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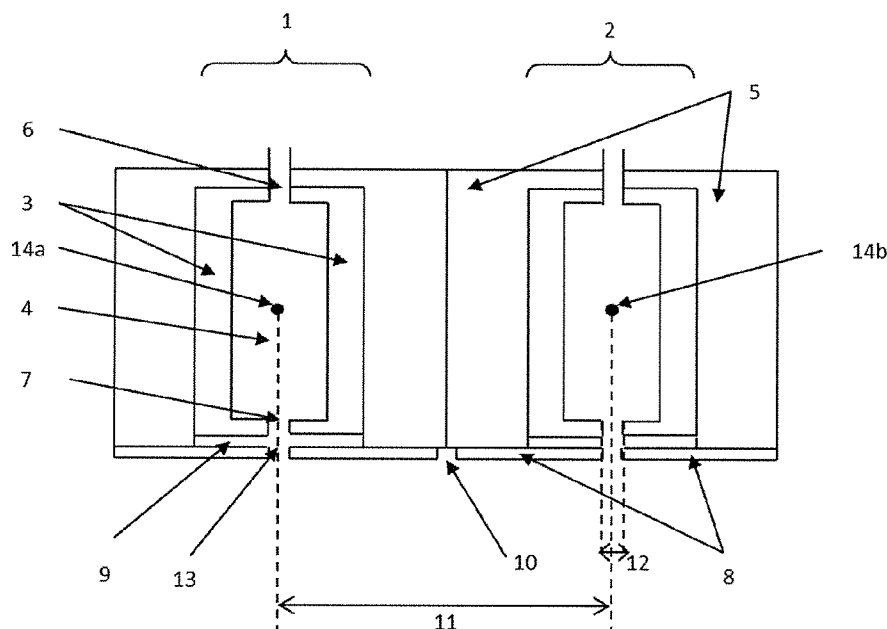
(54) **Title:** HOLLOW CATHODE PLASMA SOURCE

FIG. 1

(57) **Abstract:** The present invention relates to a hollow cathode plasma source and to methods for surface treating or coating using such a plasma source, comprising first and second electrodes (1, 2), each electrode comprising an elongated cavity (4), wherein dimensions for at least one of the following parameters is selected so as to ensure high electron density and/or low amount of sputtering of plasma source cavity surfaces, those parameters being cavity cross section shape, cavity cross section area cavity distance (11), and outlet nozzle width (12).

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HOLLOW CATHODE PLASMA SOURCE

Cross Reference to Related Application

This application is related to PCT International Application Ser. No. _____
(not yet assigned)(Attorney Docket No. 0124-374.PCT) titled "Plasma Source

- 5 Utilizing a Macro-Particle Reduction Coating and Method of Using a Plasma
Source Utilizing a Macro-Particle Reduction Coating for Deposition of Thin Film
Coatings and Modification of Surfaces," being filed concurrently herewith and
incorporated herein by reference.

Background of the Invention

- 10 The present invention relates to a plasma source for the surface treatment
and/or coating of large substrates. More particularly the present invention relates
to a linear plasma source for plasma enhanced chemical vapor deposition and for
plasma surface treatment, in particular a plasma source based on a hollow cathode
type discharge.

- 15 Various plasma sources are disclosed in the prior art for the deposition of
thin films and chemical modification of surfaces.

- When large substrates are to be treated, these plasma sources typically are
linear ionic sources like the one disclosed by Madocks in U.S. 7411352. This
plasma source is based on a magnetron discharge and produces a linear beam of
20 ions or, by combining several sources, multiple parallel beams of ions directed
towards the substrate surface. Madocks discloses that for coating purposes a
coating precursor can be provided outside of the plasma sources. The plasma
extends essentially only along one dimension, i.e. the length of plasma source.
The width of the ion beam is limited by the pressure inside the process chamber
25 which restricts the mean free path length. When a substrate is conveyed beneath
this plasma source the contact time is therefore relatively short. Thus the number
of plasma sources will have to be multiplied when for example the treatment
duration of the substrate with the plasma needs to be increased. Furthermore a
coating precursor injected next to the plasma source has limited opportunity to

interact with the plasma beam. This results in relatively low deposition yield and increases the risk of soiling the coater with precursor that has not been able to react with the substrate surface.

5 Madocks also discloses that sputtering of the electrode material occurs and that the sputtered material redeposits and thus remains within the source. Sputtering of the electrode material however results in reduced lifetime of the electrodes. The redeposition of the sputtered material may also lead to blockage of the nozzles of the plasma source, making a uniform substrate treatment or coating impossible. Furthermore, the sputtered electrode material may condense and/or
10 react further, leading to the formation of debris that either block the source's nozzles or fall on the substrate creating defects. These nozzles are made up by one of the plasma source's electrodes. The electrode is thus exposed to the coating process atmosphere in the vacuum chamber and therefore prone to soiling from the injected coating precursor.

15 Furthermore the magnetron discharge based source disclosed by Madocks requires magnets. Magnets are sensitive to high temperatures, these sources therefore cannot be run at high temperatures and need to be cooled by active or passive means. The presence of these magnets as well as the necessary presence of shunts lead to a complex and thus expensive assembly.

20 This source also produces a relatively low density of free electrons compared to plasma sources based on hollow cathode discharge. For coating purposes, the electrons of the plasma serve to ionize the coating precursor. Therefore the coating efficiency is low when a magnetron plasma based source such as disclosed by Madocks is used.

25 Jung discloses in EP0727508 A1 a hollow cathode linear plasma source based on two parallel electrodes. The plasma extends essentially only along one dimension, i.e. the length of plasma source, forming a narrow plasma beam. Jung discloses that in order to avoid sputtering of the electrode material a stream of inert gas has to be injected parallel to the electrodes. The injection of an inert gas

parallel to the electrodes however leads to a reduction of the yield of reactive ions and therefore reduced treatment efficiency or coating yield.

One of the major problem with these kinds of high deposition rate sources is the fact that the walls of the plasma sources become quickly soiled by reacting prematurely with precursors that flow through the plasma. Due to this problem,
5 the use of this process in industry is quite limited and requires frequent cleaning cycle which limits the throughput of the production line.

Another drawback of these high deposition rate sources is that it is difficult to confine the precursor to the substrate surface after it leaves the plasma source.
10 As a consequence a significant portion of the precursor cannot be used to form a coating on the substrate. This leads to reduced coating yield and to soiling of the coater with the transformation of the precursor on surfaces surrounding the plasma source.

Thus there remains a need in the large area surface treatment and large area coating field for a simple plasma source that can provide a uniform plasma of
15 considerable length that can treat and/or coat large substrates with high efficiency and low amount of soiling and of defects.

Summary of the Invention

In an aspect of the invention there is provided a linear plasma source
20 useful for the deposition of thin films on large substrates and for the plasma treatment of the surfaces of large substrates. Plasma treatment is meant to encompass e.g. surface activation, surface cleaning as well as surface etching.

In an aspect of the present invention there is provided a hollow cathode based plasma source with a very wide linear plasma.

25 In an aspect of the present invention there is provided a plasma source that is able to form a uniform wide linear plasma.

In an aspect of the present invention there is provided a plasma source with a low rate of electrode cavity surface sputtering.

In an aspect of the present invention there is provided a plasma source with a high density of free electrons.

5 In an aspect of the present invention there is provided a method of forming a large area coating using a uniform wide linear plasma.

Brief Description of the Figures

These aspects as well as other aspects of the invention will be clarified in the detailed description of particular embodiments of the invention with reference
10 to the drawings of the figures, wherein:

Fig. 1 Shows a section view of a plasma source according to the present invention

Fig. 2 Shows a section view of another plasma source according to the present invention

15 Fig. 3 Shows a section view of another plasma source according to the present invention.

Fig. 4 Shows a section view of a plasma source according to the present invention being used for the surface treatment or coating of a substrate.

20 Fig. 5 Shows a section view of possible variations of the plasma sources according to the present invention.

Detailed description of the invention

Fig. 1 shows a transverse section view of a hollow cathode plasma source according to the present invention comprising a first electrode **1** and a second electrode **2**, respectively having a first electron emitting surface and a second
25 electron emitting surface which are the walls of the cavities **3** and being

positioned in proximity to each other. The first and second electrodes each substantially encloses an elongated gas containing volume **4**, i.e. a hollow cathode cavity. The distance between the hollow cathode cavities **11** is measured from one cavity center **14a** to the other cavity center **14b**. The electrodes extend
5 substantially parallel to each other. The cathodes may be oriented perpendicular to the moving direction of the substrate to be treated or at an angle to this direction. The first and second electrodes are essentially surrounded by insulating material **5**. The first and second electrodes are both provided with a gas inlet for the plasma forming gas **6** and with a gas outlet for the ionized plasma gas **7**. At the outlet the
10 gas is directed through an outlet nozzle **13** towards the vacuum chamber in which the plasma source is placed and towards the substrate within the vacuum chamber. The gas outlet nozzle has a certain width **12**. The first and second electrodes are electrically connected to an AC power source (not depicted) supplying a voltage that is alternating between positive and negative. In between the vacuum chamber
15 structure **8** that supports the plasma source and the electrodes there is a dark space or solid electrical insulator **9**. A coating precursor injection nozzle **10** may also be combined with the plasma source to perform plasma enhanced chemical vapor deposition. The nozzle **10** directs a coating precursor comprising gas towards the plasma generated by the plasma source in the vacuum chamber. Structural
20 elements as well as cooling elements and electrical connections are not shown.

Hollow cathode plasma source is taken to mean a plasma forming device typically described as two cavities alternating between positive (anode) and negative potential (cathode) with a 180° phase shift. In the cathode cavity electrons are oscillating between negative electric fields of the cavity and are
25 thereby confined.

Plasma is taken to mean an electrically conductive gaseous medium comprising both free electrons and positive ions.

Reactant gas is taken to mean oxygen and/or nitrogen. It is often desirable to deposit on a surface compounds which may not be chemically available from

the precursor gas alone. Often, reactant gases such as oxygen or nitrogen are added to the chemical vapor deposition (CVD) process to form oxides or nitrides. Other reactant gases may comprise fluorine, chlorine, other halogens or hydrogen. A reactant gas may be differentiated from a precursor gas by the fact that even
5 when energized or chemically decomposed, condensable molecular entities are not formed. Generally, reactant gases or reactant gas fragments cannot by themselves grow a solid deposition but they can react and become chemically incorporated into a solid deposition derived from precursor gases or other solid deposition sources. Preferred reactants are O₂, N₂, NH₃, CH₄, N₂O, H₂.

10 Precursor is taken to mean a gas or a liquid, selected according to its vapor pressure, in molecular form containing a chemical element or elements to be condensed into a solid coating. The elements to be condensed from the precursor may include metals, transition metals, boron, carbon, silicon germanium and/or selenium. Generally, a precursor molecule is unreactive or not prone to attaching
15 on a surface until energized, partially decomposed, or fully decomposed by an energy source, whereupon a chemical fragment of the precursor containing the desired chemical element for coating becomes chemically able to bond to or condense upon a surface in a solid form. The condensed portion of the precursor compound may be primarily a pure element, a mixture of elements, a compound
20 derived from the precursor compound constituents or a mixture of compounds. Preferred precursor gas are inorganic compounds such as: SiH₄, N(SiH₃)₃, TMDSO, HMDSO, TTIP, ... or any other that contain appropriate metal to deposit oxide, nitride or oxynitride films such as : SiO₂, Si_xN_y, ZrO₂, TiO₂, Al₂O₃, AlN, SnO₂, ZnO, etc. ... and mixtures of one or more of these materials, such as
25 SiO_xN_y, Si_xAl_yN_z.

Substrate is taken to mean either a small area or large area item to be coated or have its surface chemically modified by this invention. Substrate referred to herein can be comprised of glass, plastic, metal, inorganic materials, organic materials or any other material that has a surface to be coated or modified.

AC power or AC power source is taken to mean electric power from an alternating source wherein the voltage is changing at some frequency in a manner that is sinusoidal, square wave, pulsed or according to some other waveform. Voltage variations are often from negative to positive. When in bipolar form,
5 power output delivered by two leads is generally about 180 degrees out of phase.

Secondary electron or secondary electron current is taken to mean electron emission from a solid surface as a result of bombardment of that surface by a particle and the current that is created as a result, respectively.

Dark space is taken to mean a narrow zone or area around an electrode
10 whereby plasma current is very low. Generally, two oppositely charged plasma electrodes or a plasma electrode and a ground potential conductor spaced apart by the dark space distance will exhibit substantially no current flow between them.

The construction material for the electrodes must be sufficiently electrically conductive so that electrons can be emitted from the electrode surfaces
15 and so that they can carry the necessary electrical current to sustain the discharge. Electrode materials comprise metals, metal alloys, metal compounds, carbon, carbon compounds, ceramics, or semiconductors. Most commonly used materials are metals, metal alloys or graphitic carbon.

Electrode materials may be selected for particular electron emission
20 properties. They may comprise materials with low work function or with high secondary emission coefficients which allow lower operating voltages and increased electron current.

The electron emitting surfaces may comprise metal, metal-based, metalloid, metalloid-based or carbon-based coatings deposited on the electrodes.
25 These coatings may comprise materials with low work function or with high secondary emission coefficients which allow lower operating voltages and increased electron current.

Almost any gas may be used as plasma forming gas. Most commonly the plasma forming gas comprises He, Ne, Ar, Kr, Xe, O₂, N₂, H₂, NH₃ or mixtures on any of these gases. The gas flow rate is generally comprised between 0.5 sccm and 10 sccm per linear mm of cavity length.

5 Different arrangements and shapes are possible for the outlet and nozzle. Typically they are an array of holes. They may also comprise a slot or elongated orifice. A gas pressure drop exists between the hollow cathode cavities and the exterior, i.e. the vacuum chamber. Thereby a sufficiently high pressure level for sustaining a stable plasma is maintained in the cathode cavity and an outflow of
10 the ionized gas from the cavity towards the exterior is obtained. The nozzles thus distance the electrodes from the coating process atmosphere in the vacuum chamber and therefore reduce the probability of soiling from the injected coating precursor.

The first and second hollow cathode electrodes function alternatingly as
15 cathodes and anodes. When one electrode is electrically positive with respect to the plasma potential, the other one is electrically negative with respect to the plasma potential and this electrical polarity reverses at some frequency.

This may be obtained by using an AC power source or a pulsed DC power source. Typically the power sources supply a bipolar voltage approximately 180
20 degrees out of phase with an alternating polarity of the phases such that the electron current between the electrodes reverses at some frequency. The preferred voltage range is comprised between 300V and 1200V, the preferred frequency range is comprised between 10 kHz and 1 MHz, preferably between 10 kHz and 100 kHz, most preferably about 40 kHz.

25 The plasmas formed by the hollow cathode plasma source of this invention are non-equilibrium, non-thermal plasmas that are highly electrically conductive and that typically carry a charge of ground potential of several 10's of volts positive. The electrodes are placed in sufficient proximity to allow an electron

current to flow between electrodes of opposite polarity at the operating pressure of the vacuum chamber.

The operating pressure in the vacuum chamber may be kept between 0.001 mbar and 1 mbar, typically between 0.002 mbar and 0.1 mbar, more typically
5 between 0.007 and 0.05 mbar.

A plasma is formed in the volumes enclosed by the first and second electron emitting surfaces, plasma that extends throughout the gas containing space that lies in between the electron emitting surfaces. The plasma is made substantially uniform over its length in the substantial absence of closed circuit
10 electron drift.

Thereby the plasma source according to the invention forms a linear plasma beam that has a high density of free electrons and that is not limited to a narrow width beneath the plasma source but rather extends in between the two hollow cathode cavities. The plasma source according to the present invention
15 therefore allows high contact times between substrate and plasma. It also presents better opportunities for a coating precursor injected in proximity to the plasma beam to interact with it. Thereby high deposition yields and high treatment efficiencies are provided while the risk of soiling of the plasma source as well as the coater as a whole is reduced.

Furthermore the plasma source according to the invention requires no additional electrodes, acceleration grids, magnetic fields, shunts, or neutralizers. It is therefore less complex and thus less costly than other plasma sources. However, when desired for particular reasons, magnets and/or additional electrodes may be
20 used in conjunction with the arrangement of hollow cathodes according to the present invention.
25

In an aspect of the invention, there are provided dimensions of certain key parameters of the hollow cathode plasma source.

The key parameters identified by the inventors are:

- The cavity cross section shape
- The cavity cross section area
- The outlet nozzle width
- 5 - The cavity distance

The inventors recognize the surprising effect of these key parameters. They have discovered that among all parameters that govern these plasma sources, these parameters in particular, either alone or in combination, have a significant impact on the density of free electrons in the plasma generated by the hollow cathode plasma source and as well as the amount of sputtering of the plasma source cavity surfaces. To achieve these effects, the inventors have discovered that these key parameters need to respect specific dimensions. The dimensions of these key parameters may be different for each hollow cathode plasma source cavity, preferably they are the same for both hollow cathode plasma source cavities.

According to an advantageous embodiment specific dimensions of these key parameters separately or in any combination lead to a reduced amount of sputtering of the cavity surfaces. The plasma source according to the invention therefore does not require the injection of an inert gas parallel to the electrodes. Therefore a high yield of reactive species is obtained leading to high treatment efficiency or coating yield. The plasma source according to the present invention therefore also limits redeposition of sputtered material inside the plasma source and its nozzles and also reduces the formation of debris. Thus the treatment or coating uniformity are improved and the amount of defects in the treatment or coating is reduced.

According to an advantageous embodiment the hollow cathode discharge based plasma source together with specific dimensions of these key parameters

separately or in any combination also lead to increased density of free electrons. Therefore the treatment efficiency or coating efficiency is increased. Furthermore the more efficient usage of coating precursor leads to reduced soiling of the vacuum chamber and vacuum pumps by unreacted coating precursor.

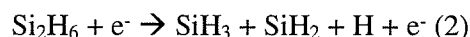
5 During long duration trials of more than 100 hours it was observed that plasma sources with a rounded rectangular cavity cross section shape (Fig. 2) showed significantly more cavity surface sputtering than plasma sources with a circular cross section shape (Fig. 3).

10 By comparing experimental results with computer simulation data, the inventors have found that the amount of sputtering of the hollow cathode cavity surfaces is related to the absorption of reactive ions on the hollow cathode cavity surfaces as determined by numerical simulation.

15 The simulation software that was used for simulating gas flows and gas discharges is a program called PIC-MC that has been developed by the Fraunhofer-Institute for Surface Engineering and Thin Films IST, Braunschweig, Germany. The software combines the simulation of gas flows, magnetic fields and plasma. For the gas flow simulation it uses the Direct Simulation Monte Carlo (DSMC), for the magnetic field simulation it uses the Boundary Element Method (BEM) and for the plasma simulation it uses the
20 Particle in Cell – Monte Carlo method (PIC-MC).

 The simulations were made on a pseudo 2D model which is a transversal 1.016 mm thick slice of the hollow cathode plasma source. Pseudo-2D means that the slice has a small thickness and a periodic condition is applied on each plane in the transversal direction.

25 For the simulations many different plasma forming gasses can be used, in the following examples argon was used. In order to limit the computation time Si_2H_6 was chosen as coating precursor and among its possible reactions the following two were selected:



Hydrogen species were not included in the simulations.

For each given set of input parameters the simulation yields data regarding
5 number and velocity of the different gas phase species (atoms, ions, molecules and electrons) throughout the space they occupy. From this data certain values can be calculated, such as densities and fluxes, where a flux is the rate of movement of gas phase species across a unit area (unit: $\text{mol} \cdot \text{m}^{-2} \cdot \text{s}^{-1}$).

Another useful calculation is the flux that is absorbed on a certain surface.
10 Given a certain sticking coefficient of the cathode cavity material, the ion absorption on its surface can be calculated from the ion flux directed at it. By correlating experimental results with simulation data the inventors found that the formation of debris and thus the cavity surface sputtering observed on real plasma sources was related to the level of ionized plasma species absorbed by the
15 electrodes' cavity surfaces according to the simulation model.

Low levels of ionized plasma species absorbed by the electrodes' cavity surfaces mean that the level of cavity sputtering is low and debris formation is low.

Another important quantity is the electron density generated. The electron
20 density has a major influence on surface treatment or coating efficiency, with high electron densities leading to high surface treatment or coating efficiencies. In the present simulations the electron density was determined in the vacuum chamber on a line set at a distance of 2.54 mm from the chamber structure that supports the plasma source and averaged.

25 In one aspect of the invention there is provided a hollow cathode cavity transverse cross section shape.

The inventors surprisingly found that the level of ionized plasma species absorbed by the cathode cavity surfaces was reduced when the rectangular cavity cross section shape was replaced by a cross section enclosing the same surface area having a rectangular shape where at least one corner is rounded or preferably all four corners are rounded (rounded rectangular shape), or preferably having a rounded rectangular shape whose four corner radii are equal to half its width or most preferably having a circular shape.

Fig. 2 Shows a section view of a plasma source according to the present invention having a rounded rectangular cavity cross section shape.

Fig. 3 Shows a section view of a plasma source according to the present invention having a circular cavity cross section shape.

Variations to these shapes, in particular leading to intermediary shapes, may be made without departing from the present invention. In particular these are elliptical or oval shapes or shape variations such as illustrated in Fig. 5.

Furthermore the inventors found that the circular cavity cross section shape also improved the electron density over the rectangular shape.

In one aspect of the invention there is provided a hollow cathode cavity transverse cross section area.

According to an embodiment of the invention the cavity cross section area is comprised between 100mm^2 and 10000mm^2 , preferably between 500mm^2 and 4000mm^2 .

According to another embodiment of the present invention the cavity cross section area is comprised between 100 mm^2 and 1000 mm^2 , preferably between 500 mm^2 and 1000 mm^2 , most preferably between 500 mm^2 and 750 mm^2 . The inventors surprisingly found that at lower cavity cross section area, electron density was increased.

According to another embodiment of the present invention the cavity cross section area is comprised between 1000 mm² and 4000 mm², preferably between 1500 mm² and 4000 mm², most preferably between 2000 mm² and 4000 mm². The inventors surprisingly found that at higher cross section area the level of ionized plasma species absorbed by the cathode cavity surfaces was reduced.

According to another embodiment of the present invention the cavity cross section area is comprised between 750 mm² and 1500 mm², preferably between 750 mm² and 1250 mm², most preferably around 1000 mm². The inventors found that at an intermediate cross section area a balanced level of ionized plasma species absorbed by the cathode cavity surfaces versus electron density was obtained.

In one aspect of the invention there is provided a hollow cathode cavity distance, measured from one cavity center to the other cavity center. The center of the cavity is the geometrical center of the cavity cross section if it has a regular geometrical shape. If it has an irregular shape it is its centroid.

The inventors surprisingly found that increasing the hollow cathode cavity distance up to a certain threshold leads to a reduced level of ionized plasma species absorbed by the cathode cavity surfaces with decreased electron density. According to the invention the cavity distance is comprised between 85 mm and 160 mm, preferably between 100 mm and 145 mm, most preferably around 125 mm.

It is clear to the person skilled in the art that the cavity distance is also dependent on the cavity size and on insulation, structural and cooling requirements.

In one aspect of the invention there is provided an outlet nozzle width.

In the present design the outlet nozzles are centered at the vertical line running through the center of the cavity cross section shape. The centers of each cavity cross section and of its outlet nozzle are aligned with the vertical line

running through the cavity cross section's center. However variations and modifications of the outlet nozzle placement and orientation may be made without departing from the present invention.

5 In its basic design the outlet nozzle width is in the range of 3.5 mm to 5 mm. The inventors found that increasing the width reduced the level of ionized plasma species absorbed by the cathodes cavity surfaces and increased the electron density. When the outlet nozzle width is increased above a threshold value the electron density is strongly reduced. Probably because the pressure in the cavity cannot be maintained at a level high enough to produce a significant
10 plasma discharge.

According to the present invention the outlet nozzle width is comprised between 1 mm and 25 mm, preferably between 3 mm and 25 mm, more preferably between 8 mm and 22 mm, more preferably between 8 mm and 12 mm, most preferably around 10 mm.

15 According to another embodiment of this invention two or more plasma sources can be combined to increase the surface treatment or coating duration, using a single power source in common or using multiple individual power sources.

20 According to another embodiment of the present invention the plasma source is used for surface treating a substrate, e.g. surface cleaning, surface refreshment, surface activation. The substrate is conveyed beneath the plasma source and exposed to the ions and electrons of the plasma that extends throughout the vacuum space in between the outlet nozzles of the plasma source.

25 According to another embodiment of the present invention the plasma source is used for coating a substrate. Fig. 4 shows the substrate **15** being conveyed beneath the plasma source and exposed to the ions and electrons of the plasma **16** that extends throughout the vacuum space in between the two nozzles

of the plasma source. The coating precursor gas is injected through nozzle 17 to be activated by the plasma in order to form the coating on the substrate.

Examples 1 & 2

Plasma sources with two 10cm (plasma length) long stainless steel hollow electrodes according to the present invention were built and operated for more than 100 hours under the following conditions:

- Voltage amplitude +/- 1200V
- Frequency 40kHz
- Voltage function: bipolar, sinusoid with voltage control
- Power set point 20kW, plasma source is operated in power control mode
- Plasma forming gas O₂ – flow rate 2 sccm per linear mm of cavity length
- cathode cavity cross section area 2000mm²
- Vacuum chamber pressure: 8-12 mTorr
- Outlet nozzle width: 3.5 mm

Two different cavity cross section shapes were compared, rounded rectangular and circular.

Cavity surface sputtering lead to the formation of debris particles. At 24 hour intervals the debris on the glass substrate was collected and the number of debris particles was counted. As can be seen from the table below the number of debris particles increased much more rapidly for the rounded rectangular cavity cross section shape than for the circular shape.

Example nr	Cavity cross section shape	Time of debris collection					
		24 h	48 h	72 h	96 h	120 h	144 h
1	Rounded rectangular	5	5	28	53	80	91
2	Circular	11	0	7	9	2	1

Simulation examples

In examples 3 to 17 hollow cathode plasma sources were simulated.

For each key parameter a set of up to five variations was compared. In each set one variation was chosen as reference. After calculating for each variation the level of absorption of ionized plasma species on the cathode cavity surfaces as well as of the electron density, the ratio of this value to the reference's value was determined.

The following parameters are kept unchanged for all simulation examples:

- Voltage amplitude +/- 1200V
- Frequency 100kHz
- Voltage function: bipolar, sinusoid with voltage control
- Power set point 25kW/m
- Wall temperature 300K
- Precursor gas species Si₂H₆ flow rate 0.13 sccm per linear m of cavity length
- Plasma forming gas Ar – flow rate 2.65 sccm per linear m of cavity length
- Electrode material having a secondary electron emission yield of 0.1 (comparable to Ag, Cu, Al, Ti, Zn, Fe)
- Vacuum chamber pressure about 10 mTorr by tuning vacuum pumping

Examples 3 to 5 – key parameter: Cavity cross section shape

Three cavity cross section shapes were simulated: rectangular, rounded rectangular and circular. The rectangular cross section was 10 mm wide and 50 mm high. The rounded rectangular shape was about 14 mm wide and 45 mm high

with four rounded corners (corner radii: 7 mm). The circular cross section shape had a radius of 13 mm.

The following parameters were kept the same for examples 3 to 5:

- Cavity cross section area: about 500 mm²
- 5 - Outlet nozzle width: 5 mm
- Cavity distance 122 mm

Example		Cathode cavity ionized plasma species absorption ratio	Electron density ratio
3	Rectangular (reference)	1	1
4	Rounded rectangular	0.87	0.90
5	Circular	0.80	1.09

Absorption of ionized plasma species on the cathode cavity and thus cavity sputtering and debris formation decrease when going from rectangular to rounded
10 rectangular to circular cavity cross section shape.

Electron density and thus process efficiency increase when going from rectangular to circular cavity cross section shape.

Examples 6 to 8 – key parameter: Cavity cross section area

Three cathode cavity cross section areas were simulated: 500 mm², 1000
15 mm² and 2000 mm²

The following parameters were kept the same for examples 6 to 8:

- Cavity cross section shape: circular
- Outlet nozzle width: 5 mm

- Cavity distance 122 mm

Example		Cathode cavity ionized plasma species absorption ratio	Electron density ratio
6	500 mm ²	1.54	2.05
7	1000 mm ² (reference)	1	1
8	2000 mm ²	0.61	0.71

Absorption of ionized plasma species on the cathode cavity and thus cavity sputtering and debris formation decrease when cavity cross section area is higher.

- 5 Electron density and thus process efficiency increases when cavity cross section area is lower.

At around 1000 mm² cavity cross section area a balanced level of absorption of ionized species and electron density is obtained.

Examples 9 to 13 – key parameter: Cavity distance

- 10 Five cavity distances were simulated: 168 mm, 142 mm, 114 mm, 104 mm, and 84mm.

The following parameters were kept the same for examples 9 to 13:

- Cavity cross section shape: circular
- Cavity cross section area: 500mm²
- 15 - Outlet nozzle width: 5 mm

Example		Cathode cavity ionized plasma species absorption ratio	Electron density ratio
9	168 mm	0.12	0.35
10	142 mm	0.68	0.97
11	114 mm	0.89	0.97
12	104 mm (reference)	1.00	1.00
13	84 mm	2.38	1.18

Absorption of ionized plasma species on the cathode cavity and thus cavity sputtering and debris formation decreases when cavity distance is higher.

Electron density and thus process efficiency remains good for all cavity
5 distances tested, except the highest. An interesting balance between both ratios is obtained between 100 mm and 145 mm cavity distance.

Examples 14 to 17 – key parameter: Outlet nozzle width

Four nozzle widths were simulated: 5 mm, 10 mm, 20 mm, and 40 mm.

10 The following parameters were kept the same for examples 9 to 13:

- Cavity cross section shape: circular
- Cavity cross section area: 500mm²
- Cavity distance: 122 mm

Example		Cathode cavity ionized plasma species absorption ratio	Electron density ratio
14	5 mm	1.00	1.00
15	10 mm	0.85	1.84
16	20 mm	0.65	1.94
17	40 mm	0.10	0.26

Absorption of ionized plasma species on the cathode cavity and thus cavity sputtering and debris formation decrease when the outlet nozzle width is larger.

Electron density and thus process efficiency increases when the outlet
5 nozzle width is larger. At very high outlet nozzle width, for example at 40 mm, the pressure difference between the inside of the cavities and the vacuum chamber cannot be held at a sufficient level for maintaining a stable plasma, leading to a very low electron density level.

Claims

1. A hollow cathode plasma source comprising a first electrode (1) and a second electrode (2) each electrode comprising an elongated cavity (4),

wherein the cathodes extend substantially parallel to each other

5 wherein the first and second electrodes (1, 2) are both provided with a gas inlet for the plasma forming gas (6) and with a gas outlet (7) which leads to an outlet nozzle (13) which is directed towards a substrate

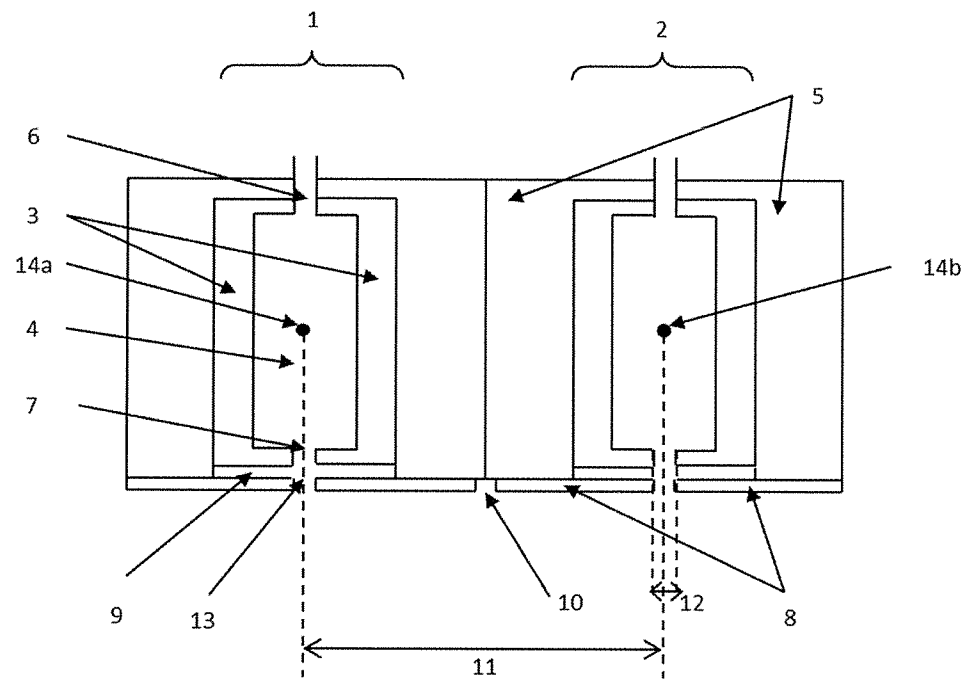
wherein first and second electrodes are electrically connected to
10 a power source supplying the electrodes with alternately opposing voltages

wherein at least one of the following parameter's dimension is selected
 - i. the cavity cross section is of rectangular, rounded
15 rectangular or circular shape or of a shape intermediary of these shapes,
 - ii. the cavity cross section area is comprised between 500 mm² and 4000 mm²,
 - iii. the cavity distance (11) is comprised between 85 mm
20 and 160 mm,
 - iv. the outlet nozzle width (12) is comprised between 1 mm and 25 mm.
2. Hollow cathode plasma source according to claim 1 wherein at least two of the parameter's dimensions i. to iv. are selected.

3. Hollow cathode plasma source according to claim 1 wherein all of the parameter's dimensions i. to iv. are selected.
4. Hollow cathode plasma source according to claim 1 wherein the cavity cross section shape is circular.
- 5 5. Hollow cathode plasma source according to claim 1 wherein the cavity cross section area is comprised between 500 mm² and 1000 mm².
6. Hollow cathode plasma source according to claim 1 wherein the cavity cross section area is comprised between 1000 mm² and 4000 mm².
- 10 7. Hollow cathode plasma source according to claim 1 wherein the cavity cross section area is comprised between 750 mm² and 1500 mm².
8. Hollow cathode plasma source according to claim 1 wherein the cavity distance (11) is comprised between 500 mm and 1000 mm.
9. Hollow cathode plasma source according to claim 1 wherein the outlet nozzle width (12) is comprised between 3.5 mm and 25 mm.
- 15 10. Method for surface treating a substrate comprising:
providing a vacuum chamber having a hollow cathode plasma source according to claim 1,
injecting a plasma forming gas through the electrodes' plasma forming gas inlets (6),
20 applying a voltage to the hollow cathode plasma source,
introducing a substrate (15) into the plasma (16) thus generated by the plasma source in the vacuum chamber.
- 25 11. Method for coating a substrate comprising:
providing a vacuum chamber having a hollow cathode plasma source according to claim 1,
injecting a plasma forming gas through the electrodes' plasma forming

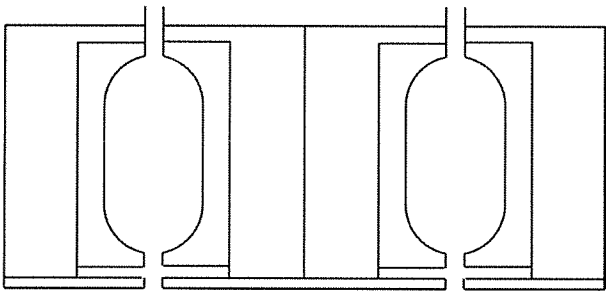
- gas inlets (6),
applying a voltage to the hollow cathode plasma source,
injecting a coating precursor gas towards the plasma generated by the
plasma source,
5 introducing a substrate (15) into the plasma (16) thus generated by the
plasma source in the vacuum chamber,
depositing a coating from the precursor gas activated by the plasma.

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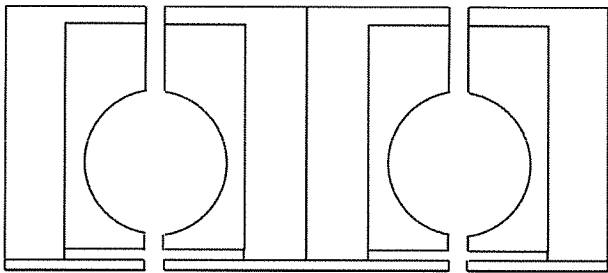
FIG. 1



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FIG. 2

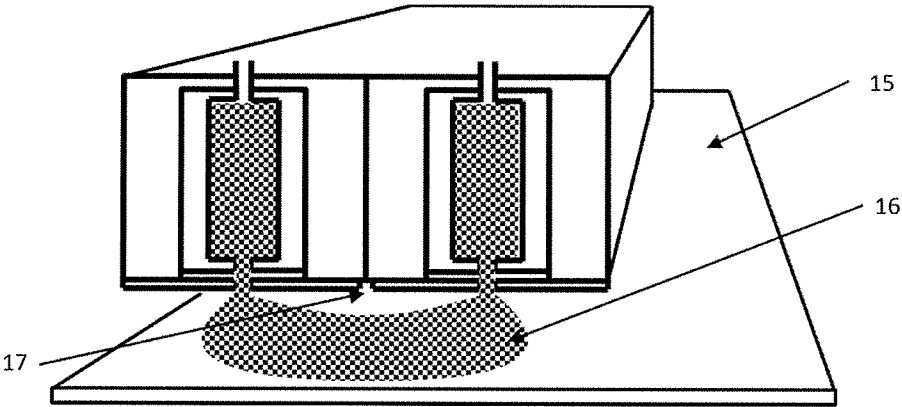
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FIG. 3

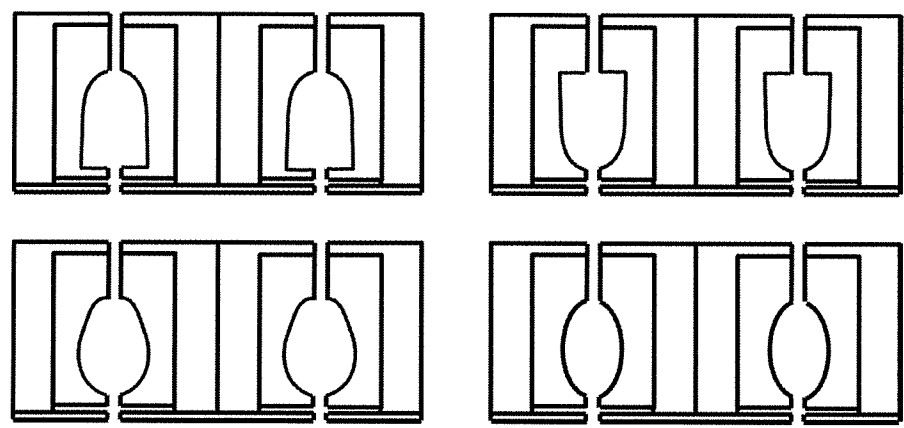
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FIG. 4

5/5



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FIG. 5

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US14/68858

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - H05H 1/24 (2015.01)

CPC - H05H 1/24; H01J 37/32596

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

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC(8): H05H 1/24; C23C 16/452, 16/50, 16/505, 16/513 (2015.01)

CPC: H05H 1/24; H01J 37/32596; C23C 16/452, 16/50, 16/505, 16/513

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)

PatSeer (US Granted, US Applications, EP, WO, JP, DE, GB, CN, FR, KR, ES, AU, IN, CA); Google; Google Scholar; ProQuest; IEEE.com;

Keywords Used: hollow cathode, plasma source, surface area, insert area, modeling, parameters, spherical

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 6,388,381 B2 (ANDERS, A) May 14, 2002; figures 13, 15, 16; column 1, lines 13-18; column 3, lines 24-29; column 6, lines 62-63; column 11, lines 11-12, 31-36, 64-67; column 12, lines 1-3; column 14, lines 13-27, 54-67; column 15, lines 34-38, 59-63.	1-11
Y	US 2010/0028238 A1 (MASCHWITZ, P) February 4, 2010; paragraphs [0006, 0069-0070, 0084].	1-11
Y	US 8,143,788 B2 (HOFER, R et al.) March 27, 2012; column 11, lines 11-16, 36-39; column 14, lines 15-26.	3, 5-7, 9
Y	US 3,253,180 A (HUBER, H) May 24, 1966; column 1, lines 9-11, 51-53; column 2, lines 26-36.	4

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

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"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

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Date of the actual completion of the international search

12 February 2015 (12.02.2015)

Date of mailing of the international search report

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