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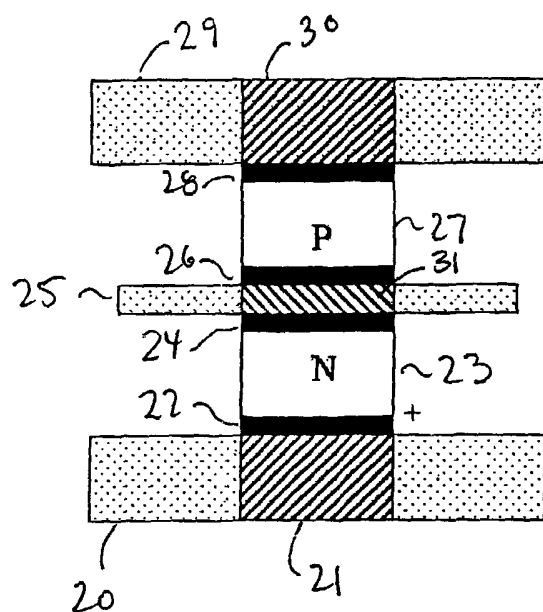
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(54) Title: THERMOELECTRIC DEVICE UTILIZING DOUBLE-SIDED Peltier JUNCTIONS AND METHOD OF MAKING THE DEVICE



(57) Abstract: A thermoelectric device and method of manufacturing the device, where thermoelectric elements (23, 27) of opposite conductivity type are located on respective opposing sides of a heat source member (25). Heat sinks (20, 29) are disposed on opposite sides of the thermoelectric elements (23, 27). Peltier metal contacts are positioned between the thermoelectric elements and each of the heat source member and heat sinks. A plurality of devices may be arranged together in a thermally parallel, electrically series arrangement, or in a thermally parallel, electrically parallel arrangement. The arrangement of the elements allow the direction of current flow through the pairs of elements to be substantially the same as the direction of current flow through the metal contacts.

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**TITLE OF THE INVENTION**

THERMOELECTRIC DEVICE UTILIZING DOUBLE-SIDED PELTIER  
JUNCTIONS AND METHOD OF MAKING THE DEVICE

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**BACKGROUND OF THE INVENTION****Field of the Invention**

The present invention relates to a thermoelectric device having a plurality of thermoelements arranged to improve the efficiency and the manufacturability of the thermoelectric device as compared to conventional thermoelectric device arrangements.

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**Discussion of the Background**

In U.S. Patent No. 6,300,150, the entire contents of which is incorporated herein by reference, a thermoelectric device and method for manufacturing the same are disclosed, where a plurality of thermoelements (p, n) are disposed on the same side of a header, as shown in FIG. 6 of this patent. The surface of the interconnecting members is parallel to the header surface. A cross-section of this device is shown in FIG. 1.

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The device includes a plurality of thermoelements that are disposed on the same side of a cooling header. A p thermoelement 13 is connected on one side by metalization 12 to an electrical lead 11 on a first heat sink 10. The Peltier junction metalization (e.g. Cr/Au, Ni/Au, Cr/Au/Ni/Au), is electrically conductive. On the other side p thermoelement 13 is connected to a heat source (i.e., a header) 17 by Peltier junction metalization 16. Element 14 is an ohmic metallization such as Cr/Au

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and element 15 is a diffusion barrier like Ni. An n thermoelement 19 is connected on one side by Peltier junction metalization 20 to electrical lead 21 on heat sink 10. On the other side n thermoelement 19 is connected to heat source 17 by Peltier junction metalization 16. Element 18 is an ohmic metallization like element 14. The voltage polarities (+,-) are shown for cooling.

There is one heat sink 10 common for both of the p and n thermoelements 13 and 19, and one heat-source (i.e., a header) 17 common to the thermoelements. The n and p elements are intermingled on the same side of header 17 during module fabrication, which can complicate the manufacturing process.

## SUMMARY OF THE INVENTION

One object of the present invention is to provide an improved thermoelectric device.

Another object of the present invention is to simplify the manufacture of thermoelectric device.

These and other objects are achieved by a thermoelectric device having a heat source member, a first thermoelectric element of one conductivity type connected to one side of the heat source member, and a second thermoelectric element of a conductivity type opposite to the one conductivity type connected to a side of the heat source member opposite to the one side.

A first heat sink may be attached to the first thermoelectric element, and a second heat sink may be attached to the second thermoelectric element.

Contacts may be made to the first and second thermoelectric devices. The first and second thermoelectric elements may be arranged so that a direction of current

flow through the first and second thermoelectric elements is substantially the same as a direction of current flow through the contacts.

The first and second thermoelectric elements may each be a bulk element, a thin film element, or a superlattice element.

5           The objects of the invention may also be achieved by a thermoelectric device having a first thermoelectric element of a first conductivity type, a second thermoelectric element of a conductivity type opposite to the first conductivity type, and a heat source member disposed between the first and second thermoelectric elements.

10           Contacts may be formed to the first and second thermoelectric devices, and the first and second thermoelectric elements and the contacts may be arranged so that a direction of current flow through the first and second thermoelectric elements is substantially the same as a direction of current flow through the contacts.

          A first heat sink may be attached to the first thermoelectric element, and a  
15           second heat sink may be attached to the second thermoelectric device.

          The first and second thermoelectric elements may each be a bulk element, thin film element, or a superlattice element.

          The objects of the invention may also be achieved by a thermoelectric device having a heat source member, a plurality of first thermoelectric elements of only one  
20           conductivity type connected to one side of the heat source member, and a plurality of second thermoelectric element of a conductivity type opposite to the one conductivity type connected to a side of the heat source member opposite to the one side.

          A first heat sink may be attached to each of the plurality of first thermoelectric elements, and a second heat sink may be attached to each of the plurality of second  
25           thermoelectric elements.

The first and second thermoelectric elements and the contacts may be arranged so that a direction of current flow through respective pairs of the first and second thermoelectric elements is substantially the same as a direction of current flow through the contacts.

5           The first and second thermoelectric elements may each be a bulk element, a thin film element, or a superlattice element.

The objects of the invention may further be achieved by a method of operating a thermoelectric device having the step of arranging first and second thermoelectric elements on opposite sides of a heat source member such that only elements of one  
10           conductivity type are on each one of the sides. Contacts may be arranged between each of the elements and the member such that a current may be caused to flow through respective pairs of the first and second thermoelectric elements in a direction substantially the same as a direction of current flow through the contacts.

## 15                           **BRIEF DESCRIPTION OF THE DRAWINGS**

A more complete appreciation of the invention and many of the attendant advantages thereof will be readily obtained as the same becomes better understood by reference to the following detailed description when considered in connection with the accompanying drawings, wherein:

20           FIG. 1 is a schematic diagram illustrating a conventional thermoelectric device;

FIG. 2 is a schematic diagram illustrating a thermoelectric device according to the present invention;

FIG. 3 is a schematic diagram illustrating heat flow in the thermoelectric  
25           device according to the present invention;

FIG. 4 is a schematic diagram of a thermally parallel, electrically series thermoelectric module according to the present invention;

FIG. 5 is a schematic diagram of a thermally parallel, electrically series thermoelectric module according to the present invention;

5        FIG. 6 is a schematic diagram of a thermally parallel, electrically parallel thermoelectric module according to the present invention;

FIG. 7 is a schematic diagram illustrating dimensions of the thermoelectric device according to the present invention;

10        FIG. 8 is a schematic diagram of a superlattice thermoelectric device according to the invention according to the present invention;

FIG. 9 is a cross-sectional diagram illustrating the manufacture of a thermoelectric module according to the present invention;

FIG. 10 is a cross-sectional diagram illustrating the manufacture of a thermoelectric module according to the present invention;

15        FIG. 11 is a cross-sectional diagram illustrating the manufacture of a thermoelectric module according to the present invention;

FIG. 12 is a cross-sectional diagram illustrating the manufacture of a thermoelectric module according to the present invention; and

20        FIG. 13 is a cross-sectional diagram illustrating the manufacture of a thermoelectric module according to the present invention.

## DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring now to the drawings, wherein like reference numerals designate identical, or corresponding parts throughout the several views, and more particularly to Figure 2 thereof, Figure 2 is a first embodiment of the device according to the

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present invention. FIG. 2 illustrates a schematic diagram of The device where the voltage polarities (+,-) are shown for cooling. It is noted that the drawing is not to scale, but is drawn to illustrate the features of the device. Dimensions of the elements are discussed below, but the present invention is not limited to those specific dimensiona. The device includes a plurality of thermoelements disposed on opposite sides of a cooling header. A p thermoelement 27 is connected on one side by Peltier junction metalization 28 to an electrical lead 30 on a first heat sink 29. The Peltier junction metalization is electrically conductive. On the other side, p thermoelement 27 is connected to a contact 31 on heat source (header) 25 by Peltier junction metalization 26. An n thermoelement 23 is connected on one side by Peltier junction metalization 22 to electrical lead 21 on heat sink 20. The other side of n thermoelement 23 is connected to contact 31 on heat source 25 by Peltier junction metalization 24.

N and p thermoelements are thin films of thickness in the range of microns to tens of microns, grown or deposited or transferred on a substrate using techniques such as metallorganic chemical vapor deposition (MOCVD), chemical vapor deposition (CVD), molecular beam epitaxy (MBE) and other epitaxial/non-epitaxial processes. The thin films can consist of thin-film superlattice or non-superlattice thermoelectric materials, quantum-well (two-dimensional quantum-confined) and quantum-dot (three dimensional quantum-confined type) structured materials, and non-quantum-confined materials. Also, materials that are peeled from bulk materials can also be used.

The advantage of having p and n thermoelements 13 and 19 on opposite sides of the header 17 is that it simplifies the arrangement of all p elements on one side of

the heat source header and correspondingly the n elements on the opposite side of the heat source header.

The energy from heat source 25 is interfaced/communicated to the Peltier junction. This can be achieved by flow of air or other high-thermal transfer-coefficient liquids such as for example water or fluorocarbon fluids. This is shown in FIG. 3. Heat is absorbed (shown schematically by arrows 32) in parallel from, for example, the heat source fluids at the Peltier junction formed by metalizations 24 and 26. The heat deposited in parallel on headers 20 and 29 is removed (shown schematically by arrows 33 and 34, respectively). In this arrangement of FIG. 3, the current flows from metal 28, through p thermoelement 27, through the Peltier junctions, through n thermoelement 23 to metal 22. The p thermoelement 27 may be made of a p type material such as a  $\text{Bi}_2\text{Te}_3/\text{Sb}_2\text{Te}_3$  superlattice or Si/Ge superlattice and the n thermoelement 23 may be made of an n type material such as a  $\text{Bi}_2\text{Te}_3/\text{Bi}_2\text{Te}_{3-x}\text{Se}_x$  superlattice or a Si/Ge superlattice. Other suitable superlattices of thermoelectric materials having alternating lattice constants between the individual superlattice layers could be used, according to the present invention.

The arrangement according to the invention avoids the problem of intermingling n and p elements on the same side of the header as discussed in US Pat. No. 6,300,150. This avoidance can lead to substantial advantages in assembly of p and n thermoelements, to produce a p-n couple and in turn a full-scale module. This can also lead to more convenient use of large-scale wafers as well. For example, the deposition of a similar type thermoelectric material, the patterning of the deposited thermoelectric materials, and subsequent metallization can occur on the same thermoelectric device wafer. The device wafer, if of a suitable thermal conductivity,



could compose the header itself. Otherwise, the deposited device layers could be removed from the device wafer and bonded on the header.

The thermoelements may be arranged in a number of configurations to form modules. One example is shown in FIG. 4 where a thermally parallel, electrically series double-sided Peltier junction module is illustrated. Three thermoelectric devices 40, 41 and 42, with elements of the same conductivity type formed on the same side of the header, are connected to heat source 44 and heat sinks (headers) 43 and 45. The movement of heat is schematically shown by the arrows. The (+,-) arrangement is shown for cooling.

Another example of a thermally parallel, electrically series double-sided Peltier junction module is illustrated in FIG. 5. The module includes thermoelectric devices 50, 51 and 52 connected to heat source (header) 54 and heat sinks (headers) 53 and 55. Heat transfer is shown by the arrows. Note the orientation of the n and p elements of the devices, relative to the headers, is alternated. Thus this “intermingled” configuration the n-element of device 50 is connected to is an extension of the conventional p, n on same side of header with the double side Peltier junction concept proposed in figure 4 p-element of device 51 by interconnect 56, and the n-element of device 51 is connected to the p-element of device 52 by interconnect 57. Here, the electrical leads 56 and 57 provide the electrical interconnection between adjacent devices. Note that these electrical leads or interconnects can be routed through compact coaxial electrical jigs at headers 53 and 55, if desired. The electrical routing is simpler than in the module of FIG. 4. Further, in some cases, these electrical leads can be used as “radiators” of heat as long as the electrical leads are on the heat-sink side. See for example U.S. Patent Application No. 10/169,721, the entire contents of which are incorporated herein by reference.

One potential advantage of this thermally parallel, electrically series thermoelectric module as shown in FIG. 5 compared to the single-side Peltier junction, thermally parallel, electrically series thermoelectric module, described in US Pat. No. 6,300,150, is that the interconnect resistance at the Peltier junction can be significantly reduced. The reduction of interconnect resistance comes from the fact that, in this present invention, the current flowing through Peltier metalization is along the direction of current flow through the thermoelement. This can be understood from the fact that it is easier to reduce resistance in a vertical direction compared to a lateral direction.

A thermally parallel, electrically parallel, double-sided Peltier junction module is shown in FIG. 6. Devices 60, 61 and 62 are connected to heat sinks (headers) 63 and 65 and heat source (header) 64. The heat flow is shown by the arrows. Each of the p-elements of devices 60-62 is connected to interconnect 66 and each of the n-elements of devices 60-62 is connected to interconnect 67. This arrangement could be useful especially for low- T (low cooling temperature requirements or low heating temperature requirement from ambient) systems as the current requirements are lower. Lower current requirements can be met with parallel configuration of devices, as here however, the electrical routing is also significantly simpler compared to the device of FIG. 4.

Preferably, the p- and n-thermoelements are made of bulk or thin film materials. The devices can be of any dimension to suit the application. FIG. 7 illustrates in general the dimensions of a thermoelement. In FIG. 7, a p-thermoelement 70 is connected between contacts 71 and 72. For thin film devices,  $l$  is in the range of approximately  $1.0\ \mu\text{m}$  to  $1000\ \mu\text{m}$ ,  $w$  is in the range of approximately  $10\ \mu\text{m}$  to  $1000\ \mu\text{m}$ , and  $h$  is in the range of approximately  $1.0\ \mu\text{m}$  to

1000  $\mu\text{m}$ . For bulk device,  $l$ ,  $h$  and  $w$  are each typically 1 mm. The elemental dimensions for an n-thermoelement are expected to be similar to those for a p-thermoelement, depending on the figure-of-merit ( $ZT$ ), thermal conductivity ( $K$ ) and other parameters such as Seebeck coefficient ( $\alpha$ ) and electrical conductivity ( $\sigma$ ) of the n and p elements as described in Venkatasubramanian et al., Nature, vol. 413, pp. 597-602 (Oct 11, 2001), the entire contents of which are incorporated herein by reference. Note circular cross sections and other cross-sections of thermoelements can also be used although rectangular cross-sections as shown here.

Note the dimensions  $l$  and  $w$  of the thermoelements in Fig. 4-6, the depth of the heat-source plate, and corresponding dimensions of the heat-sink plate can be designed to optimize the heat transfer coefficients. For example, the height of Peltier metalizations 71 and 72, as shown in FIG. 7, can be made different from the height of the heat-source plate, for better heat transfer (e.g. height of element 71  $\cong$  heights of elements 28 and 30 combined, and the height of element 72  $\cong$  heights of elements 22 and 31 combined). For example, larger heights of the heat source plate can lead to easier fluid flow (though channels having a height of the Peltier metal in the heat source plate) while a smaller height of the Peltier metalization can lead to lower electrical resistance of Peltier metalization.

Another example of the n- and p-thermoelements according to the invention is shown in FIG. 8. N-thermoelement 83 is a superlattice thermoelement (schematically shown by the parallel lines) is connected to electrical lead 81 of heat sink (header) 80 by Peltier metalization 82 and to electrical lead 91 of heat source (header) 85 by Peltier metalization 84. P-thermoelement 87 is a superlattice thermoelement connected to electrical lead 90 of heat sink (header) 89 by Peltier metalization 88 and

to electrical lead 91 of heat source (header) 85 by Peltier metalization 86. Note that in the superlattice n- and p-thermoelements, the current flow is perpendicular or approximately perpendicular through the superlattice interfaces. The current continues in the same direction through the Peltier junction metalization, while going  
5 from the p-thermoelement to the n-thermoelement. Superlattice thermoelements may be used in any arrangement, such as in FIGS. 4-6

The device according to the invention is able to lower the Peltier junction metalization resistance, and can achieve effective heat transfer between the working (heat-transfer) fluids and the Peltier junction metalization without significant losses.  
10 Effectively, the radiative and convective heat losses can be reduced with the double-sided Peltier junction structure. The p and n thermoelements can also be quantum-confined structures or quantum-dot superlattice materials. These materials may also be arranged in numerous configurations such as shown in FIGS. 4-6. The thermoelectric device according to the invention may be used with thermal  
15 spreaders/plates such as AlN, Al<sub>2</sub>O<sub>3</sub>, diamond, BeO, or other materials with good thermal conductivity. This device according to the invention can also be combined with cascading or multi-stage thermoelectric cooler concepts. See for example U.S. Patent No. 6,505,468, the entire contents of which are incorporated herein by reference.

20 Besides cooling, these devices may be applied for power conversion as well. In FIGS. 1-8, heat will be absorbed in the heat-source plate, which is hotter than the heat-sink plate, and deposited at the heat-sink plate, thereby producing an external current. This is in contrast to the arrangement where an external power source providing a current source to the cooler or heater when the thermoelectric device is  
25 operated in that mode.

These devices may be manufactured as shown in FIGS. 9-13. The manufacturing techniques described in U.S. Patent No. 6,300,150 may be applied and/or adapted for use in manufacturing the devices according to the invention. In FIG. 9, a cross-sectional view of a substrate 100 having thermoelectric elements 101-103 with corresponding Peltier metalizations 104-106 is shown. The thermoelements may be n- or p-type, and may be bulk, thin film or superlattice type elements. The thermoelements are formed using the techniques described typically as a layer on substrate 100. A layer of Peltier metalization may then be formed on the layer. The individual elements 101-103 are formed using standard patterning techniques, such as photolithography and etching to desired dimensions. The elements may be formed in any pattern, such as a matrix.

A heat sink (cooling header) 107 having a pattern of connections including connections 108, 109 and 110 is attached to the elements through the Peltier metalizations 104-106. The connections 108-110 and metalizations 104-106 form electrical contacts having as low as possible resistance. The connections on header 107 form a pattern to provide connections to and/or interconnect the thermoelements as desired. The substrate is then removed, as shown in FIG. 11, and a second Peltier metalization, forming metalizations 111, 112 and 113, is formed on the side of thermoelements from which the substrate 100 was removed. Alternatively, at least some of the thermoelements may be directly deposited on the header 107. In a preferred embodiment of the present invention, a substrate on which a thermoelectric material is deposited or which is being etched is maintained at a lower temperature than a precursor (e.g. a metal-organic) cracking temperature by deposition in an apparatus which includes a susceptor with separators, made of an optically transmissive material with low thermal conductivity, such as quartz, upon which the

substrates are mounted. The susceptor is heated to a precursor cracking temperature while the substrates are maintained at a lower deposition temperature by the separators. The substrates are heated by black body radiation transmitted through the separators to the substrates. By methods such as those disclosed in the above-noted  
5 U.S. Pat. No. 6,071,351, the thermoelectric material can be deposited on a header. The header, according to the present invention, can include a semiconductor wafer itself, and by these low temperature techniques can be a processed semiconductor wafer containing integrated or power switching devices.

A heat source (header) 114 having connections 115, 116 and 117 is then  
10 attached through the metalizations 111-113 to the thermoelements as shown in FIG. 12. The connections in the header 114 are arranged in a desired pattern to connect the thermoelements 101-103 to thermoelements that are to be arranged on the other side of header 114.

Another set of thermoelements, having an opposite conductivity type to  
15 thermoelements 101-13 are prepared in the same manner as described above in FIGS. 9-11. As shown in FIG. 13, a second set of thermoelements 121, 122 and 123 are attached to contacts 128, 129 and 130 of a heat sink (header) 127 through Peltier metalization 124, 125 and 126. The thermoelements 121-123 are attached to connections 115-117 of header 114 through Peltier metalizations 118, 119 and 120.  
20 Alternatively, at least some of the thermoelements and the Peltier metallization may be directly deposited on the header 127. Different patterns of connections in the headers can produce a series or parallel electrical connection of the thermoelements.

Additionally, the present invention can utilize for the thermoelectric devices a transthermistor employing a unipolar p-p or n-n couple with two electrical terminals  
25 and three temperature terminals to achieve a very large temperature differential across

each end of a unipolar couple, as described in the above-noted U.S. Provisional Application No. 60/428,753. For example, a p-p transthermistor unipolar couple can be used in conjunction with an n-n transthermistor unipolar couple for ease of integration into a modular device although a complete module can be constructed with a set of p-p or n-n unipolar transthermistor couples. The advantages of this unipolar transthermistor device include the use of only one type of polarity elements like p-type or n-type thermoelements, whichever has higher ZT. Current is driven in opposite directions through the pairs of unipolar elements to establish a temperature differential across each of the unipolar element pairs. For example, in the present invention, modules can be constructed using only p-type  $\text{Bi}_2\text{Te}_3/\text{Sb}_2\text{Te}_3$  superlattice thermoelements with a ZT of  $\sim 2.5$  at 300K, rather than combining with n-type  $\text{Bi}_2\text{Te}_3$ -based superlattice thermoelements with a ZT of  $\sim 1.2$  to  $1.9$  at 300K to form a conventional p-n couple. Alternatively, the present invention can use only n-type  $\text{PbTeSe}/\text{PbTe}$  quantum-dot superlattice thermoelements with a ZT of  $\sim 1.6$  at 300K, rather than combining with p-type  $\text{PbTe}$ -based superlattice thermoelements with a much lower ZT at 300K. In this approach, the thermoelement 27 depicted in Figure 2 is constructed to be a n-type thermoelement, and current can be driven in opposite directions through thermoelements 27 and 23 to ensure cooling to the heat source 25.

Numerous applications are available for the double-sided Peltier junction devices of the present invention. These applications include not only cooling applications near room temperature (e.g., replacement of compression-based cooling engines in refrigerators and air conditioning units and other cooling devices, replacement or augmentation of forced air cooling in semiconductor IC and power device thermal management, and replacement or augmentation of liquid phase change cooling, etc.) but extends to cryogenic cooling applications as well. For example, one

application of the present invention is in the cooling superconducting coils found in electric motors and generators. In this case, thermoelectric devices of the present invention are placed in thermal contact with the superconducting coils. Thermal contact to the superconducting coils accomplished similar to those techniques disclosed in U.S. Pat. No. 6,505,468. Large power industrial motors and generators can benefit significantly from the use of superconducting coils. The application of superconducting coils to industrial motors and generators would reduce substantially the rotor ohmic losses (i.e.,  $I^2R$ ). The reduction in  $I^2R$  loss would more than compensate for the extra power required for refrigeration of the superconducting coils.

While some high-temperature superconductors are superconducting at liquid nitrogen temperatures of 77 K, in the presence of magnetic fields (such as in electric motors or generators), the current carrying ability of these liquid nitrogen superconductors is deteriorated. Thus, more expensive liquid helium (at temperatures of 4.2 K) is utilized to keep the superconducting coils at 30 to 50 K, where in the presence of a magnetic field the current carrying capability is not deteriorated.

More specifically, the double-sided Peltier junction devices of the present invention could be utilized to in thermal contact with the backside of an integrated circuit chip or a power switching device as a cooling or power header. The backside, especially if it is electrically conducting, needs to be suitably modified to confine the electrical current to the thermoelectric element. One example of suitable preparation is p-n junction isolation in the backside of the chip whereby the current is made to flow through the intended thermoelectric electric elements, i.e. is confined to the elements, and is not shunted by the conducting backside of the chip. Other modifications of the backside are possible to achieve similar confinement of the current. The backside then may be used to extract heat which could be used for other



purposes such as power generation. For example, the power generated using the heat could be used provide power to other circuits or to other cooling devices.

Alternatively, the backside or the frontside of the integrated circuit chip or a semiconductor power switching device could be thermally connected to the double-  
5 sided Peltier junction devices of the present invention.

Numerous modifications and variations of the present invention are possible in light of the above teachings. It is therefore to be understood that within the scope of the appended claims, the invention may be practiced otherwise than as specifically described herein.

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**CLAIMS:**

1. A thermoelectric device, comprising:
  - a heat source member;
  - a first thermoelectric element of one conductivity type connected to one side of
  - 5 said heat source member; and
  - a second thermoelectric element of a conductivity type opposite to said one conductivity type connected to a side of said heat source member opposite to said one side.
2. The device of Claim 1, further comprising:
  - 10 a first heat sink attached to said first thermoelectric element; and
  - a second heat sink attached to said second thermoelectric element.
3. The device of Claim 1, further comprising:
  - a first metal contact formed on said first thermoelectric element and connected
  - between said first thermoelectric element and said heat source member; and
  - 15 a second metal contact formed on said second thermoelectric element and connected between said second thermoelectric element and said heat source member.
4. The device of Claim 3, further comprising:
  - a third contact formed in said heat source member and connected to said first and second metal contacts.
- 20 5. The device of Claim 3, wherein each of said first and second metal contacts comprises a Peltier metal contact.
6. The device of Claim 3, further comprising:
  - a first heat sink attached to said first thermoelectric element;
  - a second heat sink attached to said second thermoelectric device;

a third metal contact formed on said first thermoelectric element and connected between said first thermoelectric element and said first heat sink; and

a fourth metal contact formed on said second thermoelectric element and connected between said second thermoelectric element and said second heat sink.

5           7. The device of Claim 3, wherein said first and second thermoelectric elements and said first and second metal contacts are arranged so that a direction of current flow through said first and second thermoelectric elements is substantially the same as a direction of current flow through said first and second metal contacts.

8. The device of Claim 1, wherein at least one of said first and second  
10 thermoelectric elements comprises one of a bulk element, a thin film element, and a superlattice element.

9. The device of Claim 8, wherein said superlattice element comprises at least one of a  $\text{Bi}_2\text{Te}_3/\text{Sb}_2\text{Te}_3$  superlattice and a Si/Ge superlattice.

10. The device of Claim 8, wherein said superlattice element comprises layers  
15 of differing thermoelectric materials arranged parallel to the heat source member and having a ZT greater than 1.

11. The device of Claim 1, wherein at least one of said first and second thermoelectric elements comprises one of a quantum-well material and a quantum-dot structured material.

20           12. The device of Claim 1, wherein said heat source member is thermally connected to a heat exchanger in at least one of a refrigerating unit and an air conditioning unit.

13. The device of Claim 1, wherein said heat source member is thermally connected to a superconducting element.

14. The device of Claim 1, wherein said heat source member is thermally connected to at least one of an integrated circuit and a semiconductor power switching device.

15. A thermoelectric device; comprising:

5 a first thermoelectric element of a first conductivity type;

a second thermoelectric element of a conductivity type opposite to said first conductivity type; and

a heat source member disposed between said first and second thermoelectric elements.

10 16. The device of Claim 15, further comprising:

a first metal contact formed on said first thermoelectric element contacting said first thermoelectric element and said heat source member; and

a second metal contact formed on said second thermoelectric element contacting said second thermoelectric element and said heat source member.

15 17. The device of Claim 16, further comprising:

a third contact formed in said heat source member and connected to said first and second metal contacts.

18. The device of Claim 16, wherein said first and second metal contacts each comprises a Peltier metal contact.

20 19. The device of Claim 16, further comprising:

a first heat sink attached to said first thermoelectric element;

a second heat sink attached to said second thermoelectric element;

a third metal contact formed on said first thermoelectric element and connected between said first thermoelectric element and said first heat sink; and

a fourth metal contact formed on said second thermoelectric element and connected between said second thermoelectric element and said second heat sink.

20. The device of Claim 16, further comprising:

5 said first and second thermoelectric elements and said first and second metal contacts arranged so that a direction of current flow through said first and second thermoelectric elements is substantially the same as a direction of current flow through said first and second metal contacts.

21. The device of Claim 15, comprising:

a first heat sink attached to said first thermoelectric element; and  
10 a second heat sink attached to said second thermoelectric device.

22. The device of Claim 15, wherein said first and second thermoelectric elements each comprises one of a bulk element, a thin film element, and a superlattice element.

23. The device of Claim 15, wherein at least one of said first and second  
15 thermoelectric elements comprises one of a bulk element, a thin film element, and a superlattice element.

24. The device of Claim 23, wherein said superlattice element comprises at least one of a  $\text{Bi}_2\text{Te}_3/\text{Sb}_2\text{Te}_3$  superlattice and a Si/Ge superlattice.

25. The device of Claim 23, wherein said superlattice element comprises  
20 layers of differing thermoelectric materials arranged parallel to the heat source member and having a ZT greater than 1.

26. The device of Claim 15, wherein at least one of said first and second thermoelectric elements comprises one of a quantum-well material and a quantum-dot structured material.

27. The device of Claim 15, wherein said heat source member is thermally connected to a heat exchanger in at least one of a refrigerating unit and an air conditioning unit.

28. The device of Claim 15, wherein said heat source member is thermally  
5 connected to a superconducting element.

29. The device of Claim 15, wherein said heat source member is thermally connected to at least one of an integrated circuit and a semiconductor power switching device.

30. A thermoelectric device, comprising:  
10 a heat source member;  
a plurality of first thermoelectric elements of only one conductivity type connected to one side of said heat source member; and  
a plurality of second thermoelectric element of only a conductivity type opposite to said one conductivity type connected to a side of said heat source member  
15 opposite to said one side.

31. The device of Claim 30, further comprising:  
a first heat sink attached to each of said plurality of first thermoelectric elements; and  
a second heat sink attached to each of said plurality of second thermoelectric  
20 elements.

32. The device of Claim 30, further comprising:  
a first metal contact formed on each of said plurality of first thermoelectric elements and connected between each of said plurality of first thermoelectric elements and said heat source member; and

a second metal contact formed on each of said plurality of second thermoelectric elements and connected between each of said plurality of second thermoelectric elements and said heat source member.

33. The device of Claim 32, further comprising:

5 a plurality of third contacts formed in said heat source member and respectively connected to said first and second metal contacts.

34. The device of Claim 32, wherein said first and second metal contacts each comprises a Peltier metal contact.

35. The device of Claim 32, further comprising:

10 a first heat sink attached to each of said plurality of first thermoelectric elements;

a second heat sink attached to each of said plurality of second thermoelectric elements;

a third metal contact formed on each of said plurality of first thermoelectric elements and connected between each of said plurality of first thermoelectric elements and said first heat sink; and

15

a fourth metal contact formed on each of said plurality of second thermoelectric elements and connected between each of said plurality of second thermoelectric elements and said second heat sink.

20 36. The device of Claim 32, further comprising:

said first and second thermoelectric elements and said first and second metal contacts arranged so that a direction of current flow through respective pairs of said first and second thermoelectric elements is substantially the same as a direction of current flow through said first and second metal contacts.

37. The device of Claim 30, wherein said first and second thermoelectric elements each comprises one of a bulk element, thin film element and superlattice element.

38. The device of Claim 30, wherein said plurality of first and second thermoelectric devices is interconnected in a thermally parallel, electrically series arrangement.

39. The device of Claim 30, wherein said plurality of first and second thermoelectric devices is interconnected in a thermally parallel, electrically parallel arrangement.

40. The device of Claim 30, wherein at least one of said first and second thermoelectric elements comprises one of a bulk element, a thin film element, and a superlattice element.

41. The device of Claim 40, wherein said superlattice element comprises at least one of a  $\text{Bi}_2\text{Te}_3/\text{Sb}_2\text{Te}_3$  superlattice and a Si/Ge superlattice.

42. The device of Claim 40, wherein said superlattice element comprises layers of differing thermoelectric materials arranged parallel to the heat source member and having a ZT greater than 1.

43. The device of Claim 30, wherein at least one of said first and second thermoelectric elements comprises one of a quantum-well material and a quantum-dot structured material.

44. The device of Claim 30, wherein said heat source member is thermally connected to a heat exchanger in at least one of a refrigerating unit and an air conditioning unit.

45. The device of Claim 30, wherein said heat source member is thermally connected to a superconducting element.



46. The device of Claim 30, wherein said heat source member is thermally connected to at least one of an integrated circuit and a semiconductor power switching device.

47. A thermoelectric device, comprising:

5 a heat source member;

a first thermoelectric element of a given conductivity type connected to one side of said heat source member;

a second thermoelectric element of a same conductivity type connected to a side of said heat source member opposite to said one side; and

10 said first and second thermoelectric elements having an opposite current flow to each other to thereby establish a temperature differential across each of said thermoelectric elements.

48. A method of operating a thermoelectric device having first and second thermoelectric elements on opposite sides of a heat source member such that only  
15 elements of one conductivity type are on each one of said side and metal contacts between each of said elements and said member, said method comprising:

causing current to flow through respective pairs of said first and second thermoelectric elements in a direction substantially the same as a direction of current flow through said metal contacts.

20 49. A method of producing a thermoelectric device having a heat source member, a first thermoelectric element of a first conductivity type connected to one side of said heat source member; a second thermoelectric element of a second conductivity type connected to a side of said heat source member opposite to said one side, said method comprising:

depositing a first thermoelectric material as at least a part of said first thermoelectric element in a first deposition system in which a susceptor is maintained at a lower temperature than a precursor cracking temperature; and

depositing a second thermoelectric material as at least a part of said second thermoelectric element in a second deposition system in which a susceptor is maintained at a lower temperature than a precursor cracking temperature.

50. A thermoelectric device having a heat source member, a first thermoelectric element of a first conductivity type connected to one side of said heat source member; a second thermoelectric element of a second conductivity type connected to a side of said heat source member opposite to said one side, said device made by a process comprising:

depositing a first thermoelectric material as at least a part of said first thermoelectric element in a first deposition system in which a susceptor is maintained at a lower temperature than a precursor cracking temperature; and

depositing a second thermoelectric material as at least a part of said second thermoelectric element in a second deposition system in which a susceptor is maintained at a lower temperature than a precursor cracking temperature.

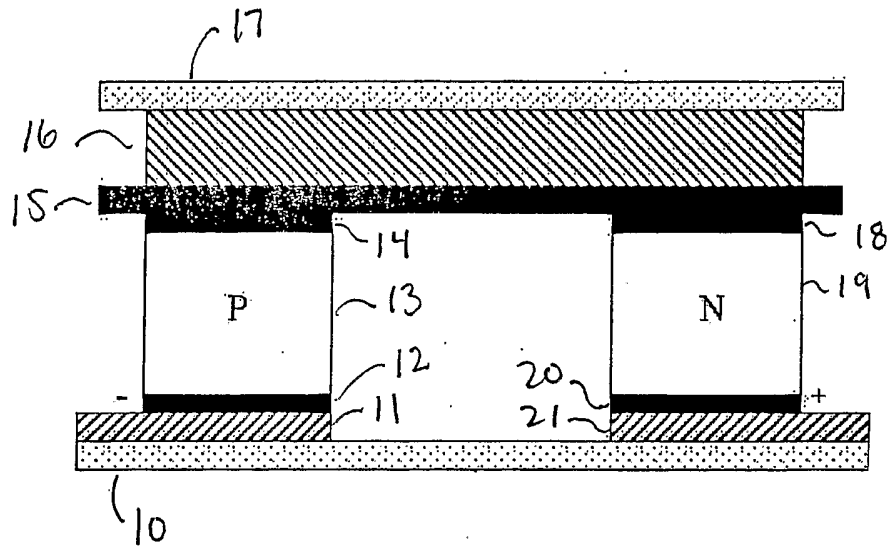


FIG. 1

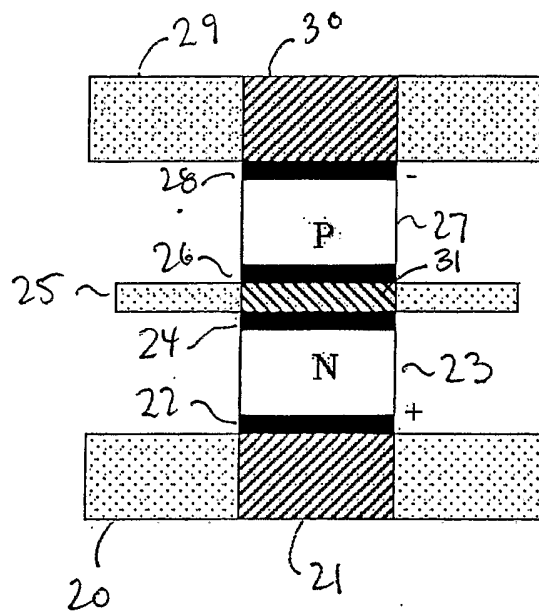


FIG. 2

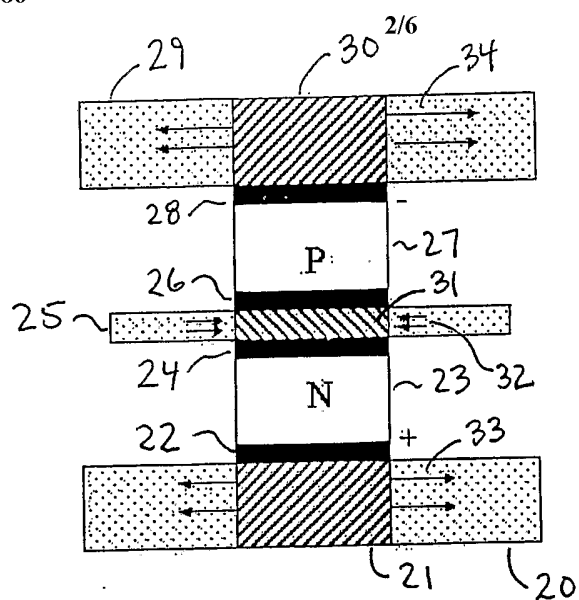


FIG. 3

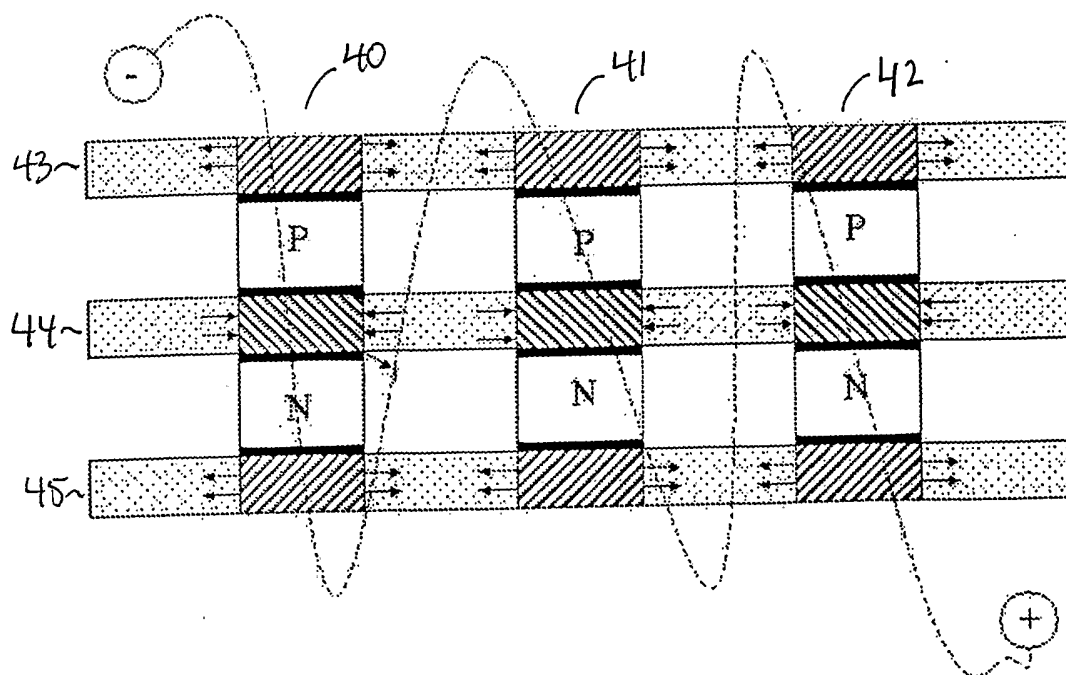


FIG. 4

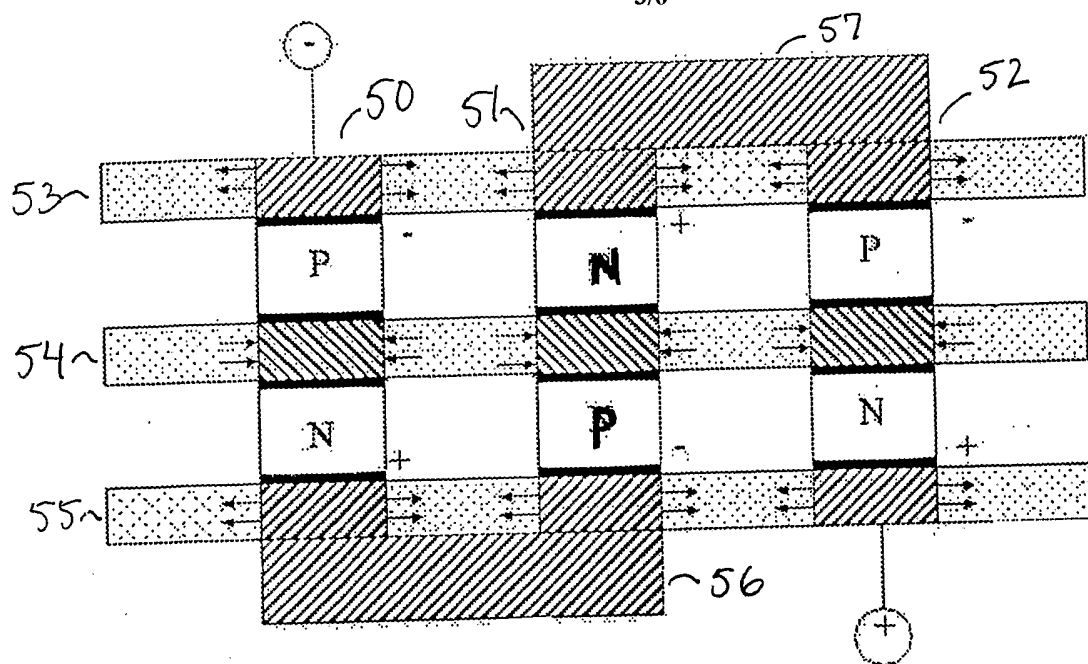


FIG. 5

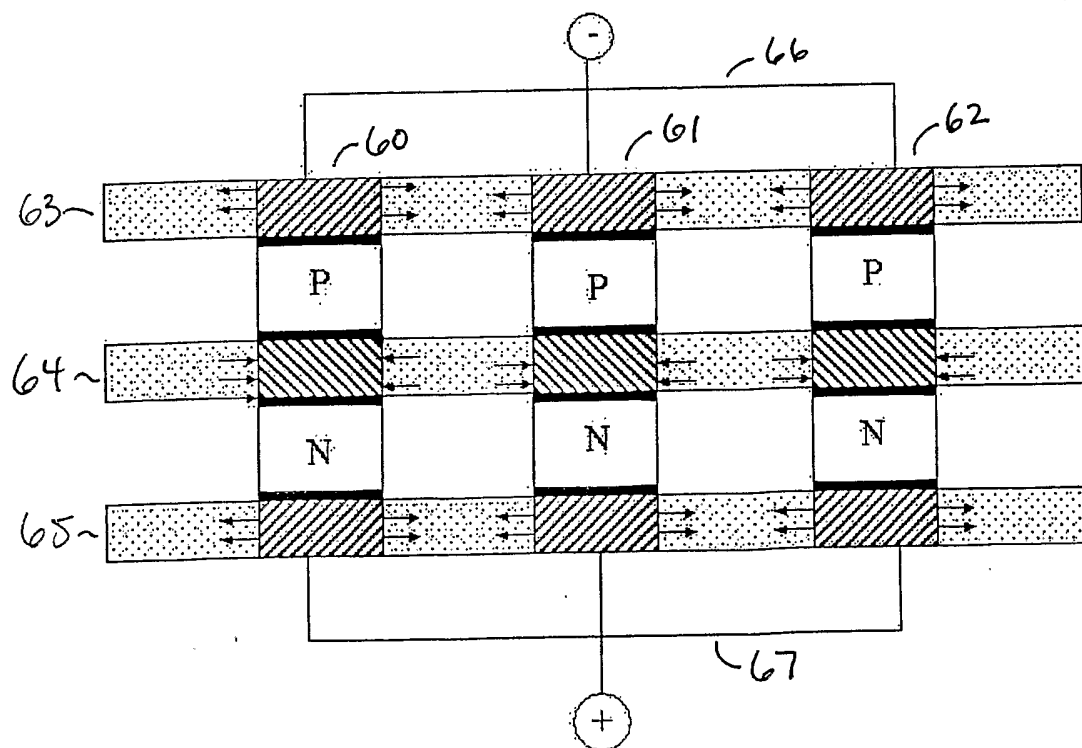


FIG. 6

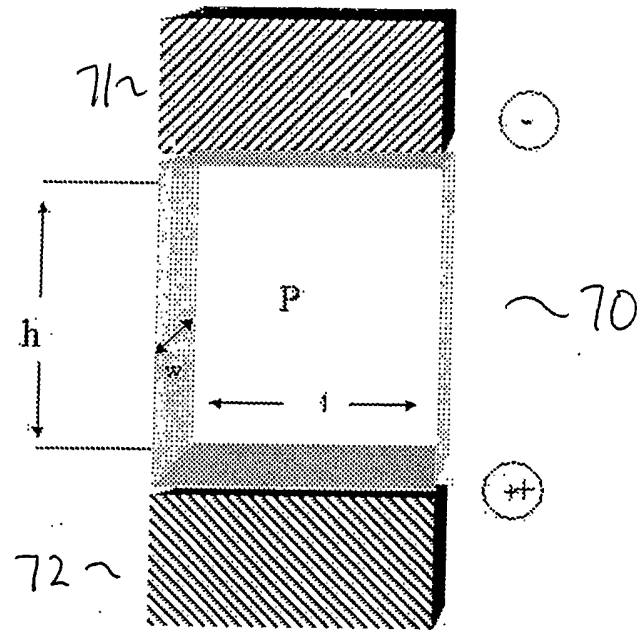


FIG. 7

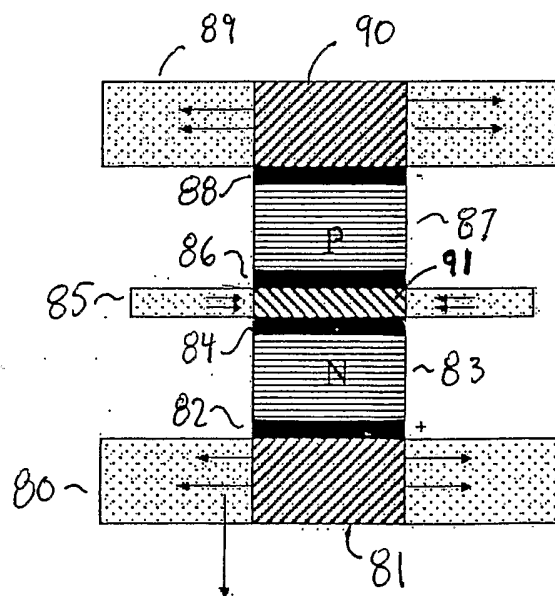


FIG. 8

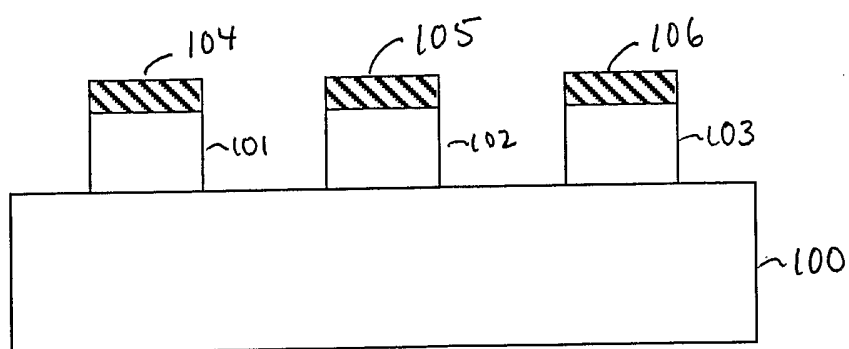


FIG. 9

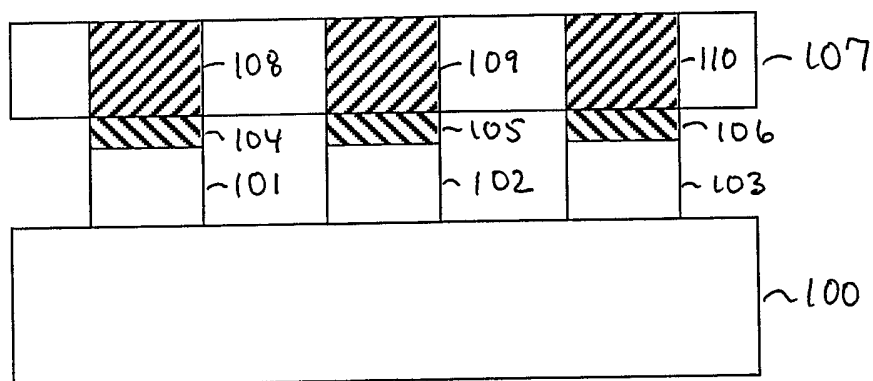


FIG. 10

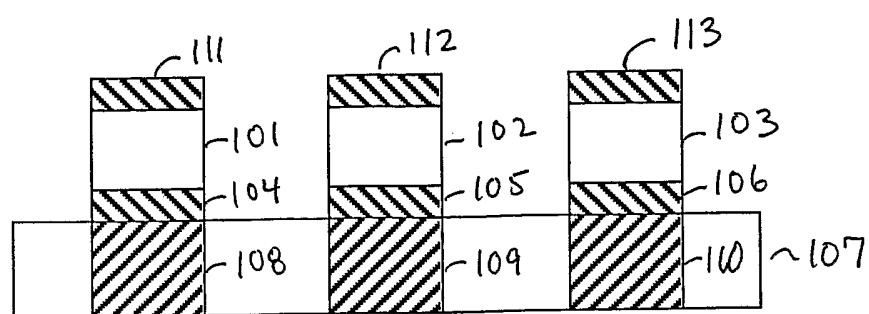


FIG. 11

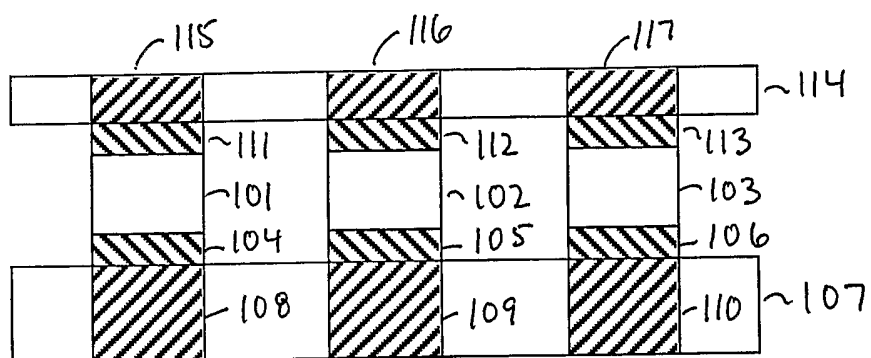


FIG. 12

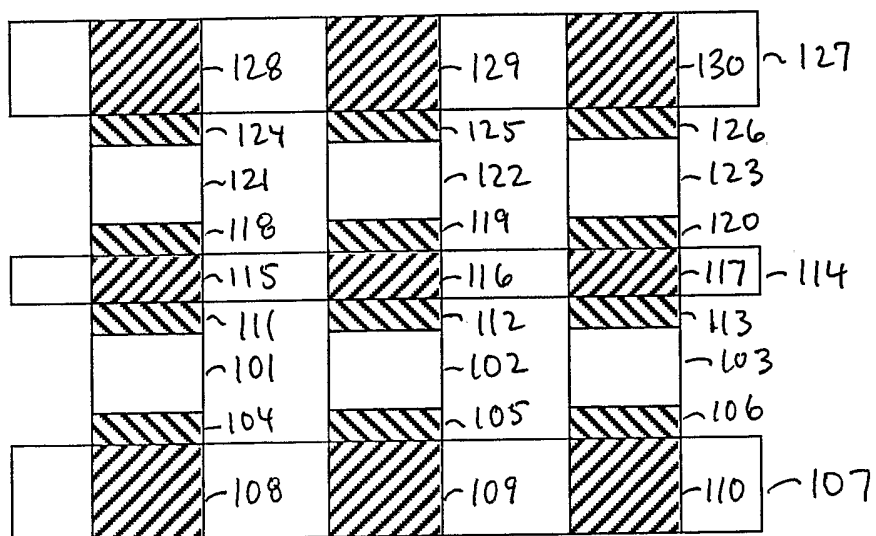


FIG. 13



# INTERNATIONAL SEARCH REPORT

International application No.

PCT/US03/11505

## A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) : H01L 35/02, 35/04, 35/28, 35/30, 35/32, 35/34

US CL : 136/203, 211, 212, 201; 257/930; 438/54

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)

U.S. : 136/203, 211, 212, 201; 257/930; 438/54

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)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X --- A	US 4,443,650 A (TAKAGI et al) 17 April 1984 (17.04.1984), figure 4A, column 3, lines 7-8, and column 7, line 52 through column 8, line 19.	1-46, 48-50 ----- 47
X --- A	US 3,296,034 A (REICH) 03 January 1967 (03.01.1967), figure 3, and column 4, lines 3-28.	1-46, 48-40 ----- 47
X --- A	US 3,607,444 A (DEBUCS) 21 September 1971 (21.09.1971), figure 3, and column 5, lines 1-12.	47 ----- 1-46, 48-50
X --- A	US 3,136,134 A (SMITH) 09 June 1964 (09.06.1964), see figure 2, and column 2, lines 41-66.	47 ----- 1-46, 48-50
A	US 5,006,178 A (BIJVOETS) 09 April 1991 (09.04.1991).	1-50



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:	
"A" document defining the general state of the art which is not considered to be of particular relevance	"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
"E" earlier application or patent published on or after the international filing date	"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
"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)	"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
"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	"&" document member of the same patent family

Date of the actual completion of the international search

23 July 2003 (23.07.2003)

Date of mailing of the international search report

10 SEP 2003

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**INTERNATIONAL SEARCH REPORT**

PCT/US03/11505

**C. (Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT**

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5,430,322 A (KOYANAGI et al) 04 July 1995 (04.07.1995).	1-50
A	US 6,300,150 B1 (VENKATASUBRAMANIAN) 09 October 2001 (09.10.2001).	1-50
A	WO 00/49664 A1 (PICONE) 24 August 2000 (24.08.2000).	1-50