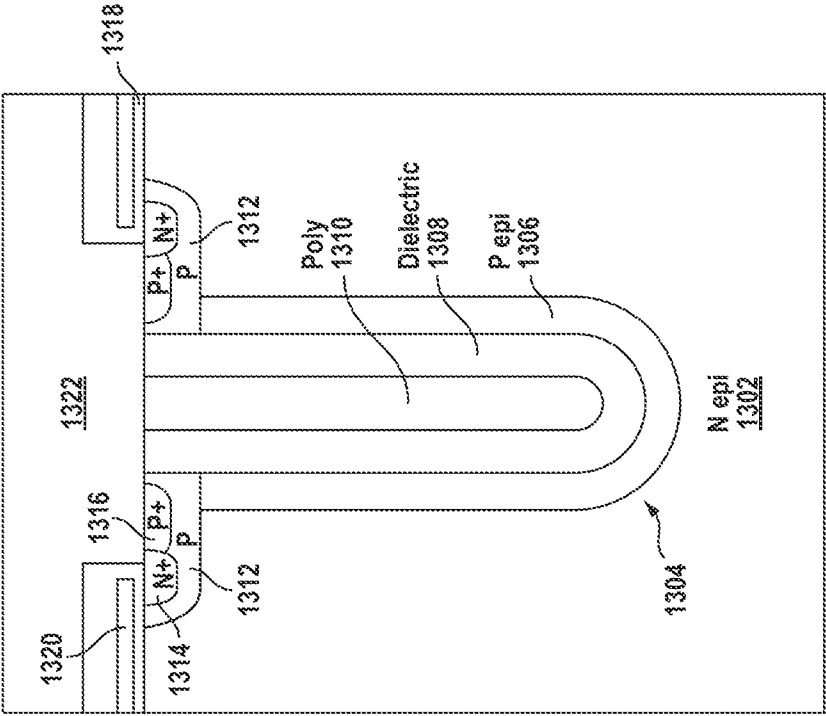


FIG. 13B

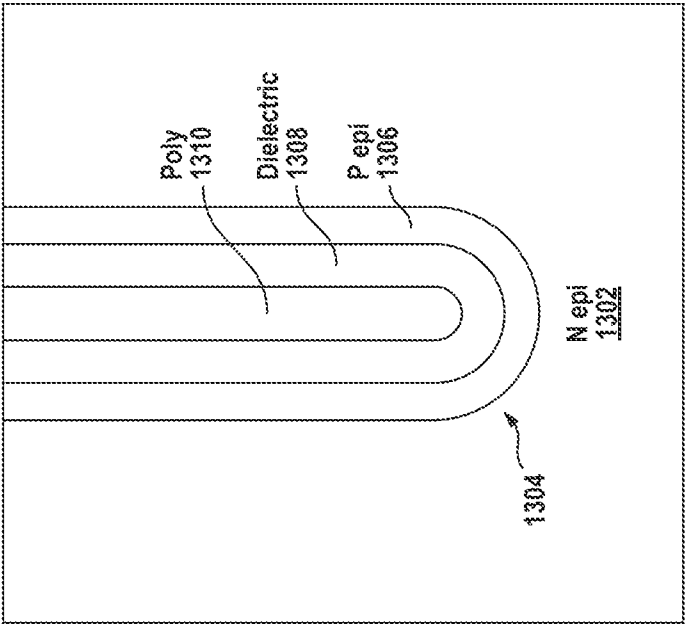


FIG. 13A

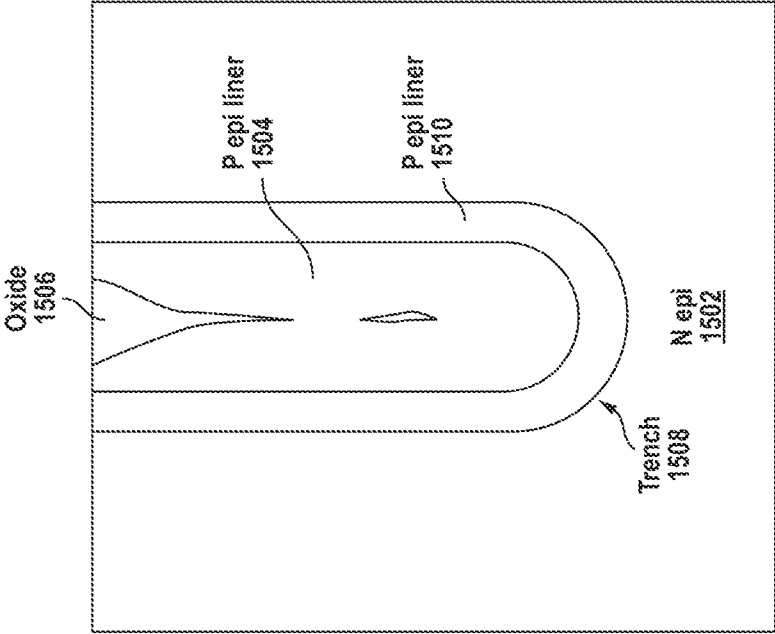


FIG. 15

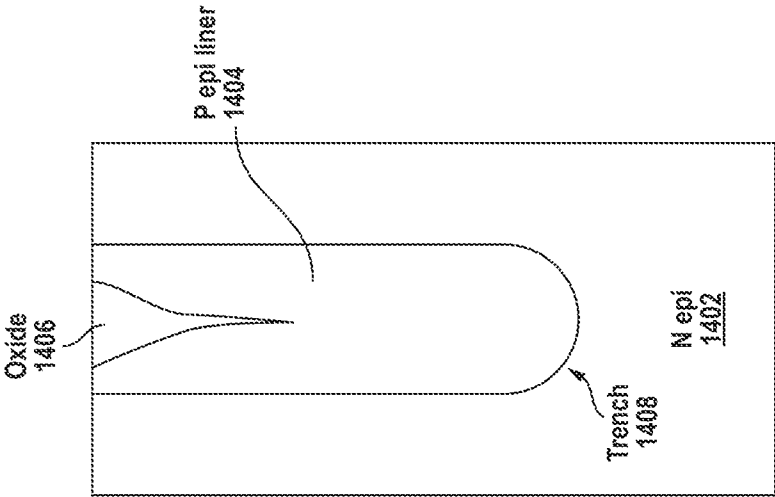
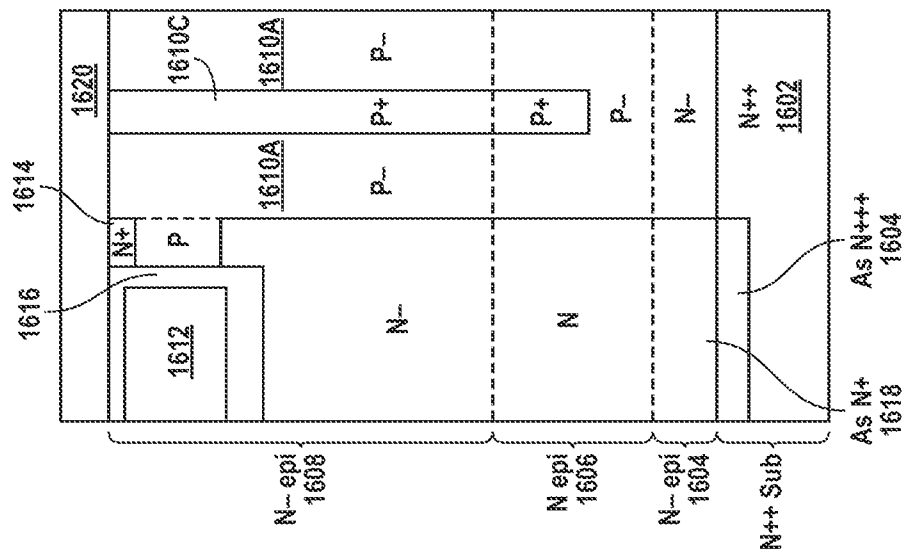
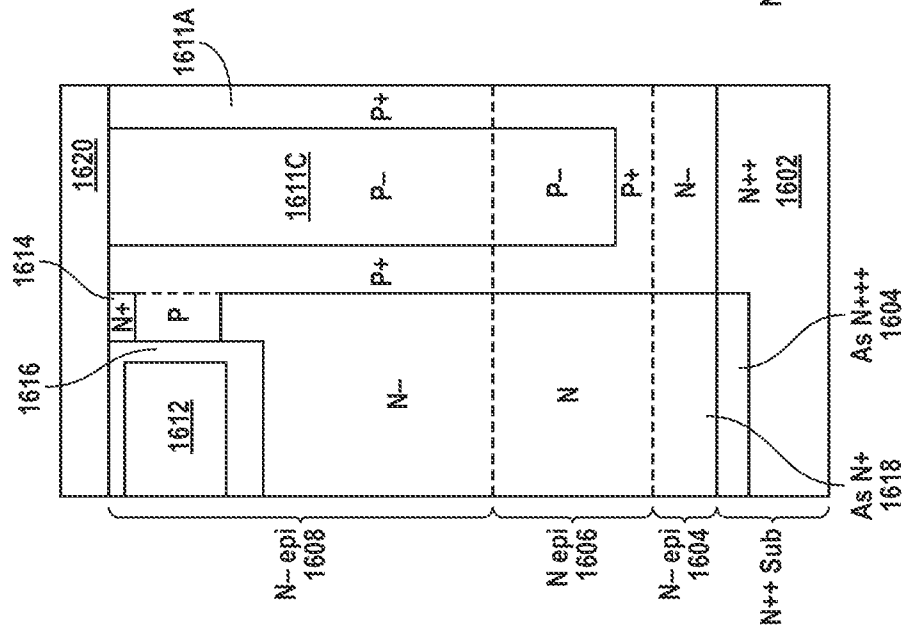
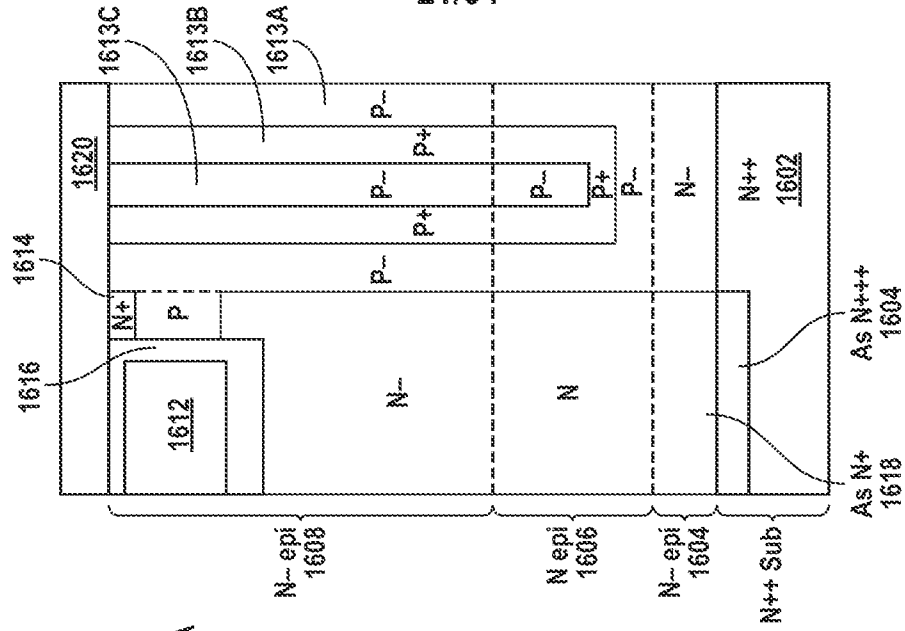


FIG. 14



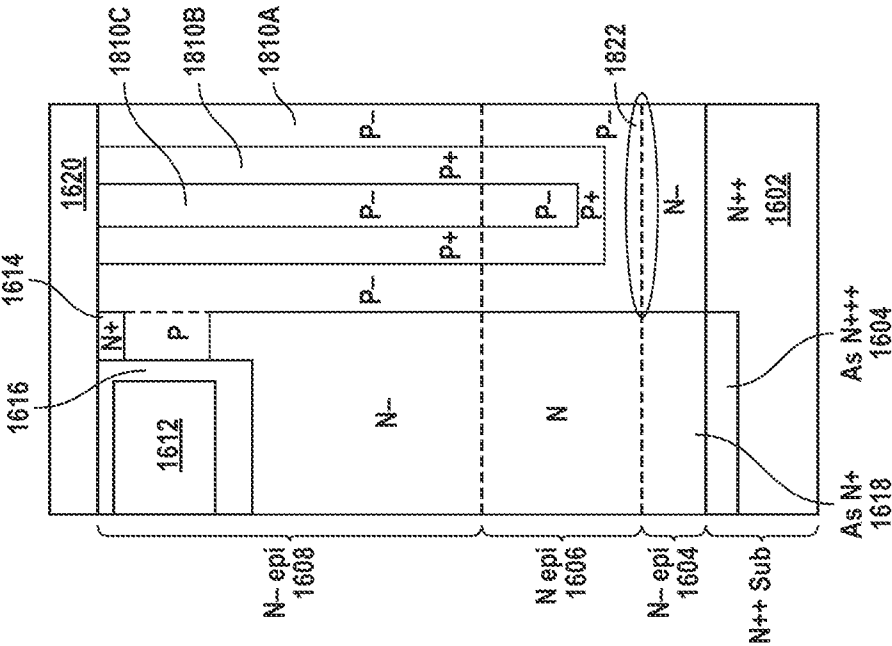


FIG. 17

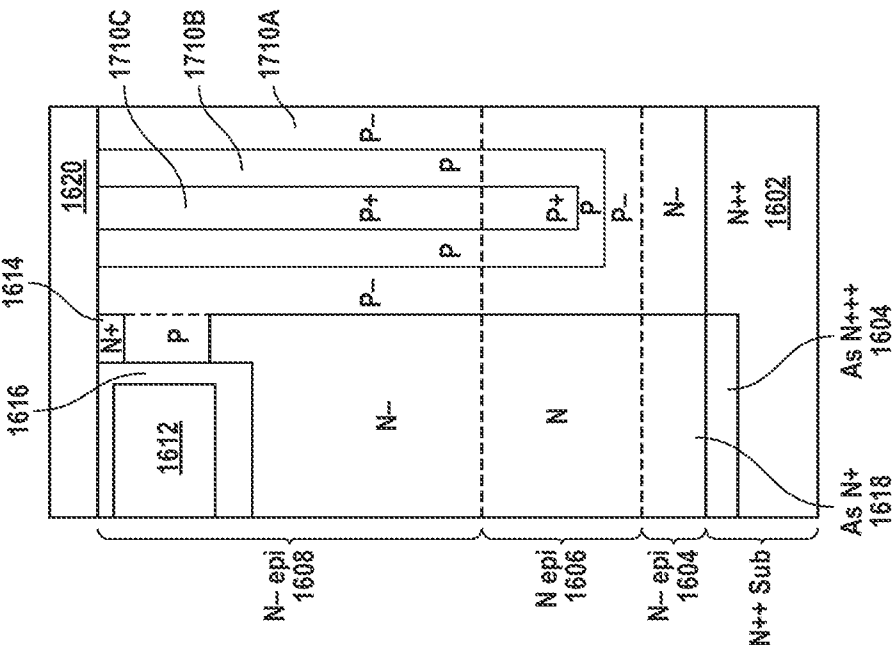


FIG. 18

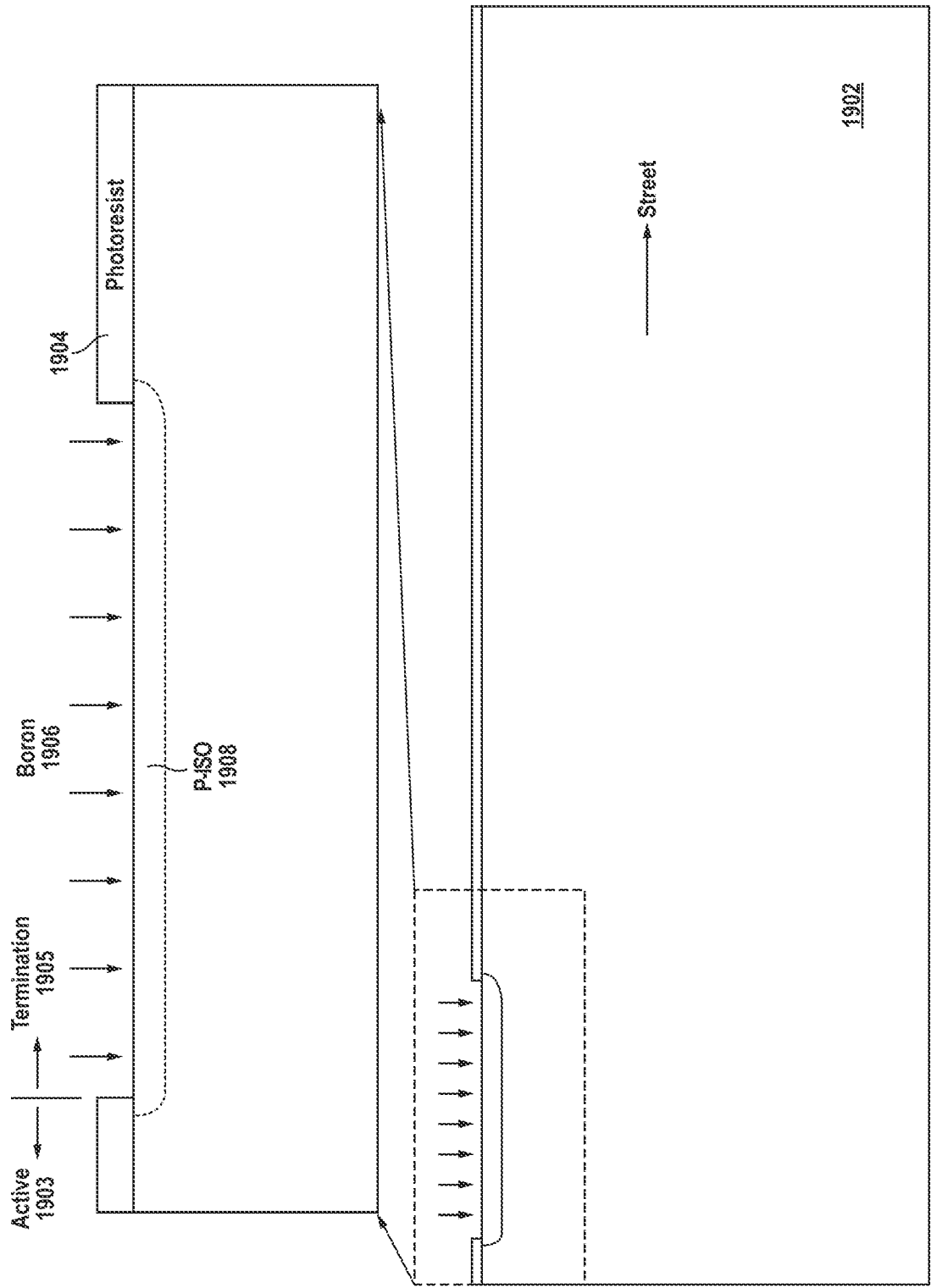
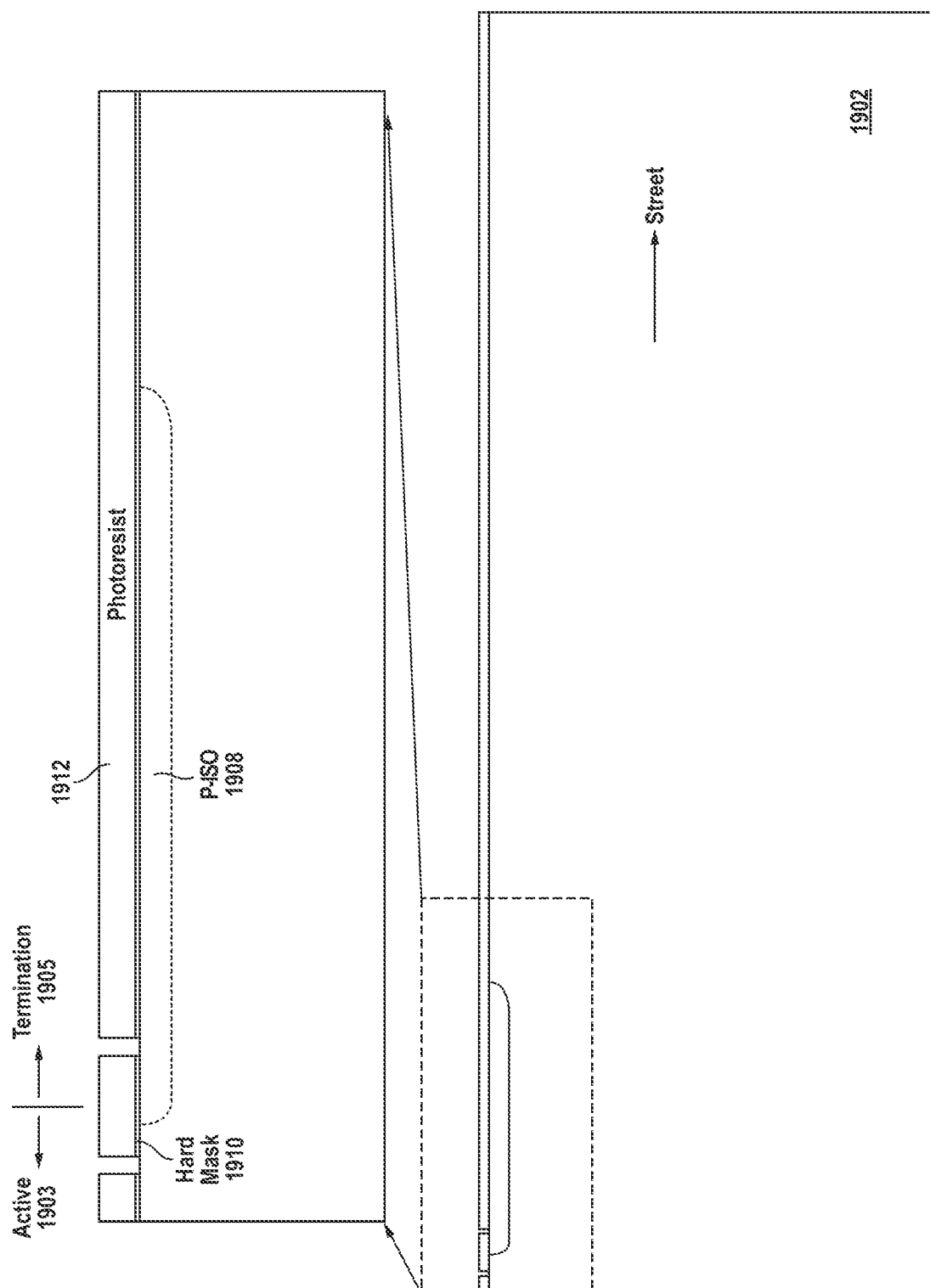


FIG. 19A



১৯৭৬

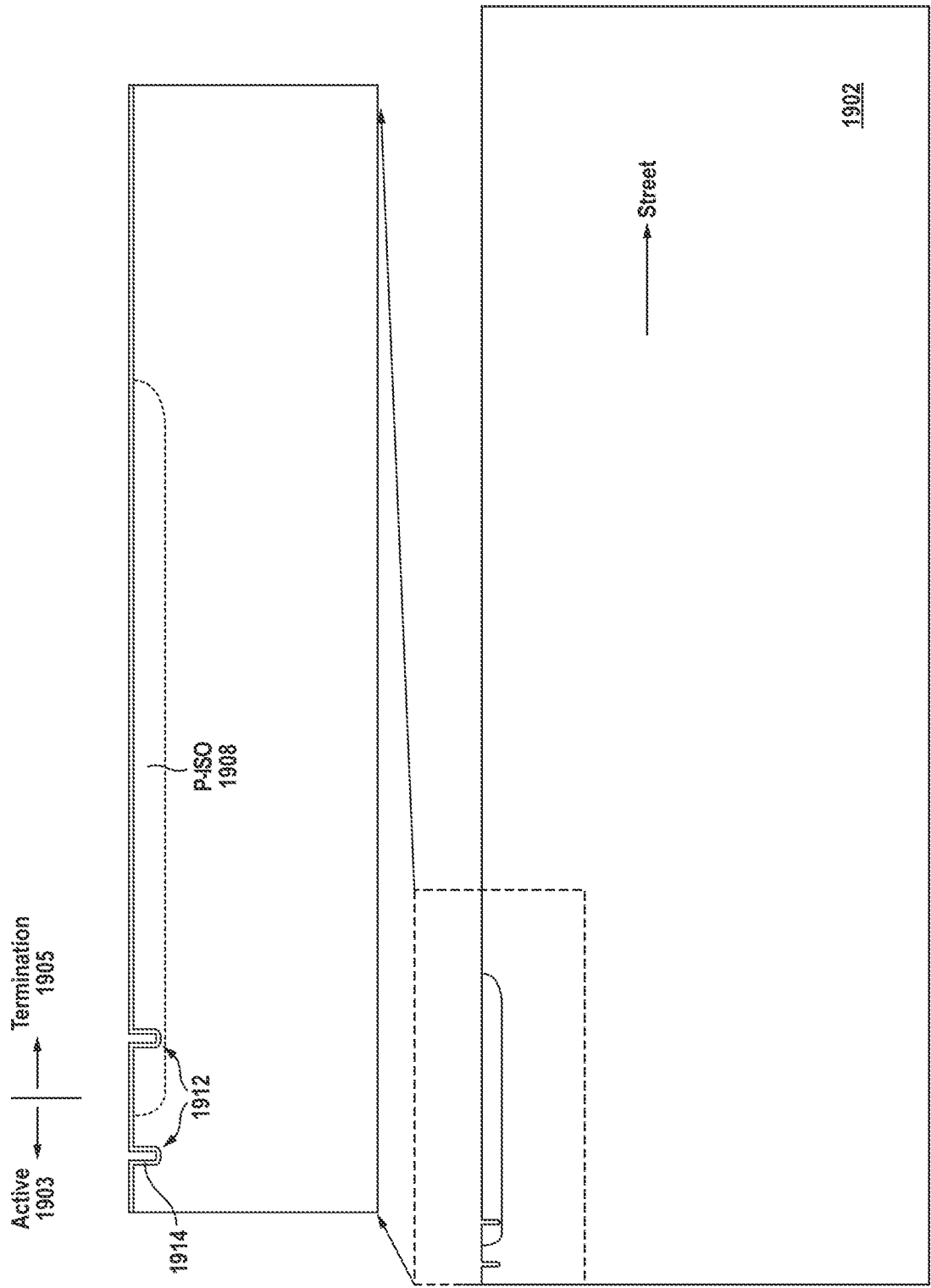


FIG. 19C

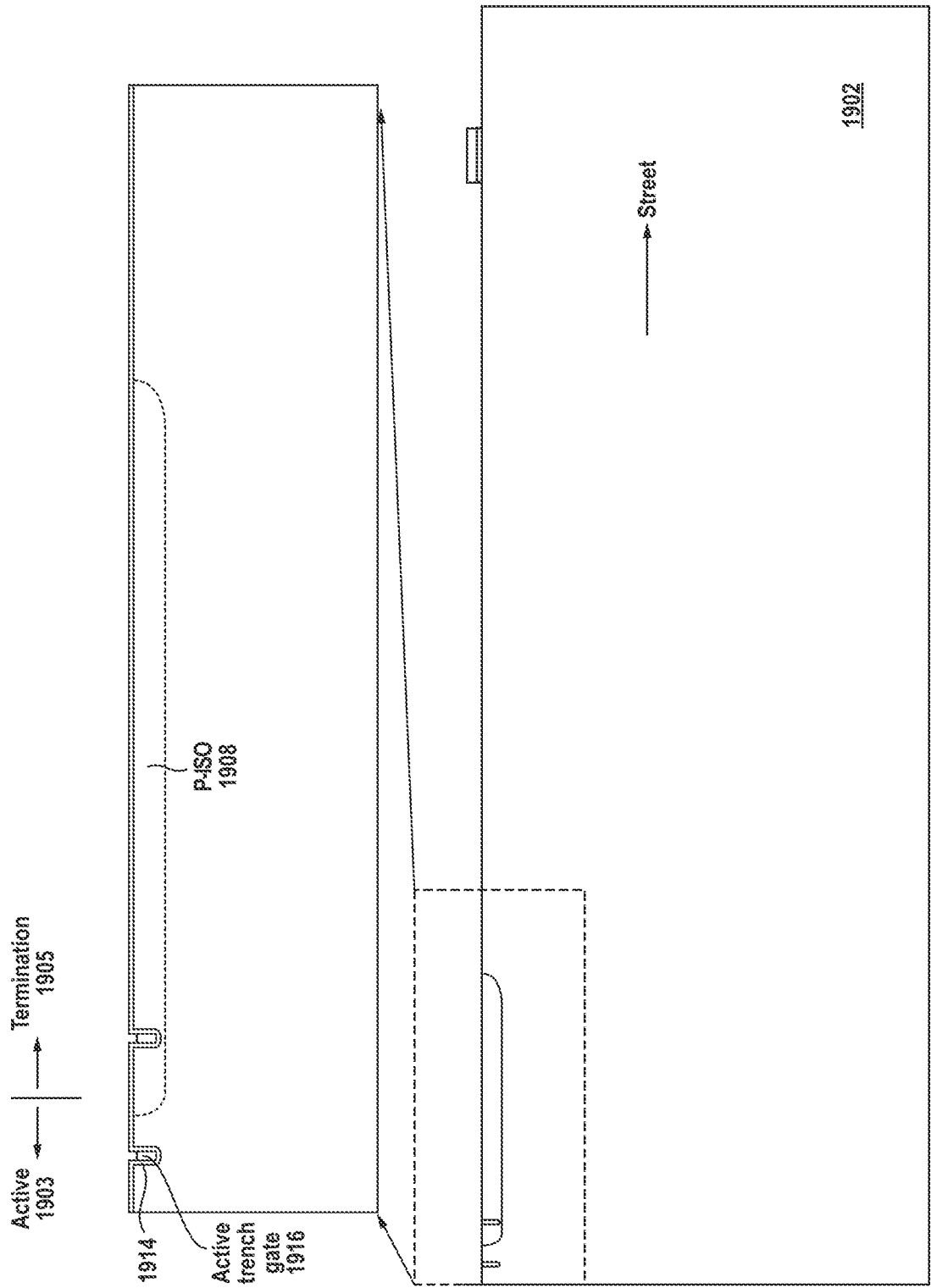
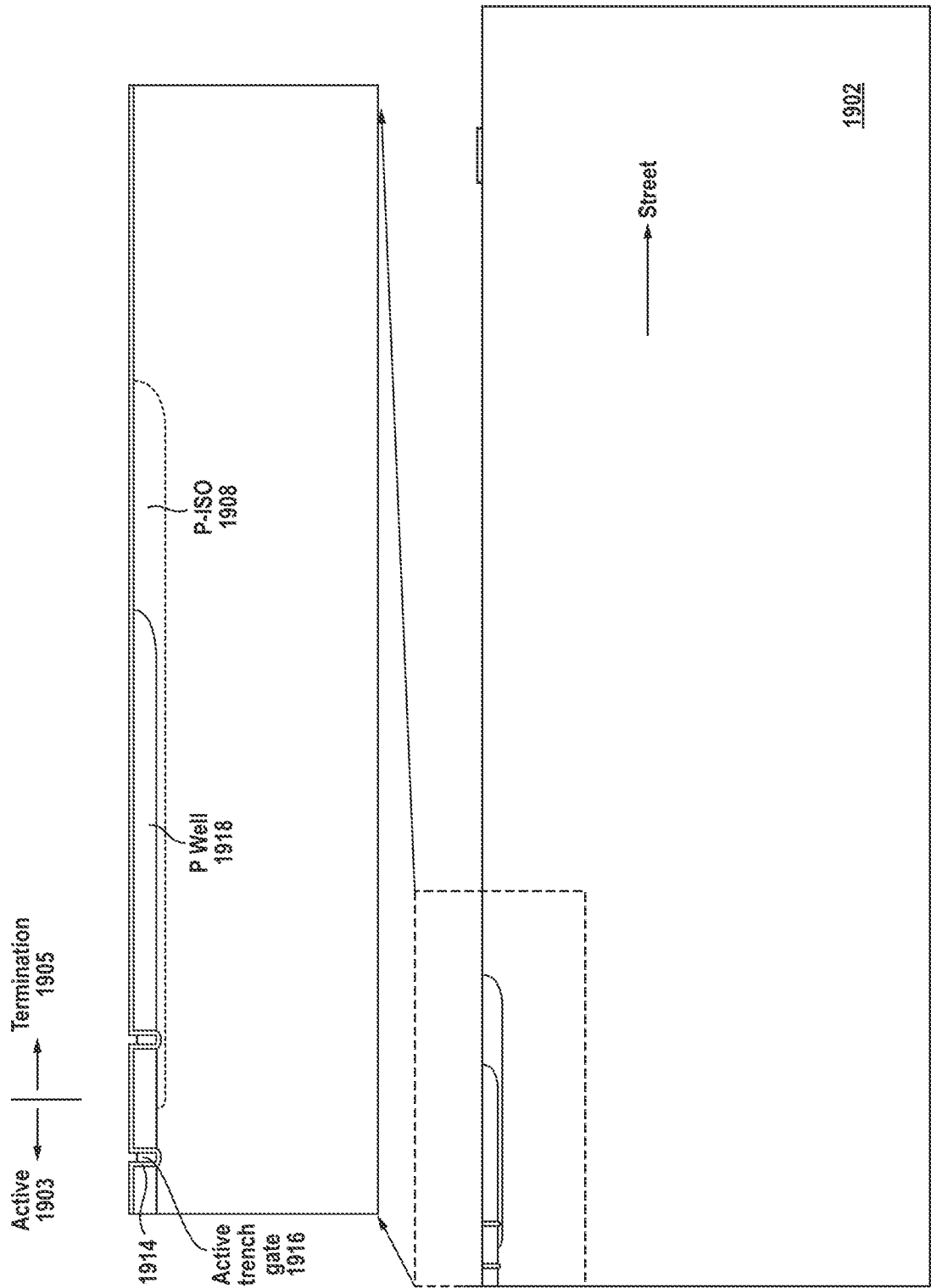


FIG. 19D



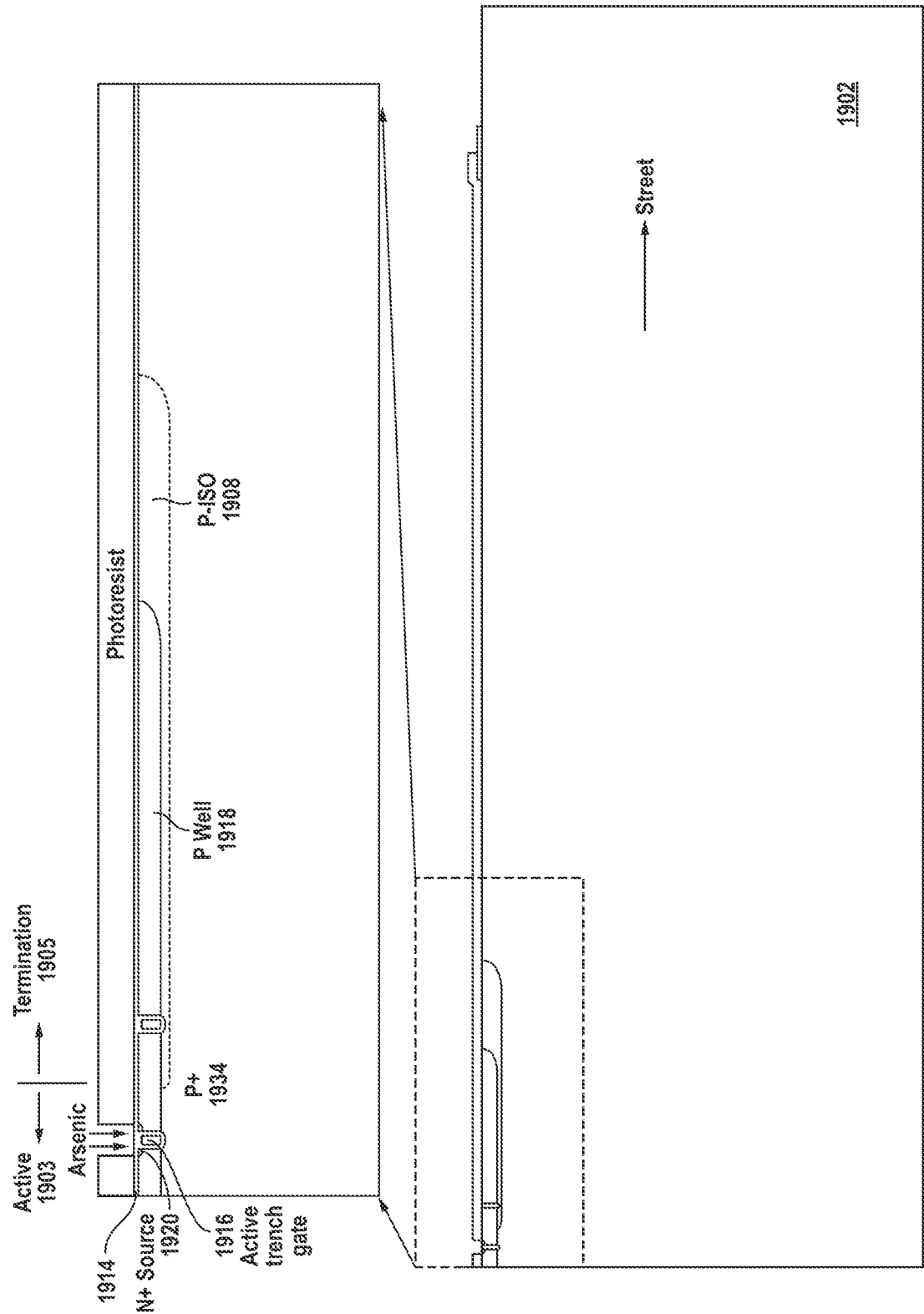
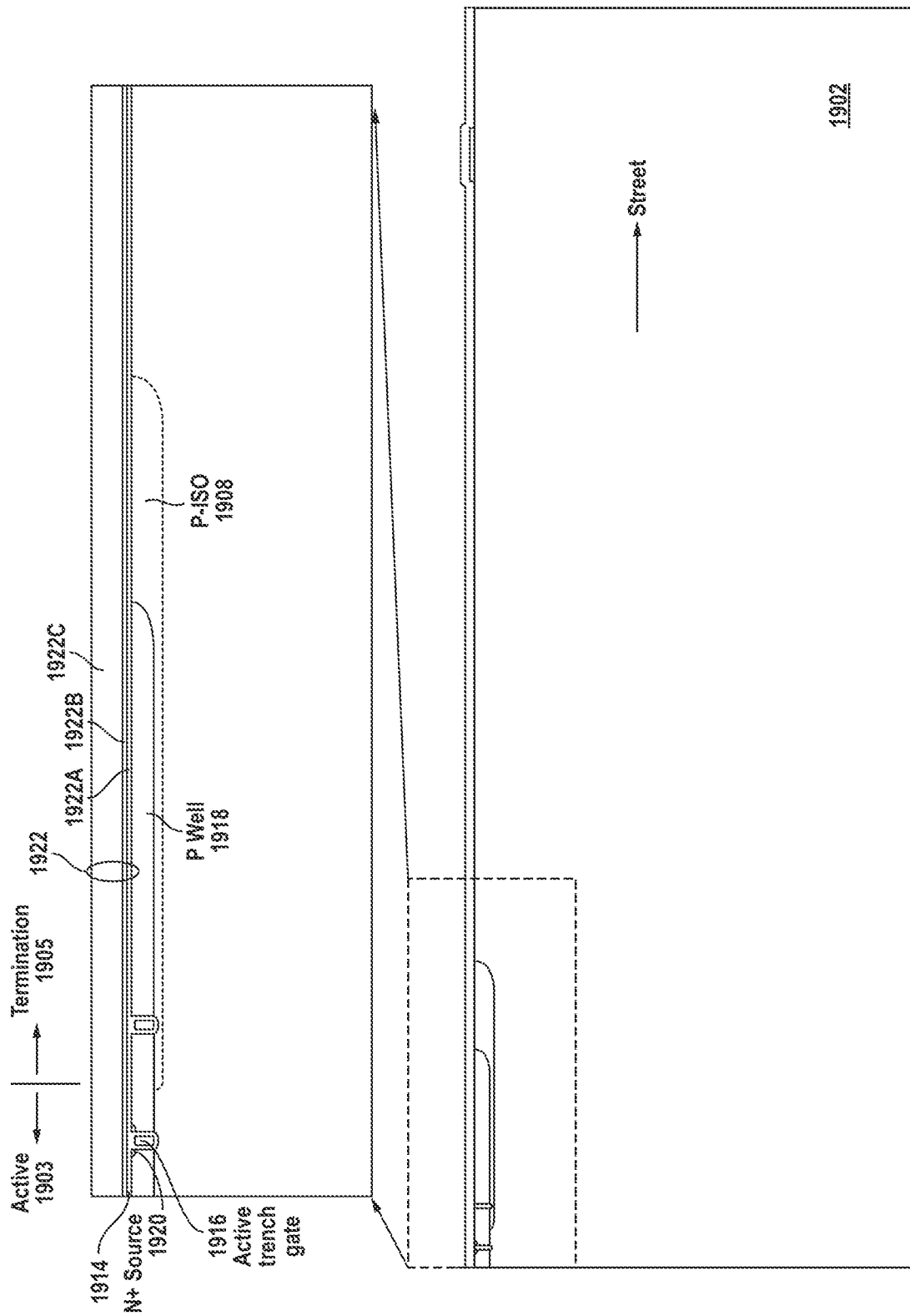
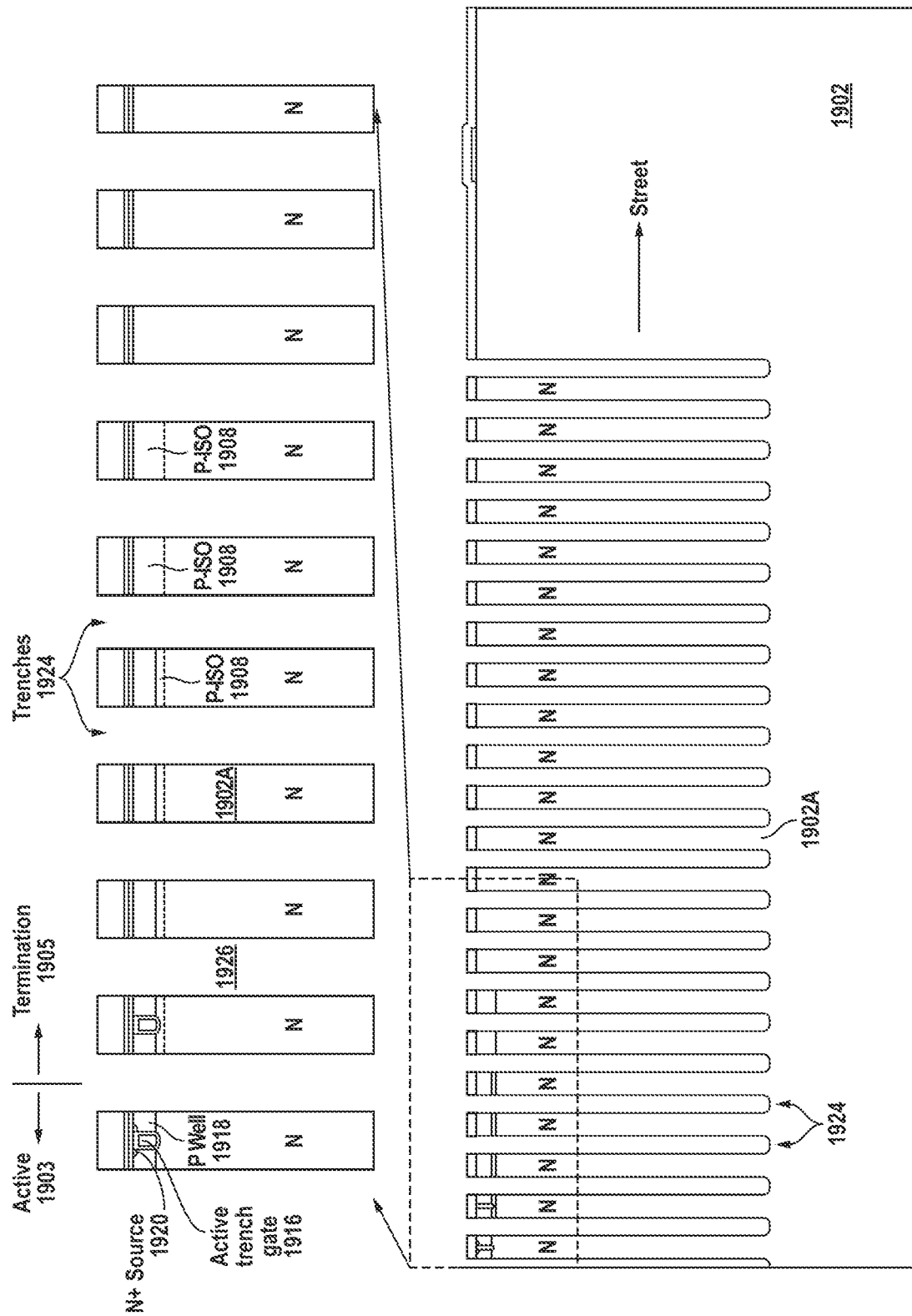
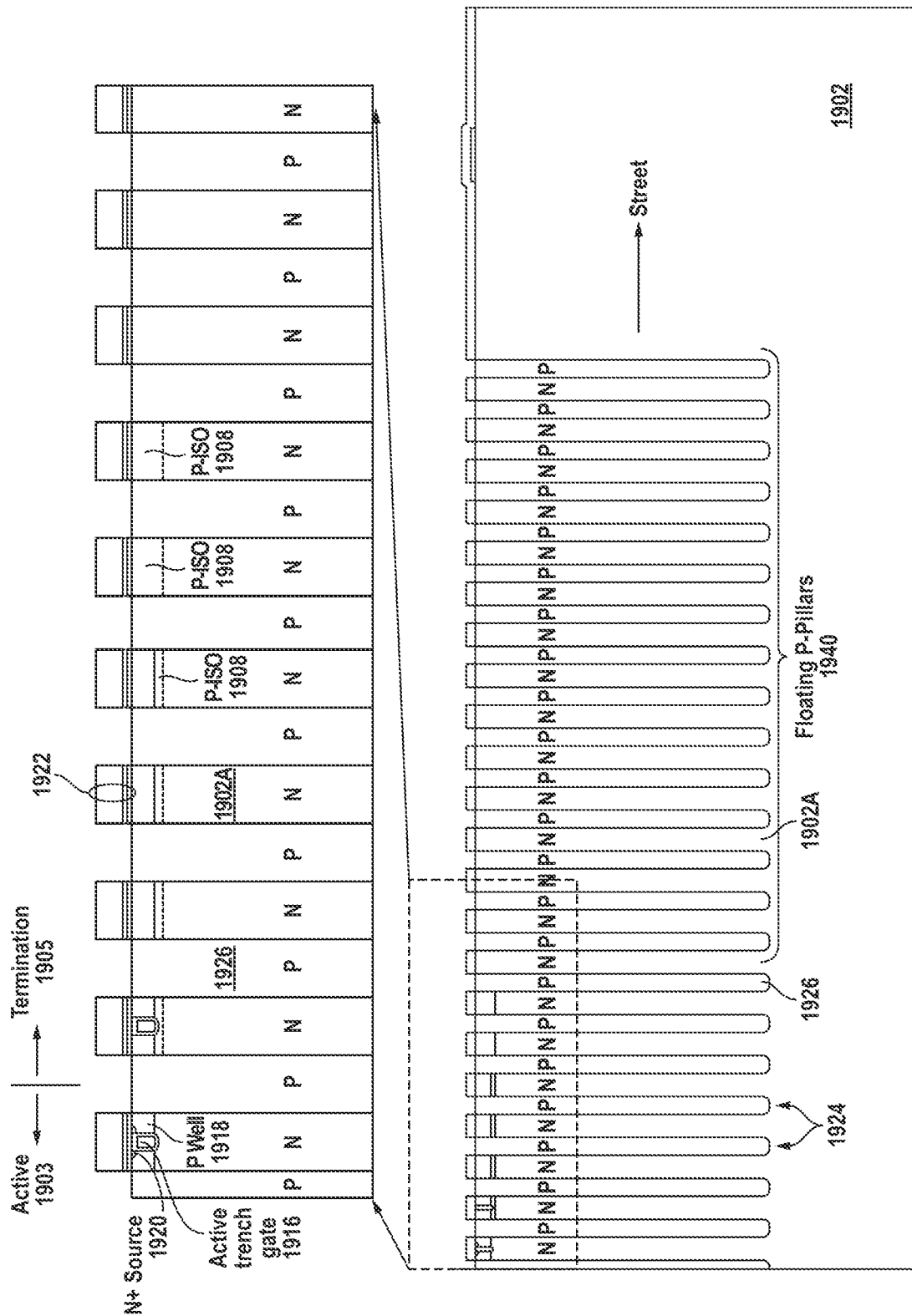


FIG. 19F



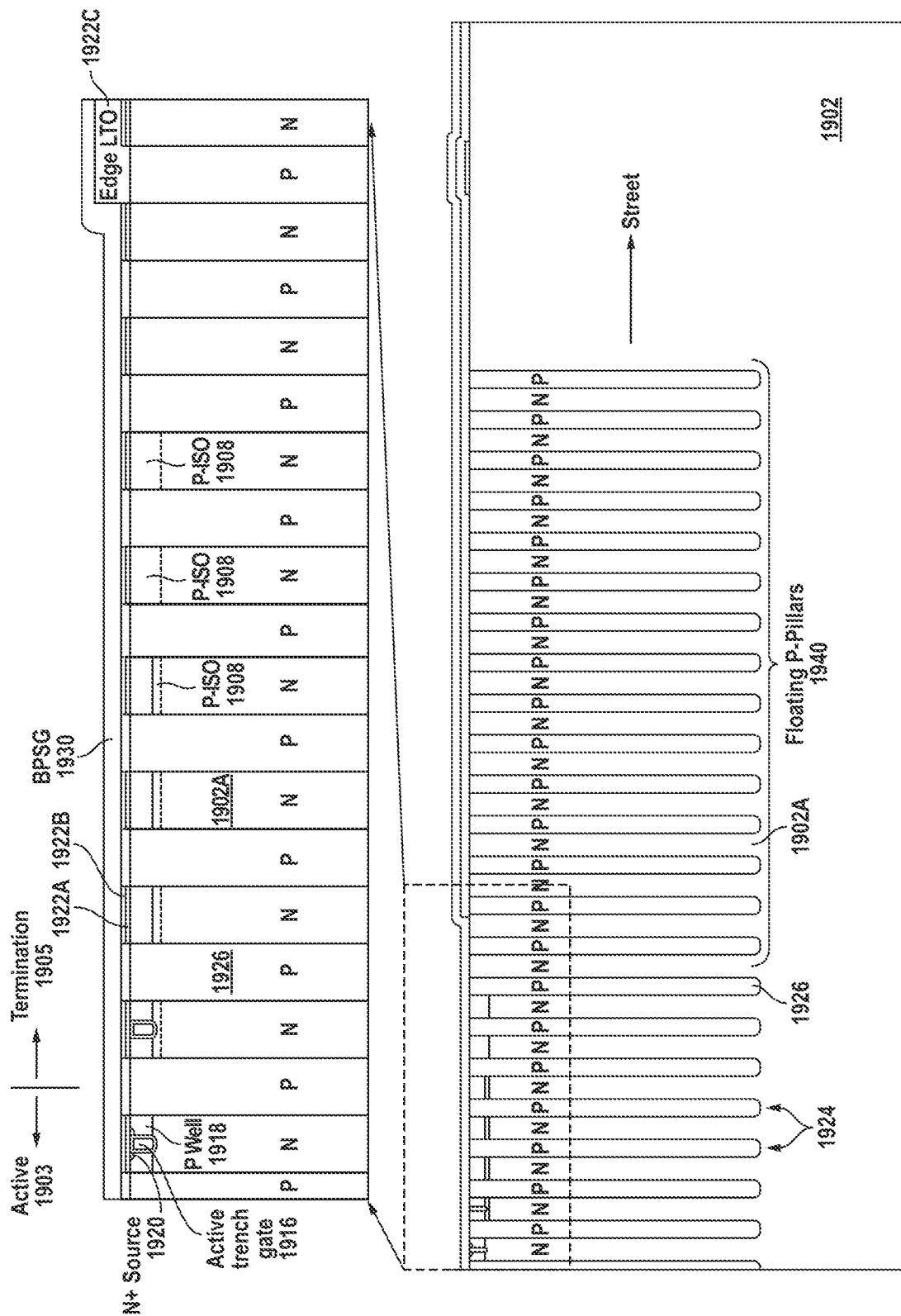
১৯৭৬







 NATIONAL BUREAU OF STANDARDS



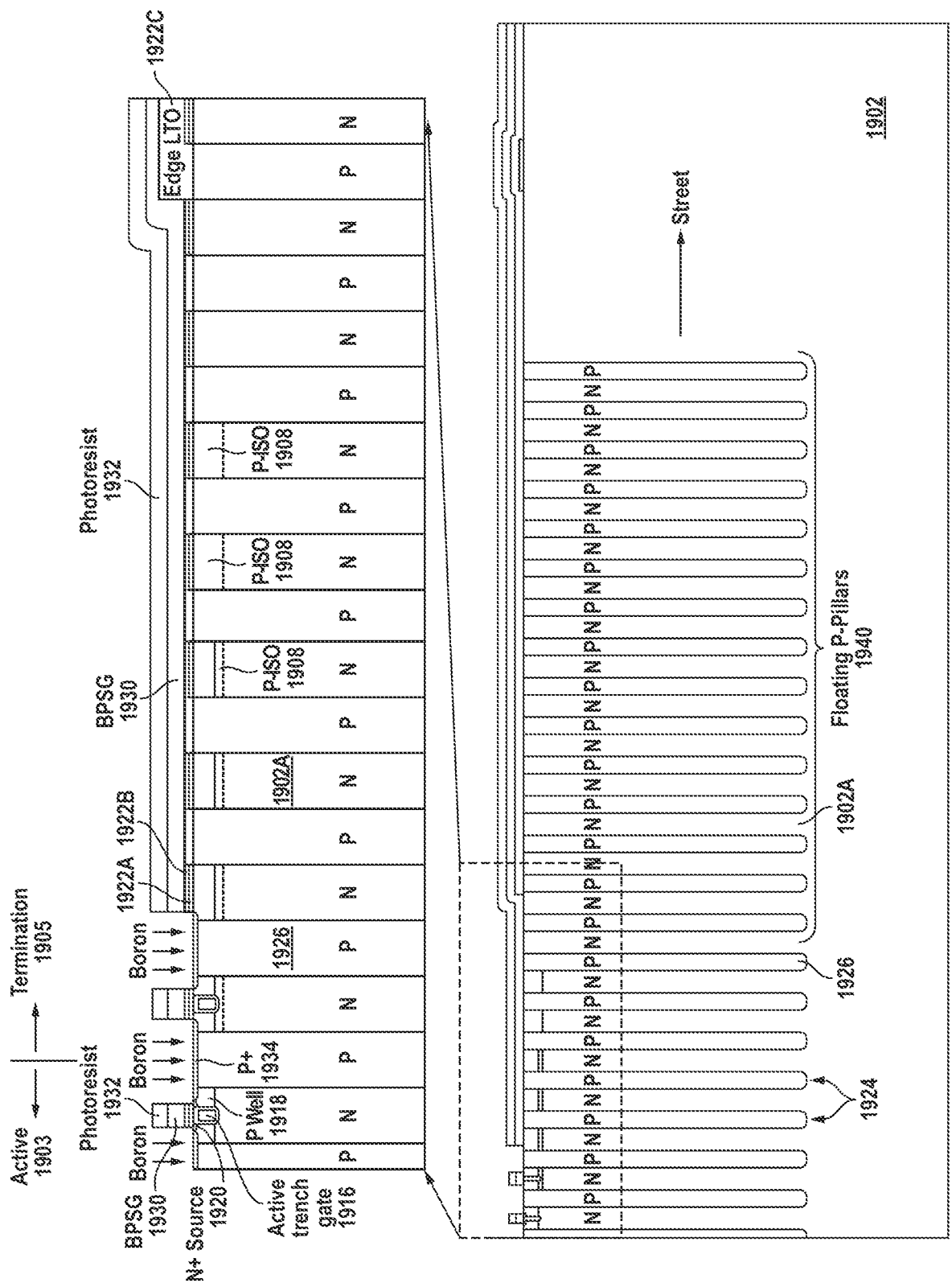
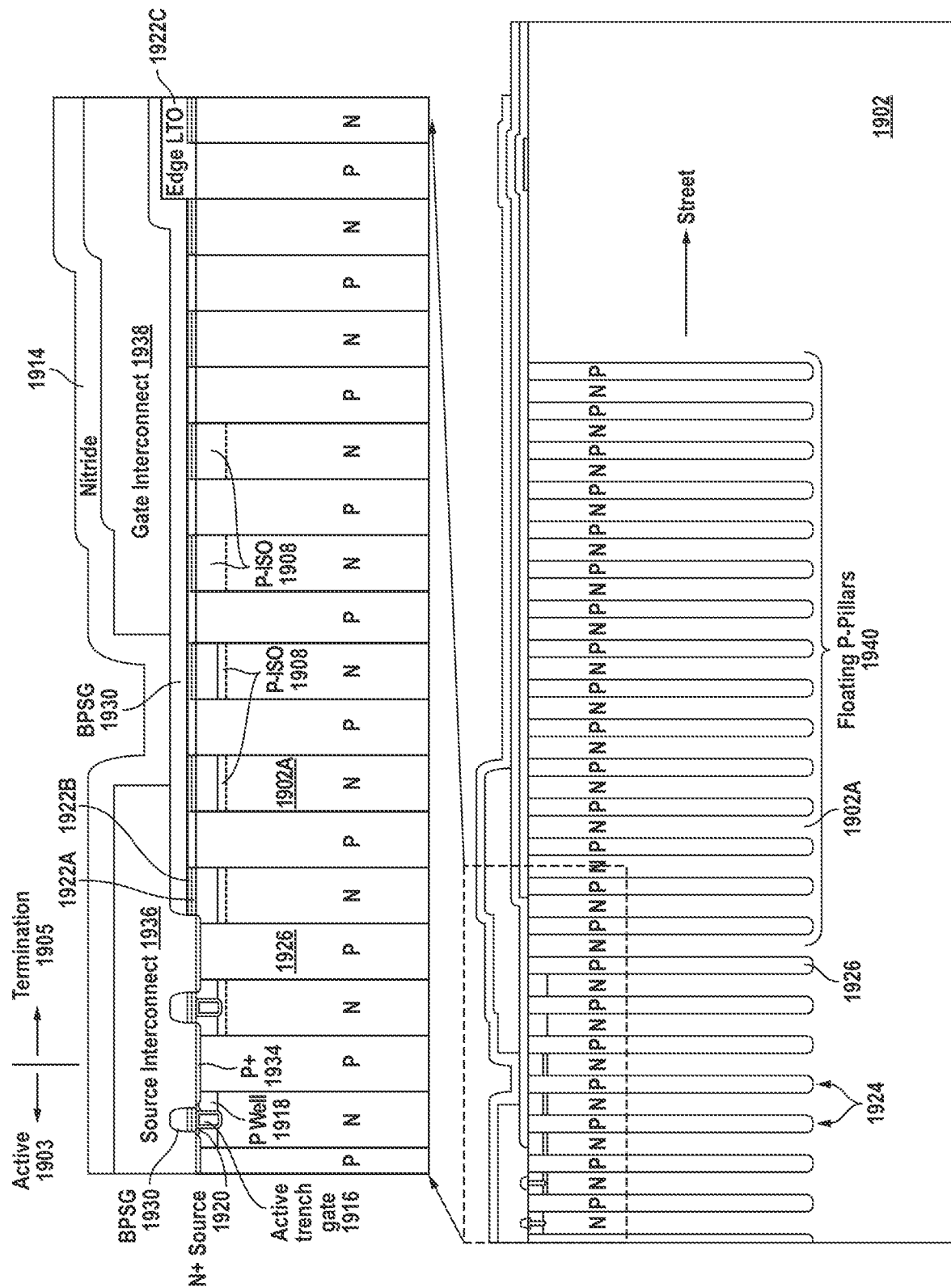


FIG. 19K



100

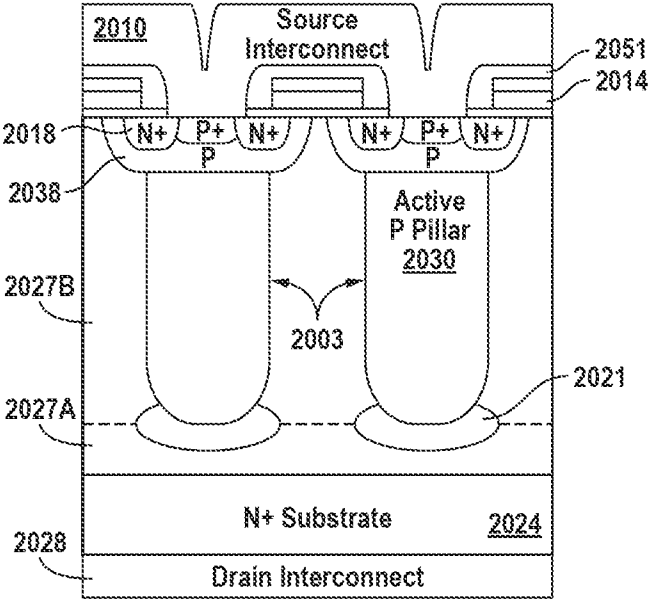
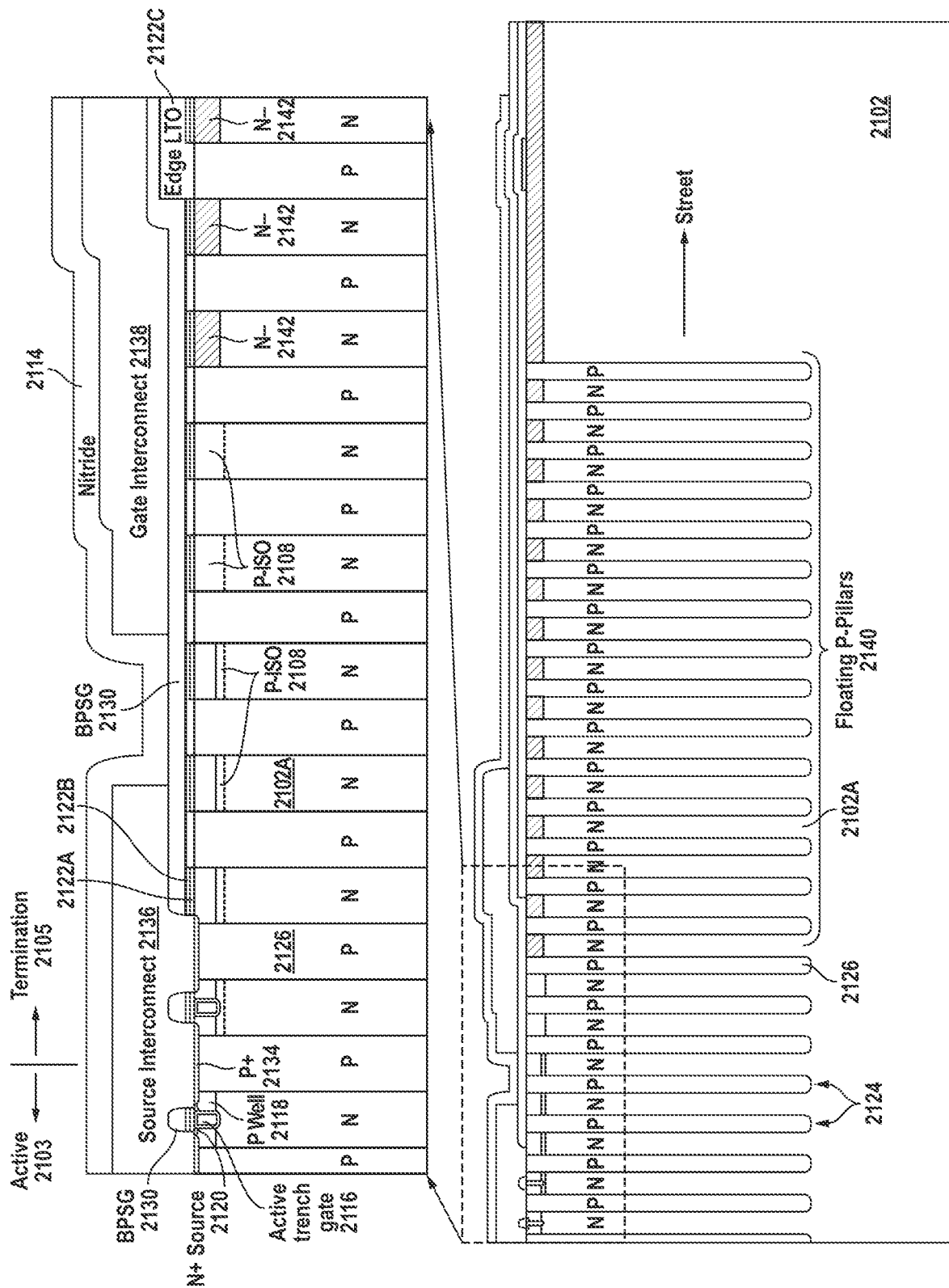
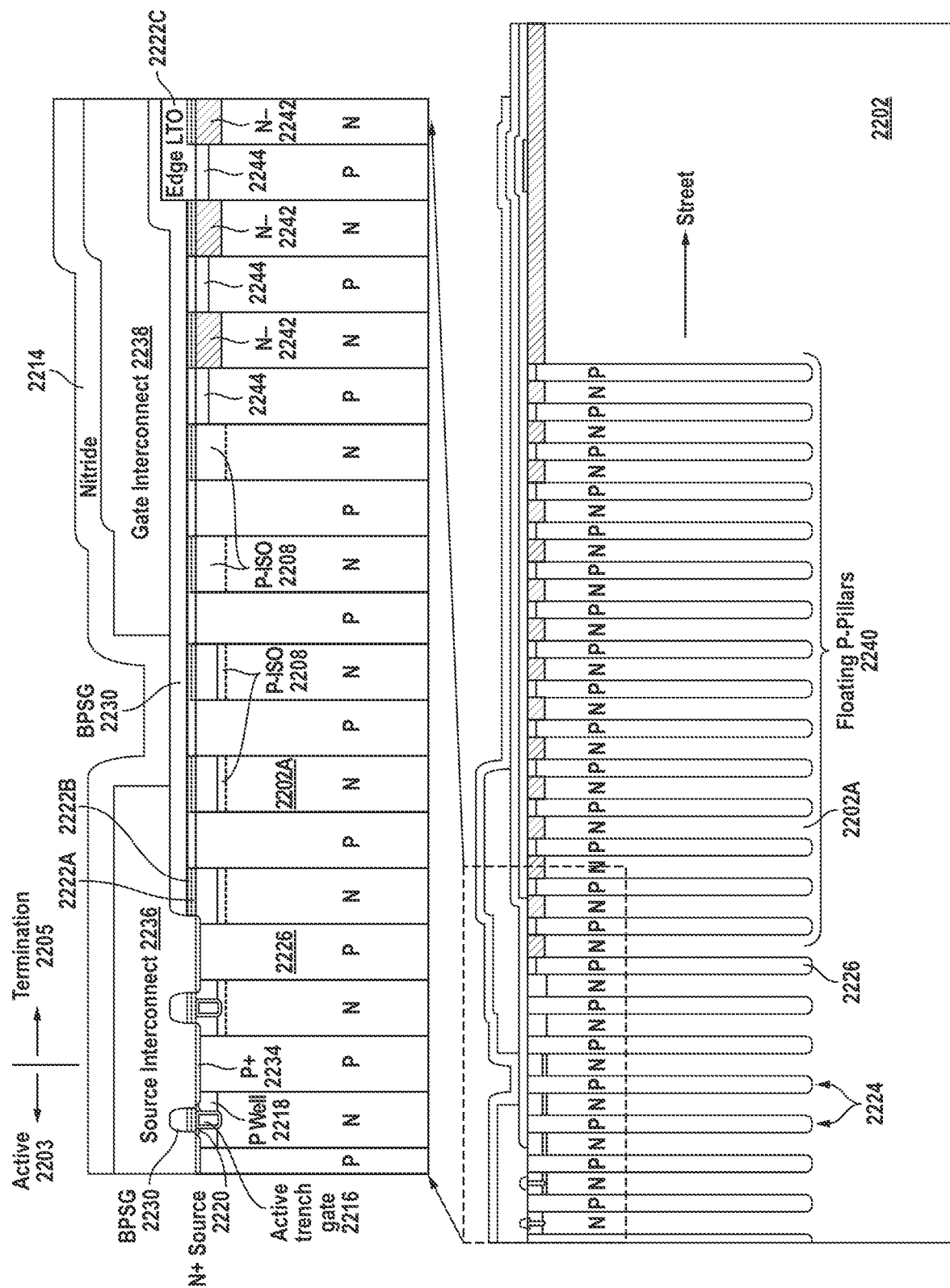


FIG. 20





229

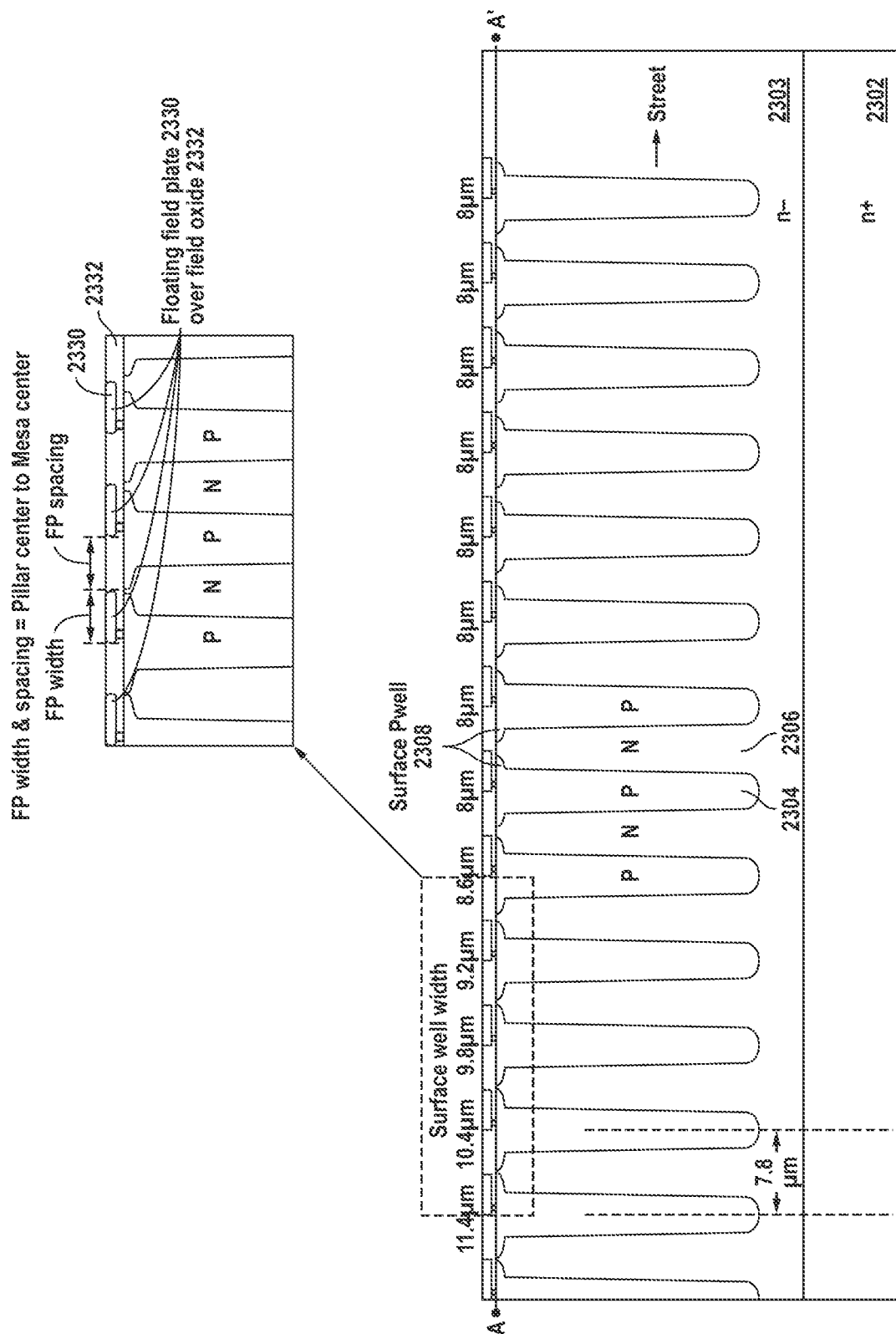


Fig. 23

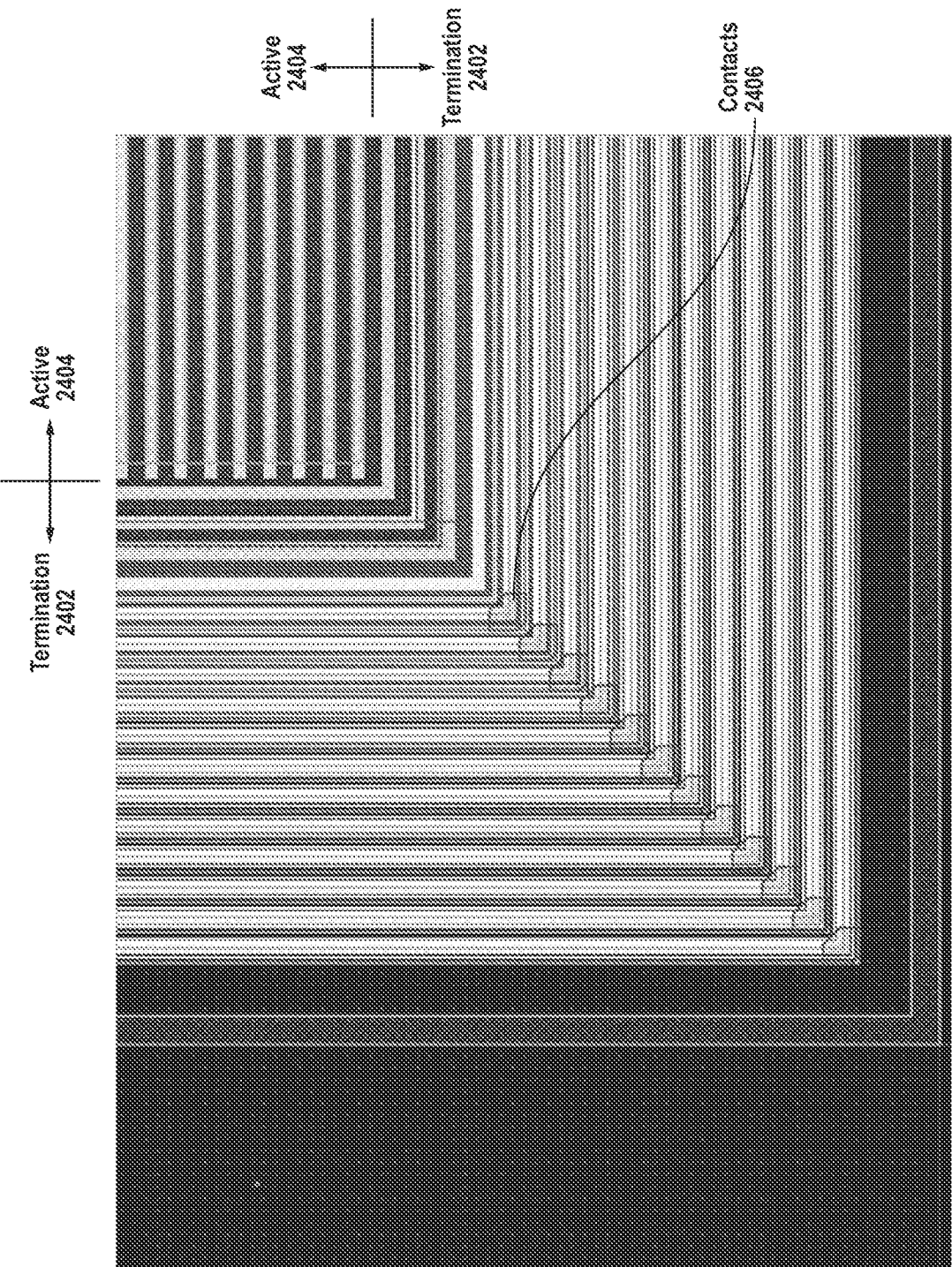


FIG. 24A

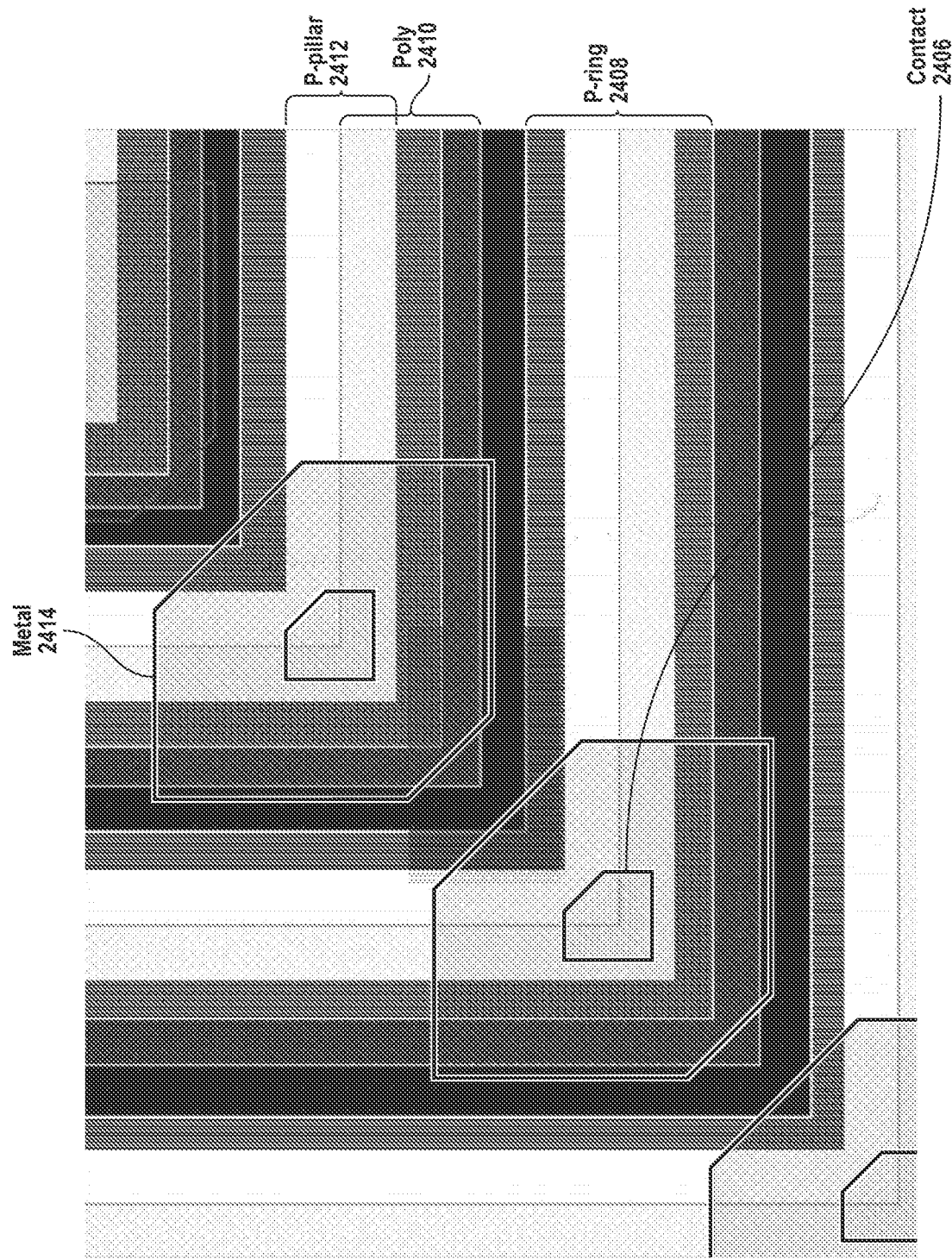


FIG. 24B

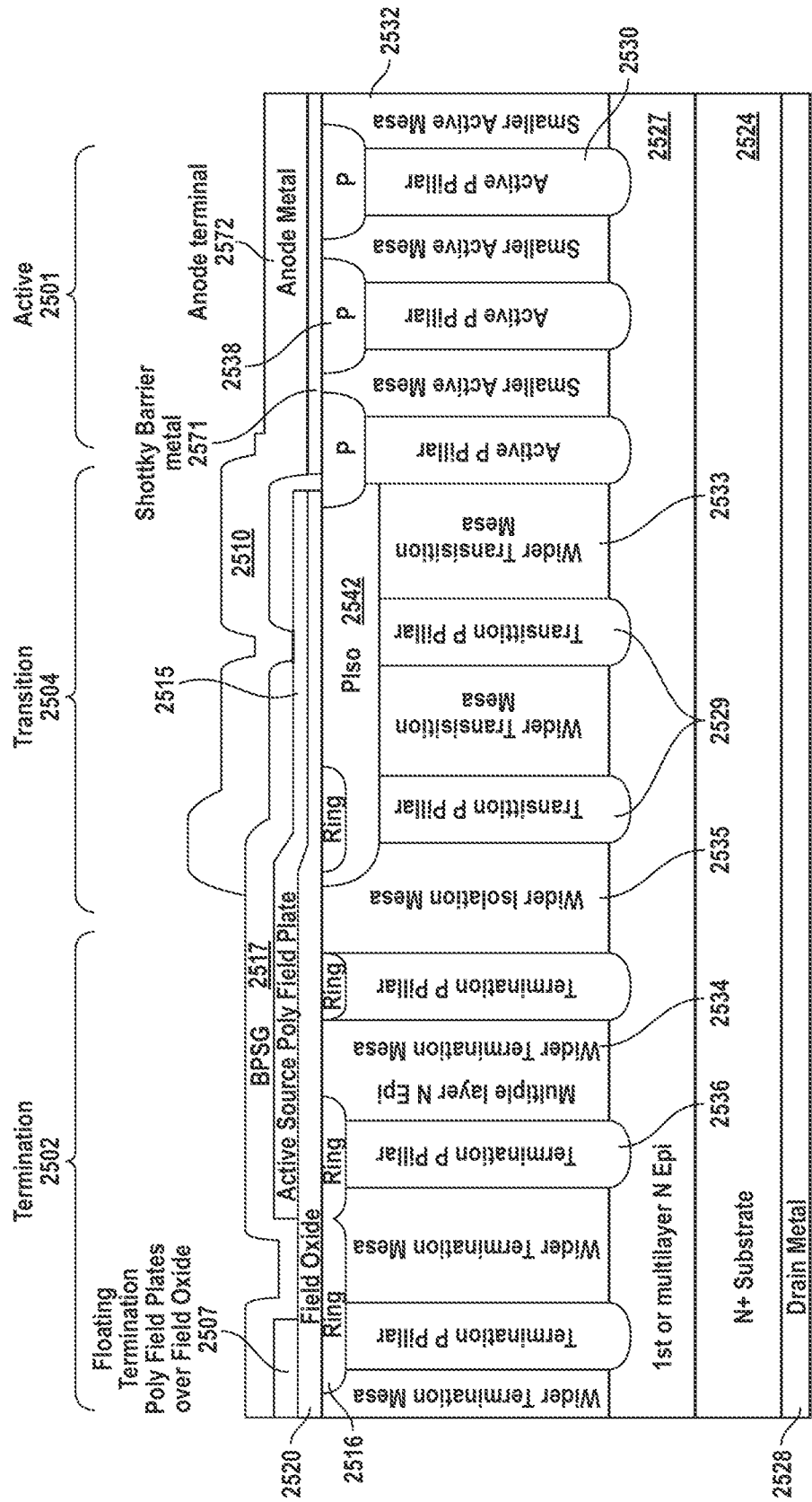


FIG. 25A

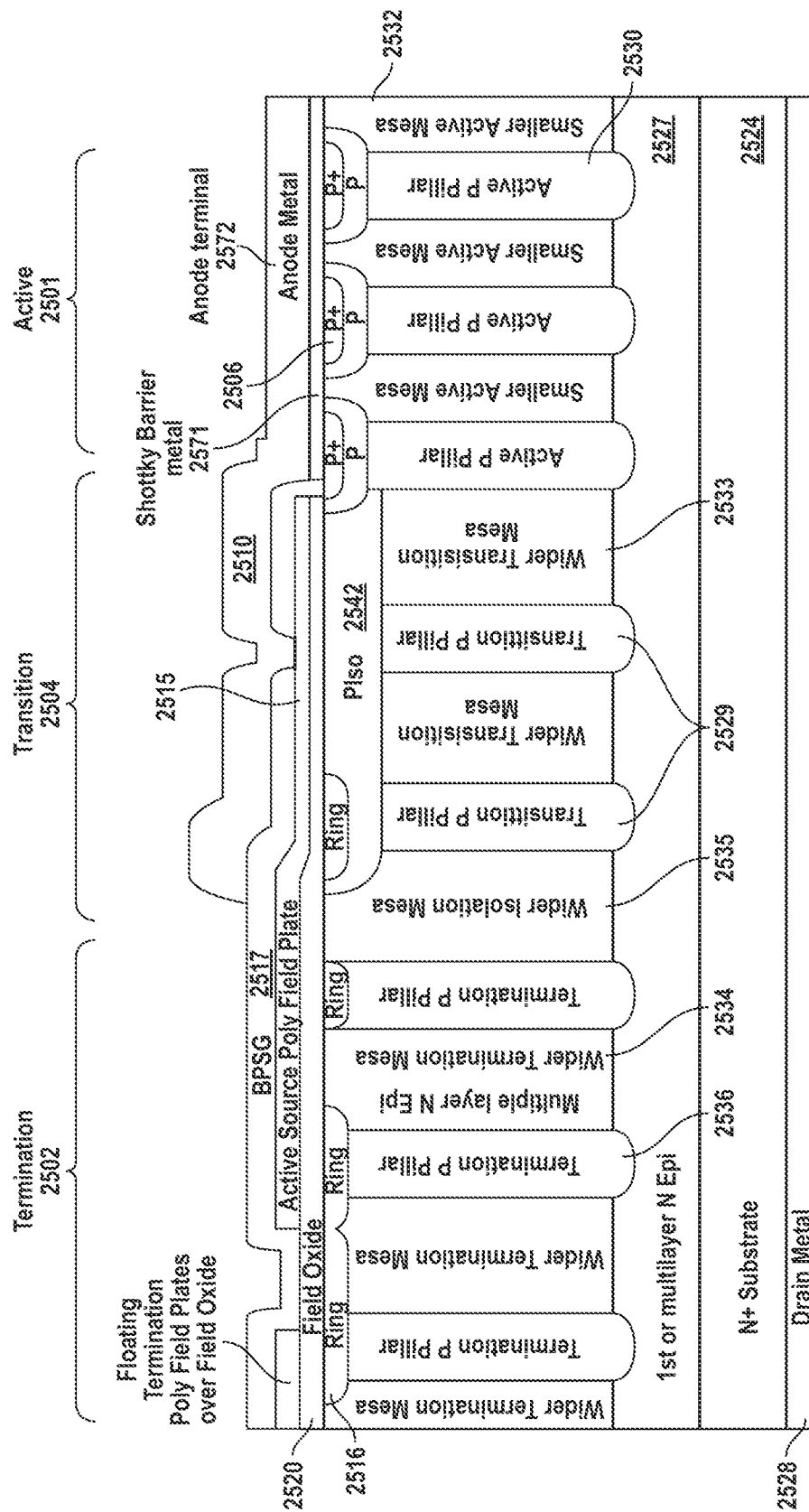


Fig. 25B

43/54

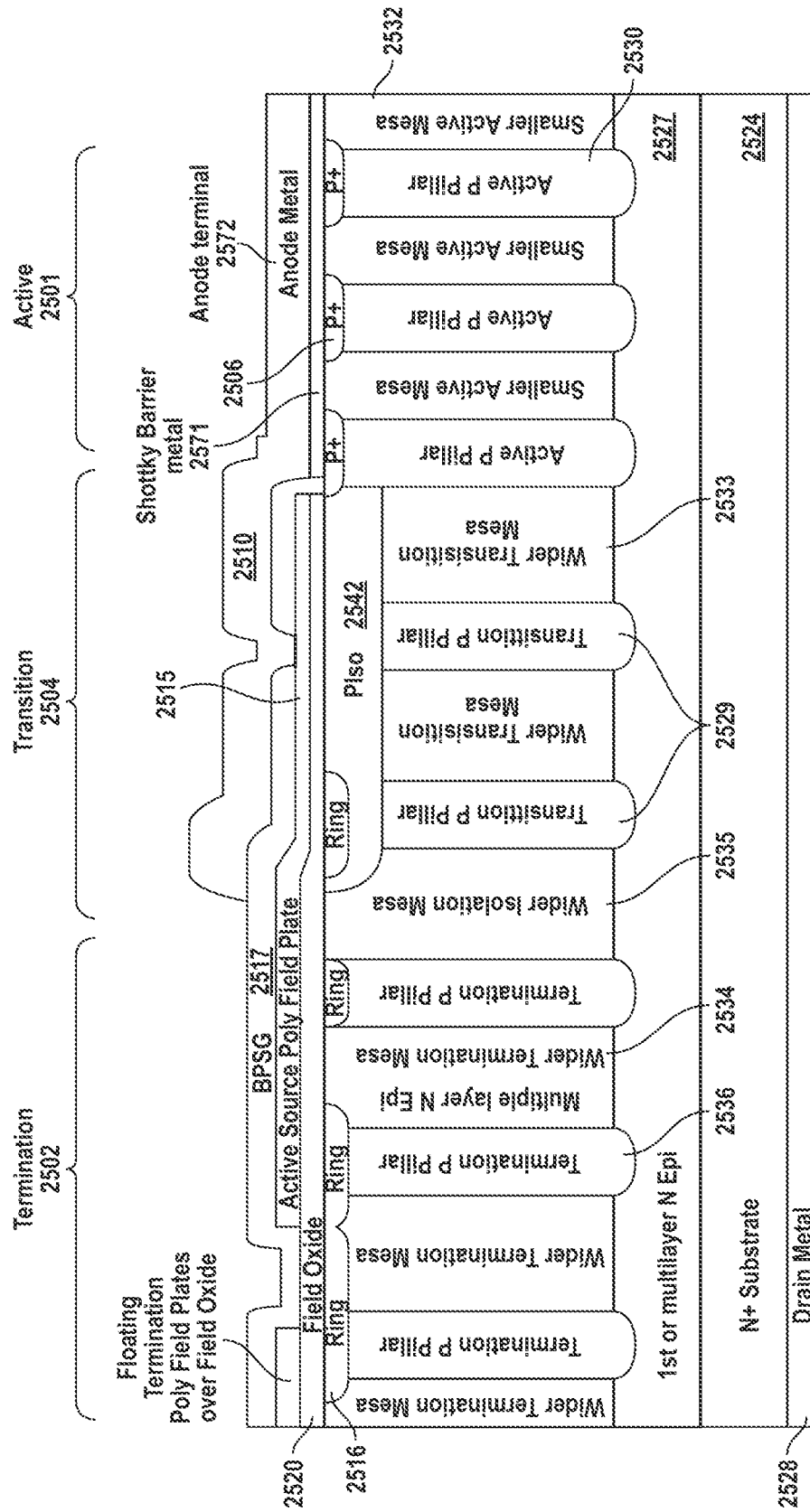


FIG. 25C

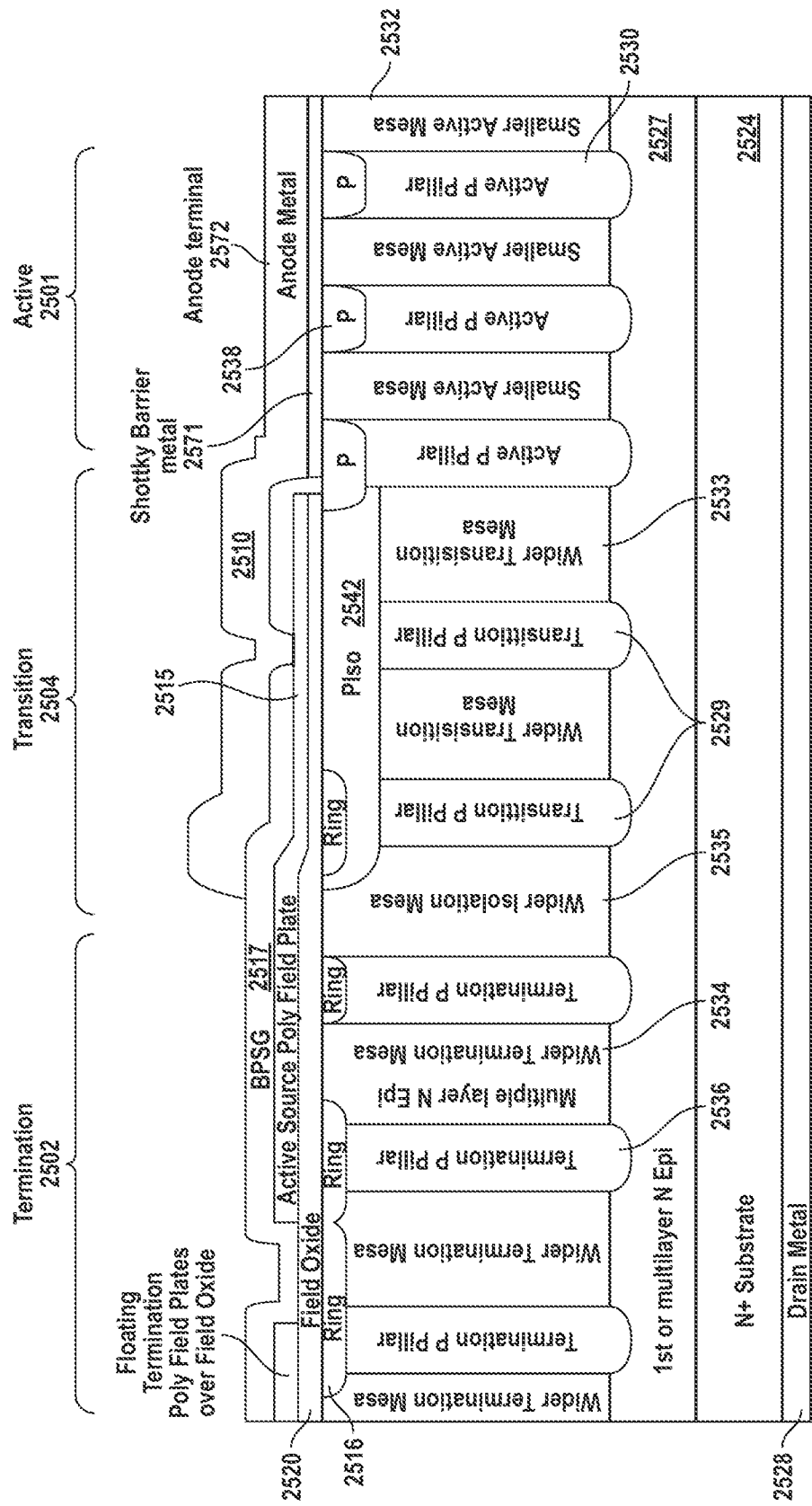


FIG. 25D

45/54

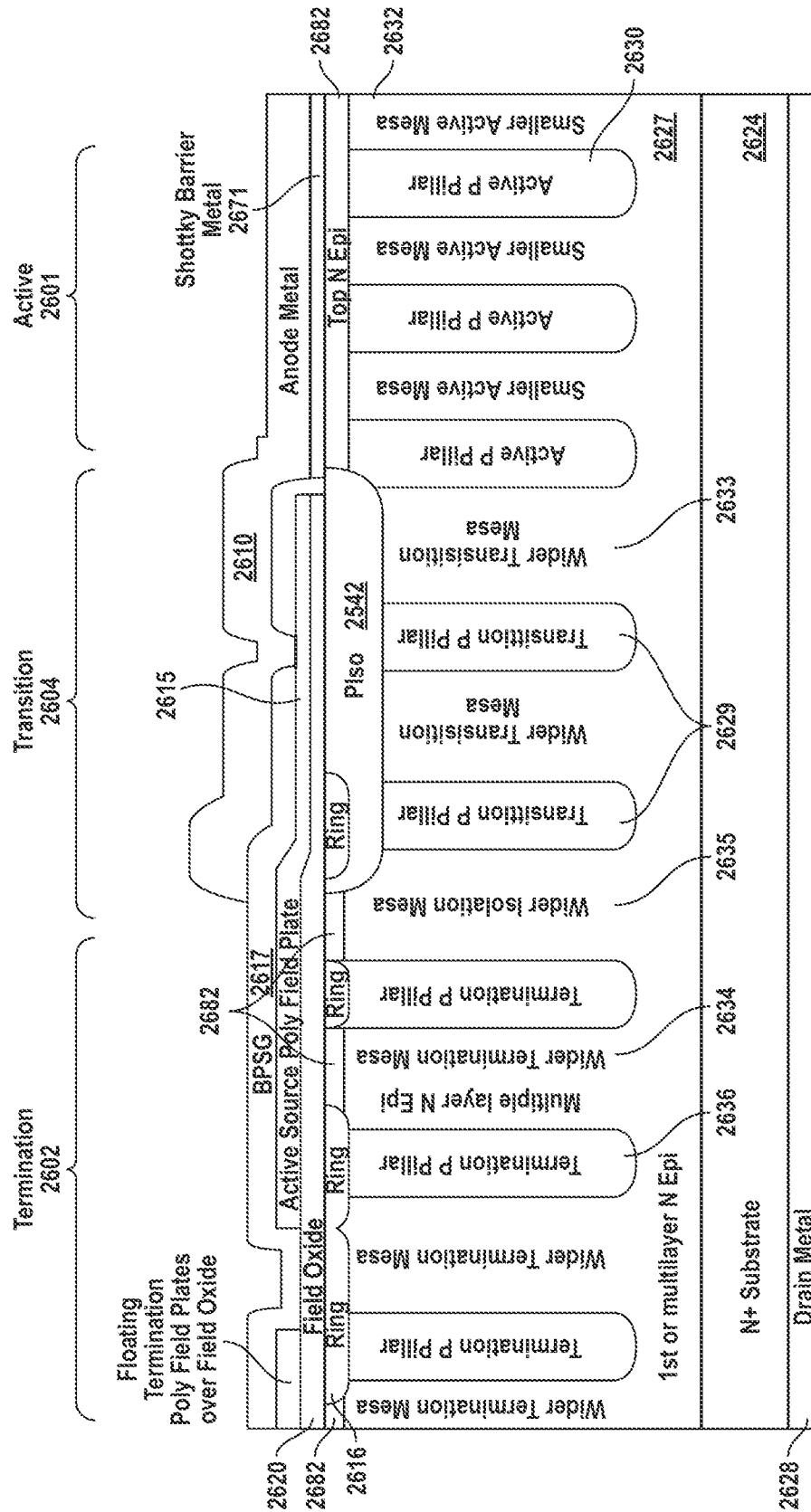
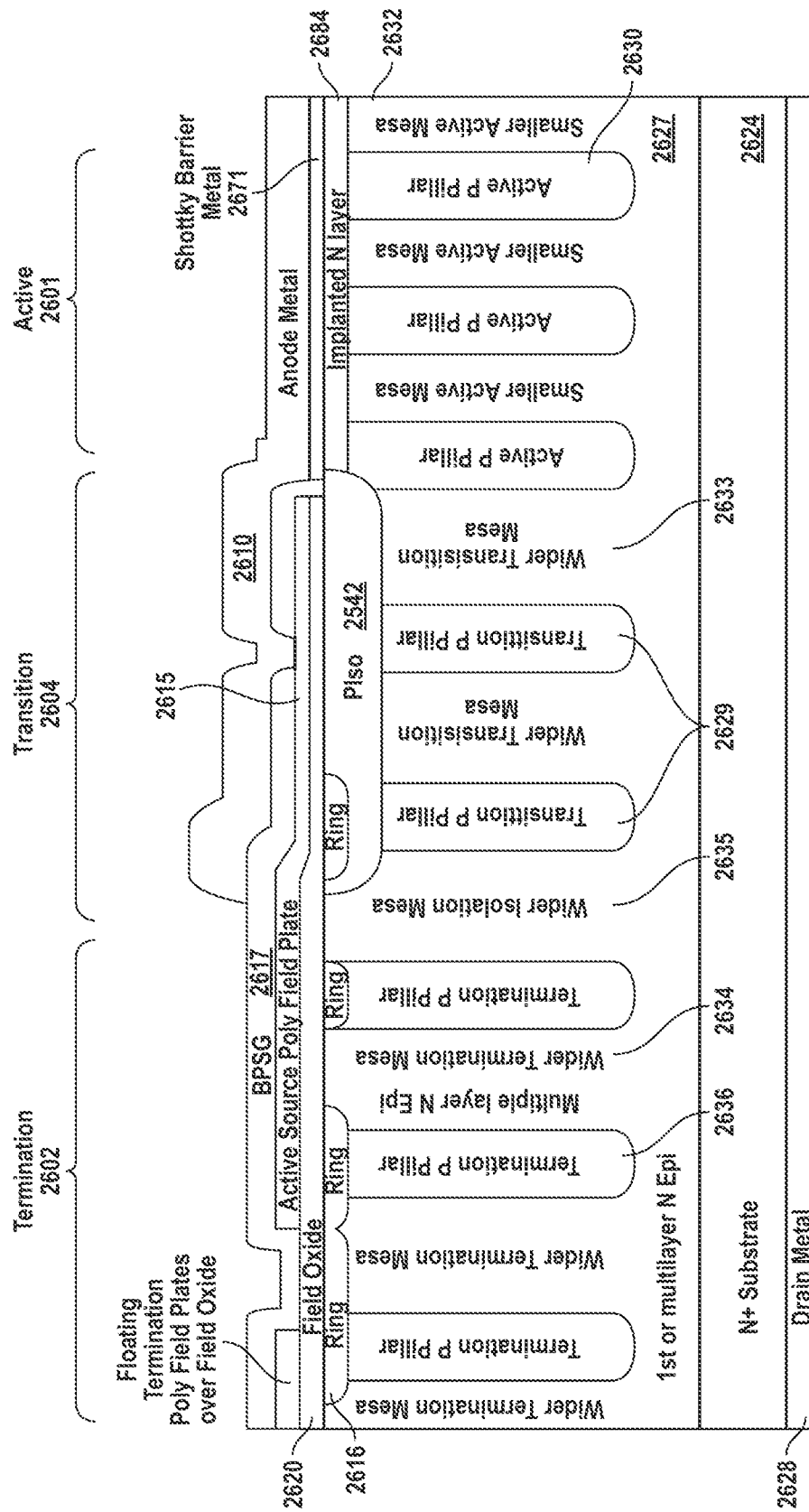


FIG. 26A



47/54

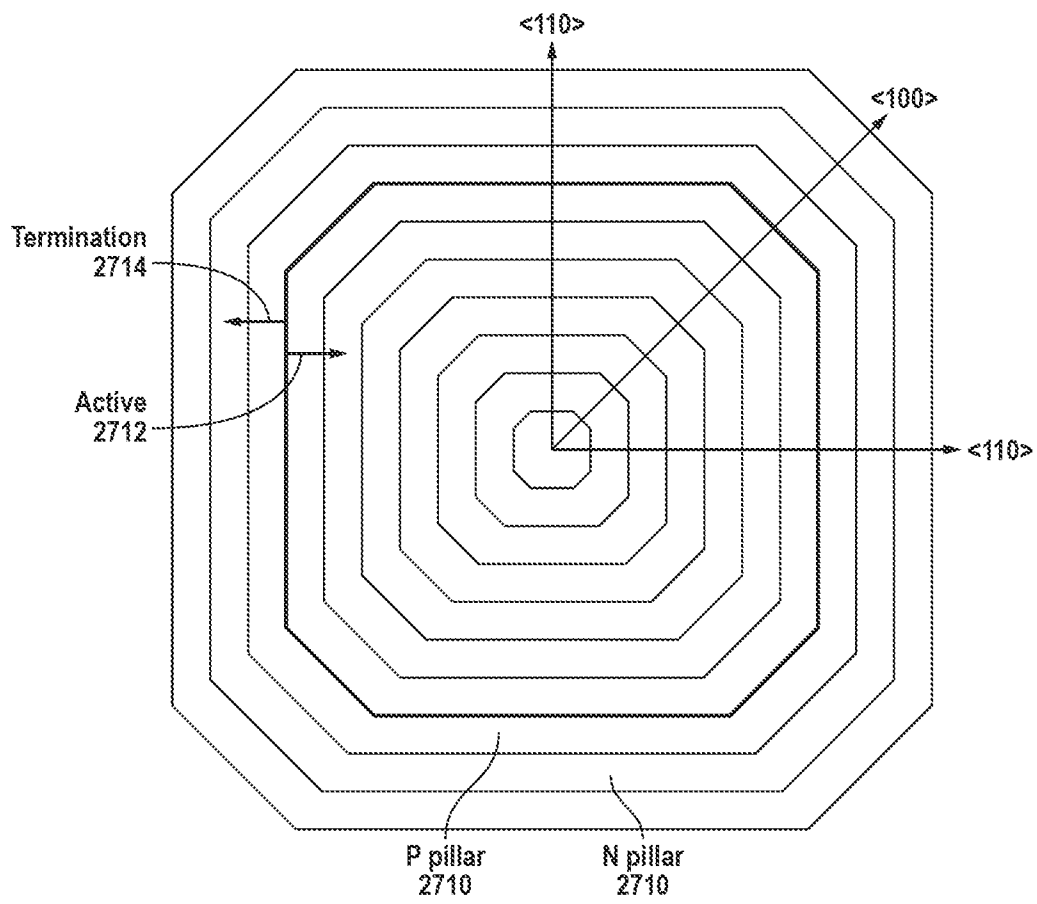


FIG. 27A

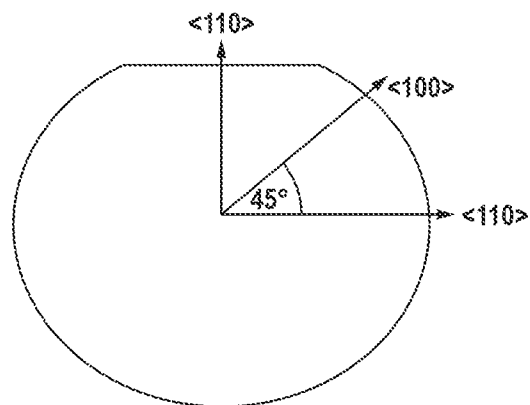


FIG. 27B

48/54

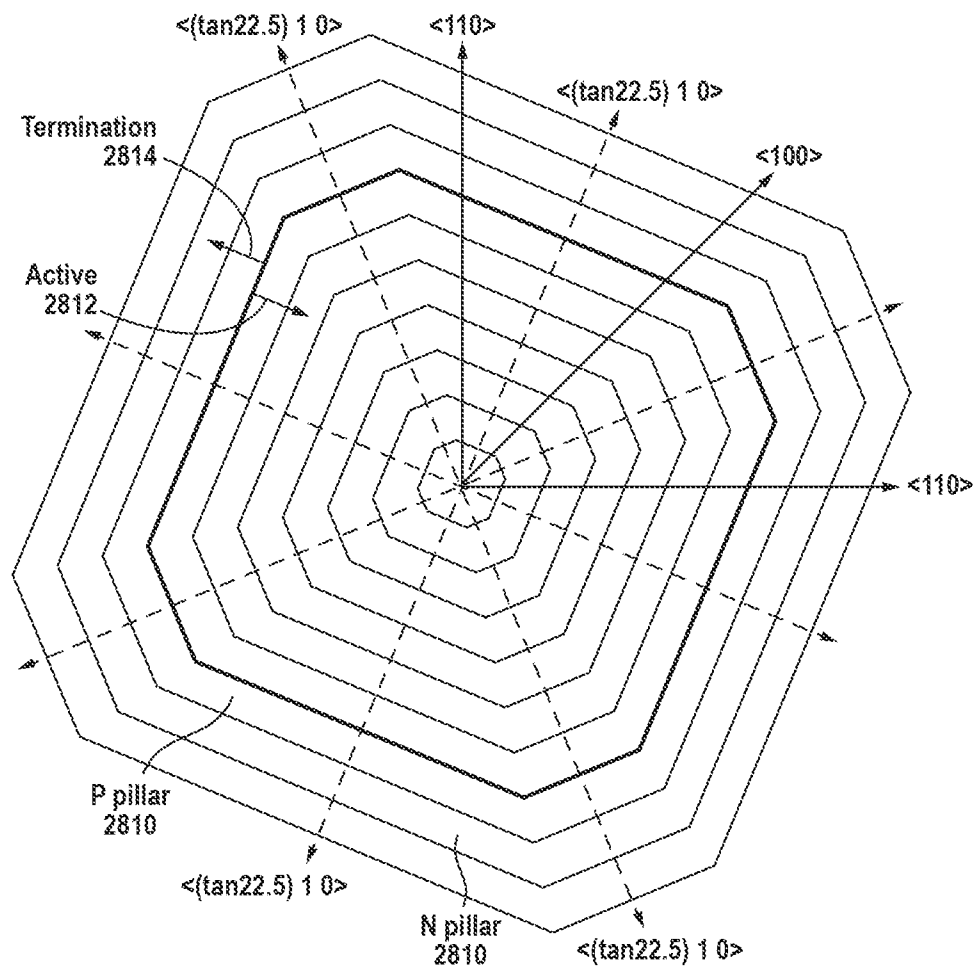


FIG. 28

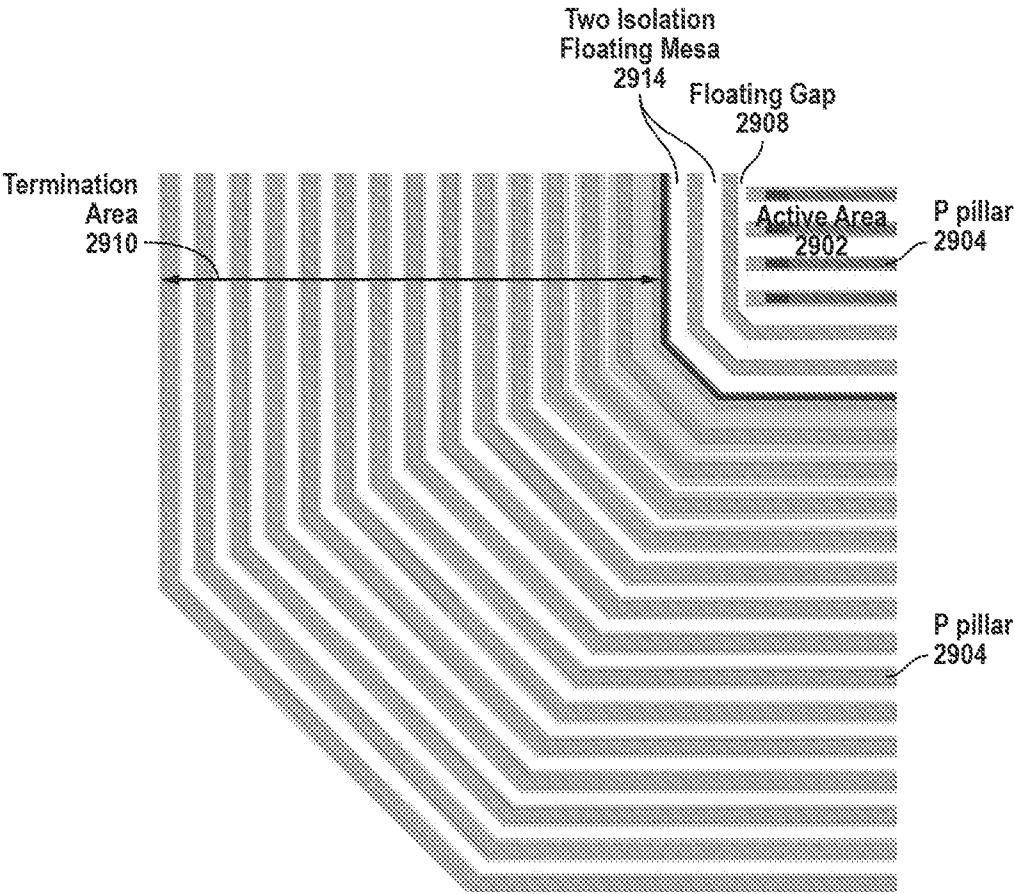


FIG. 29

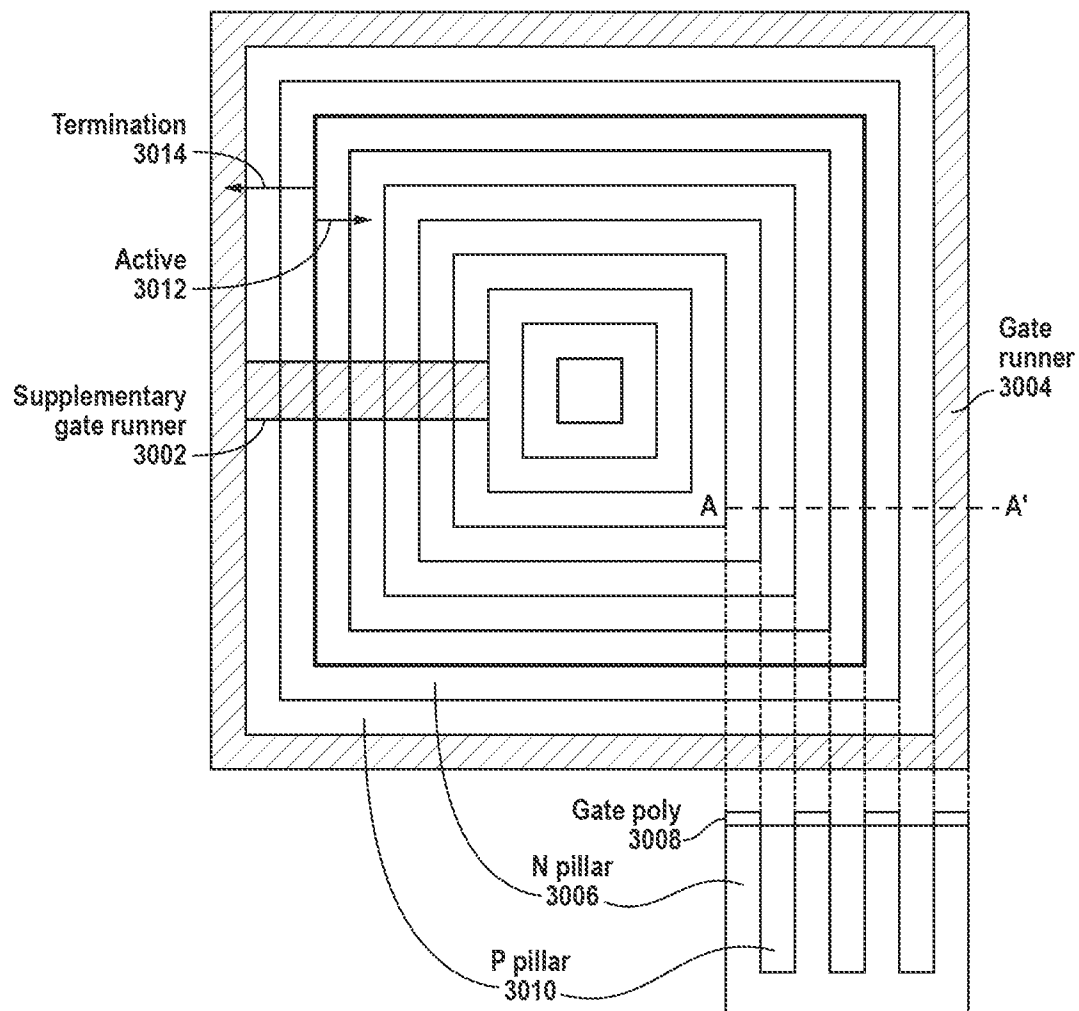


FIG. 30

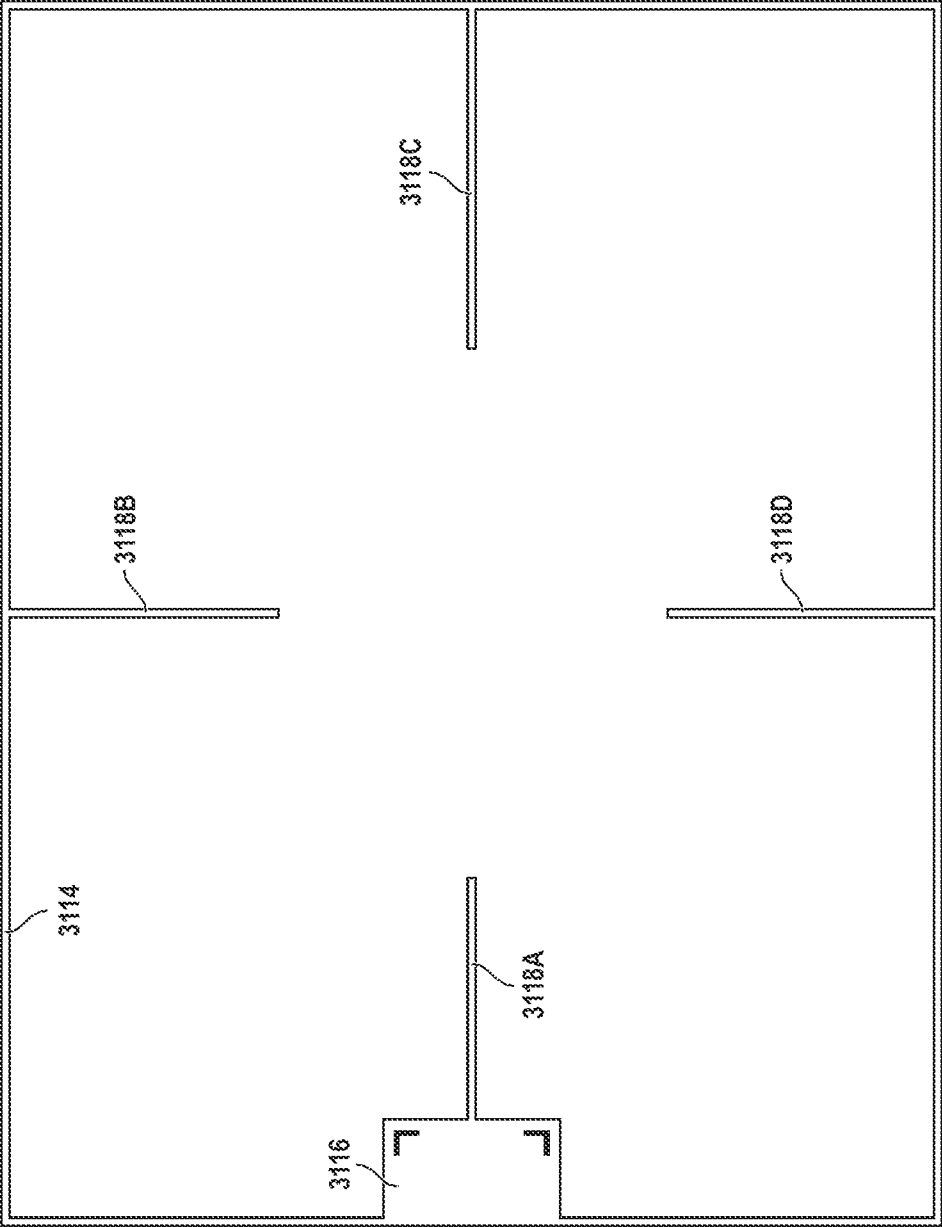


FIG. 31A

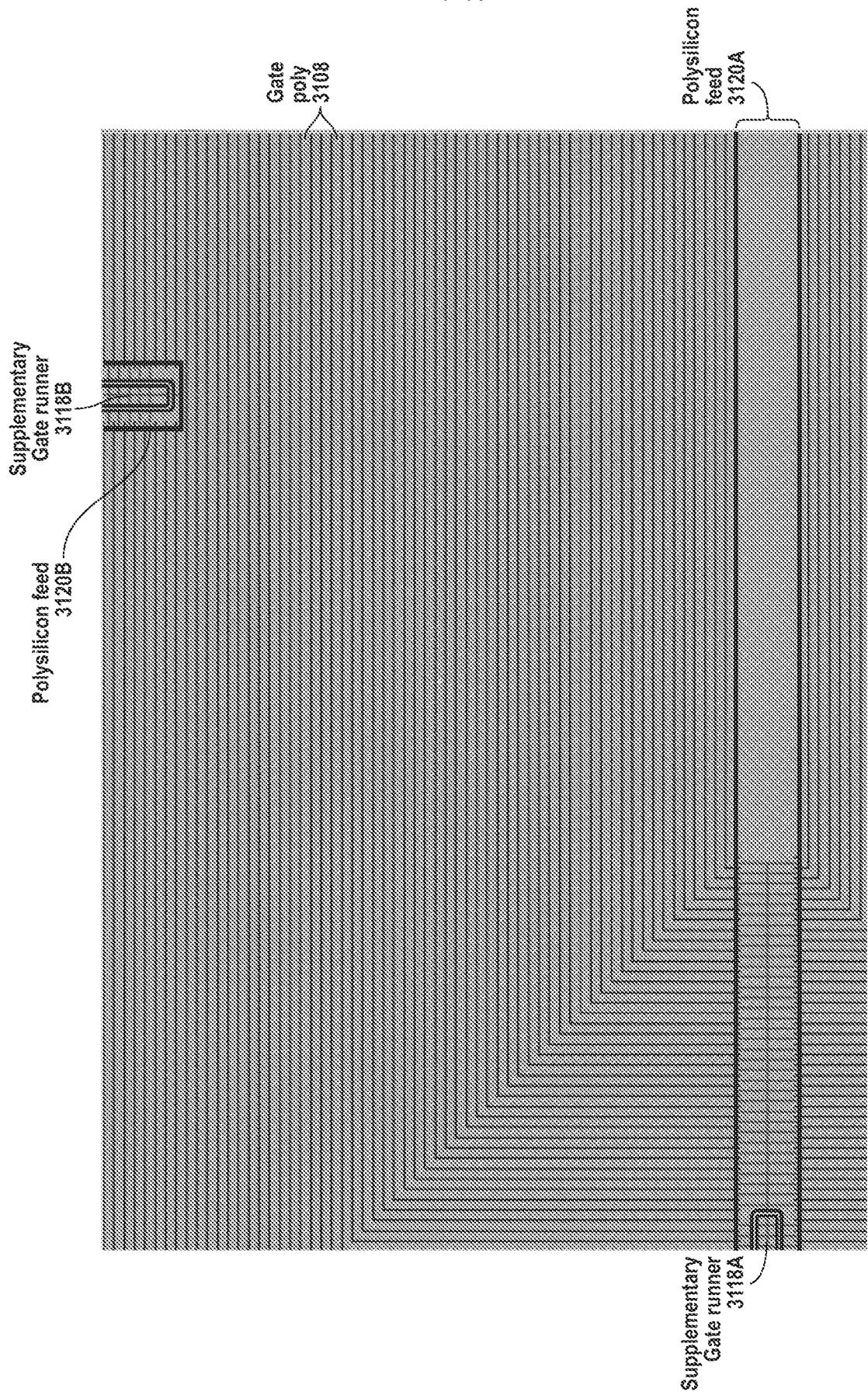


FIG. 31B

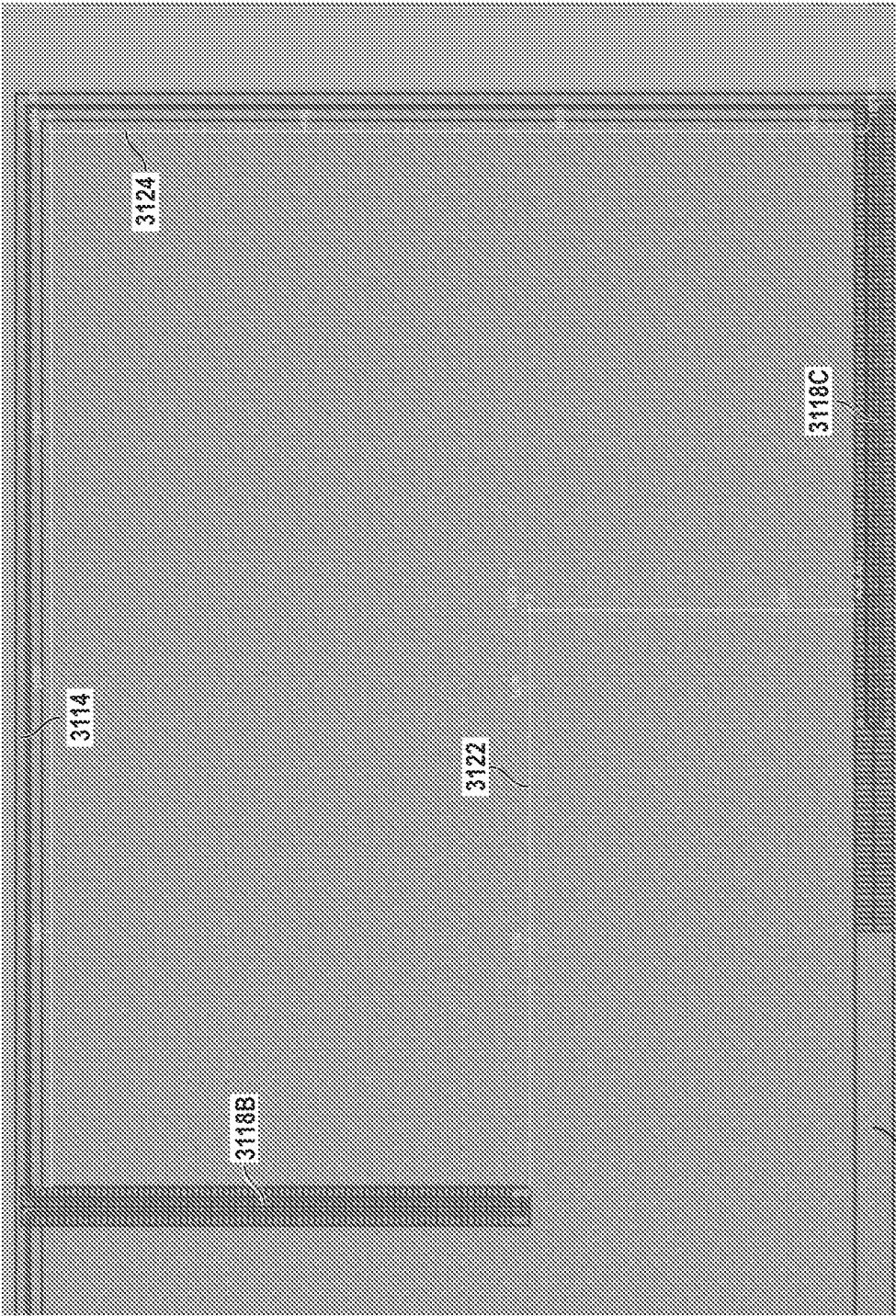


FIG. 31C

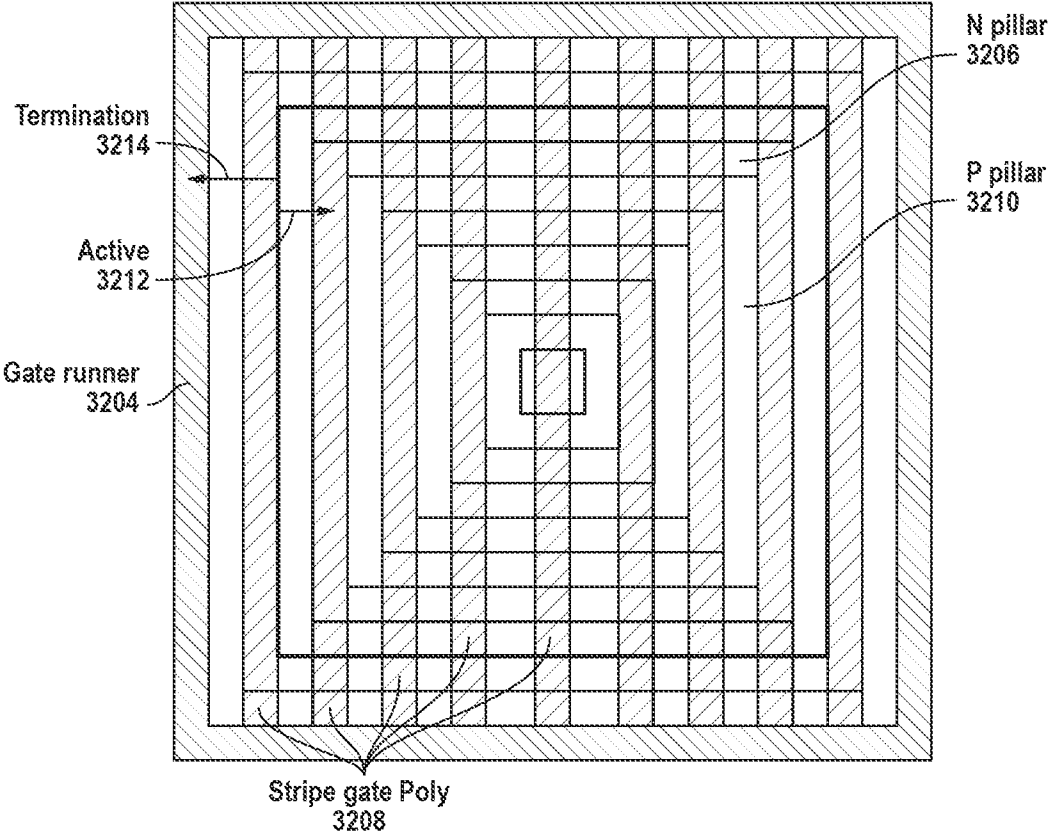


FIG. 32

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US2012/035262

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - H01L 23/62 (2012.01)

USPC - 257/355

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC(8) - H01L 21/336, 23/62, 29/76, 29/78 (2012.01)

USPC - 257/328, 341, 355; 438/268

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

PatBase, Google Patents, Google

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2009/0079002 A1 (LEE et al) 26 March 2009 (26.03.2009) entire document	1-30
Y	US 2008/0265317 A1 (BLANCHARD) 30 October 2008 (30.10.2008) entire document	1-30
Y	US 2007/0023830 A1 (PFIRSCH et al) 01 February 2007 (01.02.2007) entire document	5
Y	US 6,465,304 B1 (BLANCHARD et al) 15 October 2002 (15.10.2002) entire document	9
Y	US 2001/0028083 A1 (ONISHI et al) 11 October 2001 (11.10.2001) entire document	18, 21, 27, 30
Y	US 2010/0140698 A1 (ROIG-GUITART et al) 10 June 2010 (10.06.2010) entire document	23
A	US 2010/0200936 A1 (SAITO et al) 12 August 2010 (12.08.2010) abstract; figure 1; paragraphs 73-77; claim 1.	1-30

☐ Further documents are listed in the continuation of Box C.


* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

13 September 2012

Date of mailing of the international search report

24 SEP 2012

Name and mailing address of the ISA/US

Mail Stop PCT, Attn: ISA/US, Commissioner for Patents
P.O. Box 1450, Alexandria, Virginia 22313-1450

Facsimile No. 571-273-3201

Authorized officer:

Blaine R. Copenheaver

PCT Helpdesk: 571-272-4300

PCT OSP: 571-272-7774

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US2012/035262

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

See extra sheet.

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying additional fees, this Authority did not invite payment of additional fees.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☒ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:
1-30

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☐ No protest accompanied the payment of additional search fees.

This application contains the following inventions or groups of inventions which are not so linked as to form a single general inventive concept under PCT Rule 13.1. In order for all inventions to be examined, the appropriate additional examination fees must be paid.

Group I, claims 1-30, drawn to a device and method comprising a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant regions of second conductivity type.

Group II, claims 31-40, 151-162, drawn to a method comprising forming deep trenches.

Group III, claims 41-55, drawn to a method and device comprising gate electrodes adjacent to but insulated from the P-type body regions and the N-type semiconductor material, the gate electrodes overlapping with the N-type source regions.

Group IV, claims 56-66, drawn to a method comprising a plurality of lower trenches and a plurality of upper trenches are off-set from one another along the lateral dimension.

Group V, claims 67-73, drawn to a device comprising each of the pillars of the first conductivity type has a middle section that is wider than its upper and lower sections, and each of the pillars of the second conductivity type has a middle section that is narrower than its upper and lower sections.

Group VI, claims 74-81, drawn to a method comprising filling the plurality of trenches with conformal material.

Group VII, claims 82-88, drawn to a method comprising filling each trench with an epitaxial layer of a second conductivity type such that only a center portion of each trench along the top of the trench remains unfilled; and filling the center portion of each trench along the top of the trench with a dielectric material.

Group VIII, claims 89-92, drawn to a device comprising a third insulating layer in each trench.

Group IX, claims 93-114, drawn to a device and method comprising a third layer of conductive material in each trench.

Group X, claims 115-128, 168-171, drawn to a device comprising floating pillars.

Group XI, claims 129-141, drawn to a device and method comprising octagon-shaped pillars.

Group XII, claims 142-150, drawn to a device comprising a plurality of polysilicon gates and a plurality of metal gate runners.

Group XIII, claims 163-167, drawn to a device comprising plurality of P-wells each formed in an upper portion of one of the P-pillars.

The inventions listed as Groups I-XIV do not relate to a single general inventive concept under PCT Rule 13.1 because, under PCT Rule 13.2, they lack the same or corresponding special technical features for the following reasons:

the special technical feature of the Group I invention: a plurality of implant regions of the second conductivity type arranged on top of one another along the depth of pillars of second conductivity type, and a trench portion filled with semiconductor material of the second conductivity type directly above the plurality of implant regions of second conductivity type, as claimed therein is not present in the invention of Groups II-XIII.

The special technical feature of the Group II invention: deep trenches, as claimed therein is not present in the invention of Groups I, III-XIII.

The special technical feature of the Group III invention: gate electrodes adjacent to but insulated from the P-type body regions and the N-type semiconductor material, the gate electrodes overlapping with the N-type source regions, as claimed therein is not present in the invention of Groups I, II, IV-XIII.

The special technical feature of the Group IV invention: a plurality of lower trenches and a plurality of upper trenches are off-set from one another along the lateral dimension, as claimed therein is not present in the invention of Groups I, II, III or V-XIII.

The special technical feature of the Group V invention: each of the pillars of the first conductivity type has a middle section that is wider than its upper and lower sections, and each of the pillars of the second conductivity type has a middle section that is narrower than its upper and lower sections, as claimed therein is not present in the invention of Groups I-IV, VI-XIII.

The special technical feature of the Group VI invention: filling the trenches with conformal material, as claimed therein is not present in the invention of Groups I-V, VII-XIII.

The special technical feature of the Group VII invention: filling each trench with an epitaxial layer of a second conductivity type such that only a center portion of each trench along the top of the trench remains unfilled; and filling the center portion of each trench along the top of the trench with a dielectric material, as claimed therein is not present in the invention of Groups I-VI or VIII-XIII.

The special technical feature of the Group VIII invention: a third insulating layer in each trench, as claimed therein is not present in the invention of Groups I-VII, IX-XIII.

The special technical feature of the Group IX invention: a third layer of conductive material in each trench, as claimed therein is not present in the invention of Groups I-VIII, X-XIII.

The special technical feature of the Group X invention: floating pillars, as claimed therein is not present in the invention of Groups I-IX, XI-XIII.

The special technical feature of the Group XI invention: octagon-shaped pillars, as claimed therein is not present in the invention of Groups I-X, XII-XIII.

The special technical feature of the Group XII invention: a plurality of polysilicon gates and a plurality of metal gate runners, as claimed therein is not present in the invention of Groups I-XI, XIII.

The special technical feature of the Group XIII invention: P-wells as claimed therein is not present in the invention of Groups I-XII.

Groups I to XIII lack unity of invention because even though the inventions of these groups require the technical feature of a power device and method comprising a semiconductor region including a plurality of alternately arranged pillars of first and second conductivity type, this technical feature is not a special technical feature as it does not make a contribution over the prior art in view of US 2010/0200936 A1 (SAITO et al) 12 August 2010 (12.08.2010) abstract; figure 1; paragraphs 73-77; claim 1.

Since none of the special technical features of the Group I to XIII inventions are found in more than one of the inventions, unity of invention is lacking.