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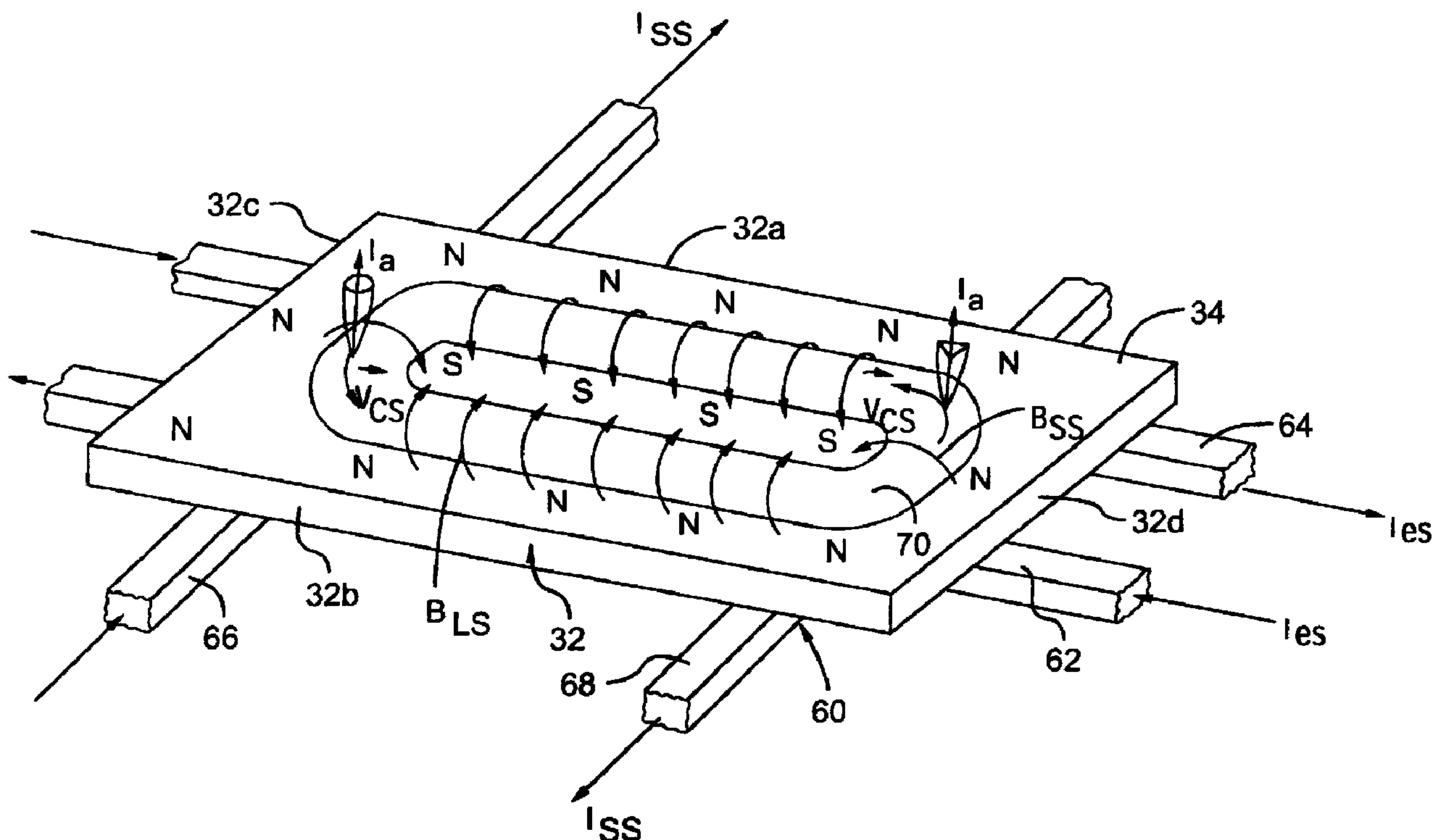
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(54) Titre : SOURCE RECTANGULAIRE POUR ARC CATHODIQUE ET METHODE PERMETTANT DE DIRIGER LE
POINT D'UN ARC

(54) Title: RECTANGULAR CATHODIC ARC SOURCE AND METHOD OF STEERING AN ARC SPOT



(57) Abrégé/Abstract:

The invention provides an arc coating apparatus having a steering magnetic field source comprising a plurality of electrically independent closed-loop steering conductors disposed in the vicinity of the target surface, each steering conductor being controlled independently of the other steering conductors. Increasing the current through one steering conductor increases the strength of the magnetic field generated by that conductor relative to the steering conductor along the opposite side of the cathode plate, shifting the magnetic field on the opposite side of the cathode plate transversely. Selective unbalancing of the steering



(57) Abrégé(suite)/Abstract(continued):

conductor currents thus increases the effective breadth of the erosion zone to provide more uniform erosion of the target surface. The steering conductors may be disposed in front of or behind the target surface of the cathode plate. In a further embodiment, groups of steering conductors are disposed along opposite sides of the cathode plate. By selectively applying a current through one conductor in each group, the path of the arc spot shifts to an erosion corridor defined by the active steering conductor. The invention also provides a plurality of internal anodes disposed within the plasma duct, for deflecting the plasma flow and preserving a high ionization level of the plasma. The invention also provides a magnetic focusing system which confines the flow of plasma between magnetic fields generated on opposite sides of the coating chamber. The plasma focusing system can be used to deflect the plasma flow off of the working axis of the cathode, to remove the neutral component of the plasma which otherwise constitutes a contaminant, by disposing the plasma focusing coils in progressively asymmetric relation to the working axis of the cathode, to deflect the flow of plasma along a curvate path toward a substrate holder. The invention also provides a shield at floating potential, restricting the cathode spot from migrating into selected regions of the target evaporation surface outside of the desired erosion zone. The shield may be positioned immediately above the region of the target surface in the vicinity of the anode, protecting the anode from deposition of cathodic evaporate and providing better distribution of cathodic evaporate over the substrates to be coated.

Abstract

The invention provides an arc coating apparatus having a steering magnetic field source comprising a plurality of electrically independent closed-loop steering conductors disposed in the vicinity of the target surface, each steering conductor being controlled independently of the other steering conductors. Increasing the current through one steering conductor increases the strength of the magnetic field generated by that conductor relative to the steering conductor along the opposite side of the cathode plate, shifting the magnetic field on the opposite side of the cathode plate transversely. Selective unbalancing of the steering conductor currents thus increases the effective breadth of the erosion zone to provide more uniform erosion of the target surface. The steering conductors may be disposed in front of or behind the target surface of the cathode plate. In a further embodiment, groups of steering conductors are disposed along opposite sides of the cathode plate. By selectively applying a current through one conductor in each group, the path of the arc spot shifts to an erosion corridor defined by the active steering conductor. The invention also provides a plurality of internal anodes disposed within the plasma duct, for deflecting the plasma flow and preserving a high ionization level of the plasma. The invention also provides a magnetic focusing system which confines the flow of plasma between magnetic fields generated on opposite sides of the coating chamber. The plasma focusing system can be used to deflect the plasma flow off of the working axis of the cathode, to remove the neutral component of the plasma which otherwise constitutes a contaminant, by disposing the plasma focusing coils in progressively asymmetric relation to the working axis of the cathode, to deflect the flow of plasma along a curvate path toward a substrate holder. The invention also provides a shield at floating potential, restricting the cathode spot from migrating into selected regions of the target evaporation surface outside of the desired erosion zone. The shield may be positioned immediately above the region of the target surface in the vicinity of the anode, protecting the anode from deposition of cathodic evaporate and providing better distribution of cathodic evaporate over the substrates to be coated.

RECTANGULAR CATHODIC ARC SOURCE AND
METHOD OF STEERING AN ARC SPOT

Field of Invention

5 This invention relates to apparatus for the production of coatings in a vacuum. In particular, this invention relates to a vacuum arc coating apparatus having a rectangular cathodic arc source providing improved arc spot scanning and a plasma focusing system.

Background of the Invention

10 Many types of vacuum arc coating apparatus utilize a cathodic arc source in which an electric arc is formed between an anode and a cathode plate in a vacuum chamber. The arc generates a cathode spot on a target surface of the cathode, which evaporates the cathode material into the chamber. The cathodic evaporate disperses as a plasma within the chamber, and upon contact with one or more
15 substrates coats the substrates with the cathode material, which may be metal, ceramic etc. An example of such an arc coating apparatus is described in U.S. Patent No. 3,793,179 issued February 19, 1974 to Sablev.

 An arc coating apparatus of this type is advantageous for use in the coating of large substrates and multiple substrates, due to the large surface area of the
20 cathode which can be evaporated into a large volume coating chamber. However, in a large surface area cathode arc coating apparatus of this type a significant portion of the target evaporation surface of the cathode plate goes largely unused, due to the scanning pattern of arc spots which follows certain physical principles:

1. The arc discharge tends to move in a direction which reduces
25 the voltage drop in the arc circuit, and the arc spot thus tends to migrate to regions on the target surface which are closest to the anodic current conductor. Where multiple current conductors traverse the cathode the arc spot will occasionally migrate into the

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region between conductors where it may remain for a considerable time because no steering mechanism is present to move the arc spot back to the desired evaporation zone.

2. In the case of metal cathodes the arc spot follows a retrograde motion according to the "anti-ampere force" principle, and is thus attracted to the coaxial magnetic force lines generated by the anodic current conductor.

3. In the case of a cathode formed from a material which does not have a melting phase, for example a sintered or graphite cathode, the arc spot moves according to the "ampere force" principle and is repelled from the coaxial magnetic force lines generated by the anodic current conductor.

4. The arc spot is attracted to the region where the tangential component of a transverse magnetic field is strongest.

5. The arc spot tends to migrate away from the apex of an acute angle at the point of intersection between a magnetic field line and the cathode target surface (the "acute angle" rule).

These effects result in a limited erosion zone relative to the available area of the target surface of the cathode plate, reducing the life of the cathode and dispersing cathodic evaporate into the coating chamber in non-uniform concentrations.

20 In a large area cathode arc coating apparatus using a metal cathode plate the anti-ampere motion of the arc spot and the tendency of the arc to seek the lowest voltage drop combine to largely confine the arc spot to the vicinity of the anodic conductor, substantially limiting the erosion zone to the region of the target surface surrounding the anodic conductor. This results in a very small area inside the
25 coating chamber in which the cathodic evaporate is concentrated enough to apply a uniform coating to the substrates. However, it is not possible to construct the cathode plate so that the desired coating material is located only in the erosion zone, since the arc spot will occasionally stray out of the erosion zone and if the target surface is not

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entirely composed of the selected coating material the cathodic evaporate from outside the desired erosion zone will contaminate the coating on the substrates.

In the case of a cathode plate formed from a material which does not have a melting phase, the tendency of the arc spot to move in an ampere direction, away from the region of the anodic conductor, is opposed by the tendency of the arc discharge to settle toward the region of lowest voltage drop. In these cases the arc spot tends to move chaotically over the target surface of the cathode and the cathodic evaporate accordingly disperses in random locations and non-uniform concentrations within the coating chamber, rendering uniform coating of the substrates improbable. This random motion also causes the arc spot to move off of the target surface of the cathode and causes undesirable erosion of non-target portions of the cathode plate, for example the side edges.

U.S. Patent No. 4,448,659 issued May 15, 1984 to Morrison, which is incorporated herein by reference, describes an arc coating apparatus providing a cathode in the form of a plate with a large target surface for creating cathodic evaporate. A confinement ring composed of a magnetically permeable material surrounds the cathode to confine the arc spot to the target surface. Such plasma sources can be used for the production of coatings on large and long articles, but present the following disadvantages:

1. Despite the initial low probability of the presence of cathodic spots on the protective ring, over time the cathodic evaporate coats the ring and cathodic spots are produced on the ring with increasing frequency. This results in contamination of the coating by the ring material, and ultimately in ring failure.

2. In self-steering cathodic arc sources it is not possible to use external magnetic fields in the vicinity of the target surface of the cathode. It is therefore not possible in such an apparatus to use a plasma-focusing magnetic field, as the influence of the focusing magnetic field makes the distribution of cathodic spots on the working surface of the cathode irregular and non-uniform. Any external magnetic field, for example for focusing or deflecting the arc plasma flow, interferes

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with the self-sustained magnetic field generated by the cathode and anode current conductors and disrupts the self-steering character of the cathode spot. However, the absence of magnetic focusing reduces the efficiency of the coating process and impairs the quality of substrate coatings, because the content of the neutral component
5 (macroparticles, clusters and neutral atoms) in the region of the substrates, and thus in the substrate coating, increases.

3. A cathode in this type of plasma source rapidly becomes concave due to evaporative decomposition, and its useful life is therefore relatively short. Moreover, since the evaporation surface of the cathode becomes concave in a
10 relatively short time it is practically impossible to use a high voltage pulse spark igniter in such a design, so that a mechanical igniter must be used which lowers working reliability and stability.

4. While the confinement ring prevents the arc spot from straying off of the target surface, it does not affect the tendency of the arc spot to migrate
15 toward the anodic conductor in the case of metal cathodes, or to move chaotically over the target surface in the case of non-metal cathodes.

Accordingly, self-steering arc plasma sources tend to use the target surface inefficiently and the cathode thus has a relatively short useful life.

The erosion efficiency of the target surface can be improved by
20 providing an arc spot steering system to steer the arc spot along a selected path about the target surface. This increases the size of the region within the coating chamber in which coating can occur.

For example, the scanning pattern of a cathode spot can be controlled by providing a closed-loop magnetic field source disposed beneath the target surface
25 of the cathode, in a manner similar to that described in U.S. Patent No. 4,724,058 issued February 9, 1988 to Morrison. The magnetic field source establishes a magnetic field in a selected direction over the target surface, which directs the cathode spot in a direction substantially perpendicular to the direction of the magnetic field

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and thus provides more efficient evaporation of the target surface. This approach is based on the principle of arc spot motion whereby an arc spot is attracted to the region where the tangential component of a transverse magnetic field is strongest.

However, this still significantly limits the area of the target surface of the cathode which is available for erosion, because this type of arc coating apparatus creates a stagnation zone in the region where the tangential component of the magnetic field is strongest. The cathode spot eventually settles in the stagnation zone, tracing a retrograde path about the erosion zone and creating a narrow erosion corridor on the target surface. This limits the uniformity of the coating on the substrates and reduces the working life of the cathode.

U.S. Patent No. 4,673,477 to Ramalingam proposes that the magnetic field source can be moved to shift the magnetic field lines and increase the utilization efficiency of the target surface. However, the mechanical adaptations required for such a system make the apparatus too complicated and expensive to be practical.

Where an external magnetic field is present the arc spot follows the "acute angle" rule, according to which the arc spot tends to migrate away from the apex of an acute angle at the point of intersection between a magnetic field line and the cathode target surface. The basic principle is that a cathodic spot formed by a vacuum arc in a fairly strong magnetic field (in the order of 100 Gauss), the force lines of which cross the surface of the cathode at an acute angle, will move in a reverse (retrograde) direction perpendicular to the tangential component of the field and, concurrently, displace away from the apex of the angle (for example, see Cathodic Processes of Electric Arc by Kesaev I.G., Nauka, 1968). This results in the arc spot settling beneath the apex of the arch-shaped portion of the magnetic field which projects over the target surface.

U.S. Patent No. 5,587,207 issued December 24, 1996 to Gorokhovsky, teaches that cathode spot confinement under a closed loop-type linear anode can be enhanced by a conductor which encases the anode to form a closed loop magnetic coil, with the magnetic field lines oriented in the direction shown in Figures 29 and 30

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therein. Simultaneous use of both the closed-loop magnetic steering coil behind the cathode and a closed-loop linear anode in front of the target evaporation surface (with or without an enclosed magnetic coil) results in a synergistic improvement of arc discharge stability and thus cathode spot motion. The anode can be configured in any
5 desired pattern, the configuration thereof being limited only by the periphery of the target surface. The arc spot will scan the target surface under the influence of the transverse magnetic field (in an ampere direction in the case of cathodes of carbon and related sintered materials or in an anti-ampere direction in the case of metal cathodes), virtually unaffected by the current flowing through the anodic conductor.

10 A disadvantage of this approach is that the arc spot will occasionally migrate from the selected erosion zone to another part of the cathode target surface where the intensity of the transverse magnetic field is small and, there being no means available to return the arc spot to the desired erosion zone, will stagnate in the low magnetic field region. In the case of a carbon-based cathode plate, when the velocity
15 of arc spot movement is low enough the arc spot can settle in any stagnation zone where the transverse magnetic field is close to zero, and will not return to the erosion zone.

Summary of the Invention

The present invention overcomes these disadvantages by providing a
20 steering magnetic field source comprising a plurality of electrically independent closed-loop steering conductors disposed in the vicinity of the target surface. In the preferred embodiment each steering conductor can be controlled independently of the other steering conductors. Increasing the current through one steering conductor increases the strength of the magnetic field generated by that conductor relative to the
25 strength of the magnetic field of the steering conductor along the opposite side of the cathode plate, shifting the magnetic field on the opposite side of the cathode plate transversely. Selective unbalancing of the steering conductor currents thus increases the effective breadth of the erosion zone and thus provides more uniform erosion of

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the target surface and a larger area within the coating chamber in which the cathodic evaporate is dispersed at concentrations sufficient to uniformly coat the substrates.

The steering conductors may be disposed in front of or behind the target surface of the cathode plate. When disposed in front of the target surface the steering magnetic field lines intersect with the target surface at an obtuse angle, which obviates the motion-limiting effect of the acute angle principle and allows the arc spot to move over a larger region of the target surface, thereby further increasing the size of the erosion zone.

In a further embodiment, groups of steering conductors are disposed along opposite sides of the cathode plate. By selectively applying a current through one conductor in each group, the path of the arc spot shifts to an erosion corridor defined by the active steering conductor.

The present invention further provides means for restricting the cathode spot from migrating into selected regions of the target evaporation surface outside of the desired erosion zone. The invention accomplishes this by providing a shield at floating potential positioned over one or more the selected regions of the target evaporation surface, which prevents the arc spot from forming in or moving into the shielded region. In one preferred embodiment the shield is positioned immediately above the region of the target surface in the vicinity of the anode, spaced from the target surface. The evaporation zone is thus restricted to the area of the target surface surrounding the shield, protecting the anode from deposition of cathodic evaporate and providing better distribution of cathodic evaporate over the substrates to be coated, which results in more uniform coatings over a greater coating area.

The shield can be used to keep arc spots away from any region where the negative conductor traverses the cathode, which represents the lowest voltage drop relative to the anode. Where a large anode or multiple anodes are provided the shield restrains the arc spot from migrating into the region of the cathode located beneath an anode, where most of evaporated material would be trapped by the anode rather than flowing to the substrate.

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Further, the presence of the shield allows the target evaporation surface of the cathode plate to be constructed of a combination of the coating material and another material, for example an expensive coating material such as titanium or platinum in the desired erosion zone and an inexpensive material such as steel outside
5 of the erosion zone. The steel portion of the target surface may be shielded by a floating shield of the invention to prevent cathode spot formation and motion thereon, and thus prevent contamination of the coating while optimizing utilization of the expensive coating material.

In an arc coating apparatus utilizing a magnetic steering system,
10 regions where the transverse magnetic field is low can be shielded in the same manner to exclude movement of the arc spot into these regions and create the desired pattern of erosion. In this embodiment of the invention the target may be placed on the poles of magnetron-type magnetic system of the type described in U.S. Patent No. 4,724,058 issued February 9, 1988 to Morrison. The region of the evaporation surface located
15 about the central part of target cathode, where the tangential component of the magnetic field is too weak to confine arc spots, may be shielded by a floating shield which prevents the arc spot from migrating into the stagnation area created between the magnetic fields generated by the magnetron.

The invention further provides a magnetic focusing system which
20 confines the flow of plasma between magnetic fields generated on opposite sides of the coating chamber. This prevents the plasma from contacting the surface of the housing, to avoid premature deposition, and increases the concentration of plasma in the vicinity of the substrate holder.

In a further embodiment the plasma focusing system can be used to
25 deflect the plasma flow off of the working axis of the cathode, to remove the neutral component of the plasma which otherwise constitutes a contaminant. In this embodiment the plasma focusing coils are disposed in progressively asymmetric relation to the working axis of the cathode, to deflect the flow of plasma along a curvate path toward a substrate holder.

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The present invention thus provides a vacuum arc coating apparatus comprising a rectangular cathode plate having opposed long sides connected to a negative pole of an arc current source, the cathode plate having an evaporation surface, a coating chamber defined by the evaporation surface and a housing, a substrate holder within the coating chamber, at least one anode within the coating chamber spaced from the evaporation surface, connected to a positive pole of a current source, an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the evaporation surface, and a magnetic steering system comprising at least first and second steering conductors arranged along opposite sides of the cathode plate, the first and second steering conductors being disposed in the vicinity of the evaporation surface so that a magnetic field generated thereby exerts a magnetic influence on the arc spot, the first steering conductor being electrically independent of the second steering conductor, wherein by varying a level of current applied through the first steering conductor relative to the second steering conductor the magnetic field generated by the first steering conductor shifts toward a long side of the cathode plate.

The present invention further provides a vacuum arc coating apparatus comprising a rectangular cathode plate having opposed long sides connected to a negative pole of an arc current source, the cathode plate having an evaporation surface, a coating chamber defined by the evaporation surface and a housing, a substrate holder within the coating chamber, at least one anode within the coating chamber spaced from the evaporation surface, connected to a positive pole of a current source, an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the evaporation surface, and a magnetic steering system comprising groups of steering conductors arranged along each of the long sides of the cathode plate, the steering conductors each being disposed in the vicinity of the evaporation surface so that a magnetic field generated thereby exerts a magnetic influence on the arc spot, each steering conductor being electrically independent of the other steering conductors, wherein an erosion zone on the evaporation surface defined within the magnetic field is shifted by selectively reducing a current from one steering

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conductor and applying a current through another steering conductor in the same group.

The present invention further provides a method of steering an arc spot on an evaporation surface of a rectangular cathode plate in an arc coating apparatus, the cathode plate being connected to a negative pole of an arc current source and disposed within a coating chamber defined by the evaporation surface and a housing, the apparatus having a magnetic steering system comprising steering conductors arranged along opposite long sides of the cathode plate and being disposed in the vicinity of the evaporation surface so that a magnetic field generated thereby exerts a magnetic influence on an arc spot generated on the evaporation surface, comprising the steps of modulating each steering conductor independently of the other steering conductors, and varying a level of current applied through a first steering conductor relative to a second steering conductor to shift a magnetic field generated by the first steering toward a long side of the cathode plate.

The present invention further provides a vacuum arc coating apparatus comprising a cathode connected to a negative pole of an arc current source, having an evaporation surface, a coating chamber defined by the evaporation surface and a housing, a substrate holder within the coating chamber, at least one anode within the coating chamber spaced from the target surface, connected to the positive pole of a current source, an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the target evaporation surface, a magnetic focusing system comprising a plurality of magnetic focusing conductors disposed about the housing, the focusing conductors being spaced apart and generating magnetic fields within the housing which confine a flow of plasma to a plasma flow path, and a substrate holder within the plasma flow path.

The present invention further provides a vacuum arc coating apparatus comprising a cathode plate connected to a negative pole of an arc current source, having an evaporation surface, a coating chamber defined by the evaporation surface and a housing, at least one anode within the coating chamber spaced from the

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evaporation surface, connected to the positive pole of an arc current source, and an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the evaporation surface, wherein the anode comprises a substantially planar anode body disposed in a direction substantially tangential to a direction of a magnetic field surrounding the anode.

The present invention further provides a vacuum arc coating apparatus comprising a cathode plate connected to a negative pole of an arc current source, having a target evaporation surface, a coating chamber defined by the target evaporation surface and a housing, a first anode within the coating chamber spaced from the target surface, connected to the positive pole of the arc current source, a substrate holder disposed within the coating chamber separated from the target surface by a plasma duct defined within the housing, an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the target evaporation surface, and a second anode disposed within the plasma duct comprising an anode body disposed in a direction substantially tangential to a direction of a magnetic field surrounding the second anode.

The present invention further provides a vacuum arc coating apparatus comprising a cathode plate connected to a negative pole of an arc current source, having an evaporation surface, a coating chamber defined by the evaporation surface and a housing, a substrate holder within the coating chamber, at least one anode within the coating chamber spaced from the target surface, connected to the positive pole of the arc current source, an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the target evaporation surface, and at least one electrically conductive shield maintained at floating potential spaced from at least one shielded region of the evaporation surface, wherein the shield prevents movement of the arc spot into the shielded region.

The present invention further provides a vacuum arc coating apparatus comprising a pair of opposed rectangular cathode plates each having opposed long sides connected to a negative pole of an arc current source and an evaporation surface,

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a coating chamber defined by the evaporation surfaces and a housing, a substrate holder within the coating chamber, anodes within the coating chamber spaced from each evaporation surface, connected to a positive pole of a current source, an arc igniter for igniting an arc between each cathode and anode and generating an arc spot
5 on the evaporation surfaces, and a magnetic focusing system comprising a plurality of magnetic focusing conductors disposed about the housing, the focusing conductors being spaced apart and generating magnetic fields within the housing which confine a flow of plasma to a plasma flow path, wherein the focusing conductors direct the plasma toward the substrate holder.

10 Brief Description of the Drawings

In drawings which illustrate by way of example only a preferred embodiment of the invention,

Figure 1 is a schematic cross-section of a prior art large area cathode vacuum arc plasma source having a magnetic steering system disposed behind the
15 cathode plate;

Figure 2 is a partial perspective view illustrating the distribution of magnetic field lines produced by a magnetic steering system according to one embodiment of the invention;

Figure 2a is a schematic elevation illustrating balanced magnetic field
20 lines produced by the magnetic steering system of Figure 2;

Figure 2b is a schematic elevation illustrating an erosion corridor produced by the magnetic steering system of Figure 2 unbalanced in a first direction;

Figure 2c is a schematic elevation illustrating an erosion corridor produced by the magnetic steering system of Figure 2 unbalanced in a second
25 direction;

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Figure 3 is a schematic elevation illustrating a variation of the embodiment of Figure 2 in which multiple steering conductors are disposed along the long sides of the cathode plate;

Figure 4 is a plan view of a further preferred embodiment of a large
5 area cathode arc source of the invention;

Figure 5 is a cross-section of the apparatus of Figure 4 taken along the line 5-5;

Figure 6 is a cross-section of the apparatus of Figure 4 taken along the line 6-6;

10 Figure 7a is a plan view of an arc coating apparatus embodying a plasma focusing system according to the invention;

Figure 7b is a side elevation of the arc coating apparatus of Figure 7a;

Figure 8 is a plan view of a variation of the arc coating apparatus of Figure 7a providing neutralizing conductors for modulating the steering and focusing
15 conductors;

Figure 9 is a plan view of an arc coating apparatus embodying a deflecting electromagnetic system according to the invention for guiding cathodic evaporate to a substrate holder disposed remote from the working axis of the cathode plate; and

20 Figure 10 is a plan view of a dual arc coating apparatus embodying the magnetic steering, focusing and deflecting aspects of the invention.

Detailed Description of the Invention

Figure 1 illustrates a prior art large area rectangular cathode vacuum arc plasma source of the type described and illustrated in U.S. Patent No. 4,724,058 to Morrison. The apparatus 10 comprises a cathode plate 12 having a target evaporation surface 14 which may be circumscribed by a confinement member 16 composed of a magnetically permeable material. As described in U.S. Patent No. 5,587,207 issued December 24, 1996 to Gorokhovsky, an anode 15 disposed opposite the target surface 14, which may be composed of a metallic or a non-metallic coating material.

A current applied between the cathode 12 and the anode 15 creates an arc which generates an arc spot on the target surface 14. In the prior art apparatus shown the scanning pattern of the cathode spot is controlled by a closed-loop magnetic field source 18 disposed behind the cathode 12. The magnetic field source 18 establishes magnetic fields 19a, 19b in opposite directions over the target surface 14 which moves the arc spot in a retrograde motion according to the formula

$$V_{cs} = -c[I_{as}(B_t)]$$

in which V_{cs} is the velocity of the arc spot, I_{as} is the arc spot current, B_t is the strength of the transverse magnetic field, and c is a coefficient based on the material of the target surface 14. The arc spot thus traces a retrograde path about the cathode plate following the length of the magnetic field source.

When trapped within the static magnetic field produced by the magnetic field source 18, the cathode spot is directed toward the apex of the magnetic field lines, the region where the tangential component of a magnetic field is strongest, which causes the target surface 14 to evaporate along a narrow evaporation corridor 14a. Further, the oppositely oriented magnetic field lines 19a, 19b create a stagnation zone at 22 in which the cathode spot can settle and remain for prolonged periods, eroding the target surface 14 unduly in the stagnation zone 22. Both of these effects result in poor utilization efficiency of the target surface 14. Accordingly, in the apparatus described in U.S. Patent No. 4,724,058 the magnetic field is activated only

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intermittently during the coating process, the arc spot being free to scan randomly most of the time. Since the cathode spot is largely self-steering, magnetic fields cannot be used for plasma focusing.

Figure 2 illustrates a preferred embodiment of a cathode spot steering system 60 according to the invention. In the embodiment illustrated in Figure 2 the steering system 60 is disposed behind the cathode plate 32 (i.e. on the side of the cathode plate 32 opposite to the target evaporation surface 34), which has long sides 32a, 32b and short sides 32c, 32d. The steering system 60 comprises linear conductors 62 and 64 respectively disposed in parallel with the long sides 32a, 32b of the cathode plate 32 having a current I_{LS} applied thereto in the direction shown, and linear conductors 66 and 68 respectively disposed in parallel with the short sides 32c, 32d of the cathode plate 32 having a current I_{SS} applied thereto in the direction shown. The conductors 62, 64 are disposed behind the cathode plate in the vicinity of the target surface 34 so that the magnetic fields generated thereby intersect the target surface 34, and thus influence arc spot formation and motion. The steering conductors 62, 64, 66, 68 may alternatively be disposed in front of the cathode plate, as in the embodiment illustrated in Figures 4 to 6, described below. In either case the steering magnetic field source 60 generates a magnetic field defining an erosion zone 70 along the target surface 34.

The configuration and polarities of the magnetic fields generated by the steering conductors 62, 64, 66 and 68 are illustrated by the magnetic field lines in Figure 2. The magnetic field lines projecting above the target surface 34 are arch-shaped, and on opposite sides of the cathode 32 are oriented in opposite directions. Arc spots moving within the erosion zone 70 are attracted toward the apex of the arch-shaped magnetic field lines, where the tangential component of the magnetic field which projects beyond the target surface 34 is strongest. When the current through opposite conductors, for example steering conductors 62 and 64, is equal or balanced (i.e. $I_1 = I_2$), the arc spot travels along a narrow erosion corridor largely confining the erosion zone 70 beneath the apex of the magnetic field lines symmetrically about the longitudinal centre of the cathode plate 32, as shown in Figure 2a.

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According to one aspect of the invention, by increasing the current in one steering conductor relative to the current in the steering conductor on the opposite side of the cathode plate 32, the magnetic field becomes unbalanced and the magnetic field lines on the side of the cathode 32 with the weaker magnetic field shift toward
5 the side of the cathode 32 with the stronger magnetic field. In the preferred embodiment each linear conductor 62, 64, 66, 68 is thus electrically independent and can be controlled in isolation.

For example, in Figure 2b the current in steering conductor 62 has been increased relative to the current in steering conductor 64, so that $I_1 < I_2$. The resulting
10 unbalancing of the strength of the magnetic fields generated thereby distorts the magnetic field generated by the conductor 64 and shifts its magnetic field lines toward the conductor 62. The point of the magnetic field generated by conductor 64 where the tangential component of the transverse magnetic field is strongest has thus shifted away from the side 32a and toward the centre of the cathode 32, and arc spots
15 accordingly trace a path closer to the centre of the cathode 32. By unbalancing the current in conductors 62, 64 so that conductor 64 generates the stronger magnetic field and $I_1 > I_2$, the path of the arc spot shifts away from the side 32b and toward the centre of the cathode, as shown in Figure 2c.

The degree of unbalancing, i.e. the current differential between
20 conductors 62 and 64, determines the extent of the magnetic field shift. By unbalancing the conductors 62, 64 at selected current levels and in properly timed intervals coinciding with the motion of the arc spot, a plurality of arc spot paths are created. This substantially increases utilization efficiency of the target surface.

A similar effect is achieved along the short sides 32c, 32d of the
25 cathode 32 by unbalancing the current through the conductors 66, 68. The path of the arc spot will shift toward the centre of the cathode 32 along the side with the weaker magnetic field. However, it will be appreciated that if the cathode plate 32 is narrow enough that the magnetic fields generated along the long sides 32a, 32b by conductors 62, 64 are relatively close together, the conductors 66, 68 along the short sides 32c,

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32d may become unnecessary; the arc spot will naturally migrate back and forth between the long magnetic fields, or as the arc spot reaches the end of its path along one long side 32a or 32b the magnetic field can be selectively decreased or momentarily deactivated along that side and the arc spot will move to the other side
5 32b or 32a where the magnetic field is stronger.

The closing conductors 62a, 64a, 66a, 68a, which are parallel to the target surface 34 and respectively complete the circuit for each steering conductor 62, 64, 66, 68, are maintained well away from the cathode plate 32 and the housing 38. This ensures that the magnetic fields generated by the closing conductors 62b, 64b,
10 66b, 68b or 72a, 72b do not influence arc spot formation or plasma flow patterns.

In operation, when an arc is created by applying a current between the anode and the cathode plate, an arc spot generated on the target surface 34 settles in an erosion corridor 70 defined within the steering magnetic fields generated by the steering conductors 62, 64, 66, 68. The arc spot follows a retrograde motion along the
15 erosion zone 70. The magnetic field is periodically unbalanced by a control switch (not shown), which intermittently increases the current through conductor 62 to increase the strength of the magnetic field generated thereby and shift the arc spot path away from the side 32a, and alternately increases the current through conductor 64 to increase the strength of the magnetic field generated thereby and shift the arc spot path
20 away from the side 34a. This effectively widens the erosion zone 70 to increase the utilization efficiency of the target surface, improving the quality of the coating and the durability of the cathode 32.

In a variation of this embodiment, illustrated in Figure 3, a plurality of steering conductors 62b, 62c, 62d and 64b, 64c, 64d are provided respectively along
25 the long sides of the cathode plate 32. In this variation the steering conductors 62b, 62c, 62d and 64b, 64c, 64d are activated or modulated alternatively so that the erosion corridor, being located generally above the currently active steering conductor 62b, 62c or 62d on one side and 64b, 64c or 64d on the other side, can be shifted in a

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widthwise direction over the cathode plate 32 to increase the breadth of the erosion zone 70.

In the embodiment of Figure 3 as many steering conductors may be provided as the size of the cathode plate 32 will practically allow. One steering
5 conductor 62b, 62c or 62d and 64b, 64c or 64d should be active on each side of the cathode plate 32 at any particular time, in order to avoid creating a stagnation zone in which the cathode spot may become trapped. However, where the conductors on each side of the cathode 32 are close together, simultaneously exciting more than one conductor on each side of the cathode 32 can allow for a more elaborate erosion
10 pattern which, properly controlled, can increase the utilization efficiency of the target surface 34 even further.

In the operation of this embodiment, when an arc is created by applying a current between the anode and the cathode plate, an arc spot generated on the target surface 34 settles in an erosion corridor 70 defined within the steering magnetic fields
15 generated by the active steering conductors, for example 62b and 64b. The magnetic field is periodically shifted by a control switch (not shown), which switches the current between the conductors 62b, 62c and 62d on the long side 32a and between the conductors 64b, 64c and 64d on the long side 32b, to thereby and shift the arc spot path to the vicinity of the active steering conductor. This widens the erosion zone 70
20 to increase the utilization efficiency of the target surface, improving the quality of the coating and the durability of the cathode 32.

It will be appreciated that in each of these embodiments the active steering conductor does not need to be deactivated completely when another steering conductor is activated, or fully energized when activated, in order to achieve the
25 desired erosion pattern in the erosion zone 70. The current can be modulated differentially as between the various steering conductors to generate the same result.

Figures 4 to 6 illustrate a further embodiment of the invention providing arc spot shielding. An arc coating apparatus is provided with a rectangular cathode plate 32 comprising a target evaporation surface 34 and a supporting plate 36

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mounted to a cathode holder 42, within a coating chamber defined by the target surface 34 and a housing 38. In the preferred embodiment the target surface 34, which may be composed of any suitable metallic or a non-metallic coating material, has long sides 32a, 32b and short sides 32c, 32d and is electrically insulated from the housing
5 38 by dielectric spacers 39 isolating the cathode holder 42 from the supporting plate 36 and spaced from the housing 38 by a gap 40. The target surface 34 may be formed from different materials, for example titanium and aluminum or titanium and chromium, integrated in a mosaic fashion along the erosion zone 70 to produce a composite metallic plasma for applying coatings such as TiAlN, TiCrN or the like.

10 The cathode plate 32 is spaced from the cathode holder 42 to create a coolant chamber 44 for circulating a coolant such as water, and is connected to the negative pole of an arc current source (not shown). A conventional high voltage pulse igniter 48 is mounted through a dielectric sleeve traversing the wall of the housing 38.

 Suspended from the housing 38 by a mounting assembly 51 is a linear
15 anode 50, spaced from the cathode plate 32 and mounted to an anode holder 52 which may be provided with a coolant channel 53 for circulation of a coolant such as water. The anode 50 is connected to the positive pole of the arc current source 46. In the preferred embodiment the anode 50 comprises a series of baffles or "fins" 50a which may be disposed generally orthogonally in relation to an anode body 50b, to increase
20 the effective anodic surface area. The fins 50a and anode body 50b are each preferably oriented in a direction parallel to the direction of the plasma flow, i.e. parallel to the direction of any focusing magnetic fields in the vicinity of the anode 50 as described below, to reduce the opportunity for vapour deposition on the anodic surfaces and thus reduce diffusion losses.

25 Arc spot formation is confined by steering magnetic fields produced by a steering magnetic field source 60 comprising linear conductors 62 and 64 respectively disposed along the long sides 32a, 32b of the cathode plate 32 and linear conductors 66 and 68 respectively disposed along the short sides 32c, 32d of the cathode plate 32. In this embodiment the conductors 66, 68 are disposed behind the

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cathode plate 32 as in the previous embodiments, but the conductors 62, 64 are disposed in front of the cathode plate 32. The conductors 62, 64 are still disposed in the vicinity of the target surface 34 so that the magnetic fields generated thereby influence arc spot formation and motion, and the operation of the steering system 60 in this embodiment is substantially as described in respect of the embodiment of Figure 2.

However, in the embodiment of Figures 4 to 6 the steering magnetic fields do not confine arc spots, as in the embodiment of Figure 2, because the magnetic field lines are not arch-shaped and intersect the target surface 34 on only one side, as seen by the magnetic field lines shown in Figure 5. Thus, because of the acute angle principle arc spots are guided toward the central region of the cathode plate 32, away from the acute angle formed where the magnetic field lines intersect the target surface 34. Arc spots therefore have a broader range of motion available in this embodiment. Moreover, in the embodiments in which the steering conductors are located behind the cathode plate 32, in which the portion of the steering magnetic fields projecting above the target surface 34 is closed (i.e. intersects the target surface 34 along both sides), the magnetic fields confine not only the arc spot but also the plasma generated as the target surface 34 evaporates. As shown in Figure 5, by disposing the conductors 62, 64 in front of the target surface 34 the cathodic evaporate has an open path to the substrate holder 6.

Arc spots are thus guided toward the central region of the cathode plate 32, from both long sides 32a, 32b. To avoid creating a stagnation zone in the central region of the cathode plate 32, a conductive shield 54 maintained at floating potential is mounted to the anode holder 52, insulated therefrom and spaced from the target evaporation surface 34, which precludes any cathode spot activity in the central region of the cathode plate 12. Preferably the shield 54 is spaced from the target surface 34 between 2 mm and 6 mm; less than about 2 mm is likely to cause the arc to short circuit through the shield 54 and more than about 6 mm allows the arc spot to creep under the edges of the shield 54. The shield 54 thus prevents evaporation of the cathode 32 in the shadow of the anode 50, confining arc spot formation to an erosion

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zone 70 surrounding the shadow of the anode 50. This protects the anode 50 from deposition of cathodic evaporate and provides a better distribution of coating material over the substrates (not shown) mounted on the substrate holder 6.

One or more floating shields 54 may be positioned over any selected
5 portion(s) of the target evaporation surface 34, to prevent arc spots from moving into the shielded region. In the embodiment illustrated the shield 54, positioned immediately above the target surface 34 in the vicinity of the anode 50, prevents arc spots from forming in or moving into the area of the target surface 34 surrounding the shield 54. This is advantageous in embodiments in which the steering conductors are
10 disposed in front of the cathode plate 32. However, a floating shield 54 can be used to keep arc spots away from any desired region of the cathode plate 32. For example, the floating shield 54 allows the target evaporation surface of the cathode plate to be constructed of more than one material; in this case an expensive coating material such as tungsten or platinum can be omitted from the region beneath the shield 54, and
15 since arc spots will not form or move in that region there is no possibility that the coating will be contaminated.

In operation, a current is applied between the anode 50 and the cathode plate 32 and a high pulse voltage applied to igniter 48 initiates a vacuum arc on the target surface 34 of the cathode plate 32. The arc spot settles in an erosion corridor 70
20 defined between the steering magnetic fields generated by the conductors 62, 64 and the shielded region of the target surface 34 behind the conductive shield 54. The arc spot follows a retrograde motion along one long side 32a or 32b of the target surface 34, and moves to the other long side 32b or 32a traveling beneath the apex of the magnetic field generated by the steering conductor 66 or 68 disposed behind the
25 cathode plate 32. As the target surface 34 evaporates the plasma is guided between the magnetic fields generated by the conductors 62, 64 and flows toward the substrate holder 6, as shown by the arrows in Figure 5.

Because the preferred embodiments of the invention employ a magnetic steering system, it is possible to use a plasma focusing system to guide the

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cathodic evaporate toward the substrate holder 6. A magnetic field forms a barrier which is largely opaque to plasma. Thus, focusing magnetic fields can be generated about the housing 38 to confine the plasma to a plasma flow region between magnetic fields, and positioning the substrate holder 6 in the plasma flow region to increases the concentration of plasma about the substrates and improves the quality of the coating.

In the embodiment illustrated in Figures 4 to 6 the conductors 62, 64, being disposed in front of the target surface 34 of the cathode plate 32, can also serve as focusing conductors in a plasma focusing system. A plasma flow path is defined between the magnetic fields generated by the conductors 62, 64, as shown by the magnetic field lines in Figure 5, such that plasma is guided along a central region of the housing 38 to the substrate holder 6.

To focus the plasma flow, additional plasma focusing conductors may be provided in series to elongate the plasma flow path. For example, Figures 7a and 7b illustrate an embodiment of the invention in which groups of plasma focusing conductors 82, 84 and 92, 94 are disposed on opposite sides of the housing 38 and, within each group, progressively further from the cathode 32. This creates a plasma confining zone between the magnetic fields generated on opposite sides of the housing 38, thus defining a plasma flow path between the target surface 34 and the substrate holder 6.

The focusing conductors 82, 84 and 92, 94 are disposed too far from the cathode plate 32 to influence arc spot formation or motion, and preferably the focusing conductors in each group 82, 84 or 92, 94 are disposed in closely spaced relation so that their respective magnetic fields overlap to create a continuous magnetic wall confining the plasma to the plasma flow path and magnetically isolating the wall of the housing 38 from the plasma flow. As in the case of the steering conductors, the closing conductors 82a, 84a of the focusing conductors 82, 84 and the closing conductors 92a, 94a of the focusing conductors 92, 94 are maintained well away from the housing 38 and the cathode plate 32 to eliminate any canceling effect of the magnetic fields generated thereby in the region of the housing 38 (plasma duct).

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In the operation of this embodiment, as the target surface 34 evaporates the plasma is concentrated between the focusing magnetic fields generated by focusing conductors 82, 84 and 92, 94. The plasma thereby flows toward the substrate holder 6 without contacting the housing 38.

5 The focusing conductors 82, 84 and 92, 94 are preferably independently powered, so that the intensity of the magnetic field generated by each conductor 82, 84, 92, 94 can be varied independently of the others. Closed loop focusing conductors can be disposed on only one side of the housing 38, however in the preferred embodiment illustrated in Figures 7a, 7b pairs of independent focusing
10 conductors 82 and 92, and 84 and 94, respectively, are disposed on opposite sides of the housing 38 parallel to the long sides 32a, 32b of the cathode 32. The closing conductors 82a, 84a, 92a and 94a are maintained well away from the housing 38 and the cathode plate 32.

In a further embodiment illustrated in Figure 8 the opposed focusing
15 conductors 82, 92 and 84, 94 are formed from the same closed loop conductor with the focusing conductors 82, 92, 84 and 94 disposed parallel to the long sides 32a, 32b of the cathode 32 with closing conductors 82a, 92a, 84a and 94a disposed parallel to the short sides 32c, 32d of the cathode 32.

By connecting focusing conductors 82, 84 and 92, 94 independently to
20 the power supply it is also possible to "raster" the plasma flow by varying the current through opposed focusing conductors 82, 92 and/or 84, 94. This helps to distribute the plasma more uniformly about the plasma duct and to create a more homogeneous plasma mixture. Within the coating chamber the focusing conductors 82, 84 and 92, 94 can be independently activated to deflect plasma toward the substrate holder 6.

25 Figure 8 illustrates an alternative mode of modulating the focusing conductors 82, 92 and/or 84, 94 using neutralizing conductors 140 disposed alongside focusing conductors 82, 92 and 84, 94, but in an opposite orientation. When activated the neutralizing conductors 140 interfere with the magnetic fields generated by one or

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more of the focusing conductors 82, 92 or 84, 94 to reduce the effect of the magnetic field generated thereby and deflect the plasma flow.

In all embodiments the closing conductors 82a, 84a, 92a and 94a are maintained well away from the housing 38 and the cathode plate 32 to eliminate any canceling effect of the magnetic fields generated thereby in the region of the housing 38 (especially the plasma duct region of the housing 38).

The plasma focusing system of the invention can also be used as a plasma deflecting system 100, allowing the substrate holder 6 to be disposed remote from the working axis of the cathode plate 32, designated 33 in Figure 9, to eliminate from the plasma the neutral component (macroparticles, clusters and neutral atoms) which are unaffected by the focusing magnetic field and further improve the quality of the coating. As shown in Figure 9, by arranging deflecting conductors 86, 87, 88 and 96, 97, 98 along a curvate housing 38 in a progressively asymmetrical pattern relative to the working axis 33 of the cathode plate 32, the plasma is deflected toward the substrate holder 6 while the inertia of the plasma causes the neutral component to separate from the plasma in the deflection region.

The conductors 86, 87, 88 and 96, 97, 98 thereby create a chain of deflecting conductors to form a deflecting electromagnetic system. As in the previous embodiments, closing conductors 86a, 87a, 88a and 96a, 97a, 98a are maintained well away from the housing 38 (especially the plasma duct region) and the cathode plate 32. The closing conductors 86a, 87a, 88a and 96a, 97a, 98a may be disposed on the same side of the housing 38 as the deflecting conductors 86, 87, 88 and 96, 97, 98 of the deflecting system, for example by disposing the closing conductors 86a, 87a, 88a and 96a, 97a, 98a well above or below the level of the housing 38. Alternatively the closing conductors 86a, 87a, 88a and 96a, 97a, 98a may be disposed on the opposite side of the housing 38 but remote therefrom, in which case it is preferable that the distance S between the closing conductors and focusing conductors on one side of the housing (for example focusing conductors 86, 87, 88 and closing conductors 96a, 97a, 98a) be governed by the formula

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$$S = 1.5 - 2H$$

where H is the width (transverse) of the housing 38.

In the operation of this embodiment, as the target surface 34 evaporates the plasma is concentrated between the magnetic fields generated by the conductors 62, 64 and flows into the deflection region defined between the magnetic fields generated by deflecting conductors 86, 87, 88 and 96, 97, 98. The plasma is thereby deflected along a flow path coinciding with the asymmetrical pattern of the deflecting conductors 86, 87, 88 and 96, 97, 98 and flows toward the substrate holder 6 without contacting the housing 38. The plasma remains confined between magnetic fields and is thereby deflected away from the working axis 33 of the cathode plate 32. The neutral component continues in a generally straight direction and settles on an interior wall of the housing 38 in the vicinity of the working axis 33 of the cathode plate 32, while the plasma continues along the plasma duct into the coating chamber to the substrate holder 6.

Figure 10 illustrates a preferred embodiment of an arc coating apparatus according to the invention, providing a pair of cathode plates 32 disposed at opposite ends of the housing 38. Internal linear anodes 50 configured as described above are suspended above each target surface 34, separated therefrom by a shield 54. Anodes 50 are defined herein as "internal" because they are disposed within the plasma duct, which is defined between the cathode plates 32 and the substrate holder 6. A further internal anode 120 comprising a linear plate 122 having baffles 124 is disposed along the plasma duct at the approximate center between the two cathode plates 32. The baffles increase the anodic surface area, effectively functioning as a chain of internal anodes, which provides better stabilization and steering of arc spots. As in the previous embodiment, the baffles 124 are oriented as much as possible parallel to the direction of the magnetic field to reduce diffusion losses. This "dividing" anode 120 also serves to repel ions and thus deflect the plasma streams toward the substrate holder 6.

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In this embodiment focusing conductors 82, 84, 92 and 94 are disposed parallel to the long sides 32a, 32b of the cathode plates both about the regions in front of the cathode plates 32 and about the exit of the plasma duct in the coating chamber. In between the sets of focusing conductors 82, 92 and 84, 94, deflecting conductors
5 86, 96 are disposed about the portion of the housing 38 where the plasma duct turns toward the axis of the substrate holder 6, to deflect plasma toward the substrate holder 6.

The embodiment of Figure 10 also provides one or more external anodes 130 surrounding the substrate holder 6. Anodes 130 are defined herein as
10 "external" because they are disposed outside of the plasma duct. Thus, the external anodes 130 do not deflect the plasma, but instead repel ions to prevent diffusion losses on the walls of the housing 38 and prolong ionization of the coating material to improve coating efficiency. Such external anodes 130 can also be provided about any desired portion of the housing 38.

15 Further, since the housing 38 is insulated from the cathode plates 32 by dielectric spacers 39, a current can be applied as shown in Figure 5, or the housing 38 may be left at floating potential, to effectively turn the housing 38 (or any portion thereof) into an external anode, which produces the effects described above and prevents the arc from approaching the housing walls.

20 The internal anodes 32, 120 and external anode 130 are preferably electrically isolated and thus each is provided with an independent power supply, which allows for better control over their independent functions.

It is also possible to differentially activate the focusing conductors 82, 84 and 92, 94 to trap the metal vapour component of the plasma within the plasma
25 duct while allowing the electron current to flow freely through the coating chamber to

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the auxiliary anodes 130 surrounding the substrate holder 6. This mode of operation is a "plasma immersed" mode, which provides a high degree of ionization and activation of the gaseous plasma environment in the coating chamber without deposition of metal cathodic arc plasma coatings. The plasma immersed mode supports several different types of plasma processes, such as fast ion cleaning, ion nitriding, ion implantation, and arc plasma-assisted low pressure CVD coating processes. For example, the first stage of a particular coating process may require ion cleaning. The cathodic arc sources 34 may be used as a powerful electron emitters, to extract electron current from the cathode to the external anode 130 surrounding the substrate holder 6, providing a plasma immersed environment for fast ion cleaning. Argon may be injected as a plasma-created gas in conjunction with an RF generator providing a self bias potential at the substrate holder for effective ion bombardment, as illustrated by the following examples.

15 Example 1

Deposition of a diamond-like coating (DLC) on set of knives such as scalpels, razors, knives for cutting papers using two rectangular arc sources mounted in the dual rectangular plasma guide chamber of Fig. 10 with deposition zone 500 mm height x 300 mm width. The array of knives was installed on a rotating substrate platform facing the filtered arc source over the entire area of the deposition zone, with uniform rotation speed between about 10 to 20 rpm. A graphite rectangular plate evaporation target was attached to the cathode plate assembly. The current in the vertical steering conductors was set to 2000 amps, and the current in the horizontal steering conductors was set to 1300 amps. The arc current between the cathode and the primary (internal) anode plate was set to 300 amps. After igniting the arc with an impulse high voltage igniter, the arc spot began moving along an erosion corridor with an average speed ranging from 20 to 30 cm/s. About three to five cathodic arc spots subsisted simultaneously on the target surface. The current in the deflecting coils was set to 1500 amps each.

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The first stage of the process involved ion cleaning. At this stage the cathodic arc sources were used as a powerful electron emitters. The deflecting conductors were turned off and electron current was extracted from the cathode to the auxiliary (external) anode surrounding the substrate platform, providing a plasma
5 immersed environment for fast ion cleaning. Argon was injected as a plasma-created gas with pressure of about 4×10^{-2} Pa and an RF generator provided a 400 volt self bias potential at the substrate platform for effective ion bombardment.

During the deposition stage the pressure in the vacuum chamber was
10 set to 10^{-3} Pa. The RF generator having a 13.56 MHz frequency provided a self bias potential ranging from 40 V to 60 V during deposition. The deflecting coils were turned off during deposition periodically with a duty cycle of 20s on/5s off to prevent overheating of the coating. The time of deposition was 20 minutes. The thickness of the coating, as measured by micro cross section, ranged from 0.3 to 0.35 mkm which
15 corresponds to a deposition rate of about 1 mkm/hr with a uniformity of +/- 10%.

Example 2

Deposition of graphite coating on molybdenum glass for using as a substrate for flat panel display using rectangular molybdenum glass plates with
20 dimensions 400mm height x 200 mm width x 3 mm thick installed vertically on the rotating substrate platform. Each glass plate was attached to a metal plate-holder and a self bias of about 150 V was applied to the substrate platform using an RF generator with a 13.56 MHz frequency. The dual filtered cathodic arc source of Figure 10 was provided with one aluminum target evaporation surface and one graphite target
25 evaporation surface. The pressure during coating deposition was maintained at about 10^{-3} Pa. The temperature during deposition of the graphite coating was about 400° C, provided by an array of radiative electrical heaters.

In the first stage the arc was ignited on the aluminum target, providing
30 an aluminum sublayer with thickness about 50 nm. In the second stage a graphite

coating with thickness about 150 nm was deposited over the aluminum sublayer during a coating interval of 30 minutes.

Example 3

5 Deposition of TiAlN coatings on an array of hobs and end mills. The array of hobs and end mills was installed on substrate platform facing the filtered arc source exit over the entire area of the deposition zone, the substrate platform having a double (satellite) rotation with platform rotation speed 12 rpm. The dual rectangular filtered arc source of Figure 10 was provided with an aluminum target evaporation
10 surface mounted to one cathode and a titanium target evaporation surface mounted to the second cathode, for deposition of the TiAlN coating. The current for the titanium target was set at about 150 amps while current for the aluminum target was set at about 60 amps.

15 In the first stage the current of the auxiliary (external) anode was set at about 70 amps, providing a high density gaseous plasma immersed environment during both fast ion cleaning and coating deposition. The self bias potential of substrate platform provided by a RF 13.56 MHz generator was maintained at about 400 volts during ion cleaning in argon, and at about 40 volts during deposition of
20 TiAlN coating in nitrogen. The time for ion cleaning was 5 minutes, and for deposition was about 2 hours. The argon pressure during ion cleaning was set at 6×10^{-2} Pa of argon, and for the deposition stage it was set at 2×10^{-2} Pa of nitrogen. The deposition rate for TiAlN coating for double rotated hobs and end mills was found to be about 1-1.5 $\mu\text{m/hr}$.

25

Example 4

Deposition of multi-layer coatings on dies and molds. An array of forging dies and extrusion molds was installed on the substrate platform with uniform rotation speed 20 rpm facing the filtered arc source exit in the dual rectangular filtered
30 arc source of Figure 10, for the deposition of Ti/TiN multi-layer coating with thickness ratio 0.05 μm of Ti and 0.3 μm of TiN. Before deposition of the coatings

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fast ion cleaning and arc plasma immersed ion nitriding was performed to provide gradually increased hardness of near surface layer in a transition zone between bulk material of coating parts and the coating layer. The thickness of nitriding layer was about 40 μm , provided by an auxiliary arc discharge with the current of auxiliary
5 (external) anode set at about 90 amps and a pressure of nitrogen set at about 6×10^{-2} Pa. The number of coating layers was 11 with total thickness about 3.5 μm . The current of the auxiliary anode during the deposition stage was set at about 120 amps, providing maximum total current at both titanium targets of about 500 amps. The DC bias during the ion cleaning/ion nitriding stage was set at about 200 volts, and during
10 the deposition stage the current was reduced to 40 volts. The temperature of substrates was maintained at about 400° C during all stages of the vacuum plasma treatment cycle.

Preferred embodiments of the invention having been thus described by way of example, modifications and adaptations will be apparent to those skilled in the
15 art. The invention includes all such modifications and adaptations as fall within the scope of the appended claims.

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I claim:

1. A vacuum arc coating apparatus comprising
a rectangular cathode plate having opposed long sides connected to a negative
pole of an arc current source, the cathode plate having an evaporation surface,
5 a coating chamber defined by the evaporation surface and a housing,
a substrate holder within the coating chamber,
at least one anode within the coating chamber spaced from the evaporation
surface, connected to a positive pole of a current source,
an arc igniter for igniting an arc between the cathode and the anode and
10 generating an arc spot on the evaporation surfaces, and
a magnetic steering system comprising at least first and second steering
conductors arranged along opposite sides of the cathode plate, the first steering
conductor carrying a current in a direction opposite to a direction of current in the
second steering conductor, the first and second steering conductors each being
15 disposed in the vicinity of the evaporation surface so that a magnetic field generated
thereby exerts a magnetic influence on the arc spot, the first steering conductor being
electrically independent of the second steering conductor, wherein by varying a level
of current applied through the first steering conductor relative to the second steering
conductor the arc spot shifts toward a long side of the cathode plate.
- 20 2. The apparatus of claim 1 in which the first and second steering conductors are
substantially linear.
3. The apparatus of claim 1 in which the first and second steering conductors are
oriented substantially parallel to the long sides of the cathode plate.
4. The apparatus of claim 1 in which steering conductors are provided only along
25 long sides of the cathode plate.
5. The apparatus of claim 1 in which the first and second steering conductors are
disposed behind the evaporation surface.
6. The apparatus of claim 1 in which varying a level of current applied through
the first steering conductor relative to the second steering conductor shifts the

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magnetic field generated by the first conductor toward a long side of the cathode plate.

7. The apparatus of claim 5 in which the magnetic field generated by the first and second steering conductors confines a flow of plasma from the cathode plate to the substrate holder.

8. A vacuum arc coating apparatus comprising a rectangular cathode plate having opposed long sides and opposed short sides and connected to a negative pole of an arc current source, the cathode plate having an evaporation surface, a coating chamber defined by the evaporation surface and a housing, containing a substrate holder, at least one anode within the coating chamber spaced from the evaporation surface, connected to a positive pole of a current source, an arc igniter for igniting an arc between the cathode and the anode and generating an arc spot on the target evaporation surface, and a magnetic steering system comprising at least first and second steering conductors respectively arranged behind the evaporation surface along the short sides of the cathode plate, the first steering conductor carrying a current in a direction opposite to a direction of current in the second steering conductor, the first and second steering conductors being electrically independent and being disposed in the vicinity of the evaporation surface so that a magnetic field generated thereby exerts a magnetic influence on the arc spot, wherein the magnetic fields generated by the steering conductors are oriented in the same direction in front of the evaporation surface such that a level of current through the first and second steering conductors is variable independently to thereby direct arc spots in a desired direction around the evaporation surface.

9. The arc coating apparatus of claim 8 in which the steering conductors are substantially linear.

10. The arc coating apparatus of claim 8 further comprising a magnetic focusing system comprising at least first and second substantially linear focusing conductors arranged in front of the evaporation surface along opposite long sides of the cathode plate, the focusing conductors carrying a current in opposite directions and being electrically independent of the steering conductors, wherein the magnetic fields

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generated by the focusing conductors direct plasma away from the evaporation surface.

11. The arc coating apparatus of claim 10 in which the focusing conductors are interconnected and form a single circuit with closing conductors arranged parallel to the short sides of the cathode plate.
12. The arc coating apparatus of claim 8 in which each steering conductor is a part of a coil having closing conductors oriented away from the cathode plate.
13. The arc coating apparatus of claim 10 in which the focusing conductors are electrically independent, whereby varying a level of current applied through the first focusing conductor relative to a current applied through the second focusing conductor shifts the plasma flow toward a long side of the cathode plate.
14. The arc coating apparatus of claim 13 in which each focusing conductor is a part of a coil having closing conductors oriented away from the cathode plate.
15. The arc coating apparatus of claim 12 in which a portion of the circuit closing conductors is oriented perpendicular to the cathode plate.
16. The arc coating apparatus of claim 14 in which a portion of the circuit closing conductors is oriented perpendicular to the cathode plate.
17. The arc coating apparatus of claim 8 in which steering conductors are provided only along the short sides of the cathode plate.
18. The arc coating apparatus of claim 10 in which focusing conductors are provided only along the long sides of the cathode plate.
19. The arc coating apparatus of claim 10 in which magnetic fields generated by the focusing conductors confine a flow of plasma from the cathode plate to the substrate holder.

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20. The arc coating apparatus of claim 12 in which the closing conductors are disposed remote from the evaporation surface so as not to exert any magnetic influence thereon.
21. The arc coating apparatus of claim 10 in which closing conductors for the
5 focusing conductors are disposed remote from the evaporation surface so as not to exert any magnetic influence thereon, and the evaporation surface is disposed within magnetic cusps generated by the focusing conductors.
22. The arc coating apparatus of claim 8 in which at least a portion of each
10 steering conductor is surrounded by a magnetic core to enhance a steering magnetic field on the evaporation surface in the vicinity of the magnetic core.
23. The arc coating apparatus of claim 22 in which the magnetic core is provided in the vicinity of a short side of the cathode plate.
24. The arc coating apparatus of claim 23 in which the magnetic core comprises at
15 least one additional independent magnetic coil to enhance the steering magnetic field on the evaporation surface in the vicinity of the magnetic core.
25. The arc coating apparatus of claim 22 in which one end of the magnetic core is disposed in front of evaporation surface.
26. The arc coating apparatus of claim 22 in which at least one end of the magnetic core is disposed behind the evaporation surface.
- 20 27. The arc coating apparatus of claim 8 comprising at least one electrically conductive shield maintained at a floating potential, disposed spaced from at least one shielded region of the evaporation surface, to prevent the arc spot from moving onto the shielded region of the evaporation surface.
- 25 28. The arc coating apparatus of claim 27 in which the shield prevents movement of the arc spot onto a zone of the evaporation surface where the magnetic field is substantially perpendicular to the evaporation surface.

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29. The arc coating apparatus of claim 8 in which the anode comprises an internal anode having a substantially planar anode body forming a plate oriented in a direction substantially tangential to a direction of a magnetic field surrounding the anode, and disposed above the evaporation surface in a zone where the magnetic field is
5 substantially perpendicular to the evaporation surface.
30. The arc coating apparatus of claim 29 in which the anode body is arranged parallel to the long sides of the cathode plate and oriented substantially perpendicular to the evaporation surface.
31. The arc coating apparatus of claim 29 in which the anode body is provided
10 with a plurality of baffles to increase an effective surface area of the anode.
32. The arc coating apparatus of claim 31 in which the baffles are disposed in a direction substantially tangential to a direction of a magnetic field surrounding the anode.
33. The arc coating apparatus of claim 32 in which the baffles are disposed in a
15 direction substantially orthogonal to the anode body.
34. The arc coating apparatus of claim 8 in which a surrounding anode surrounds the cathode plate.
35. The arc coating apparatus of claim 29 in which a surrounding anode surrounds the cathode plate.
- 20 36. The arc coating apparatus of claim 35 in which the internal anode and the surrounding anode are each connected to a positive pole of an independent current source.
- 25 37. The arc coating apparatus of claim 8 comprising a plurality of internal anodes each comprising a plate arranged parallel to long side of the cathode plate and connected to a positive pole of an independent current source, wherein each anode plate is disposed above the evaporation surface in a direction substantially tangential

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to a direction of a magnetic field surrounding the anode and in a one where the magnetic field is substantially perpendicular to the evaporation surface.

38. The arc coating apparatus of claim 37 in which at least one of the internal nodes is provided with a plurality of baffles to increase an effective surface area of the anode.

39. The arc coating apparatus of claim 38 in which the baffles are arranged parallel to short side of target, forming a path for plasma flowing toward the substrate holder.

40. The arc coating apparatus of claim 39 in which internal anodes disposed in the vicinity of the short side of the cathode plate comprise solid water-cooled blocks.

41. The arc coating apparatus of claim 27 in which the shield is disposed between the evaporation surface and an internal anode.

42. The arc coating apparatus of claim 41 comprising a surrounding anode at substantially a right angle to the evaporation surface, connected to independent power supply.

43. The arc coating apparatus of claim 8 comprising a plurality of focusing conductors.

44. The arc coating apparatus of claim 43 wherein magnetic fields generated by adjacent focusing conductors are oriented in the same direction and overlap.

45. The arc coating apparatus of claim 44 in which the one or more focusing conductors are disposed in progressively increasing asymmetrical relation to a working axis of the cathode plate.

46. The arc coating apparatus of claim 21 wherein the closing conductors are arranged behind the evaporation surface.

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47. The arc coating apparatus of claim 45 wherein the focusing conductors each comprise a closing conductor arranged substantially parallel to the evaporation surface on a side of the cathode plate opposite to the respective focusing conductor.
48. The arc coating apparatus of claim 21 wherein the substrate holder is disposed
5 off of an optical axis of a cathode chamber containing the cathode and in communication therewith through a plasma duct, and wherein the focusing conductors are disposed adjacent to an intersection of the cathode chamber and the plasma duct.
49. The arc coating apparatus of claim 48 comprising a pair of opposed cathode
10 chambers each containing a cathode plate and in communication with a common plasma duct.
50. The arc coating apparatus of claim 21 wherein the closing conductors are arranged asymmetrically relative to their respective focusing conductors.
51. The arc coating apparatus of claim 8 wherein the steering system further comprises third and fourth steering conductors respectively arranged behind the
15 evaporation surface along the long sides of the cathode plate, the third steering conductor carrying a current in a direction opposite to a direction of current in the fourth steering conductor, the third and fourth steering conductors being disposed in the vicinity of the evaporation surface so that a magnetic field generated hereby exerts a magnetic influence on the arc spot.
- 20 52. The arc coating apparatus of claim 51, wherein the third and fourth steering conductors are electrically independent, whereby varying a level of current applied to the third steering conductor relative to fourth steering conductor the magnetic field generated by the third steering conductor shifts toward a long side of the cathode plate.
- 25 53. The arc coating apparatus of claim 21 comprising a pair of cathode plates disposed in opposition at one end of a parallelepipedal plasma duct, an anode spaced from the evaporation surface of each cathode plate, the substrate holder being disposed at another end of the plasma duct off of an optical axis of each cathode plate,

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wherein plasma evaporated from the evaporation surfaces is deflected from the optical axis of the cathode plates into the plasma duct.

54. The arc coating apparatus of claim 53 comprising a dividing anode disposed substantially along an axis of the plasma duct.

5 55. The arc coating apparatus of claim 54 comprising deflecting conductors disposed about a portion of the plasma duct adjacent to a portion of the housing containing the cathode plates, for deflecting plasma toward the substrate holder.

56. The arc coating apparatus of claim 54 comprising one or more external anodes surrounding the substrate holder.

10 57. A method of steering an arc spot around a rectangular cathode plate having long sides and short sides and a front evaporation surface, comprising the steps of a. generating a magnetic field in front of the evaporation surface in a first direction along a first long side of the cathode plate and generating a magnetic field in front of the evaporation surface in a second direction opposite the first direction along
15 a second long side of the cathode plate, and b. generating a magnetic field behind the evaporation surface in a third direction along a first short side of the cathode plate and generating a magnetic field behind the evaporation surface in a fourth direction opposite the third direction along a second short side of the cathode plate, wherein the magnetic fields extend in front of the evaporation surface to steer
20 the arc spot along an erosion zone around the evaporation surface.

58. The method of claim 57 including the step of modulating one or more of the magnetic fields.

59. The method of claim 58 including the step of modulating one or both of the magnetic fields generated along the long sides of the evaporation surface.

25 60. The method of claim 57 including the step of modulating one or more magnetic fields generated by closing conductors associated with steering conductors generating the magnetic fields along the long sides of the evaporation surface.

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61. The method of claim 57 comprising the step of generating a chain of focusing magnetic fields in front of the evaporation surface, to confine a flow of plasma along a path created by the chain of focusing magnetic fields.

62. The method of claim 61 comprising the step of modulating one or more of the
5 focusing magnetic fields.

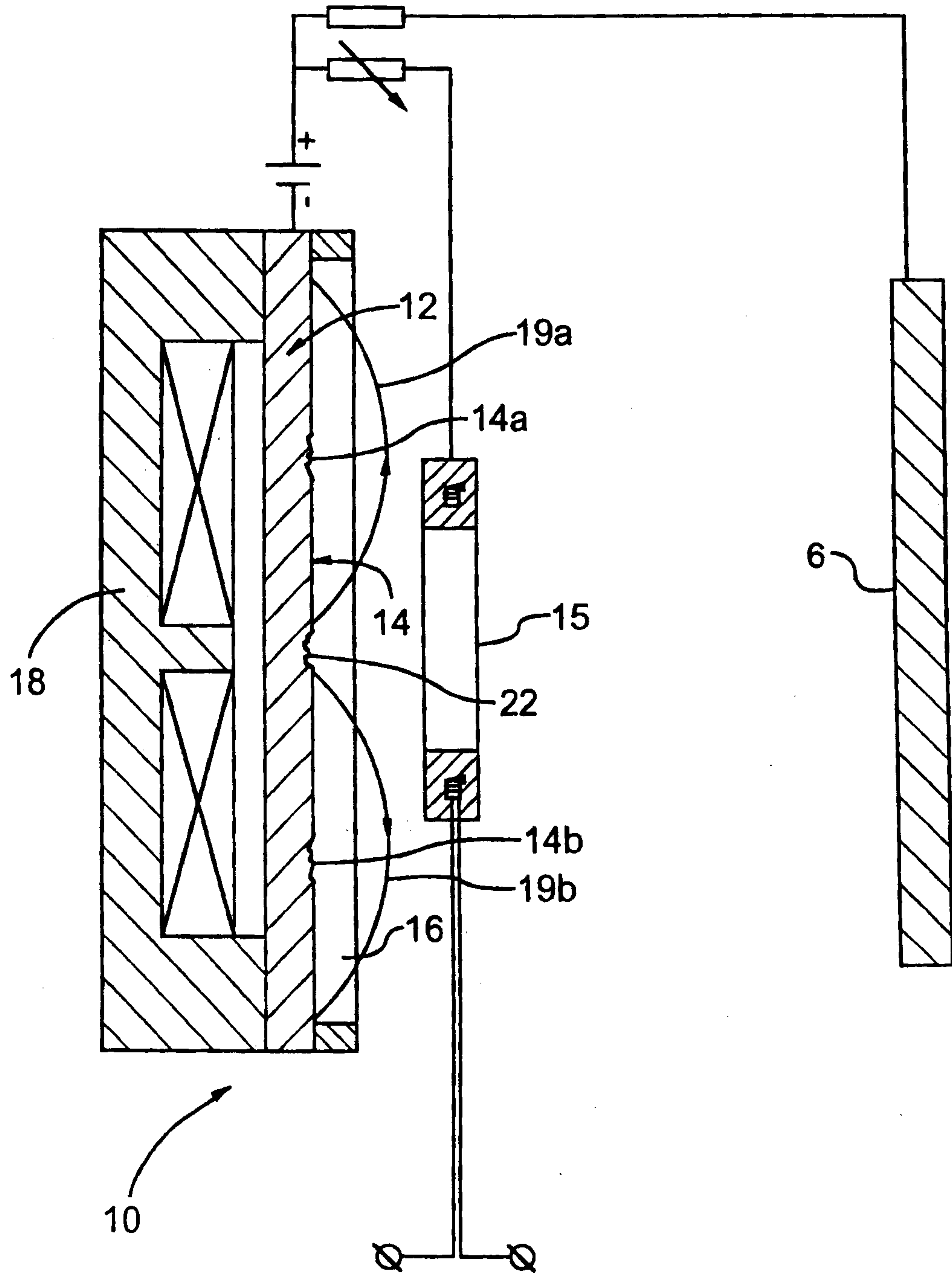


FIG. 1
PRIOR ART

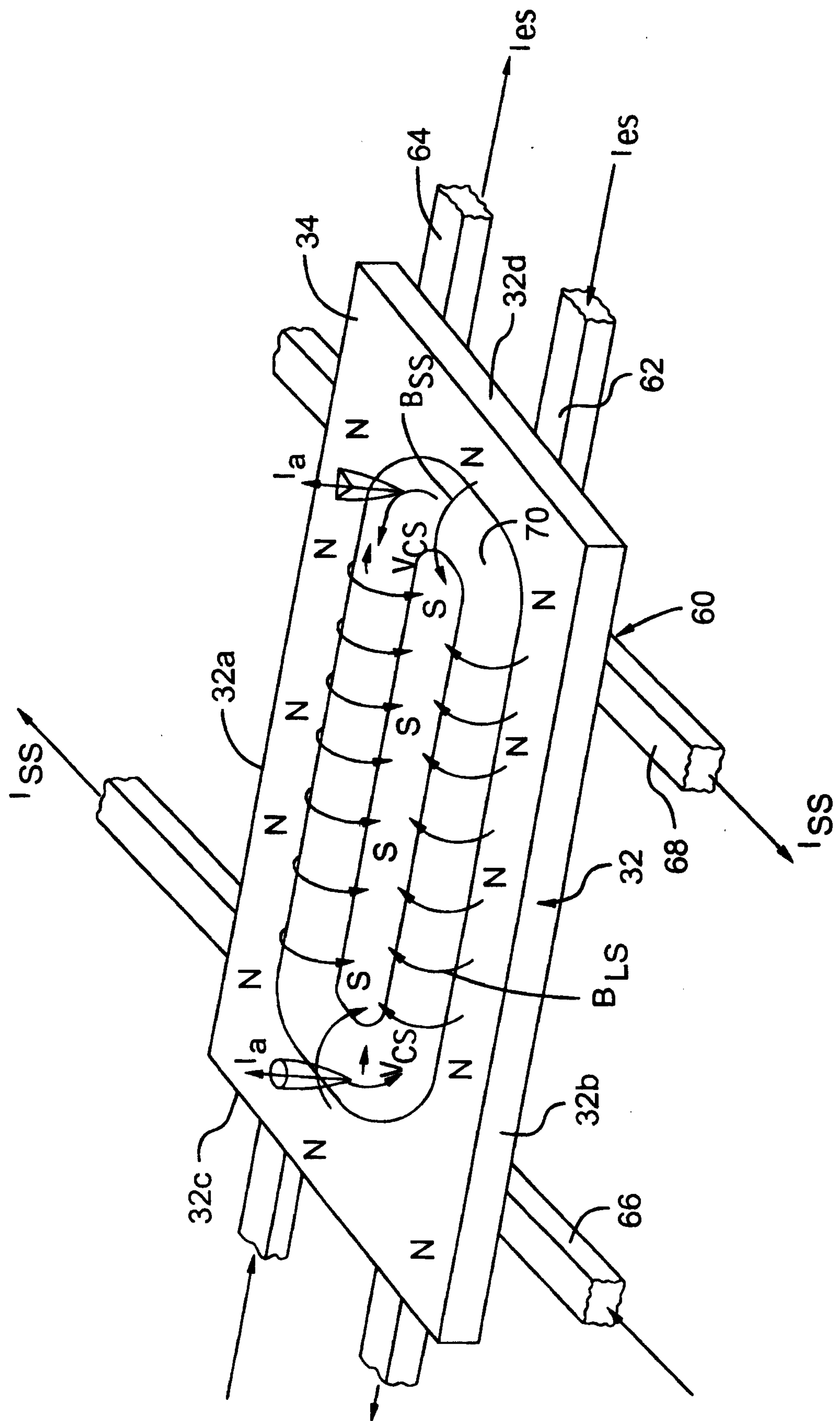


FIG. 2

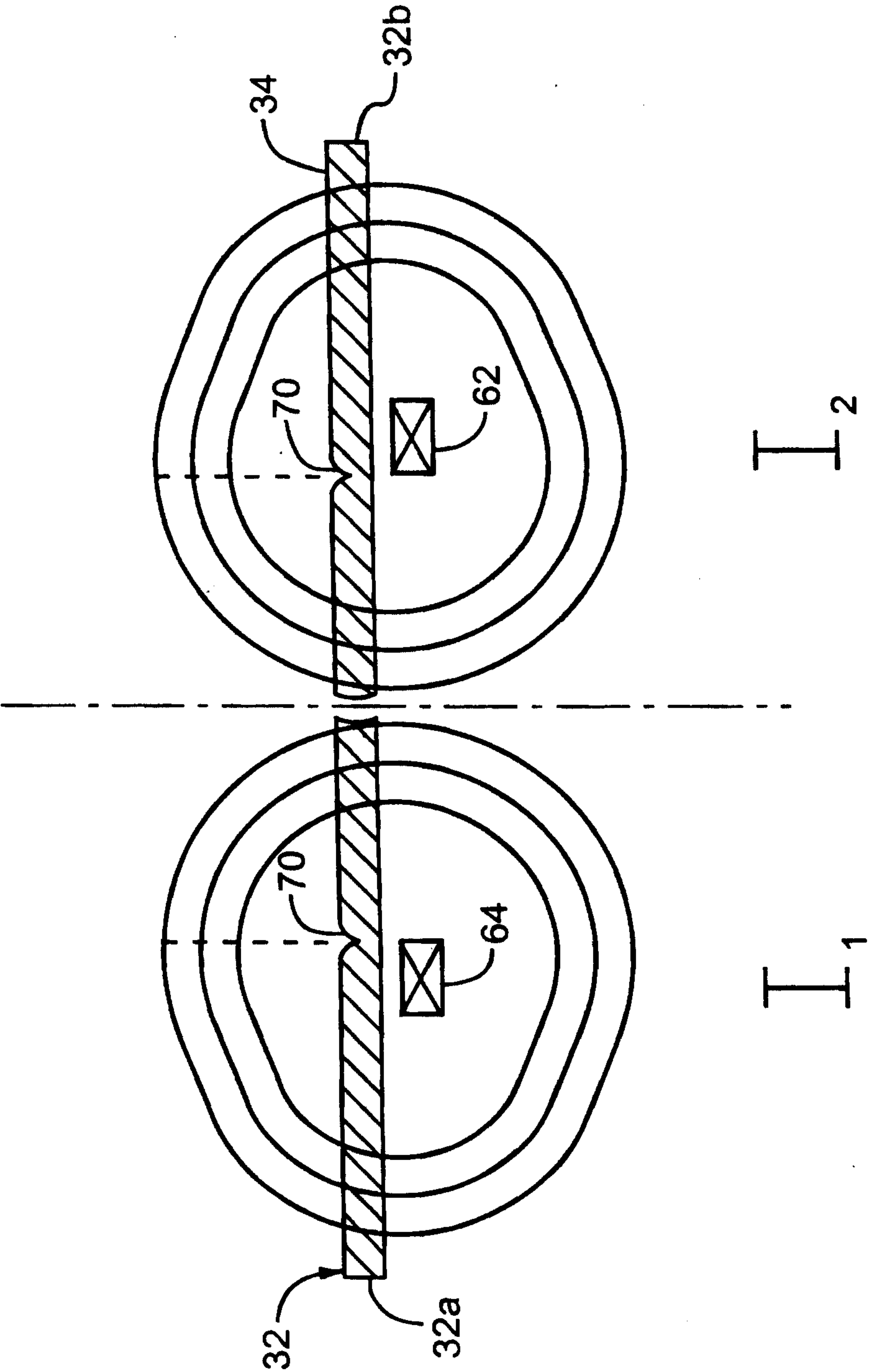


FIG. 2a

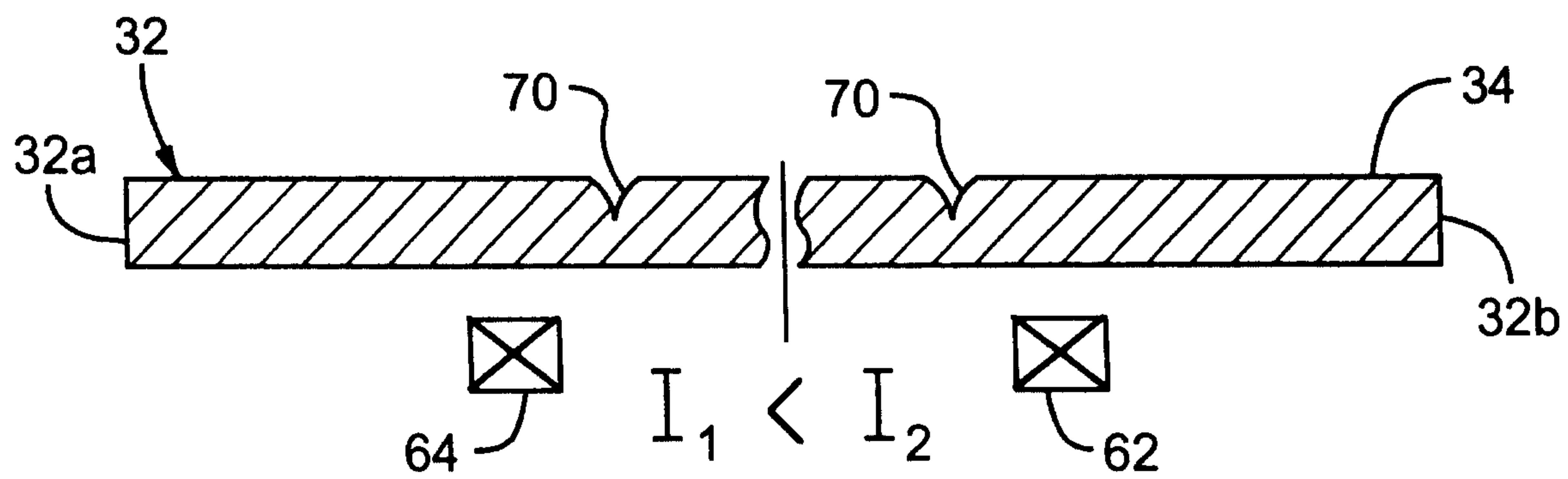


FIG. 2b

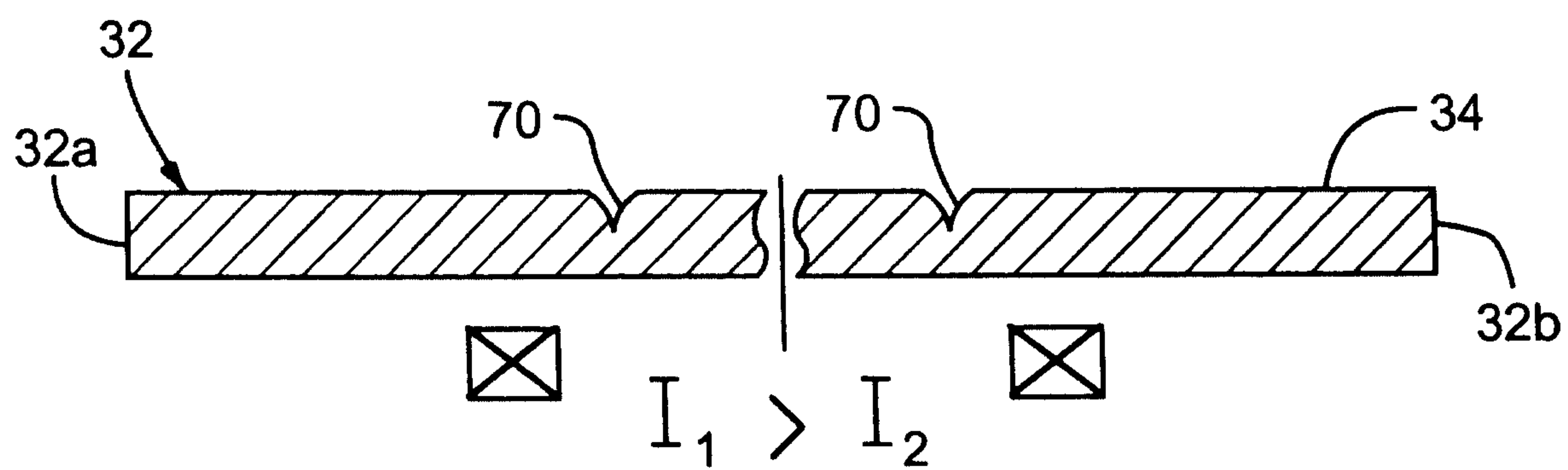


FIG. 2c

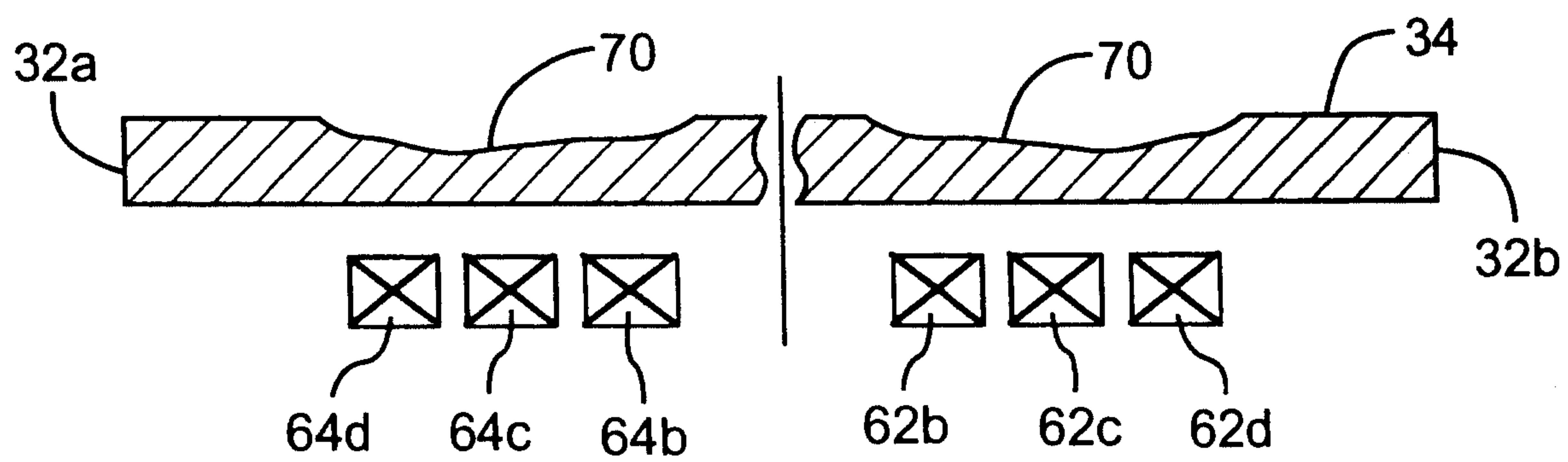


FIG. 3

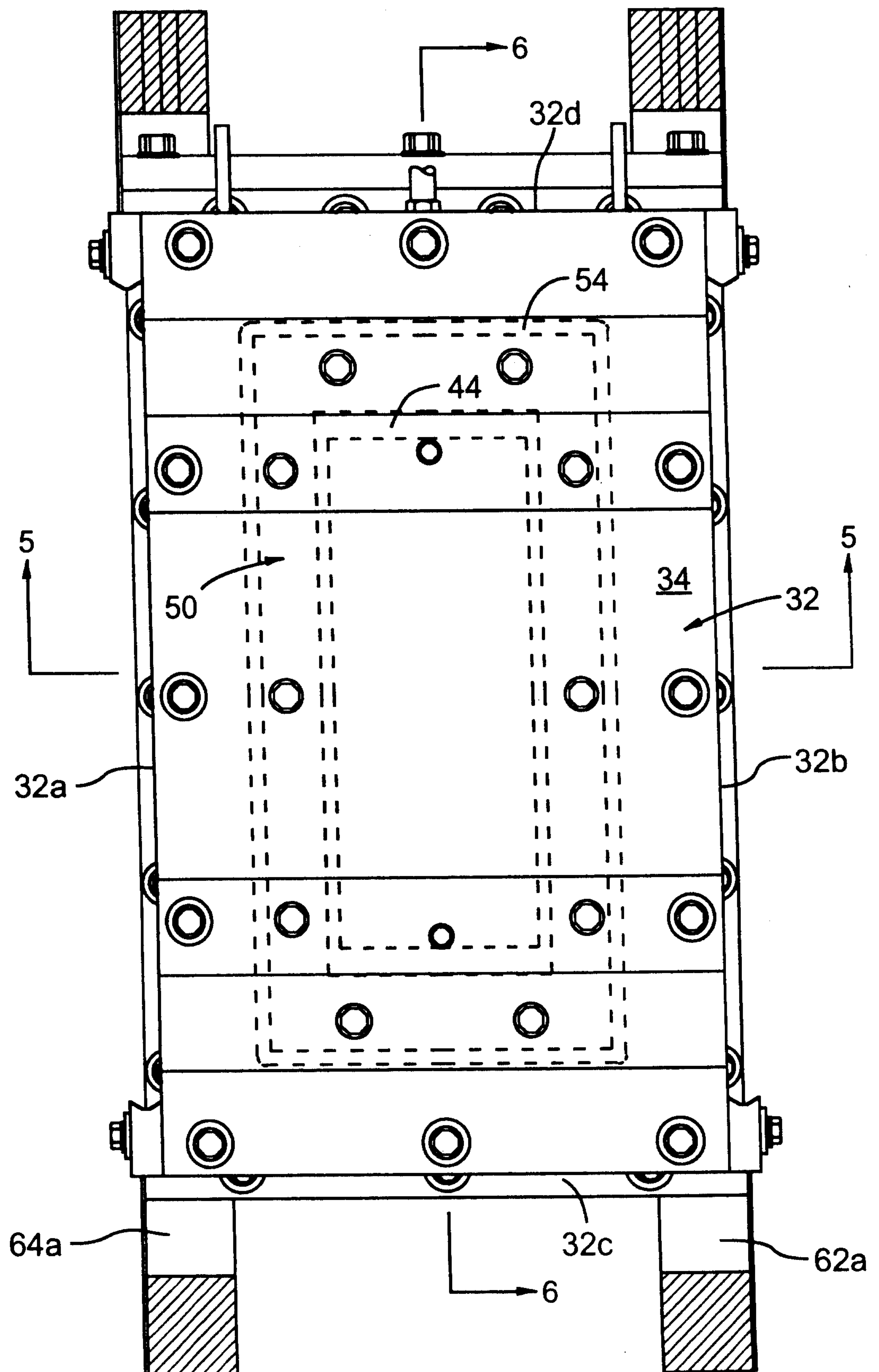


FIG.4

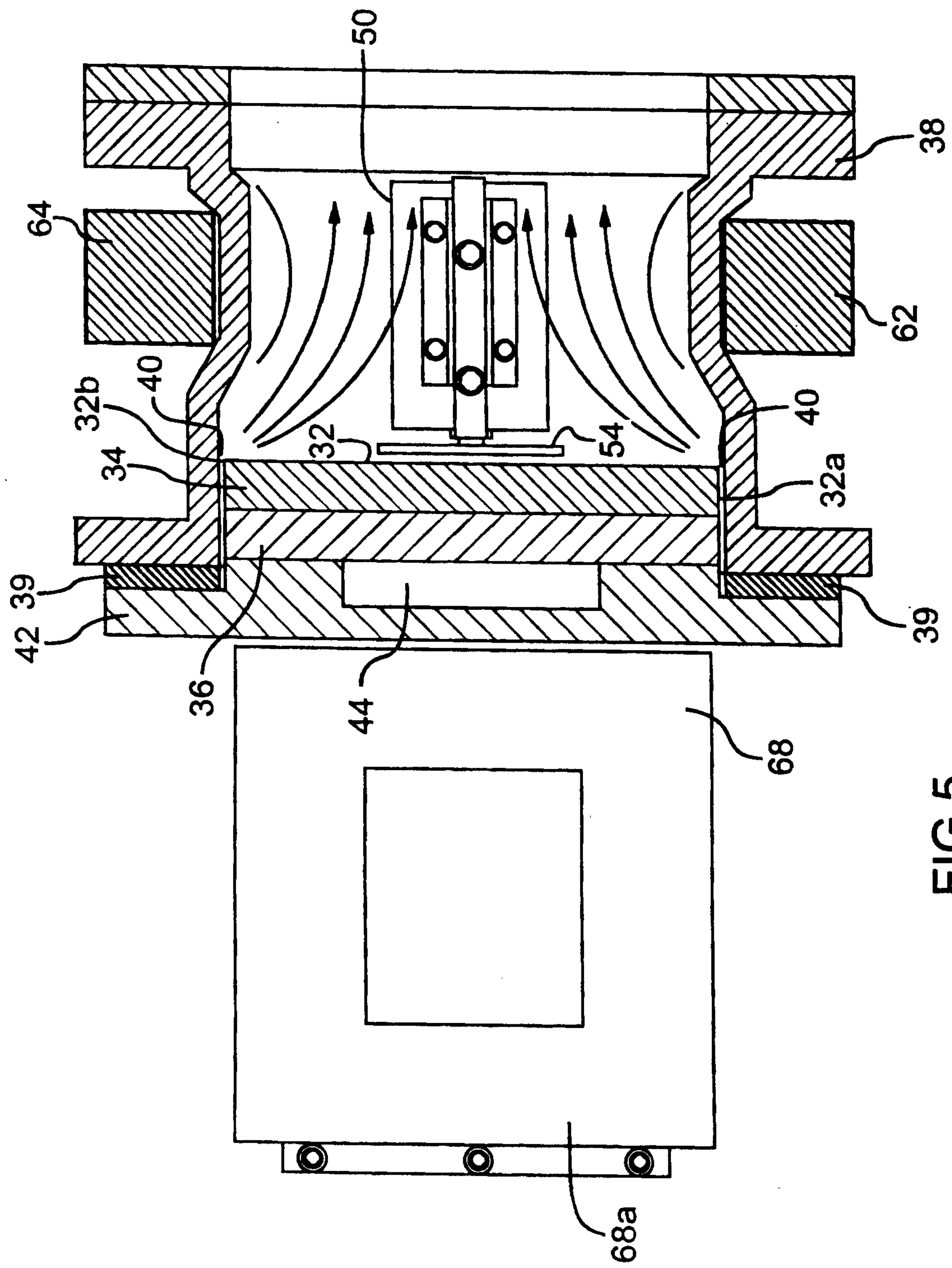
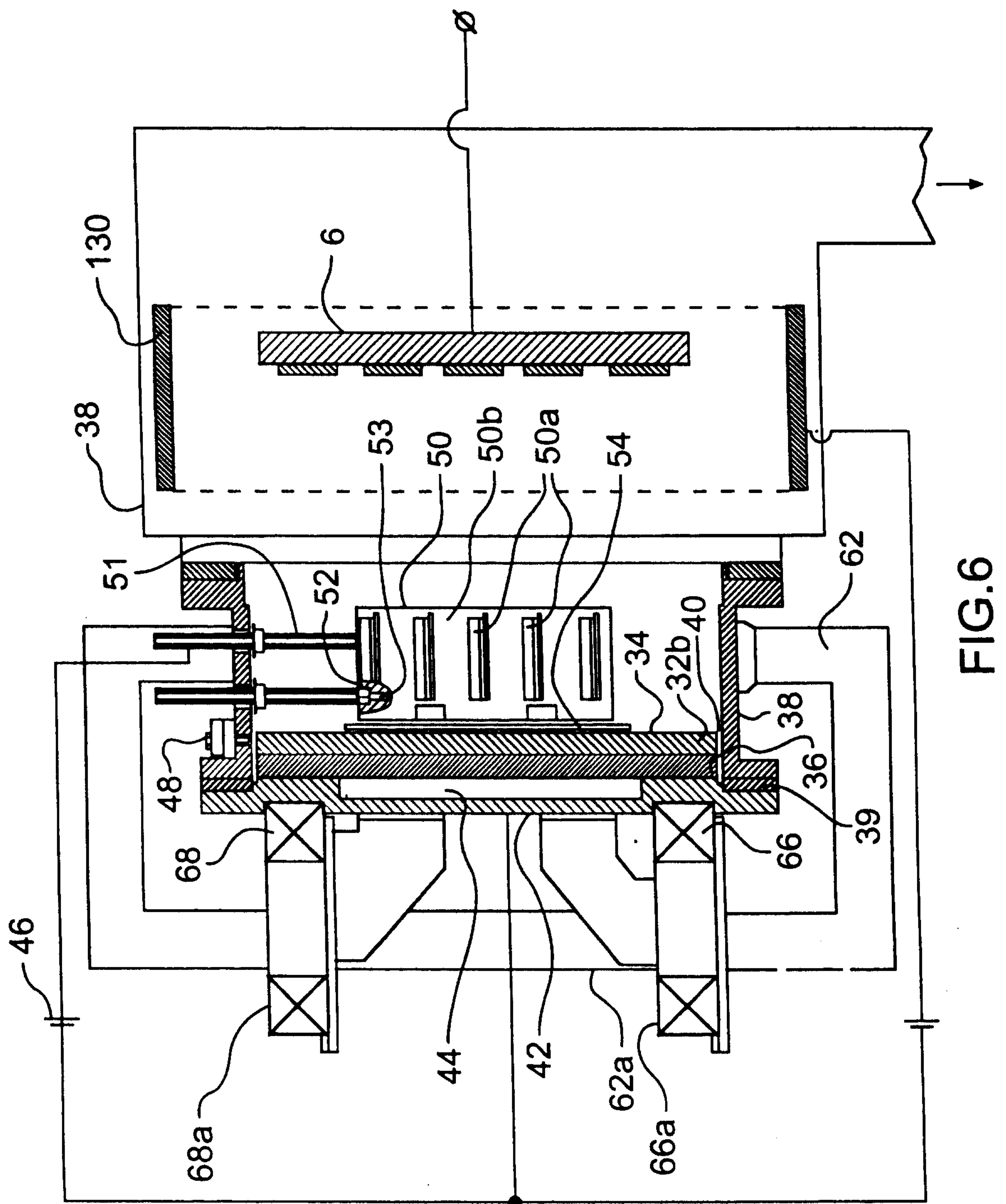


FIG.5



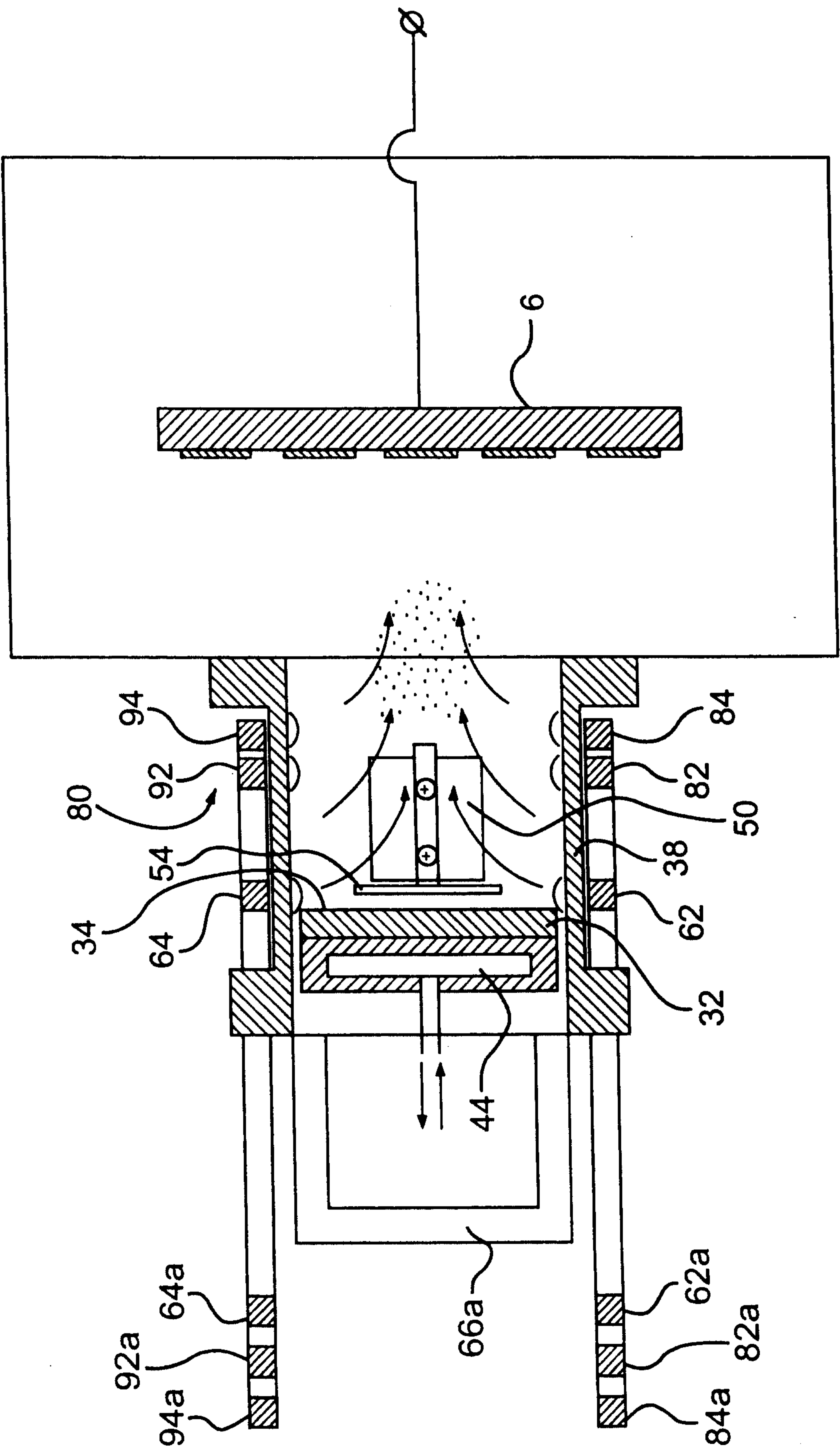


FIG.7a

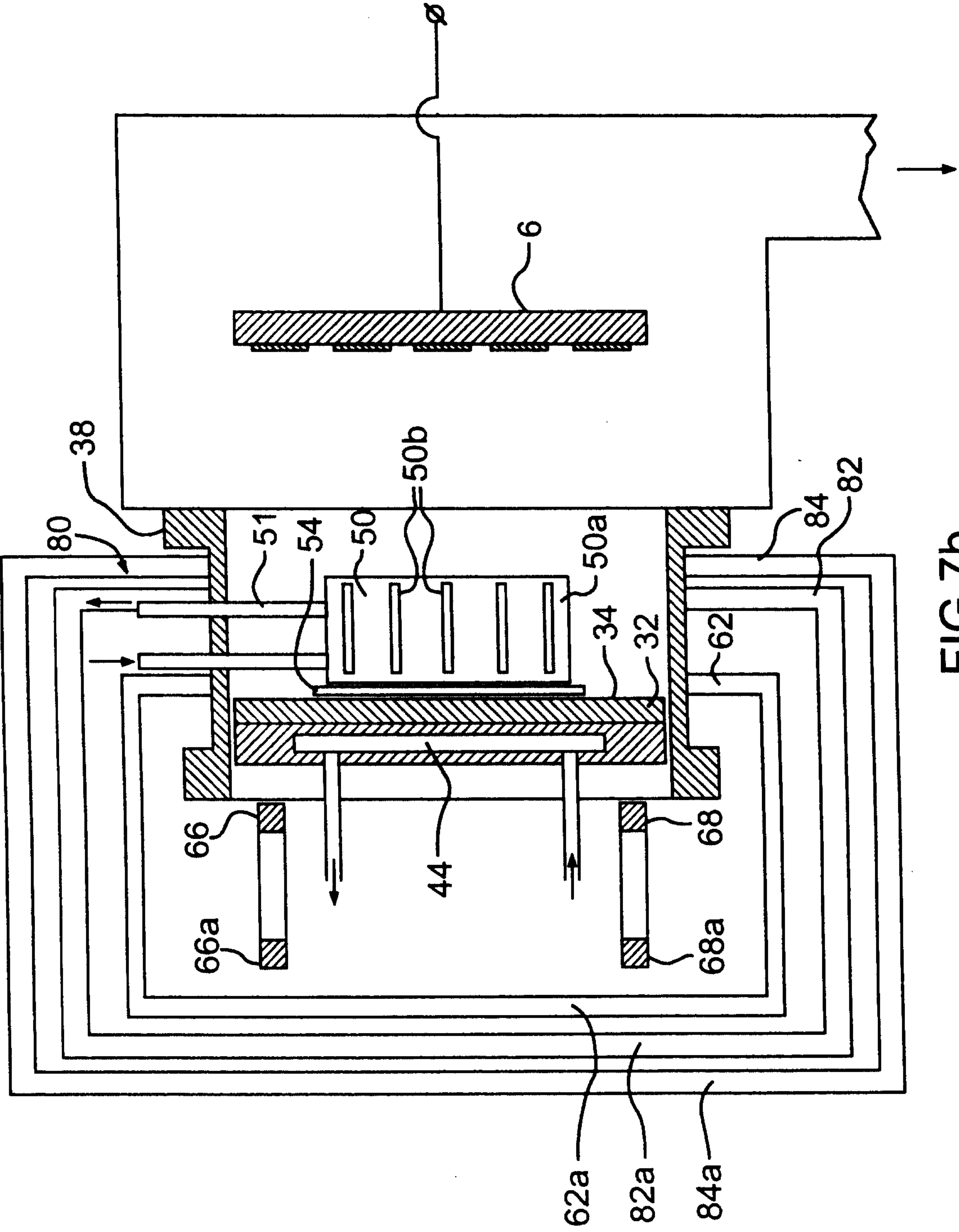
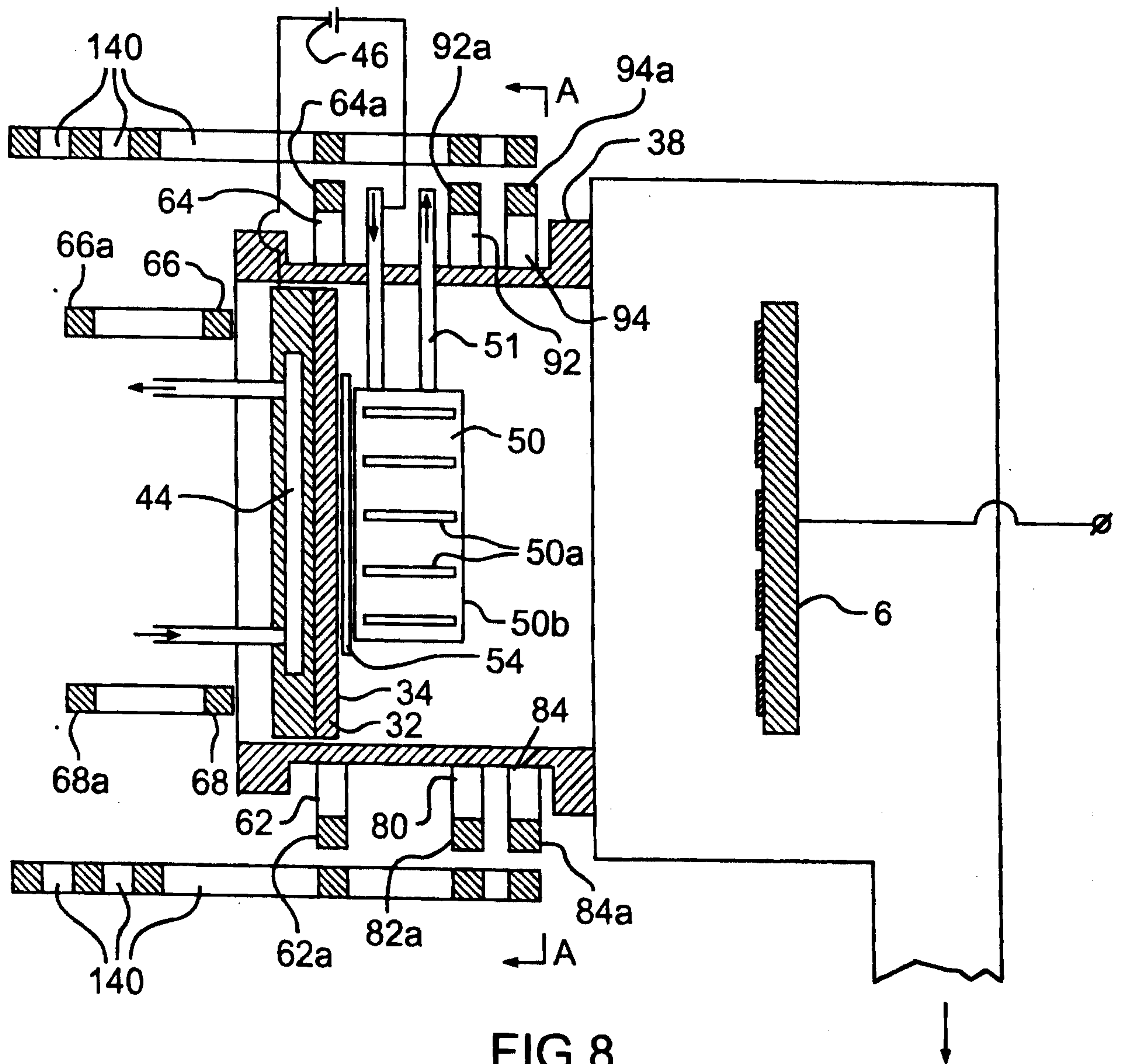


FIG.7b



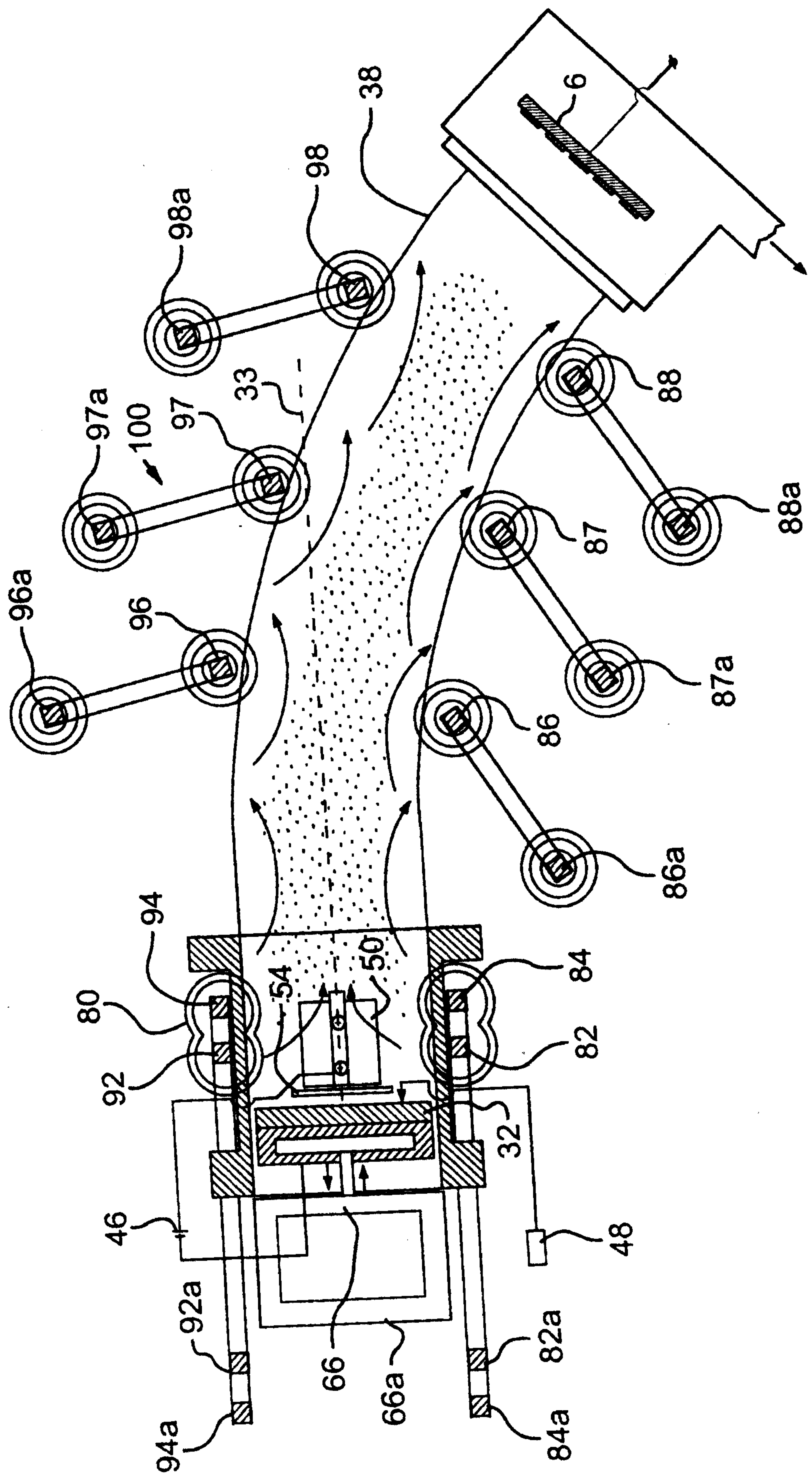


FIG. 9

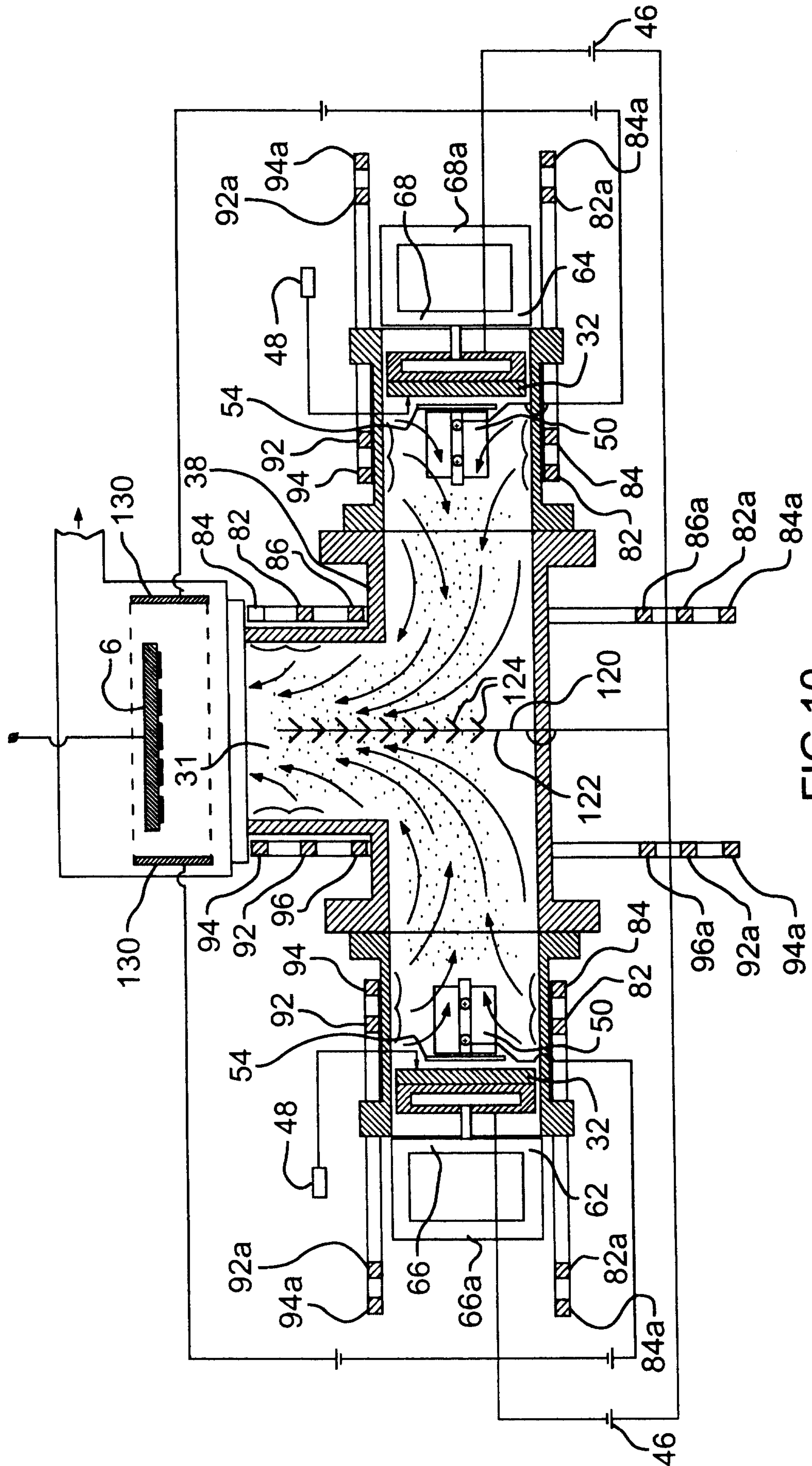


FIG. 10

