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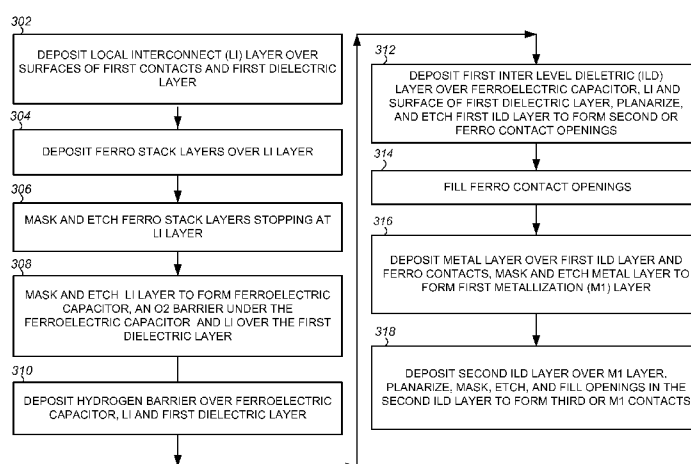


FIG. 3

(57) **Abstract:** Non-volatile memory cells including complimentary metal-oxide-semiconductor transistors and embedded ferroelectric capacitor and methods of forming the same are described. In one embodiment, the method includes forming on a surface of a substrate a gate level including a gate stack of a MOS transistor, a first dielectric layer overlying the MOS transistor and a first contact extending through the first dielectric layer from a top surface thereof to a diffusion region of the MOS transistor. A local interconnect (LI) layer is deposited over the top surface of the first dielectric layer and the first contact, a ferro stack including a bottom electrode, a top electrode and ferroelectric layer there between deposited over the LI layer, and the ferro stack and the LI layer patterned to form a ferroelectric capacitor and a LI through which the bottom electrode is electrically coupled to the diffusion region of the MOS transistor.

METHODS OF FABRICATING AN F-RAM

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of priority under 35 U.S.C. 119(e) to U.S. Provisional Patent Application Ser. No. 61/839,997, filed June 27, 2013, to U.S. Provisional Patent Application Ser. No. 61/840,128, filed June 27, 2013, and to U.S. Provisional Patent Application Ser. No. 61/841,104, filed June 28, 2013, both of which are incorporated by reference herein.

TECHNICAL FIELD

[0002] The present disclosure relates generally to semiconductor devices, and more particularly to ferroelectric random access memories (F-RAM) including embedded or integrally formed ferroelectric capacitors and complementary metal-oxide-semiconductor (CMOS) transistors and methods for fabricating the same.

BACKGROUND

[0003] Ferroelectric random-access memories (F-RAM) typically include a grid or an array of storage elements or cells, each including at least one ferroelectric capacitor and one or more associated transistors to select the cell and control reading or writing thereto. When an external electric field is applied across a ferroelectric material of a ferroelectric capacitor in the cell, dipoles in the material align with the field direction. After the electric field is removed, the dipoles retain their polarization state. Data is stored in the cells as one of two possible electric polarizations in each data storage cell. For example, in a one transistor-one capacitor (1T1C) cell, a "1" may be encoded using a negative remnant polarization, and a "0" is encoded using a positive remnant polarization.

[0004] The ferroelectric capacitor in an F-RAM cell typically includes a ferroelectric material, such as lead zirconate titanate (PZT) between an upper electrode and a lower electrode. The transistors in the cells are typically metal-oxide-semiconductor (MOS) transistors fabricated using a standard or baseline complimentary-metal-oxide-semiconductor (CMOS) process flows, involving the formation and patterning of conducting, semiconducting, dielectric and materials. The composition of these materials, as well as the composition and concentration of processing reagents, and temperature used in such a CMOS process flow are stringently controlled for each operation to ensure the resultant MOS transistors will function properly. Materials and processes typically used to fabricate the ferroelectric capacitor differ significantly from those of the baseline CMOS process flow, and can detrimentally impact the MOS transistors.

[0005] Thus, in conventional methods of fabricating F-RAM the ferroelectric capacitor is fabricated in a separate layer overlying or the layer in which the MOS transistors are fabricated and isolated therefrom by one or more layers. It will be understood by those skilled in the art that conventional methods of fabricating F-RAM require several extra mask and processing steps, all of which increase fabrication time, costs, and defect density lowering a yield of working memories.

SUMMARY

[0006] Non-volatile memory cells including complimentary metal-oxide-semiconductor (CMOS) transistors and embedded ferroelectric capacitors formed according to methods of the present disclosure minimizes changes to the CMOS process

flow, reducing cost of fabricating ferroelectric random access memories (F-RAM), lowering defect density and enabling tighter design rules.

[0007] In one embodiment, the method includes forming over a first dielectric layer, a ferroelectric capacitor including a bottom electrode electrically coupled to a diffusion region of a MOS transistor through a first contact, a top electrode and ferroelectric layer there between. A second dielectric layer is formed overlying the ferroelectric capacitor and a second contact extending through the second dielectric layer from a top surface thereof to the top electrode of the ferroelectric capacitor. A local interconnect (LI) layer is deposited over the top surface of the second dielectric layer and electrically coupled to the second contact.

[0008] In another embodiment, the method includes forming on a surface of a substrate a gate level including a gate stack of a MOS transistor, a first dielectric layer overlying the MOS transistor and a first contact extending through the first dielectric layer from a top surface thereof to a diffusion region of the MOS transistor. A local interconnect (LI) layer is deposited over the top surface of the first dielectric layer and the first contact, a ferro stack including a bottom electrode, a top electrode and ferroelectric layer there between deposited over the LI layer, and the ferro stack and the LI layer patterned to form a ferroelectric capacitor and a LI through which the bottom electrode is electrically coupled to the diffusion region of the MOS transistor.

[0009] In yet another embodiment, the LI and the LI contact are formed using a dual-damascene process, lowering a total height of the ferro stack and resulting ferroelectric capacitor.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010] The present invention will be understood more fully from the detailed description that follows and from the accompanying drawings and the appended claims provided below, where:

[0011] FIG. 1 is a flowchart illustrating an embodiment of a method for fabricating a ferroelectric random access memory (F-RAM) including an embedded ferroelectric capacitor and metal-oxide-semiconductor (MOS) transistor;

[0012] FIGs. 2A-2I are block diagrams illustrating cross-sectional views of a portion of an F-RAM cell during fabrication thereof according to the method of FIG. 1;

[0013] FIG. 2J is a block diagram illustrating a cross-sectional views of a portion of an F-RAM cell fabricated according to the method of FIG. 1;

[0014] FIG. 3 is a flowchart illustrating another embodiment of a method for fabricating an F-RAM including an embedded ferroelectric capacitor and MOS transistor, in which a portion of a local interconnect forms a bottom electrode of the ferroelectric capacitor;

[0015] FIGs. 4A-4I are block diagrams illustrating cross-sectional views of a portion of an F-RAM during fabrication thereof according to the method of FIG. 3;

[0016] FIG. 4I is a block diagram illustrating a cross-sectional views of a portion of an F-RAM cell fabricated according to the method of FIG. 3;

[0017] FIG. 5 is a flowchart illustrating yet another embodiment of a method for fabricating an F-RAM including an embedded ferroelectric capacitor and MOS transistor using a damascene or dual-damascene process;

[0018] FIGs. 6A-6M are block diagrams illustrating cross-sectional views of a portion of an F-RAM during fabrication thereof according to the method of FIG. 5; and

[0019] FIG. 7 is a block diagram illustrating a cross-sectional view of a portion of a completed F-RAM fabricated according to an alternate embodiment of the method of FIG. 5.

DETAILED DESCRIPTION

[0020] Embodiments of ferroelectric random access memories (F-RAM) including embedded or integrally formed ferroelectric capacitors and complementary metal-oxide-semiconductor (CMOS) transistors and methods of fabricating the same are described herein with reference to figures. However, particular embodiments may be practiced without one or more of these specific details, or in combination with other known methods, materials, and apparatuses. In the following description, numerous specific details are set forth, such as specific materials, dimensions and processes parameters etc. to provide a thorough understanding of the present invention. In other instances, well-known semiconductor design and fabrication techniques have not been described in particular detail to avoid unnecessarily obscuring the present invention. Reference throughout this specification to "an embodiment" means that a particular feature, structure, material, or characteristic described in connection with the embodiment is included in at least one embodiment of the invention. Thus, the appearances of the phrase "in an embodiment" in various places throughout this specification are not necessarily referring to the same embodiment of the invention. Furthermore, the

particular features, structures, materials, or characteristics may be combined in any suitable manner in one or more embodiments.

[0021] The terms "over," "under," "between," and "on" as used herein refer to a relative position of one layer with respect to other layers. As such, for example, one layer deposited or disposed over or under another layer may be directly in contact with the other layer or may have one or more intervening layers. Moreover, one layer deposited or disposed between layers may be directly in contact with the layers or may have one or more intervening layers. In contrast, a first layer "on" a second layer is in contact with that second layer. Additionally, the relative position of one layer with respect to other layers is provided assuming operations deposit, modify and remove films relative to a starting substrate without consideration of the absolute orientation of the substrate.

[0022] An embodiment of a method for integrating or embedding a ferroelectric capacitor into a standard or baseline CMOS process flow for fabricating an F-RAM will now be described in detail with reference to FIG. 1 and FIGs. 2A through 2J. FIG. 1 is a flowchart illustrating an embodiment of a method for fabricating a ferroelectric random access memory (F-RAM) including an embedded ferroelectric capacitor and metal-oxide-semiconductor (MOS) transistor. FIGs. 2A-2I are block diagrams illustrating cross-sectional views of a portion of an F-RAM cell during fabrication thereof according to the method of FIG. 1. FIG. 2J is a block diagrams illustrating a cross-sectional views of a portion of a completed F-RAM cell fabricated according to the method of FIG. 1

[0023] Referring to FIG. 1 and FIG. 2A, the process begins with planarizing surfaces of first contact plugs or contacts **202** and an inter-metal dielectric or first dielectric layer **204** after formation of a gate level **206** on a surface **208** of a substrate

210, the gate level including gate stacks **212** of one or more metal-oxide-semiconductor (MOS) transistors **214**, separated by one or more isolation structures **216** the first dielectric layer overlying the MOS transistors and the first contacts extending through the first dielectric layer from a top surface **218** thereof to a diffusion region **220**, such as a source or a drain, in the MOS transistor in the substrate (block **102**).

[0024] In addition to a source and a drain, diffusion regions **220** can include a channel region (not shown in this figure). Generally, the substrate **210** and, hence, diffusion regions **220**, may be composed of any material suitable for semiconductor device fabrication. In one embodiment, the substrate **210** is a bulk substrate composed of a single crystal of a material which may include, but is not limited to, silicon, germanium, silicon-germanium or an III-V compound semiconductor material. In another embodiment, the substrate **210** includes a bulk layer with a top epitaxial layer. In a specific embodiment, the bulk layer is composed of a single crystal of a material which may include, but is not limited to, silicon, germanium, silicon-germanium, a III-V compound semiconductor material and quartz, while the top epitaxial layer is composed of a single crystal layer which may include, but is not limited to, silicon, germanium, silicon-germanium and a III-V compound semiconductor material. The top epitaxial layer is composed of a single crystal layer which may include, but is not limited to, silicon (i.e. to form a silicon-on-insulator (SOI) semiconductor substrate), germanium, silicon-germanium and an III-V compound semiconductor material. The insulator layer is composed of a material which may include, but is not limited to, silicon dioxide, silicon nitride and silicon oxy-nitride. The lower bulk layer is composed of a single crystal

which may include, but is not limited to, silicon, germanium, silicon-germanium, an III-V compound semiconductor material and quartz.

[0025] The substrate **210** and, hence, the channel region, may include dopant impurity atoms. In a specific embodiment, channel region is doped P-type and, in an alternative embodiment, channel region is doped N-type. Source and drain diffusion regions **220** in the substrate **210** have opposite conductivity to channel region. For example, in one embodiment the substrate **210** and, hence, channel region, is composed of boron-doped single-crystal silicon having a boron concentration in the range of 1×10^{15} - 1×10^{19} atoms/cm³. Source and drain diffusion regions **220** are composed of phosphorous- or arsenic-doped regions having a concentration of N-type dopants in the range of 5×10^{16} - 5×10^{19} atoms/cm³. Generally, source and drain diffusion regions **220** have a depth in the substrate **210** in the range of 80-200 nanometers (nm). In accordance with an alternative embodiment of the present disclosure, source and drain diffusion regions **220** are P-type doped regions while the substrate **210** and channel region is an N-type doped region.

[0026] The gate stacks **212** can include a gate oxide **222** formed on the surface **208** of the substrate **210**, a gate layer **224** formed on gate oxide, and one or more sidewall spacers **226** isolating the gate layer from the first dielectric layer **204**. Additionally, although not shown in this figure it will be understood by those skilled in the art that the gate layer **224** is generally electrically coupled to an overlying local interconnect (LI) or a metallization layer, such as a first metallization (M1) layer described in more detail below.

[0027] The first dielectric layer **204** can include a single layer of dielectric

material or multiple layers of dielectric material as in the embodiment shown. For example, in one embodiment the first dielectric layer **204** includes a lower or bottom first dielectric layer **204a** including phosphosilicate glass (PSG) formed or deposited by a chemical vapor deposition (CVD) process, such as plasma, low pressure or atmospheric CVD, and an upper or top first dielectric layer **204b** including a silicon oxide, deposited by low pressure CVD (LPCVD) tool using tetraethyl-orthosilicate (TEOS) based process gas or precursors.

[0028] The first contacts **202** are formed by performing a contact etch to etch the first dielectric layer **204** exposing the underlying diffusion regions **220** followed by filling the openings formed with a conductive material, typically a refractory metal. The contact etch can be accomplished using standard photolithographic techniques and any suitable wet or dry etching chemistry for etching a silicon oxide and/or PSG. Suitable contact etch chemistries can include, for example, wet etching using hydrofluoric acid (HF), or gas phase etching (GPE) using a reactive ion etch (RIE) process gas including HF and methanol or methyl alcohol (CH₃OH). Contact openings formed in the first dielectric layer **204** are filled with a refractory metal. By refractory metals it is meant metals of elements of the groups 4, 5 and 6 of the periodic table, including titanium (Ti), tantalum (Ta), tungsten (W), and nitrides or alloys thereof, which are resistant to high temperatures. The refractory metal can be deposited, for example, by physical vapor deposition, such as sputtering or evaporation, or by CVD and electroless plating.

[0029] As indicated in step or block **102** of FIG. 1, once formed the surfaces of the first contacts **202** and first dielectric layer **204** are planarized, for example, using a chemical mechanical polishing (CMP) process.

[0030] Next, referring to FIG. 1 and FIG. 2B layers of a ferro stack from which a ferroelectric capacitor will be formed are deposited or formed over the planarized surfaces of the first contacts **202** and first dielectric layer **204** (block **104**). Generally, the ferro stack layers includes a layer of a ferroelectric material, such as a lead zirconate titanate (PZT) ferroelectric layer **228**, between a top electrode **230** and bottom electrode **232** in electrical contact with or electrically coupled to one of the underlying first contacts **202**. In some embodiment, such as that shown, the ferro stack can further include an oxygen (O₂) barrier **234**. The O₂ barrier **234** can include a layer of titanium aluminum nitride (TiAlN) or aluminum titanium nitride (AlTiN) having a thickness of from about 0.03 to about 0.10 μm , and is deposited or formed using any suitable deposition method, such as CVD, atomic layer deposition (ALD), or physical vapor deposition (PVD). The top and the bottom electrodes **230**, **232**, can include one or more layers of iridium or iridium oxide having a thickness of from about 0.05 to about 0.20 μm , and deposited or formed using CVD, ALD or PVD. In the embodiment shown the top electrode **230** is a multi-layer top electrode including, for example, a lower layer of iridium oxide (IrO₂) in contact with the PZT ferroelectric layer **228** and an upper layer of iridium (Ir) overlying the lower layer of the top electrode. The PZT ferroelectric layer **228** is deposited on the bottom electrode **232** to a thickness of from about 0.04 to about 0.10 μm , using CVD, ALD or PVD.

[0031] Referring to FIG. 1 and FIG. 2C a hard mask **236** is formed over the ferro stack layers and the ferro stack layers patterned using a patterned hardmask and standard etching technologies to form a ferroelectric capacitor **238** (block **106**). In certain embodiments, the hard mask **236** can include multiple layers and the material of the hard

mask is selected to form a hydrogen (H_2) barrier, and is left on the ferro stack layers after forming the ferroelectric capacitor **238**. The hard mask **236** can include, for example, a layer of titanium aluminum nitride (TiAlN) having a thickness of from about 0.15 to about 0.20 μm , and deposited or formed using a PVD process. Suitable chemistries and techniques for etching the ferro stack layers can include standard metal etch chemistries.

[0032] Next, referring to FIG. 1 and FIG. 2D further layers of an H_2 barrier **240** is deposited over the top and sidewalls of the ferroelectric capacitor **238** and over the surface **218** of first dielectric layer **204** and any exposed first contact **202**, substantially encapsulating the ferroelectric capacitor (block **108**). It has been observed that when the ferroelectric capacitor **238** is exposed to hydrogen introduced, for example during subsequent processing the properties of the ferroelectric capacitor can be severely degraded. The H_2 barrier **240** can include a single material layer, or multiple material layers. In one embodiment, such as that shown, the H_2 barrier **240** can include a lower or first hydrogen encapsulation layer **240a** of aluminum oxide (Al_2O_3) having a thickness of from about 100 to about 300 Å, and deposited by ALD, and an upper or second hydrogen encapsulation layer **240b** of silicon nitride (SiN) having a thickness of from about 0.02 to about 0.10 μm , and deposited by CVD or ALD.

[0033] Referring to FIG. 1 and FIG. 2E, a first inter-level dielectric (ILD) layer **242** is deposited or formed over the H_2 barrier **240**, the ILD layer is planarized and openings **244** for second or ferro contacts etched through the ILD layer and H_2 barrier to the hard mask **236** to electrically couple to the top electrode **230** of the ferroelectric capacitor **238**, and to any exposed first contact **202** (block **110**). The ILD layer **242** can include one or more layers of an undoped oxide, such as silicon-dioxide (SiO_2), a nitride,

such as silicon nitride (Si_xN_y), a silicon-oxynitride ($\text{Si}_x\text{O}_y\text{N}_z$) or, as with the inter-metal or first dielectric layer **204** described above an oxide, such as phosphosilicate glass (PSG). For example, in one embodiment the ILD layer **242** can include a SiO_2 having a thickness of from about 0.60 to about 0.80 μm , by deposited by LPCVD using TEOS.

[0034] As indicated in step or block **110** of FIG. 1, once formed the surface of the ILD layer **242** is planarized using, for example, a CMP process, and openings **244** for second or ferro contacts etched through the ILD layer and H_2 barrier **240** using standard photolithographic and contact etching techniques. For an SiO_2 ILD layer **242** suitable contact etching techniques can include forming a patterned photoresist layer, and etching the ILD layer with an etch chemistry comprising carbon-monoxide (CO), argon (Ar), octafluorocyclobutane (C_4F_8) or Freon[®] 318, and, optionally, nitrogen (N_2).

[0035] Next, referring to FIG. 1 and FIG. 2F ferro contact openings **244** are filled to form second or ferro contacts **246**, and a local interconnect (LI) layer deposited, masked and etched to form a LI **248** over the ferro contacts and the surface of the ILD layer **242** (block **112**). As with the first contacts **202** described above, the ferro contacts **246** are formed by filling the contact openings with a refractory metal, such as titanium (Ti), tantalum (Ta), tungsten (W), and nitrides or alloys thereof, by physical vapor deposition, such as sputtering, evaporation or CVD. After filling the first contact openings the contacts are planarized using, for example, a CMP process. The LI **248** is formed by depositing a LI layer (not shown in this figure) including one or more layers of titanium (Ti) or titanium nitride (TiN) having a thickness of from about 850 to about 1150 Å formed over the ferro contacts and the ILD layer **242** using CVD, ALD or PVD, and patterning the LI layer using standard photolithographic and etching techniques. For

example, a Ti/TiN LI layer can be dry etched using a mixture of a fluorine based gas, such as sulfur hexafluoride (SF₆), nitrogen trifluoride (NF₃) or tetrafluoromethane (CF₄), a chlorine based gas, such as chlorine (Cl₂) or Boron Trichloride (BCl₃), and, optionally, an argon gas to increase the etch rate by sputtering.

[0036] Referring to FIG. 1 and FIG. 2G, the LI **248** is covered or encapsulated by local interconnect nitride layer (LINIT **250**) to isolate and protect the LI in subsequent processing steps (block **114**). The LINIT **250** can include a layer of silicon nitride (SiN) deposited by CVD or ALD to a thickness of about 850Å.

[0037] Next, referring to FIG. 1 and FIG. 2H a second ILD layer **252** is deposited or formed over the LINIT **250**, planarized and openings for third or LI contacts (LICON **254**) etched through the second ILD layer and the LINIT to the LI **248** to electrically couple to the top electrode **230** of the ferroelectric capacitor **238**, and to any exposed ferro contacts **246** (block **116**). As with the first ILD layer **242** described above the second ILD layer **252** can include one or more layers of SiO₂, a silicon nitride, a silicon-oxynitride, or PSG, deposited to a thickness of from about 0.35 to about 0.38 μm by CVD or LPCVD. As with the first contacts **202** and the ferro contacts **246** described above, the local interconnect contacts or LICON **254** are formed by filling the contact openings with titanium (Ti), tantalum (Ta), tungsten (W), and nitrides or alloys thereof, by sputtering, evaporation, CVD or electroless plating. After filling the contact openings the contacts are planarized using, for example, a CMP process.

[0038] Referring to FIG. 1 and FIG. 2I, a metal layer is deposited over the second ILD layer **252** and LICON **254**, masked and etched to form a first metallization (M1) layer **256** (block **118**). Generally, the metal layer includes aluminum, copper or alloys

or mixtures thereof, and is deposited by PVD, such as sputtering, evaporation, or electroless plating to a thickness of from about 1000 to about 5000 Å. The metal layer is patterned to form the M1 layer **256** using standard photolithographic and metal etching techniques, including for example, high density plasma (HDP) etching, and various post-metal etch cleaning processes to prevent corrosion defects.

[0039] Next, a third ILD layer **258** is deposited over M1 layer **256**, masked, etched and openings formed in the third ILD layer filled to form fourth or M1 layer contacts **260** in a substantially complete F-RAM cell (block **120**). FIG. 2J is a block diagram illustrating a cross-sectional view of a portion of a complete F-RAM cell fabricated according to the method of FIG. 1. As with the first and second ILD layers **242**, **252**, described above the third ILD layer **258** can include one or more layers of SiO₂, silicon nitride, silicon-oxynitride, or PSG, deposited to a thickness of from about 0.50 to about 0.78 μm by CVD or LPCVD. The contact openings are formed using a standard contact or oxide etch, and the fourth or M1 layer contacts **260** are formed by filling the contact openings with titanium (Ti), tantalum (Ta), tungsten (W), and nitrides or alloys thereof, by sputtering, evaporation, CVD or electroless plating. After filling the contact openings the contacts are planarized using, for example, a CMP process.

[0040] It will be understood by those skilled in the art that the embodiment of a method of manufacturing or fabricating an F-RAM cell including embedded or integrally formed ferroelectric capacitor and CMOS transistors described above advantageously minimizes changes to the standard complimentary metal-oxide-semiconductor (CMOS) process flow, including the addition of just two additional mask steps, thereby reducing cost of fabricating ferroelectric random access memories (F-RAM).

[0041] Another embodiment of a method for fabricating an F-RAM including an embedded ferroelectric capacitor and MOS transistor, in which a portion of a local interconnect forms a bottom electrode of the ferroelectric capacitor will now be described in detail with reference to FIGs. 3 and 4A through 4I.

[0042] Referring to FIG. 3 and FIG. 4A, the process begins with depositing a local interconnect (LI) layer **402** over a planarized surface of a gate level formed on a surface **404** of a substrate **406** (block **302**). As with the embodiment of FIG. 4A, the gate level includes an inter-metal dielectric or first dielectric layer **408** with gate stacks **410** of one or more metal-oxide-semiconductor (MOS) transistors **412** separated by one or more isolation structures **414**, and one or more first contact plugs or contacts **416** extending therethrough to diffusion regions **418**, such as a source or a drain, of the MOS transistor.

[0043] The first dielectric layer **408** can include a single layer of dielectric material or multiple layers of dielectric material as in the embodiment shown. For example, in one embodiment the first dielectric layer **408** includes a lower or bottom first dielectric layer **408a** including PSG formed or deposited by a CVD process, and an upper or top first dielectric layer **408b** including a silicon oxide, deposited by an LPCVD tool using a TEOS based process gas or precursor.

[0044] The LI layer **402** can include one or more layers of titanium (Ti) or titanium nitride (TiN) having a thickness of from about 800 to about 1200 Å formed over the first contacts **416** and the first dielectric layer **408** using CVD, ALD or PVD.

[0045] Next, referring to FIG. 3 and FIG. 4B ferro stack layers are deposited or formed over the LI layer **402** (block **304**). The ferro stack layers include a PZT ferroelectric layer **420**, between a top electrode **422** and bottom electrode **424** in electrical

contact with or electrically coupled through the LI layer **402** to one of the underlying first contacts **416**. In some embodiments, such as that shown, the bottom electrode **424** includes or consists of a portion of the LI layer **402**. The materials and thicknesses of the PZT ferroelectric layer **420**, top electrode **422** and bottom electrode **424** can be substantially the same as those described above with respect to FIG. 2B.

[0046] Optionally, in an embodiment not shown, the ferro stack can further include a separate layer as an O₂ barrier formed over the LI layer **402** prior to depositing the PZT ferroelectric layer **420**, or, as in the embodiment shown, the LI layer can include a material selected to form an O₂ barrier.

[0047] Referring to FIG. 3 and FIG. 4C a hard mask **426** is formed over the ferro stack layers using standard photolithographic and etching techniques, and the ferro stack layers etched using the hard mask to stop on the LI layer **402**(block **306**).

[0048] Next, referring to FIG. 3 and FIG. 4D a LI mask (not shown in this figure) is formed over LI layer **402**, and the LI layer etched to form an oxygen (O₂) barrier **429** under the ferroelectric capacitor and a LI **430** over the first dielectric layer **408** (block **308**).

[0049] Referring to FIG. 3 and FIG. 4E a H₂ barrier **432** is deposited over the top and sidewalls of the ferroelectric capacitor **428**, over the surface of first dielectric layer **408** and any exposed LI **430**, substantially encapsulating the ferroelectric capacitor and LI (block **310**). The H₂ barrier **432** can include a single material layer, or multiple material layers including a lower or first hydrogen encapsulation layer **432a** and an upper or second hydrogen encapsulation layer **432b**. The materials, thicknesses and methods of depositing the hydrogen encapsulation layers are substantially the same as those

described above with respect to FIG. 2D.

[0050] Next, referring to FIG. 3 and FIG. 4F a first ILD layer **434** is deposited or formed over the H₂ barrier **432**, the first ILD layer is planarized and openings **436** for second or ferro contacts etched through the ILD layer and H₂ barrier to electrically couple to the top electrode **422** of the ferroelectric capacitor **428**, to the contact **416** to the diffusion regions of the MOS transistor(not shown in this figure), and to one or more portions of the LI **430** not covered by the ferroelectric capacitor (block **312**). The materials, thicknesses and methods of depositing and etching first ILD layer **434** and the H₂ barrier **432** are substantially the same as those described above with respect to FIG. 2E.

[0051] Referring to FIG. 3 and FIG. 4G, the ferro contact openings **436** are filled to form second or ferro contacts **438** (block **314**). The materials of the ferro contacts **438** and methods of filling ferro contact openings **436** are substantially the same as those described above with respect to FIG. 2F.

[0052] Next, referring to FIG. 3 and FIG. 4H a metal layer is deposited over the first ILD layer **434** and masked and etched to form a first metallization (M1) layer **440** (block **316**). The materials, thicknesses and methods of depositing and etching first metal layer to form the M1 layer **440** are substantially the same as those described above with respect to FIG. 2I.

[0053] A second ILD layer **442** may be deposited over M1 layer **440**, masked, etched and openings formed in the second ILD layer filled to form third or M1 layer contacts **444** in a substantially complete F-RAM cell (block **318**). FIG. 4I is a block diagram illustrating a cross-sectional view of a portion of a complete F-RAM cell

fabricated according to the method of FIG. 3. The materials, thicknesses of the second ILD layer as well as forming the third or M1 layer contacts **444** are substantially the same as those described above with respect to FIG. 2J. In particular, it is noted that as with the second ILD layer **442** can include one or more layers, including a first or lower second ILD layer **442a** including SiO₂, silicon nitride, silicon-oxynitride, or PSG, and a second or upper second ILD layer **442b** including a silicon oxide, deposited by an LPCVD tool using a TEOS based process gas or precursor.

[0054] It will be understood by those skilled in the art that the method of manufacturing or fabricating an F-RAM cell including embedded or integrally formed ferroelectric capacitor and CMOS transistors described above advantageously minimizes changes to the standard complimentary metal-oxide-semiconductor (CMOS) process flow, including the addition of just a single additional mask step to form the ferroelectric capacitor and the modification of another, i.e., the LI mask referred to in connection with the step described in block **308** and FIG. 4D, thereby further reducing cost of fabricating F-RAM, and enabling tighter design rules. It will further be understood that introducing the LI **430** below the ferroelectric capacitor **428** and utilizing a portion of the LI as the bottom electrode **424** enables tighter design rules.

[0055] In still another method for fabricating an F-RAM including an embedded ferroelectric capacitor and MOS transistor, a local interconnect (LI) and LI contacts are formed using a damascene or dual-damascene process. An embodiment of this method will now be described in detail with reference to FIG. 5 and FIG. 6A through 6M.

[0056] Referring to FIG. 5 and FIG. 6A, the process begins with depositing an undoped cap oxide (NCAPOX) layer **602** over a surface of a gate level **603** formed on a

surface **604** of a substrate **606** (block **502**). As with the embodiments of FIGs. 2A and 4A described above, the gate level **603** includes an inter-metal dielectric or first dielectric layer **608** with gate stacks **610** of one or more MOS transistors **612** separated by one or more isolation structures **614**, and one or more diffusion regions **618**, such as a source or a drain, of a MOS transistor.

[0057] The first dielectric layer **608** can include a single layer of dielectric material or multiple layers of dielectric material, such as PSG formed or deposited by a CVD process. The NCAPOX layer **602** can be deposited to a thickness of from about 1800 to about 2200 by CVD or ALD.

[0058] Next, referring to FIG. 5 the NCAPOX layer **602** and the first dielectric layer **608** are masked and etched to form openings for local interconnect (LI) contact (LICON) using a dual damascene process (block **504**). By a dual damascene process it is meant an iterative process for forming a multilevel structure in which several processing steps including, for example, forming a first mask and etching a first opening for the LICON through the NCAPOX layer **602** and the first dielectric layer **608**, followed by forming a second mask and etching a second opening, also referred to as a damascene trench, for the LI through the NCAPOX layer. Referring to FIG. 6B, an opening **620** for the LICON can be etched through the NCAPOX layer **602** and the first dielectric layer **608** using standard photolithographic techniques and any suitable wet or dry etching chemistry for etching a silicon oxide and/or PSG, as described above with respect to FIGs. 1 and 2A.

[0059] Referring to FIG. 6C, a second patterned mask, with a larger opening is then formed and a second etch selective to the material of the NCAPOX layer **602** is then

performed to etch second openings or damascene trenches **622** for the LI through the NCAPOX layer (block **506**).

[0060] Referring to FIG. 5 and FIG. 6D openings **620** for the LICON and damascene trenches **622** are filled to form a number of first or LICON **624** and the LI **626** (block **508**). It will be understood that while upper portions of the LICON **624** are formed from the same material as LI **626** and may have the same dimensions as portions of the LI, these upper portions of the LICON are not physically or electrically coupled to the LI and do not function as a part of the LI. Rather these LICON **624** underlie a subsequently formed ferroelectric capacitor and couple the ferroelectric capacitor to diffusion regions **618** of the MOS transistor **612**. As with the first contacts described above with respect to FIG. 2A, the LICON **624** and the LI **626** can be formed by filling the openings **620** for the LICON and damascene trenches **622** with a refractory metal, such as titanium (Ti), tantalum (Ta), tungsten (W), and nitrides or alloys thereof, by physical vapor deposition, such as sputtering or evaporation, or by CVD or electroless plating. In one embodiment, the LICON **624** and the LI **626** are formed by filling the openings **620** for the LICON and damascene trenches **622** with tungsten using a CVD process.

[0061] Next, referring to FIG. 5 and FIG. 6E ferro stack layers are deposited or formed over the surface of the first dielectric layer **608** and the LI **626** (block **510**). The ferro stack layers include a bottom electrode **628** in electrical contact with or electrically coupled through the LI **626** and one of the underlying LICON **624** to a diffusion region **618** of the MOS transistor **612**, a PZT ferroelectric layer **630** formed on the bottom electrode, and a single-layer or a multi-layer top electrode **632** formed on the PZT ferroelectric layer. The ferro stack can further include an O₂ barrier **634** formed or

deposited prior to depositing bottom electrode **628**. The O₂ barrier **634** is a separate layer of material formed over or on top of the LI **626**. The material of the LI **626** is tungsten (W) and generally can have dimensions or a thickness substantially the same as those described above with respect to FIG. 4B. The materials and thicknesses of the bottom electrode **628**, the PZT ferroelectric layer **630**, the top electrode **632**, and the O₂ barrier **634** can be substantially the same as those described above with respect to FIG. 4B.

[0062] Referring to FIG. 5 and FIG. 6F a hard mask **636** is formed over the ferro stack layers, and the ferro stack layers etched using a hard mask and standard etching techniques, such as those described above with respect to FIG. 4C, to stop on the O₂ barrier **634** (block **512**).

[0063] Next, referring to FIG. 5 and FIG. 6G a photoresist mask **638** is formed over the O₂ barrier **634**, and the O₂ barrier etched to form a ferroelectric capacitor **640** and LI **626** including the O₂ barrier formed thereon as shown in FIG. 6H (block **514**).

[0064] Referring to FIG. 5 and FIG. 6I, a H₂ barrier **642** is deposited over the top and sidewalls of the ferroelectric capacitor **640**, over the surface of first dielectric layer **608** and the O₂ barrier formed on the LI **626**, substantially encapsulating the ferroelectric capacitor and the LI (block **516**). The H₂ barrier **642** can include a single material layer, or multiple material layers including a lower or first hydrogen encapsulation layer **642a** and an upper or second hydrogen encapsulation layer **642b**. The materials, thicknesses and methods of depositing the hydrogen encapsulation layers are substantially the same as those described above with respect to FIGs. 2D and 4E.

[0065] Next, referring to FIG. 5 and FIG. 6J a first ILD layer **644** is deposited or formed over the H₂ barrier **642** (block **518**). The materials, thicknesses and methods of

depositing and etching first ILD layer **644** and the H₂ barrier **642** are substantially the same as those described above with respect to FIGs. 2E and 4F.

[0066] Referring to FIG. 5 and FIG. 6K the first ILD layer **644** is planarized and openings **646** for second or ferro contacts etched through the first ILD layer and H₂ barrier to electrically couple to the top electrode **632** of the ferroelectric capacitor **640**, and to one or more portions of the LI **626** not covered by the ferroelectric capacitor (block **520**). The methods of etching first ILD layer **644** and the H₂ barrier **642** are substantially the same as those described above with respect to FIGs. 2E and 4F.

[0067] Next, referring to FIG. 5 and FIG. 6L, the ferro contact openings **646** are filled to form second or ferro contacts **648** (block **520**). The materials of the ferro contacts **648** and methods of filling ferro contact openings **646** are substantially the same as those described above with respect to FIGs. 2F and 4G.

[0068] Next, referring to FIG. 5 and FIG. 6M a metal layer is deposited over the first ILD layer **644** and masked and etched to form a first metallization (M1) layer **650** (block **522**). The materials, thicknesses and methods of depositing and etching first metal layer to form the M1 layer **650** are substantially the same as those described above with respect to FIGs. 2I and 4H.

[0069] A second ILD layer **652** can be deposited over M1 layer **650**, masked, etched and openings formed in the second ILD layer filled to form third or M1 layer contacts **654** in a substantially complete F-RAM cell (block **524**). FIG. 6M is a block diagram illustrating a cross-sectional view of a portion of a complete F-RAM cell fabricated according to the method of FIG. 5. The materials, thicknesses of the second ILD layer as well as forming the third or M1 layer contacts **654** are substantially the same

as those described above with respect to FIG. 2J and 4I. In particular, it is noted that as with the second ILD layer **652** can include one or more layers, including a first or lower second ILD layer **652a** including SiO₂, silicon nitride, silicon-oxynitride, or PSG, and a second or upper second ILD layer **652b** including a silicon oxide, deposited by an LPCVD tool using a TEOS based process gas or precursor.

[0070] It will be understood by those skilled in the art that the method of manufacturing or fabricating an F-RAM cell including embedded or integrally formed ferroelectric capacitor and CMOS transistors using the dual damascene process described above advantageously minimizes changes to the standard CMOS process flow, thereby further reducing cost of fabricating F-RAM and enabling tighter design rules. It will further be understood that introducing the LI **626** below the surface of the NCAPOX layer **602** enables tighter design rules.

[0071] FIG. 7 is a block diagram illustrating a cross-sectional view of a portion of a completed F-RAM fabricated according to an alternate embodiment of the method of FIG. 5. Referring to FIG. 7, in this embodiment the forming of a photoresist mask is over the O₂ barrier **634** described with respect to the step of block **514** and FIG. 6G, is omitted and the O₂ barrier etched or removed from the LI **626** prior to the step of forming the H₂ barrier **642**.

[0072] Thus, embodiments of ferroelectric random access memories including embedded or integrally formed F-RAM capacitors and CMOS transistors and methods of fabricating the same have been described. Although the present disclosure has been described with reference to specific exemplary embodiments, it will be evident that various modifications and changes may be made to these embodiments without departing

from the broader spirit and scope of the disclosure. Accordingly, the specification and drawings are to be regarded in an illustrative rather than a restrictive sense.

[0073] The Abstract of the Disclosure is provided to comply with 37 C.F.R. §1.72(b), requiring an abstract that will allow the reader to quickly ascertain the nature of one or more embodiments of the technical disclosure. It is submitted with the understanding that it will not be used to interpret or limit the scope or meaning of the claims. In addition, in the foregoing Detailed Description, it can be seen that various features are grouped together in a single embodiment for the purpose of streamlining the disclosure. This method of disclosure is not to be interpreted as reflecting an intention that the claimed embodiments require more features than are expressly recited in each claim. Rather, as the following claims reflect, inventive subject matter lies in less than all features of a single disclosed embodiment. Thus, the following claims are hereby incorporated into the Detailed Description, with each claim standing on its own as a separate embodiment.

[0074] Reference in the description to one embodiment or an embodiment means that a particular feature, structure, or characteristic described in connection with the embodiment is included in at least one embodiment of the circuit or method. The appearances of the phrase one embodiment in various places in the specification do not necessarily all refer to the same embodiment.

IN THE CLAIMS**WHAT IS CLAIMED IS:**

1. A method comprising:

forming a gate level on a surface of a substrate, the gate level including a gate stack of a metal-oxide-semiconductor (MOS) transistor, a first dielectric layer overlying the MOS transistor and a first contact extending through the first dielectric layer from a top surface thereof to a diffusion region of the MOS transistor in the substrate;

depositing a local interconnect (LI) layer over the top surface of the first dielectric layer and the first contact;

depositing a ferro stack over the LI layer, the ferro stack including a bottom electrode electrically coupled to the LI layer, a top electrode and ferroelectric layer there between; and

patterning the ferro stack and the LI layer to form a ferroelectric capacitor and a LI through which the bottom electrode is electrically coupled to the diffusion region of the MOS transistor.
2. The method of claim 1, wherein the bottom electrode of the ferro stack comprises a portion of the LI layer.
3. The method of claim 2, wherein depositing the LI layer comprises depositing a material selected to form an oxygen (O₂) barrier.
4. The method of claim 2, further comprising encapsulating the ferroelectric

capacitor and the LI with an encapsulation layer.

5. The method of claim 4, wherein the encapsulation layer comprises multiple layers including a hydrogen (H_2) barrier comprising aluminum oxide (Al_2O_3) deposited over the ferroelectric capacitor and the LI.

6. The method of claim 5, wherein the encapsulation layer further comprises a nitride layer comprising silicon nitride over the H_2 barrier.

7. A method comprising:

forming a gate level on a surface of a substrate, the gate level including a gate stack of a metal-oxide-semiconductor (MOS) transistor and a first dielectric layer overlying the MOS transistor;

forming and filling a trench for a local interconnect (LI) and an opening for a LI contact in the first dielectric layer using a dual-damascene process, the LI contact extending through the first dielectric layer to a diffusion region of the MOS transistor in the substrate; and

forming a ferroelectric capacitor including a ferroelectric layer between a top electrode and bottom electrode, wherein the bottom electrode overlies the LI, and is electrically coupled to the diffusion region of the MOS transistor through the LI and LI contact.

8. The method of claim 7, further comprising encapsulating the ferroelectric

capacitor and the LI with an encapsulation layer.

9. The method of claim 8, wherein the encapsulation layer comprises multiple layers including a hydrogen (H_2) barrier comprising aluminum oxide (Al_2O_3) deposited over the ferroelectric capacitor and the LI.

10. The method of claim 9, wherein the encapsulation layer further comprises a nitride layer comprising silicon nitride over the H_2 barrier.

11. The method of claim 7, further comprising forming an oxygen (O_2) barrier over the LI prior to forming the ferroelectric capacitor.

12. The method of claim 7, wherein forming and filling the trench for the LI and comprises depositing a layer of material on top of the LI selected to form an oxygen (O_2) barrier.

13. The method of claim 7, wherein forming and filling the trench for the LI and opening for the LI contact comprises filling the trench for the LI and the opening for the LI contact with tungsten (W).

14. A method comprising:

forming a gate level on a surface of a substrate, the gate level including a gate stack of a metal-oxide-semiconductor (MOS) transistor, a first dielectric layer overlying

the MOS transistor and a first contact extending through the first dielectric layer from a top surface thereof to a diffusion region of the MOS transistor in the substrate;

forming a ferroelectric capacitor over the first dielectric layer, the ferroelectric capacitor including a bottom electrode electrically coupled to the diffusion region of the MOS transistor through the first contact, a top electrode and ferroelectric layer there between;

forming a second dielectric layer overlying the ferroelectric capacitor and a second contact extending through the second dielectric layer from a top surface thereof to the top electrode of the ferroelectric capacitor; and

depositing a local interconnect (LI) layer over the top surface of the second dielectric layer and electrically coupled to the second contact.

15. The method of claim 14, further comprising encapsulating the ferroelectric capacitor with an encapsulation layer.

16. The method of claim 15, wherein the encapsulation layer comprises multiple layers including a hydrogen (H_2) barrier comprising aluminum oxide (Al_2O_3) deposited over the ferroelectric capacitor.

17. The method of claim 16, wherein the encapsulation layer further comprises a nitride layer comprising silicon nitride over the H_2 barrier.

18. The method of claim 14, further comprising forming an oxygen (O_2)

barrier over the first contact prior to forming the ferroelectric capacitor.

19. The method of claim 14, further comprising encapsulating the LI layer with a local interconnect nitride layer.

20. The method of claim 19, further comprising forming a third dielectric layer overlying the ferroelectric capacitor and a third contact extending through the third dielectric layer from a top surface thereof to the LI layer.

21. The method of claim 20, further comprising forming a metal 1 (M1) layer on the third dielectric layer, wherein the M1 layer electrically couples to the LI layer through the third contact.

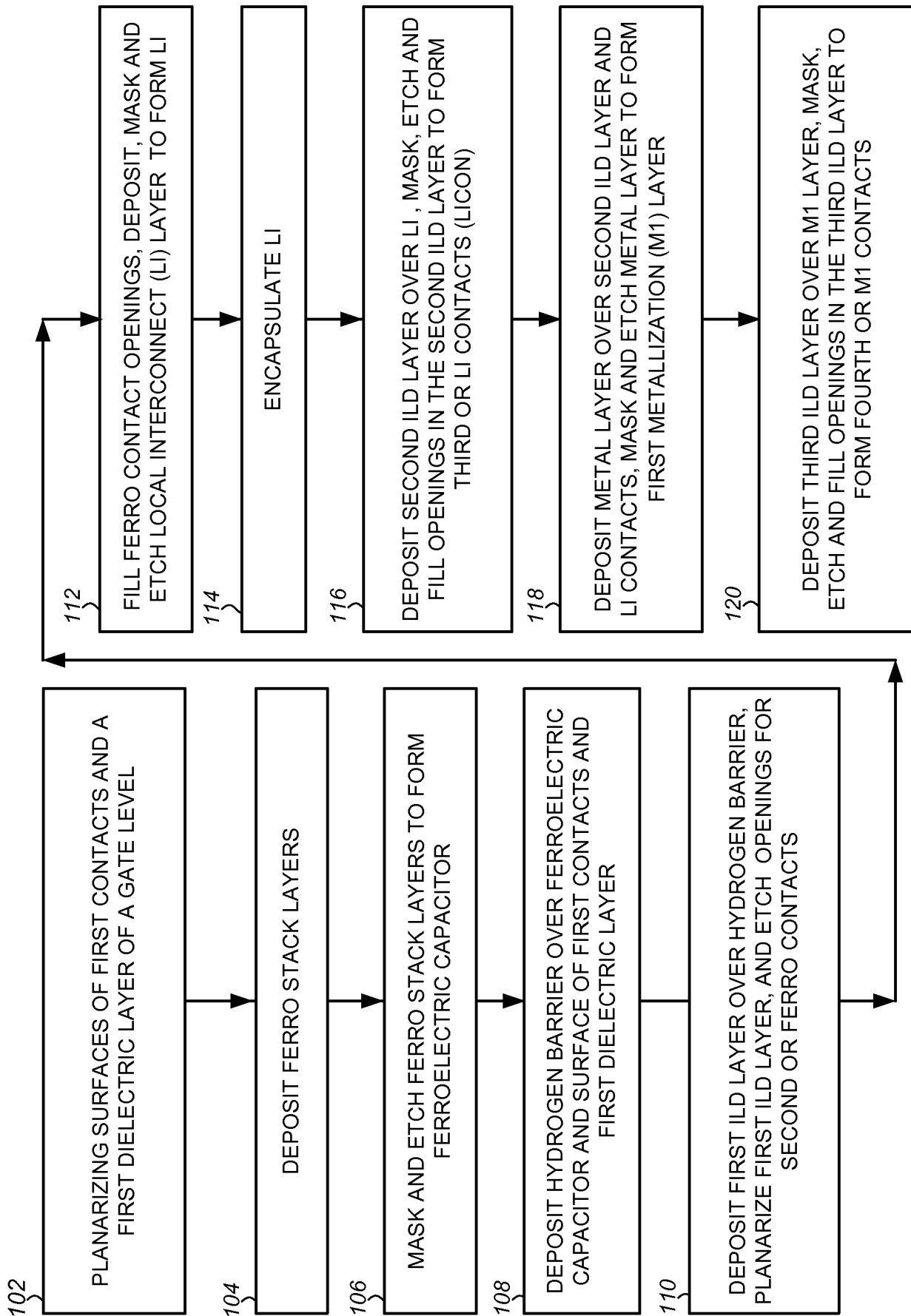


FIG. 1

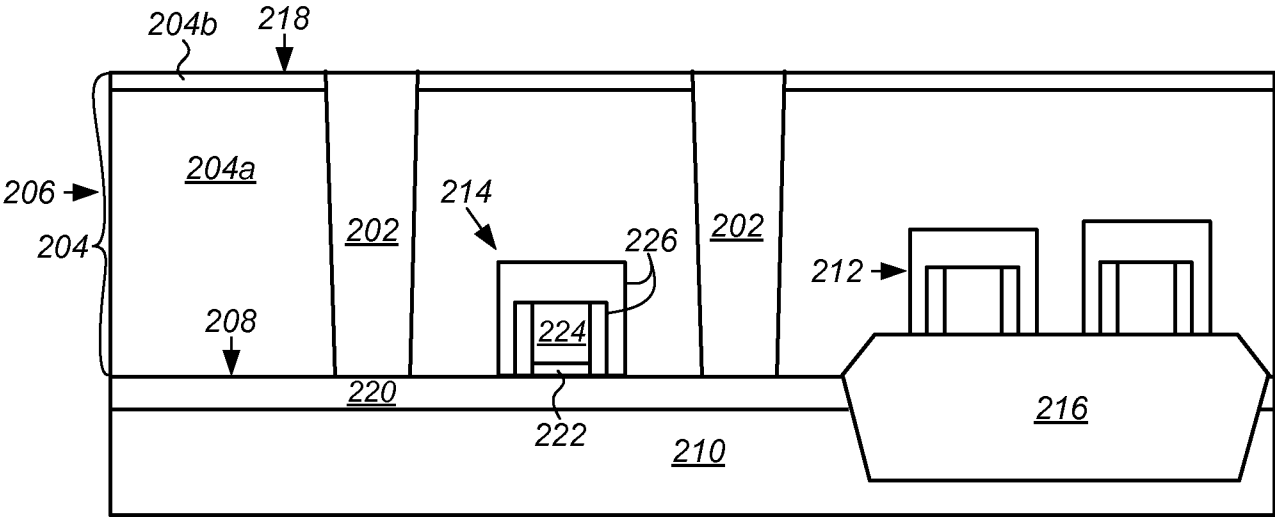


FIG. 2A

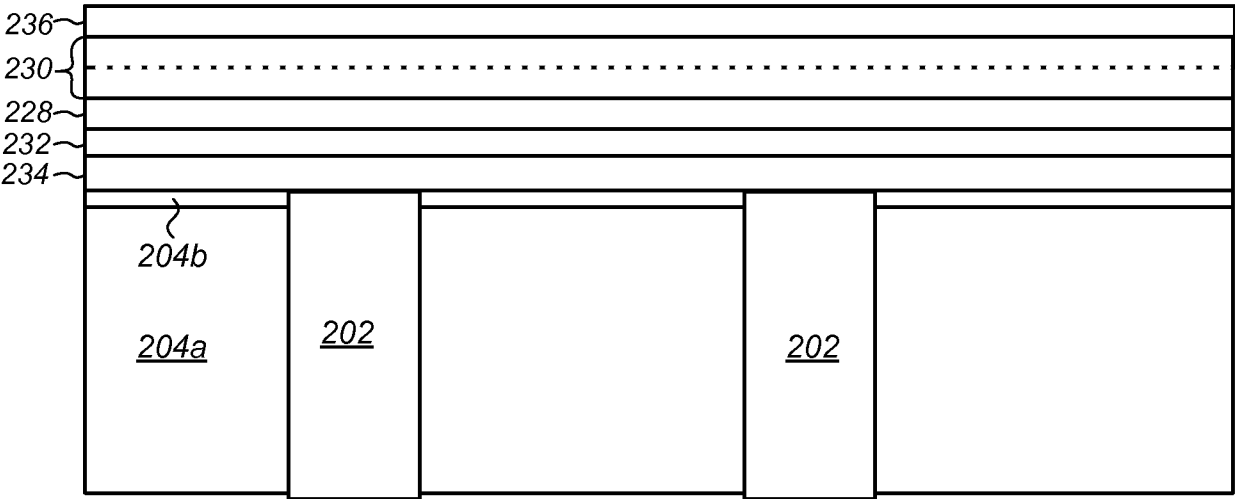


FIG. 2B

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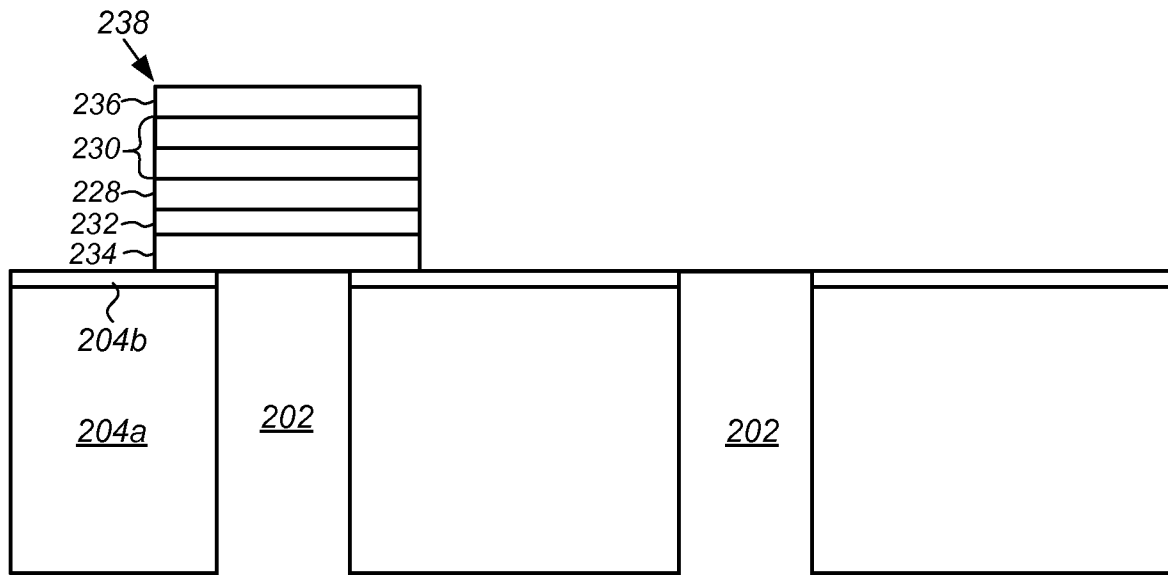


FIG. 2C

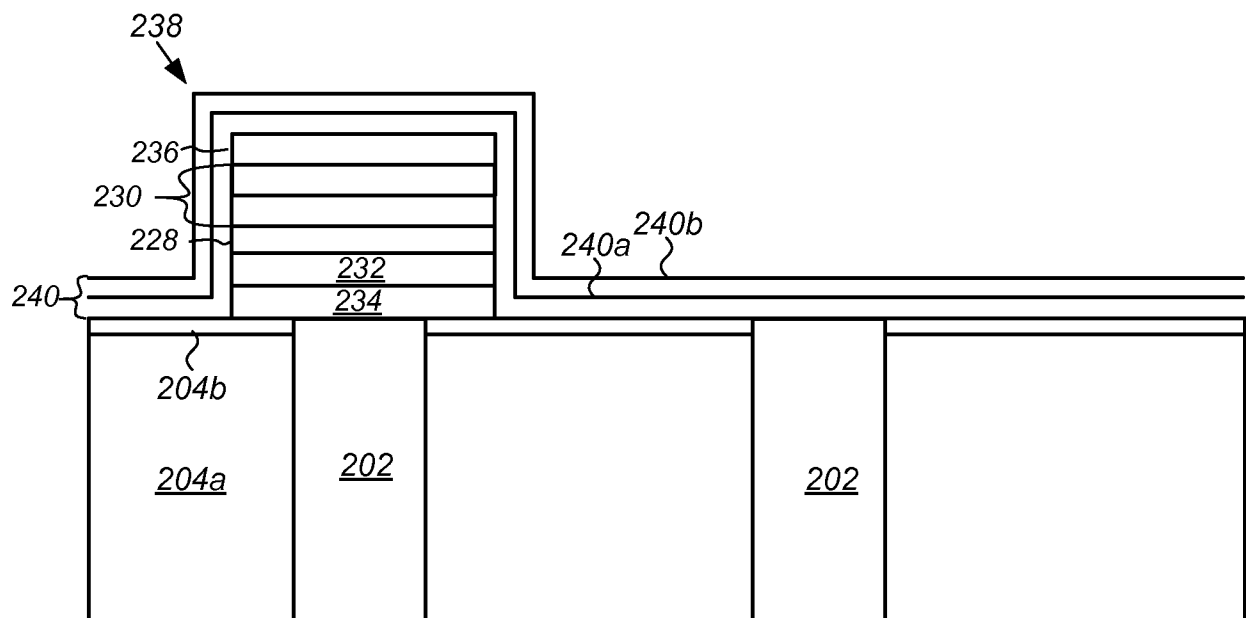


FIG. 2D

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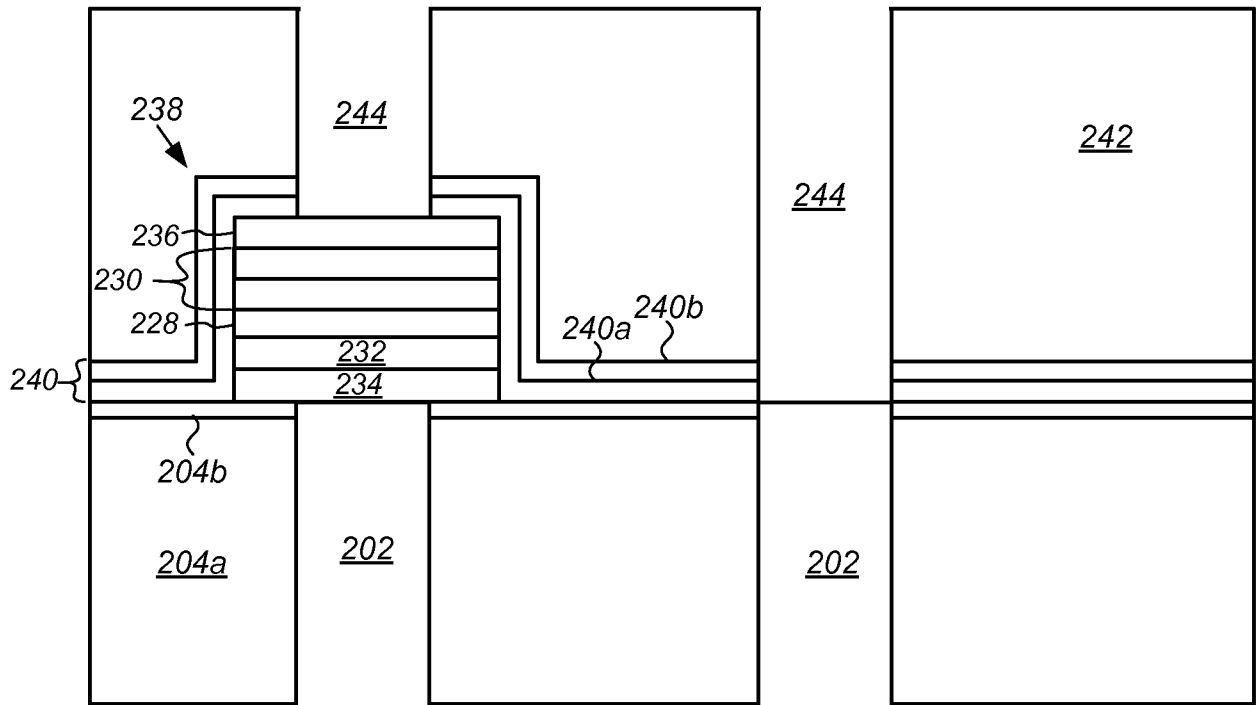


FIG. 2E

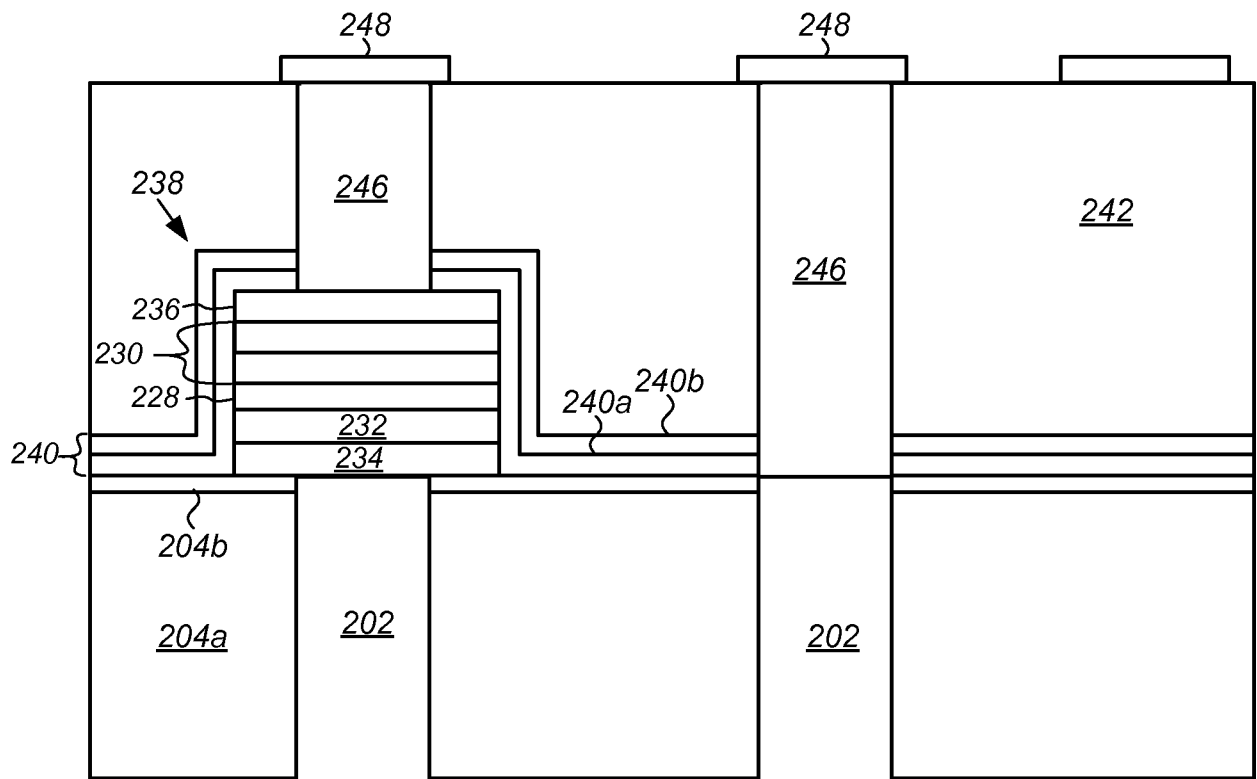


FIG. 2F

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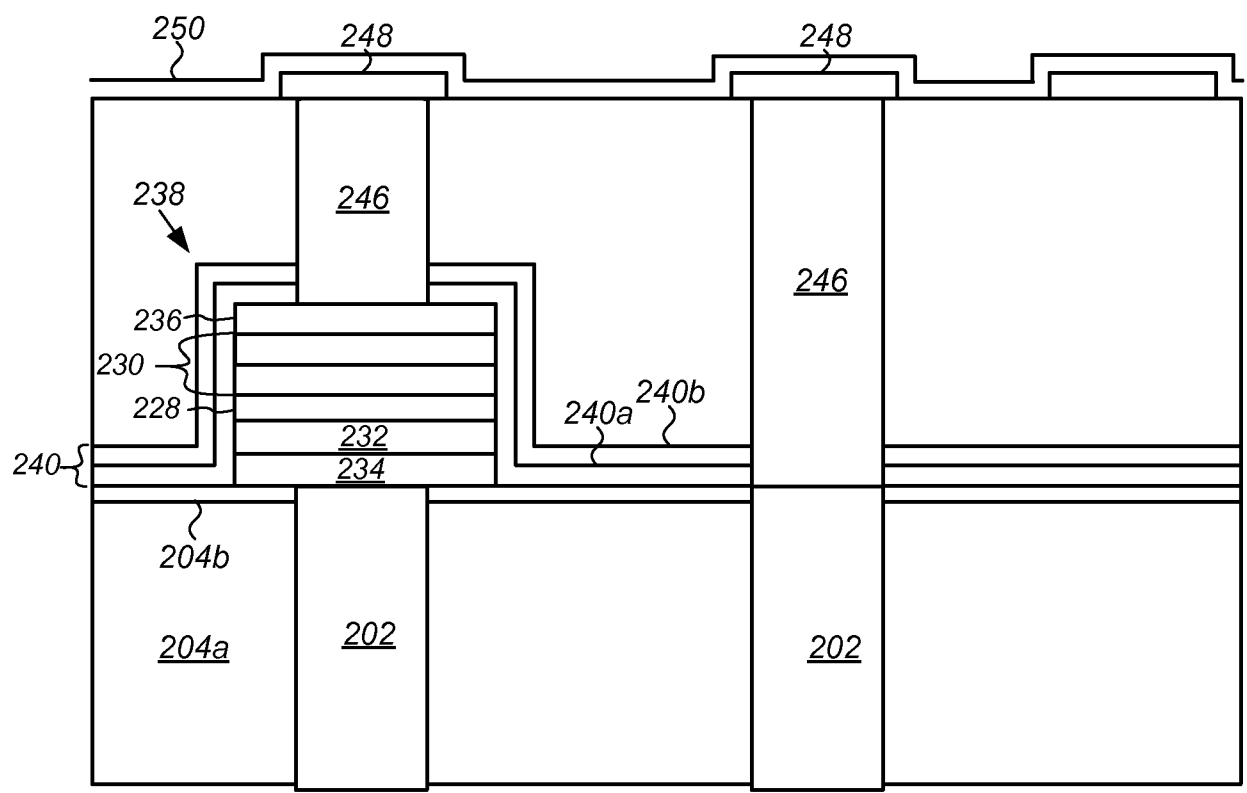


FIG. 2G

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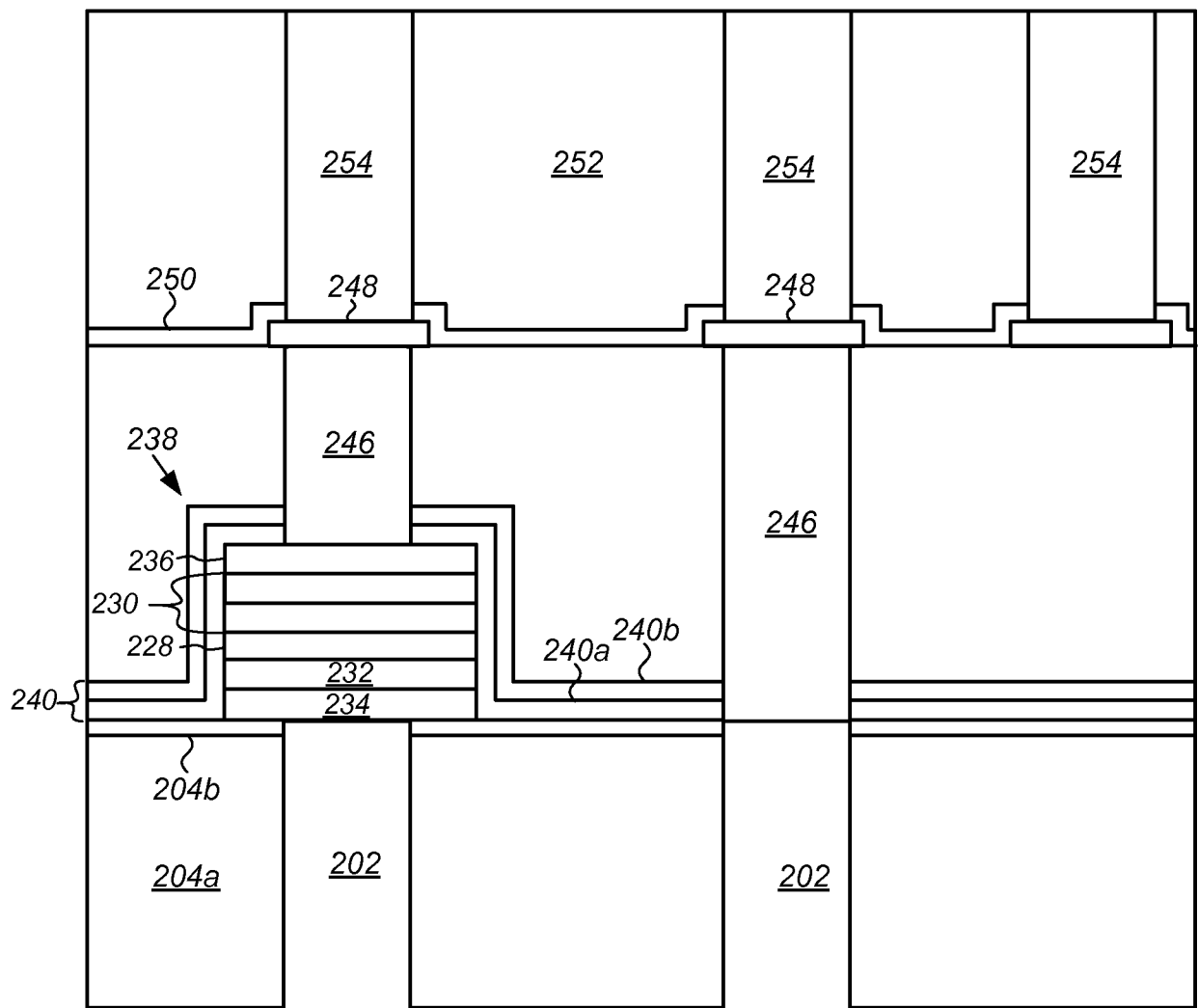


FIG. 2H

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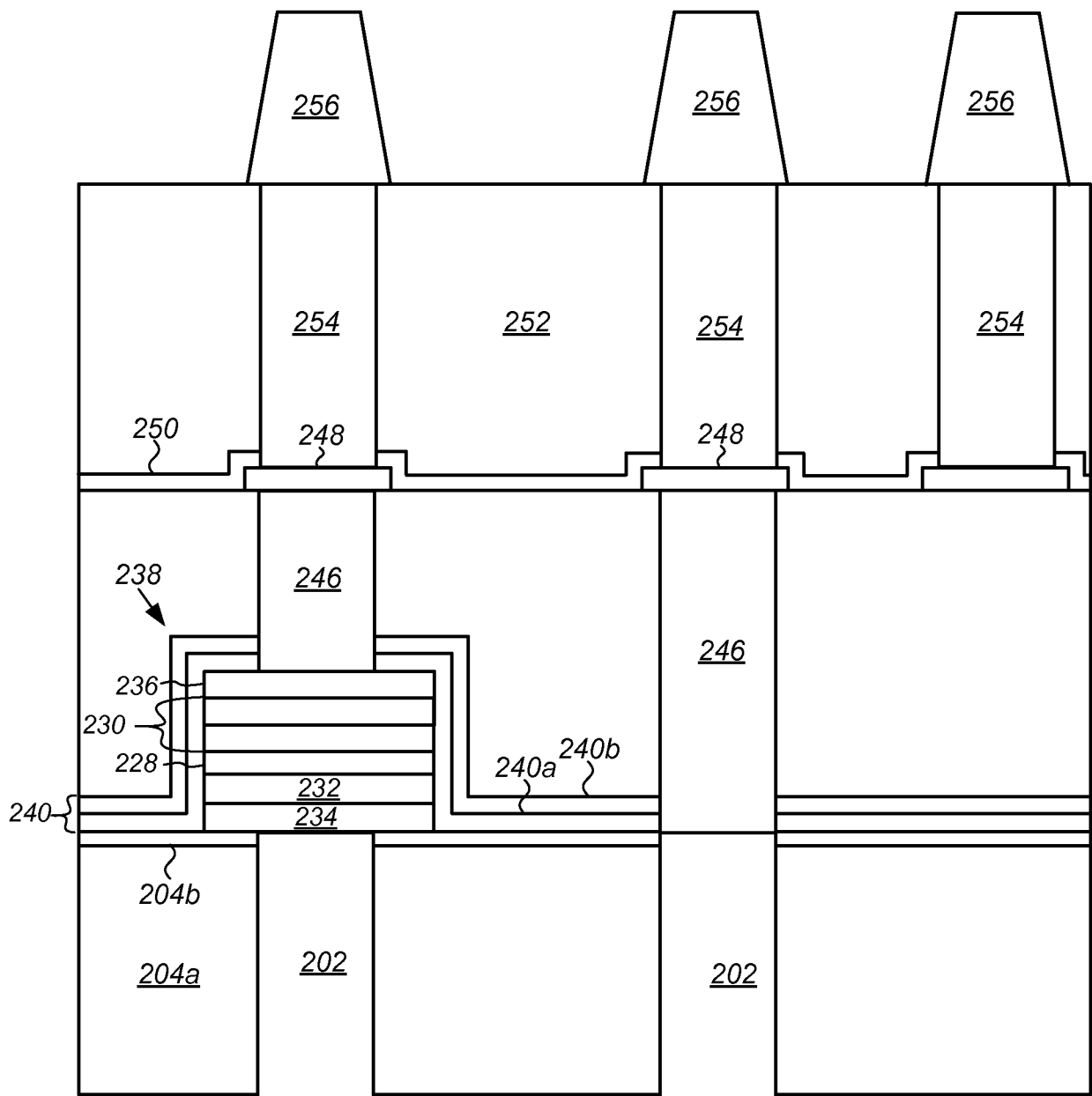


FIG. 2I

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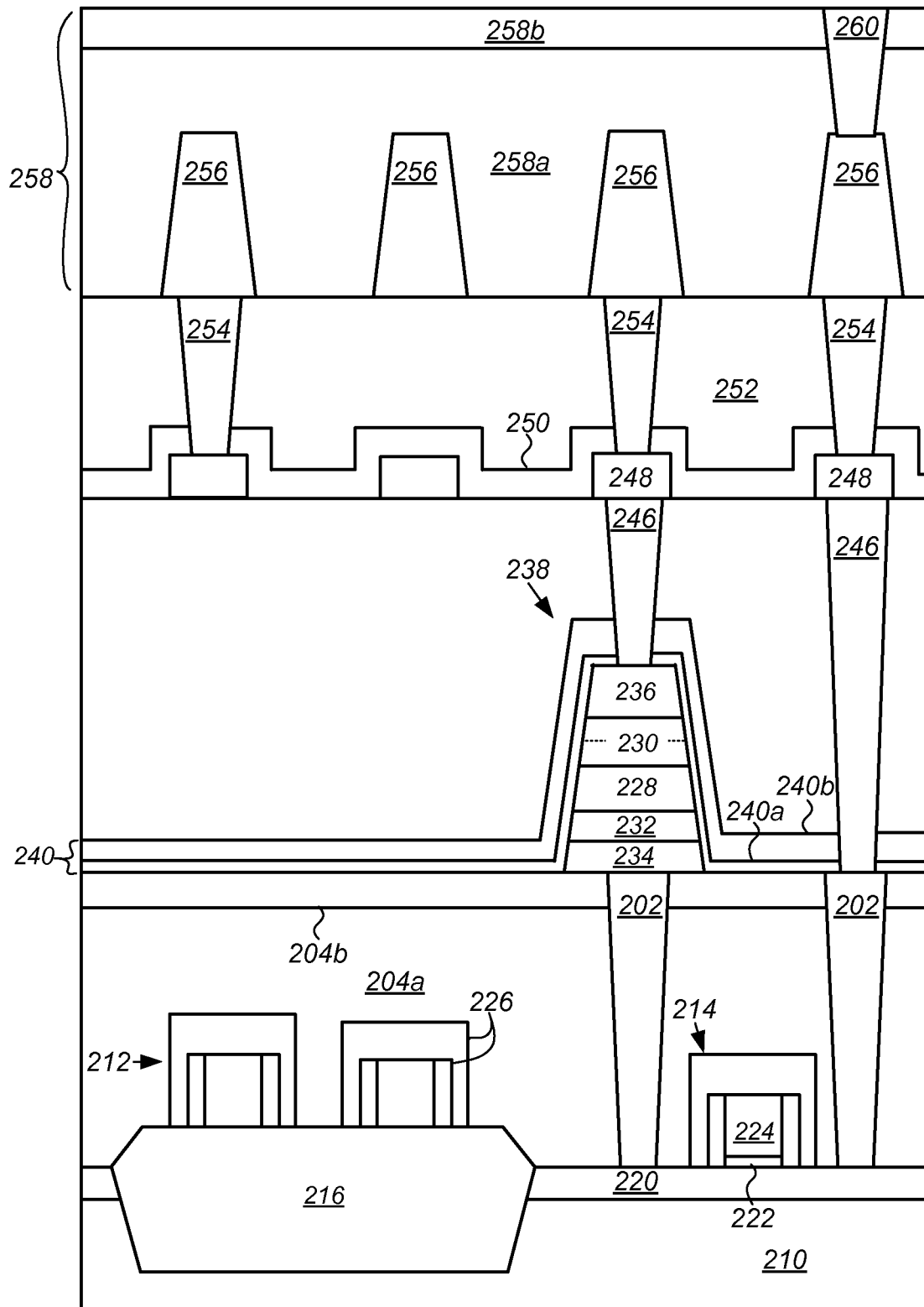


FIG. 2J

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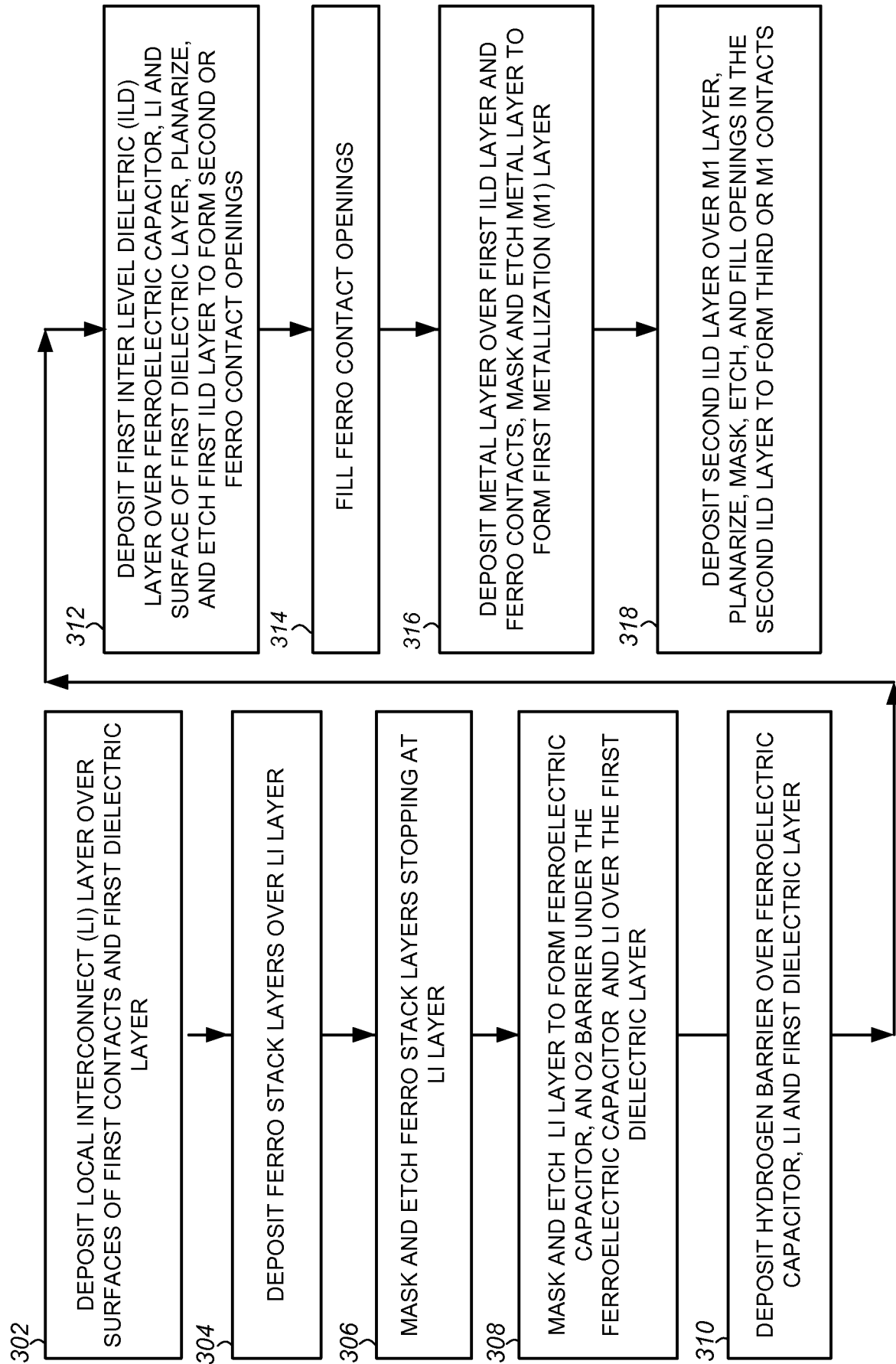


FIG. 3

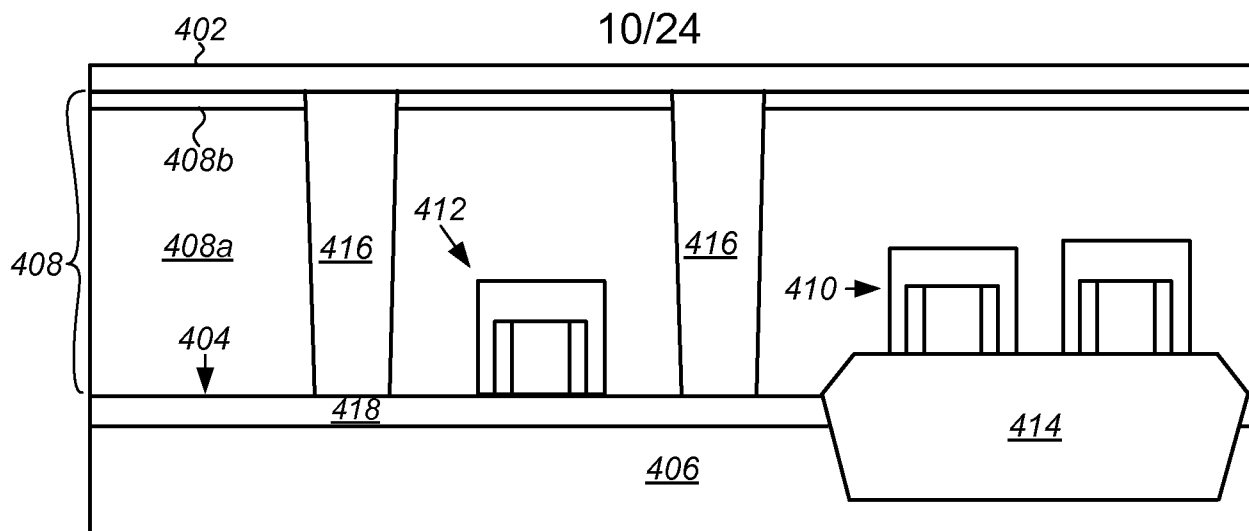


FIG. 4A

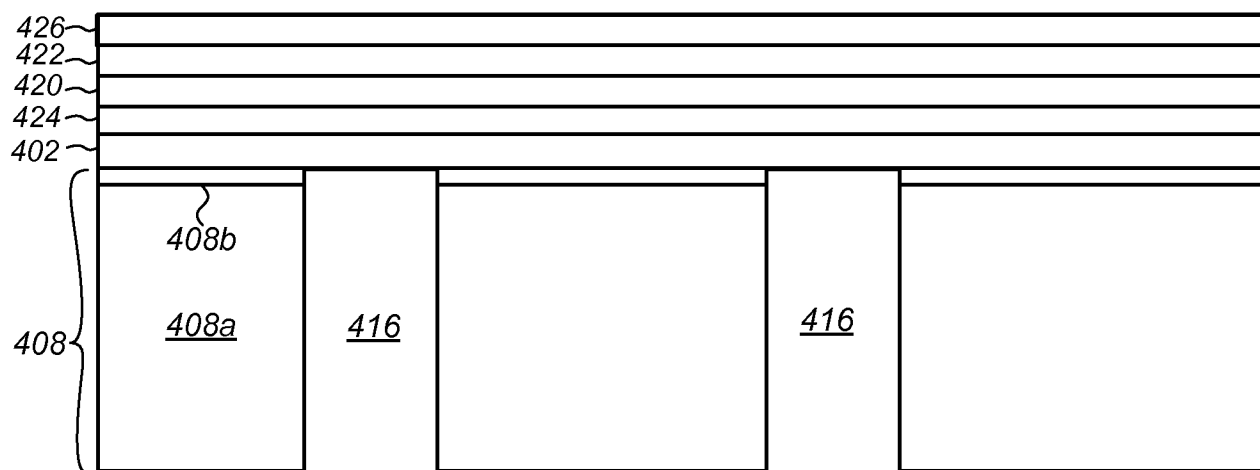


FIG. 4B

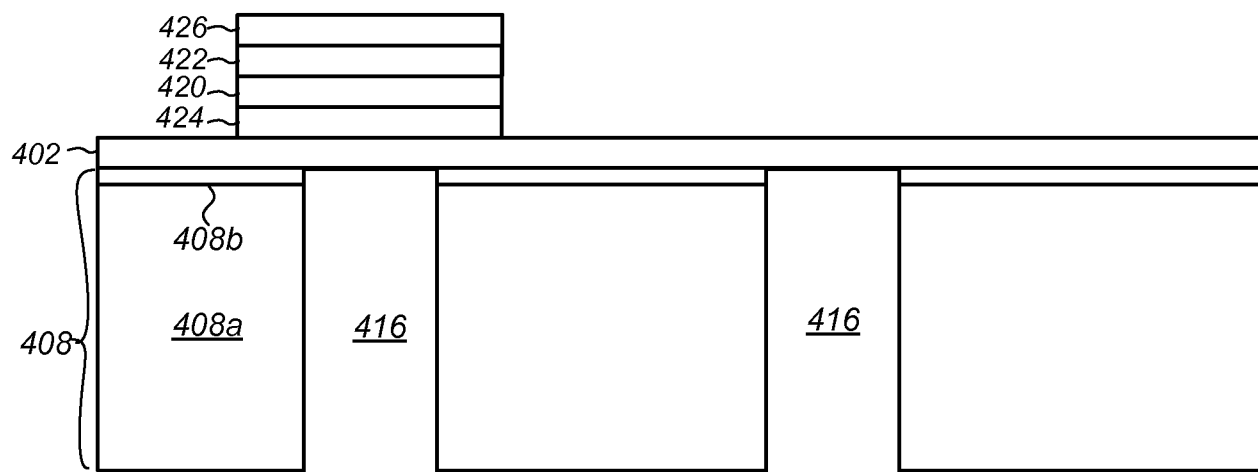


FIG. 4C

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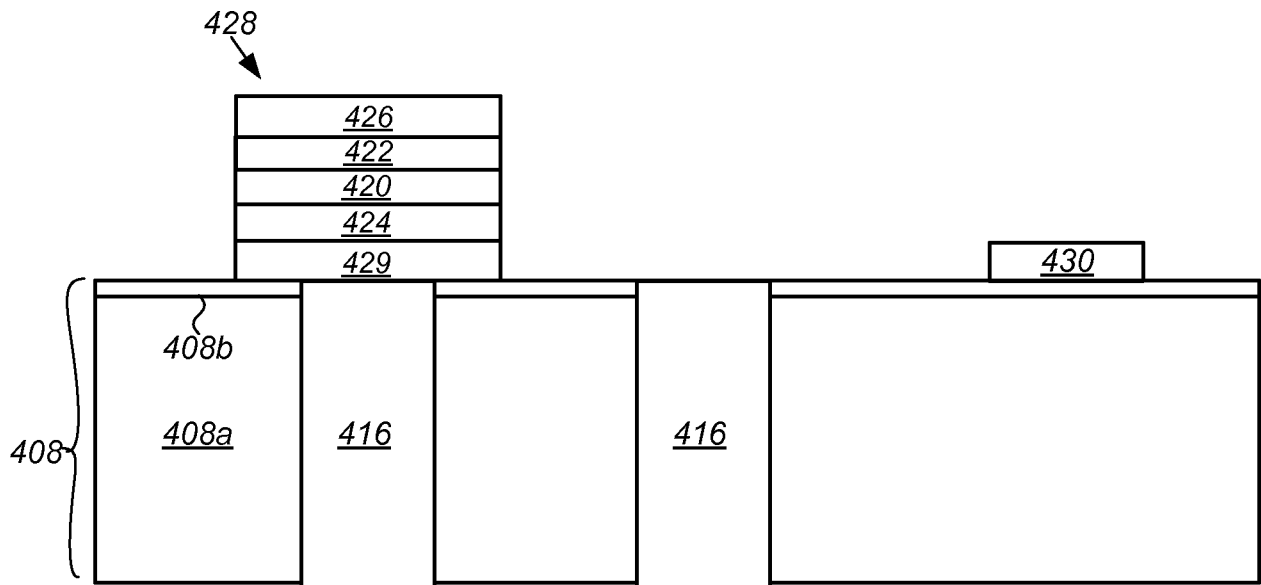


FIG. 4D

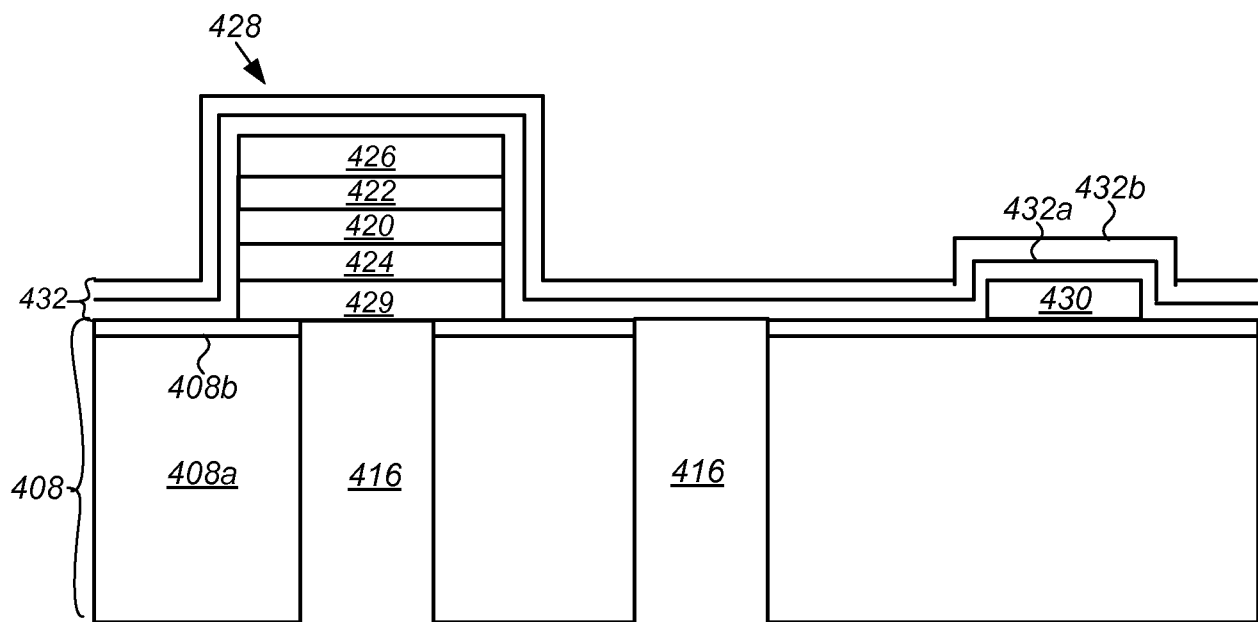


FIG. 4E

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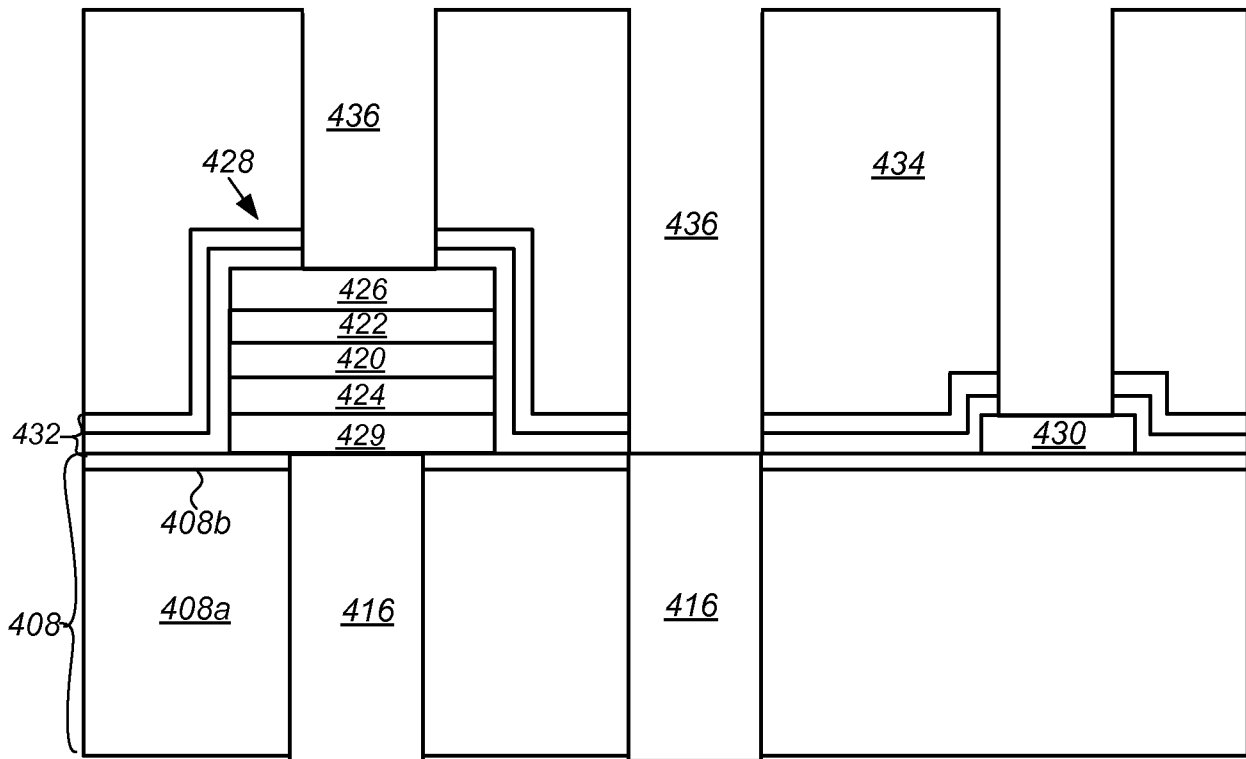


FIG. 4F

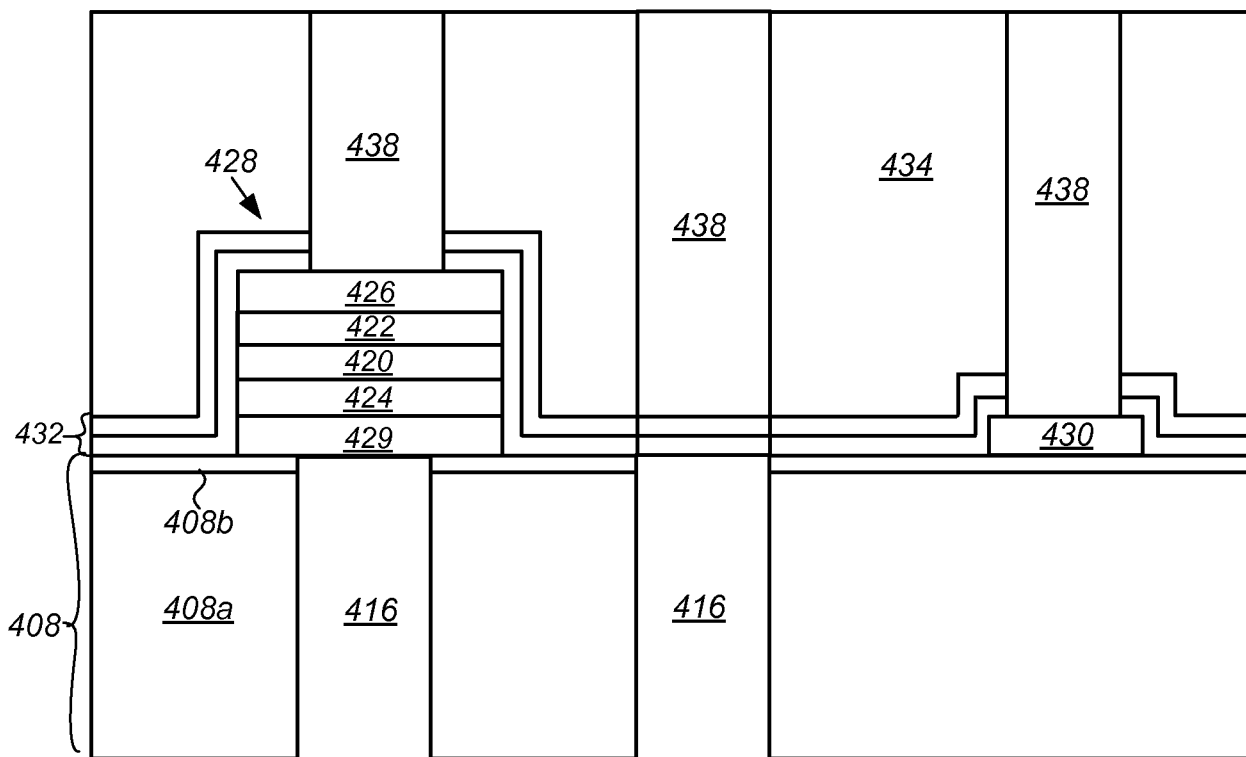


FIG. 4G

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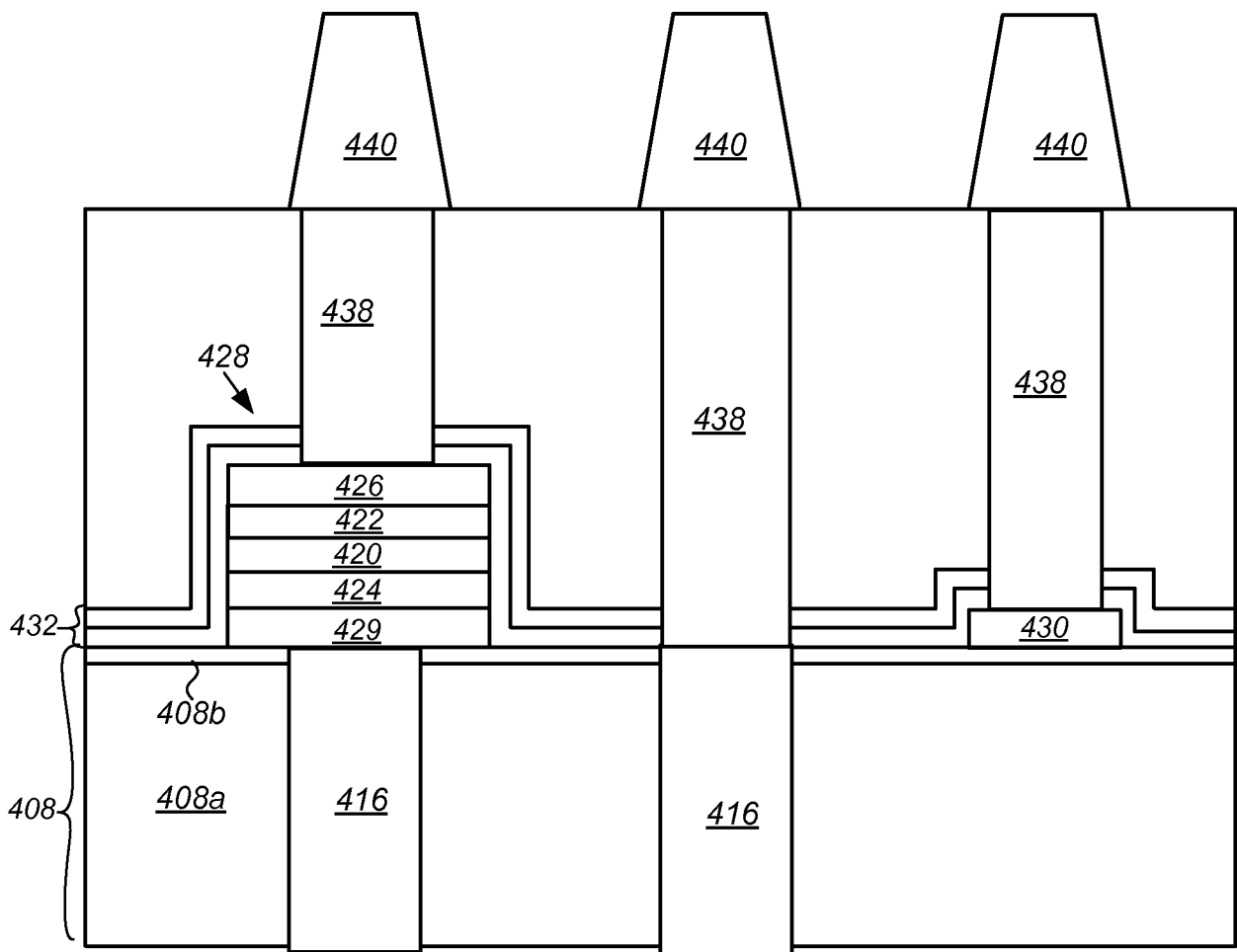


FIG. 4H

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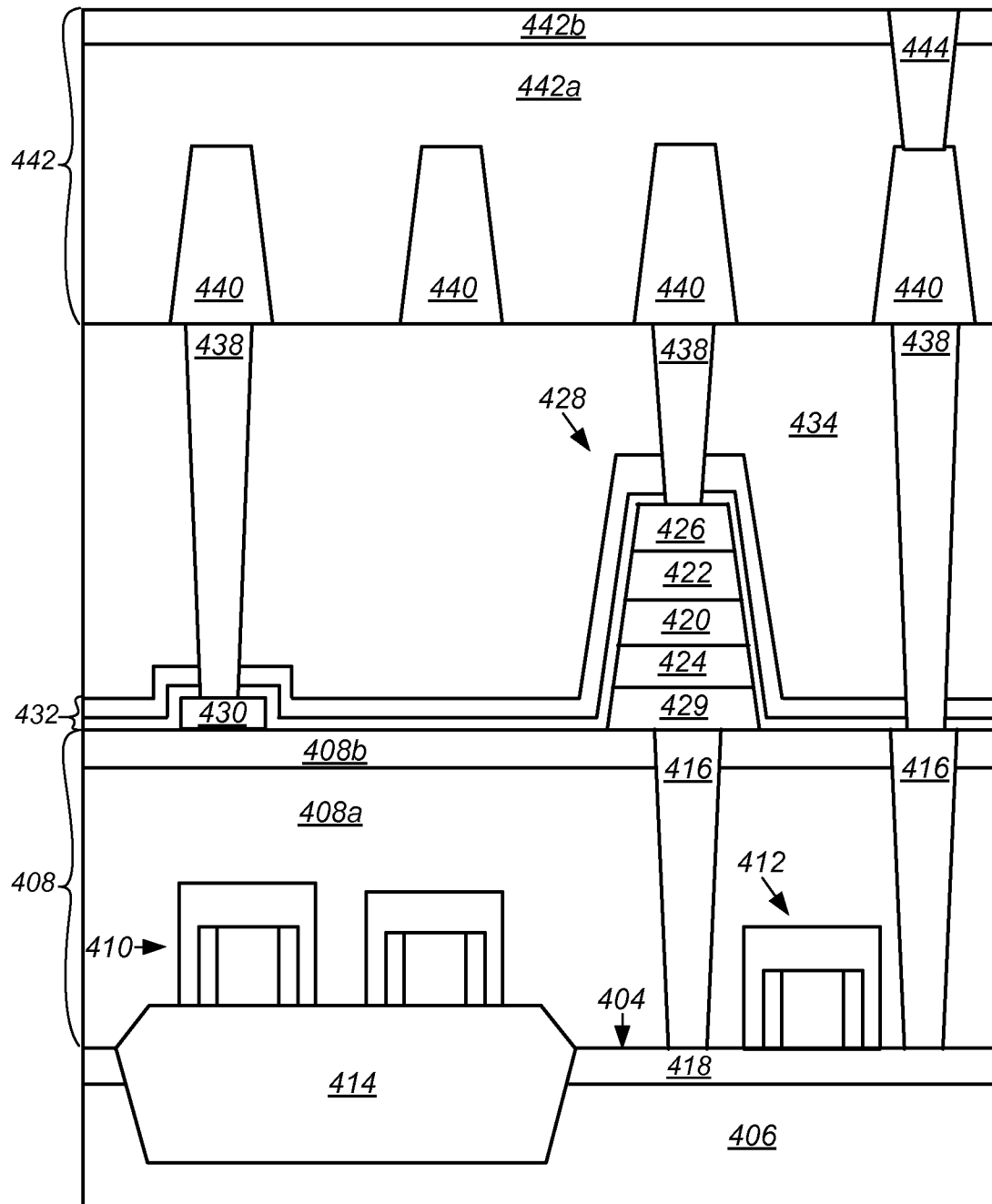


FIG. 4I

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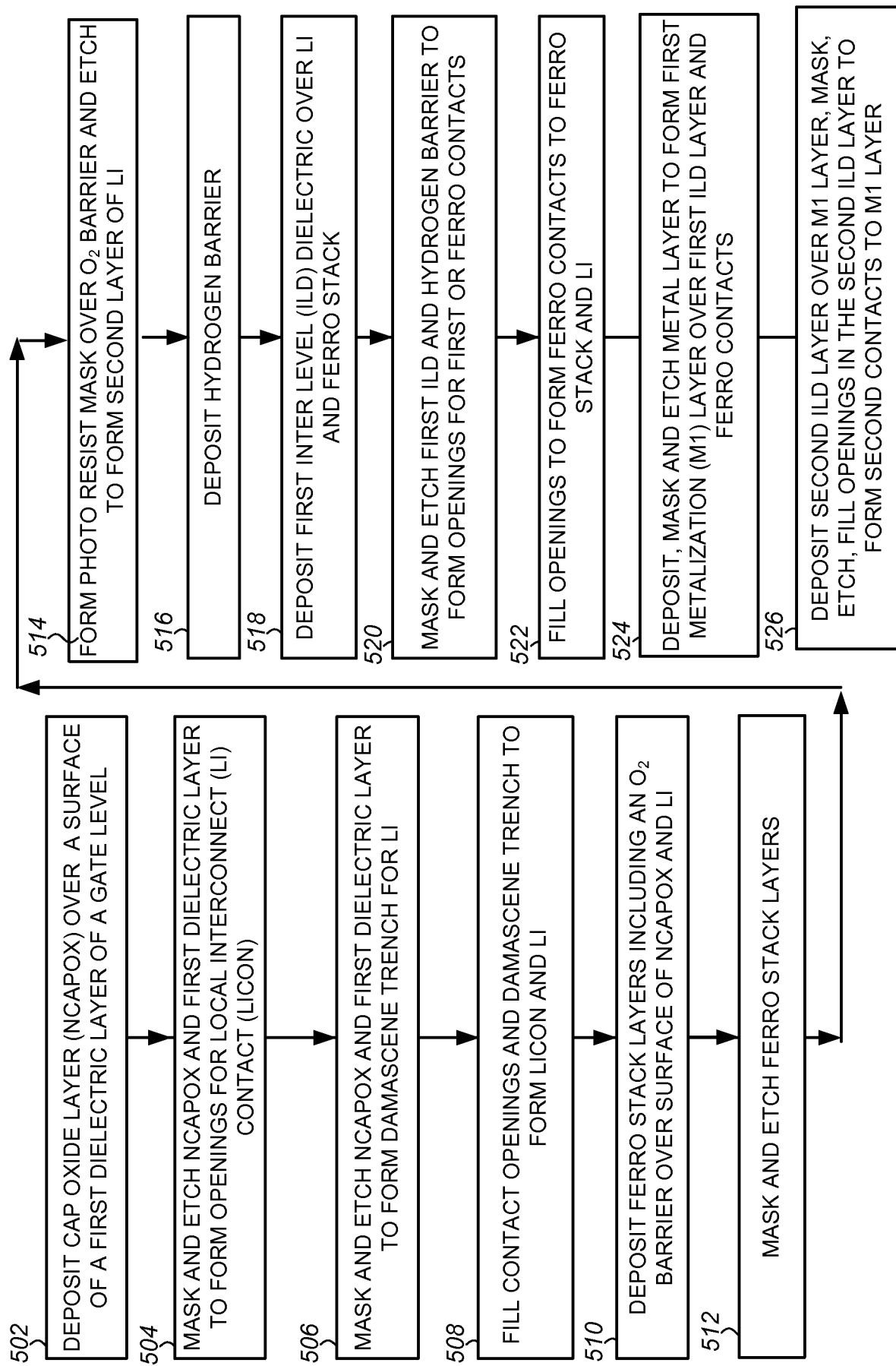


FIG. 5

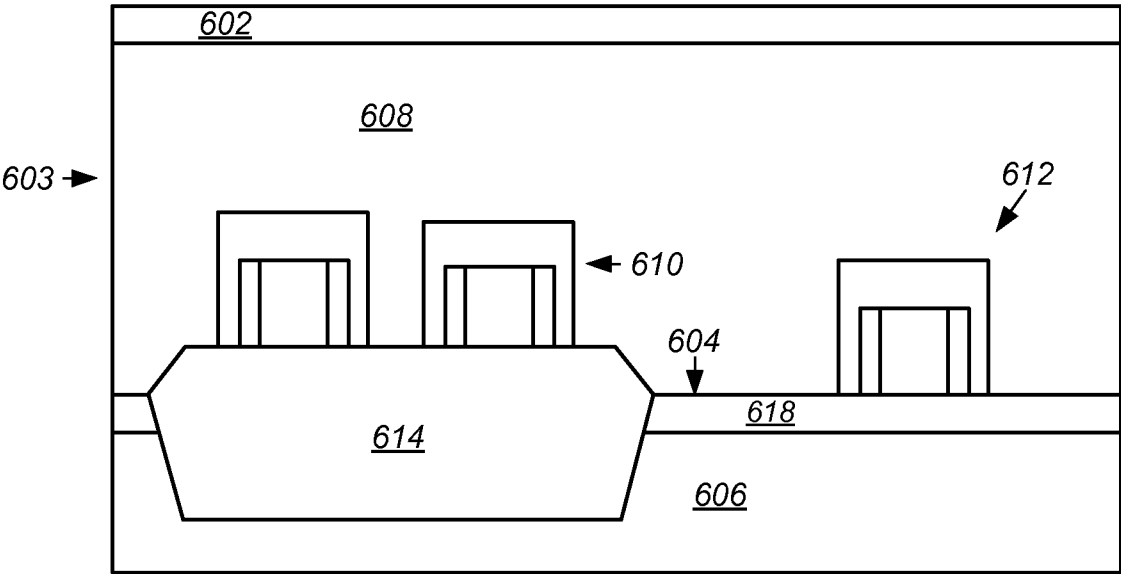


FIG. 6A

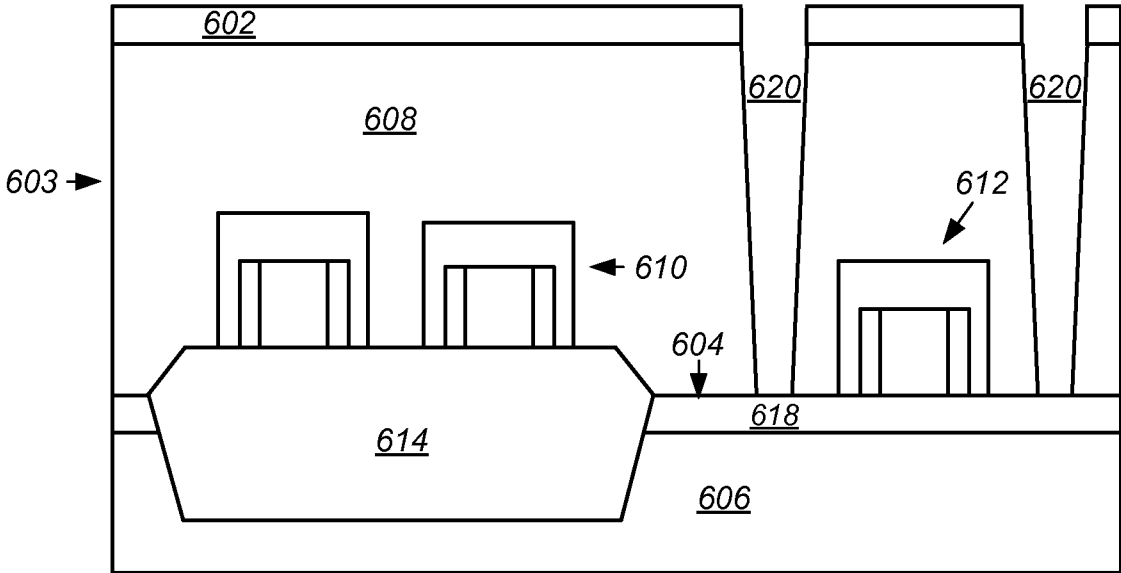


FIG. 6B

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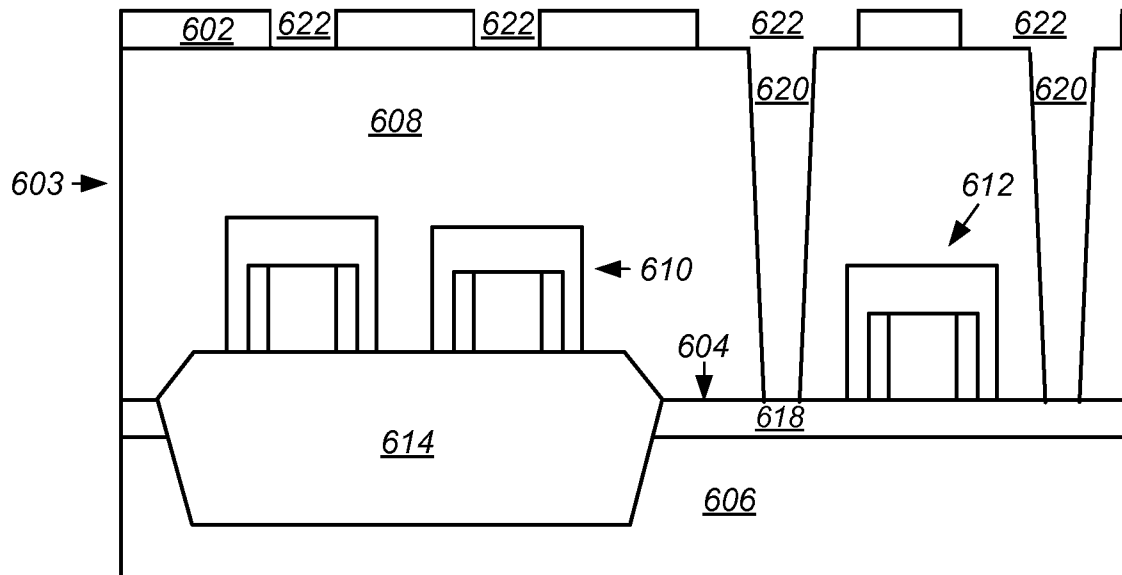


FIG. 6C

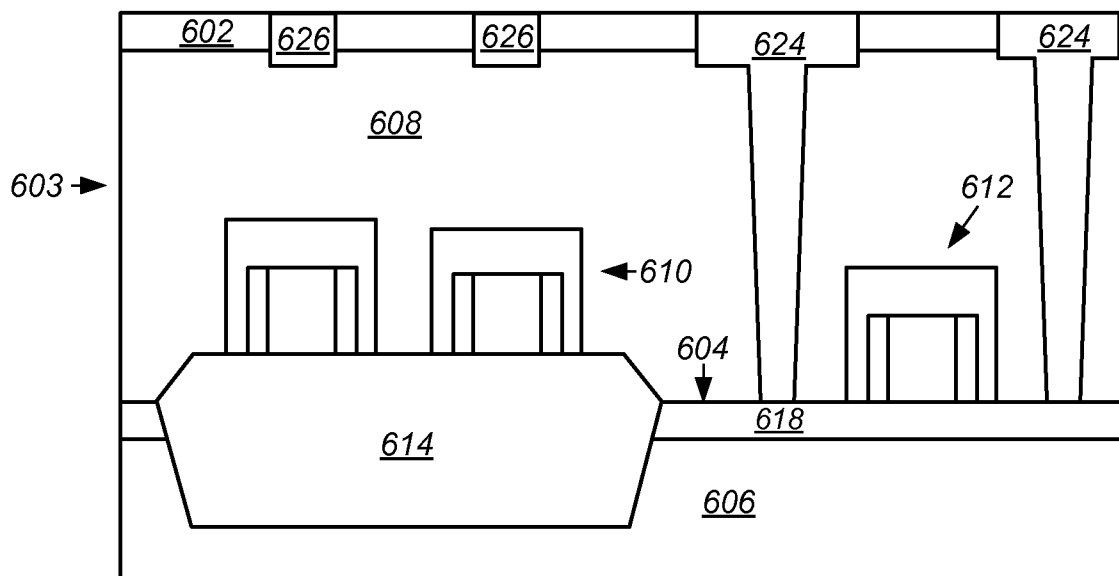


FIG. 6D

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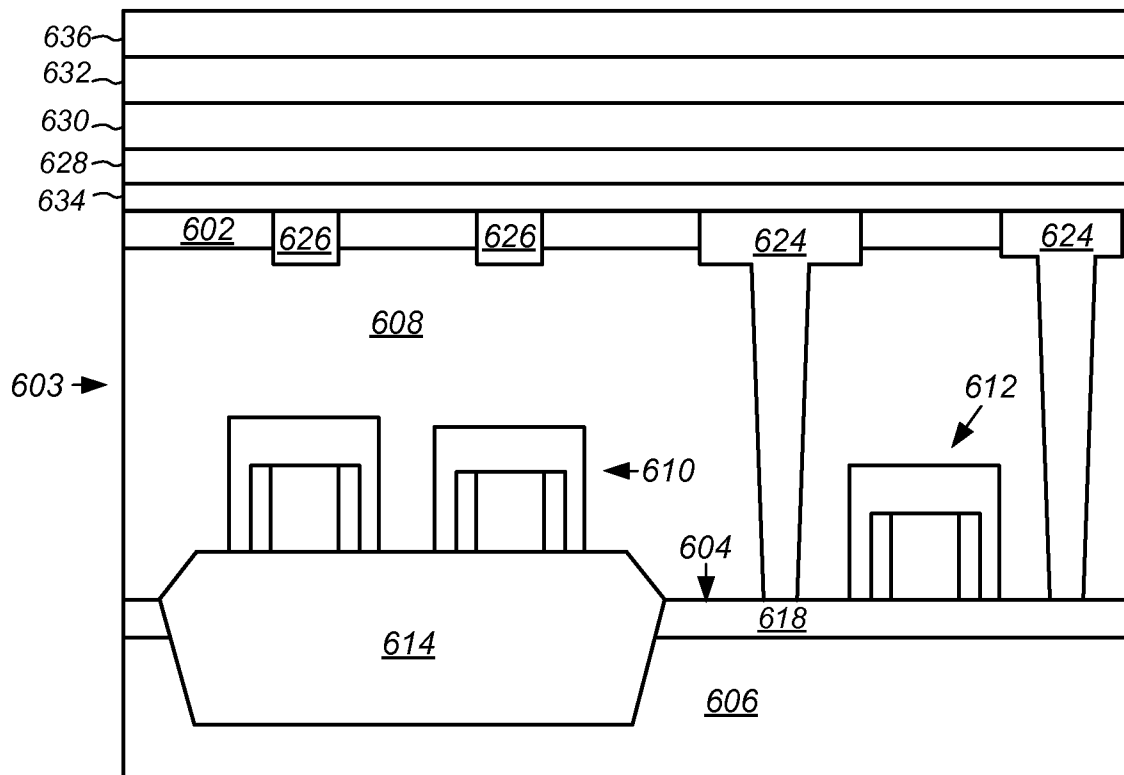


FIG. 6E

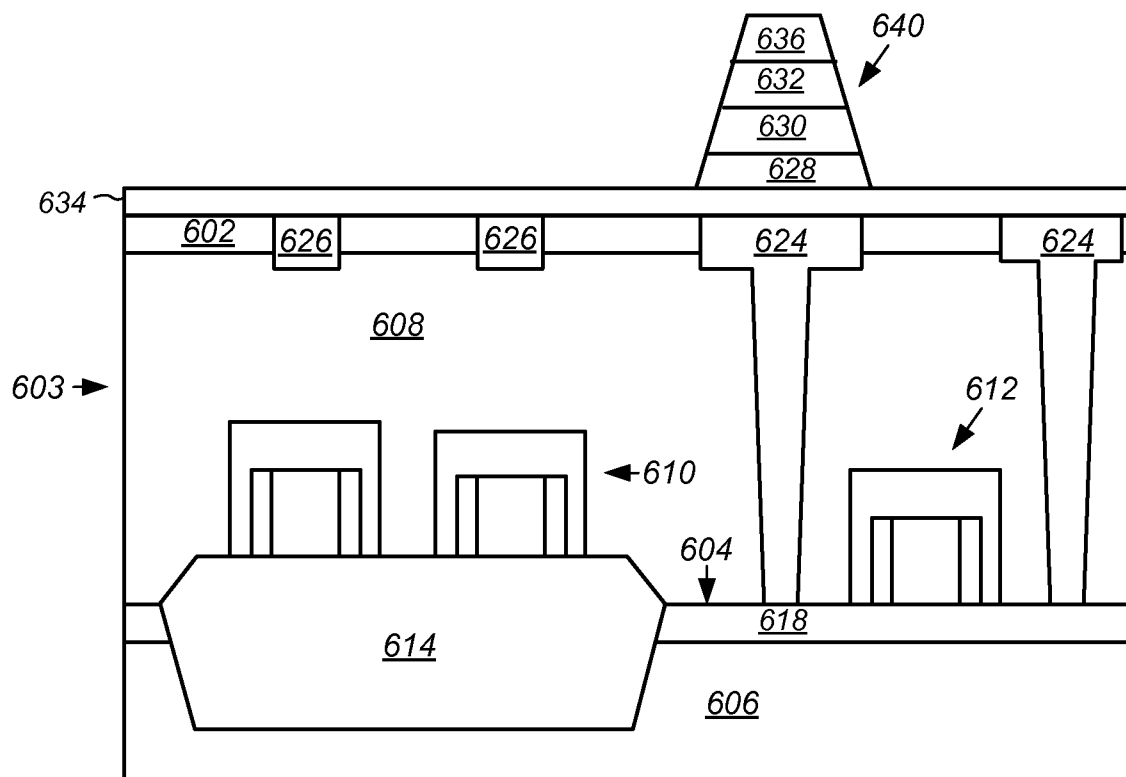


FIG. 6F

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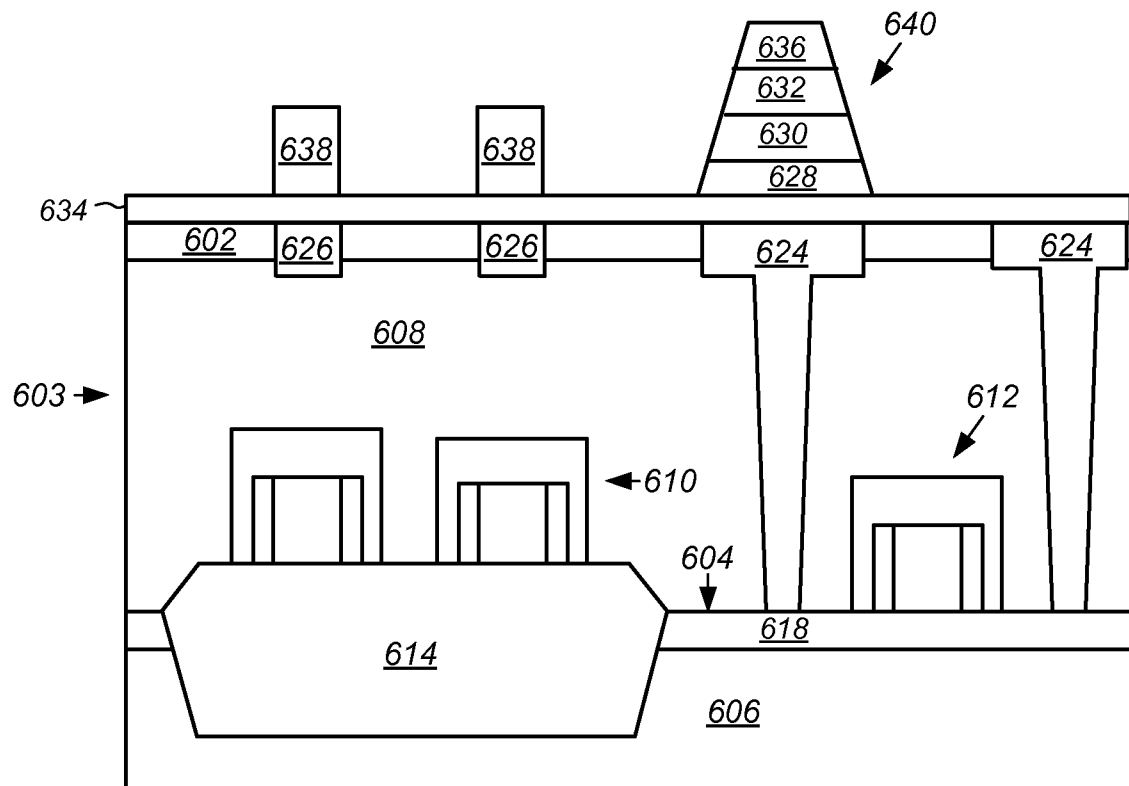


FIG. 6G

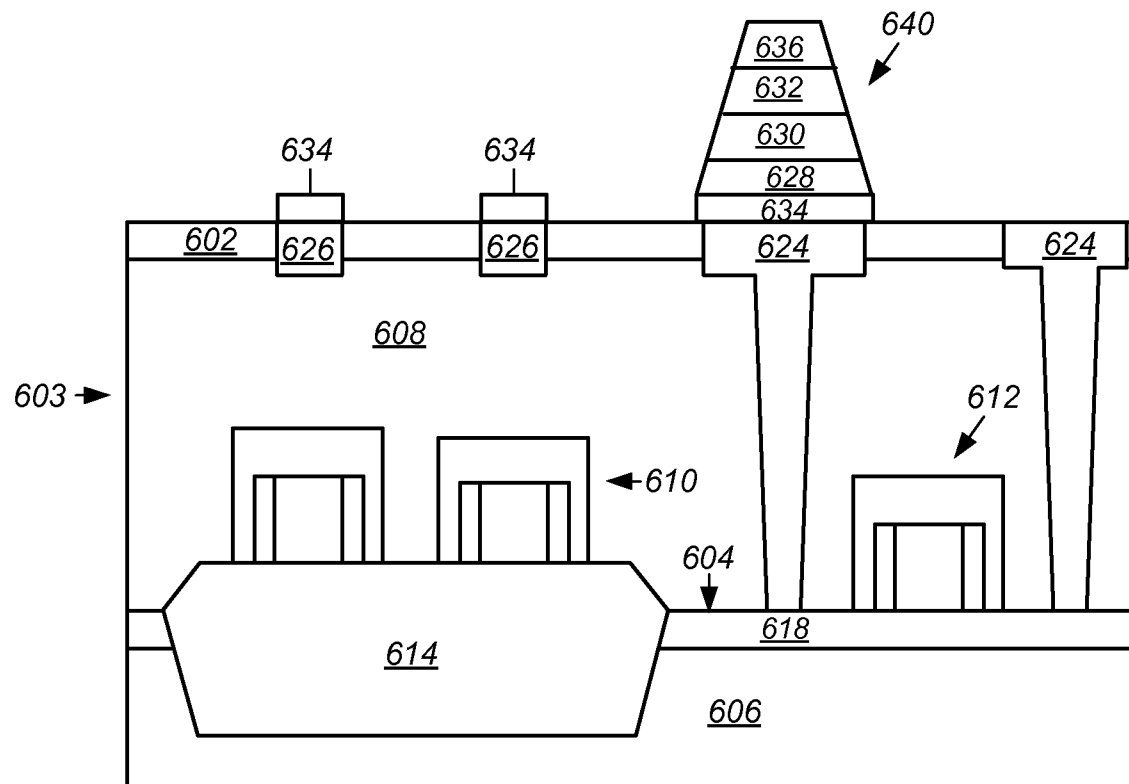


FIG. 6H

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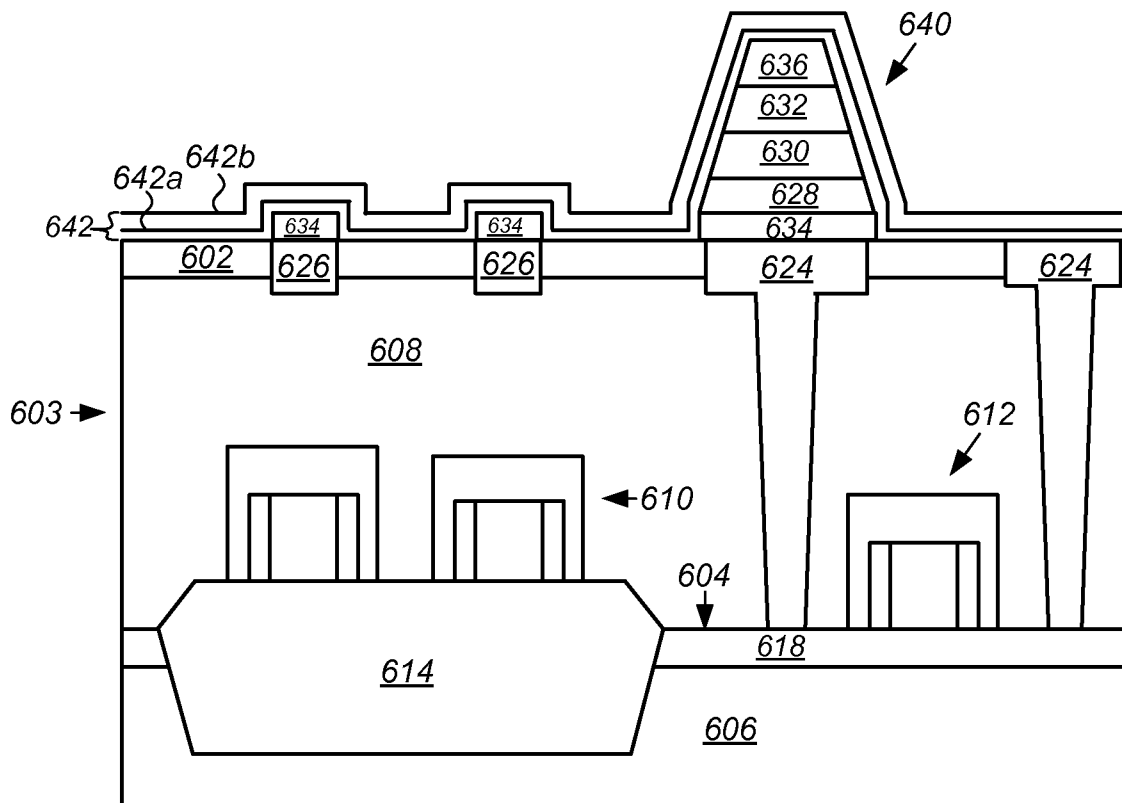


FIG. 6I

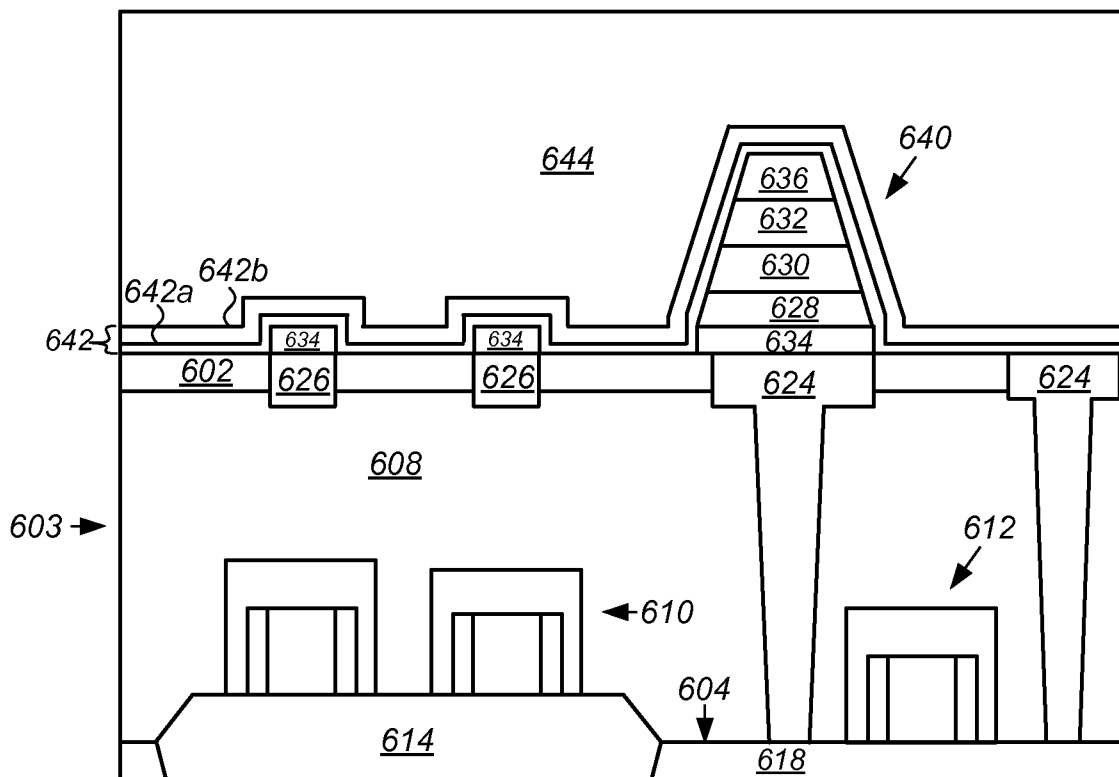


FIG. 6J

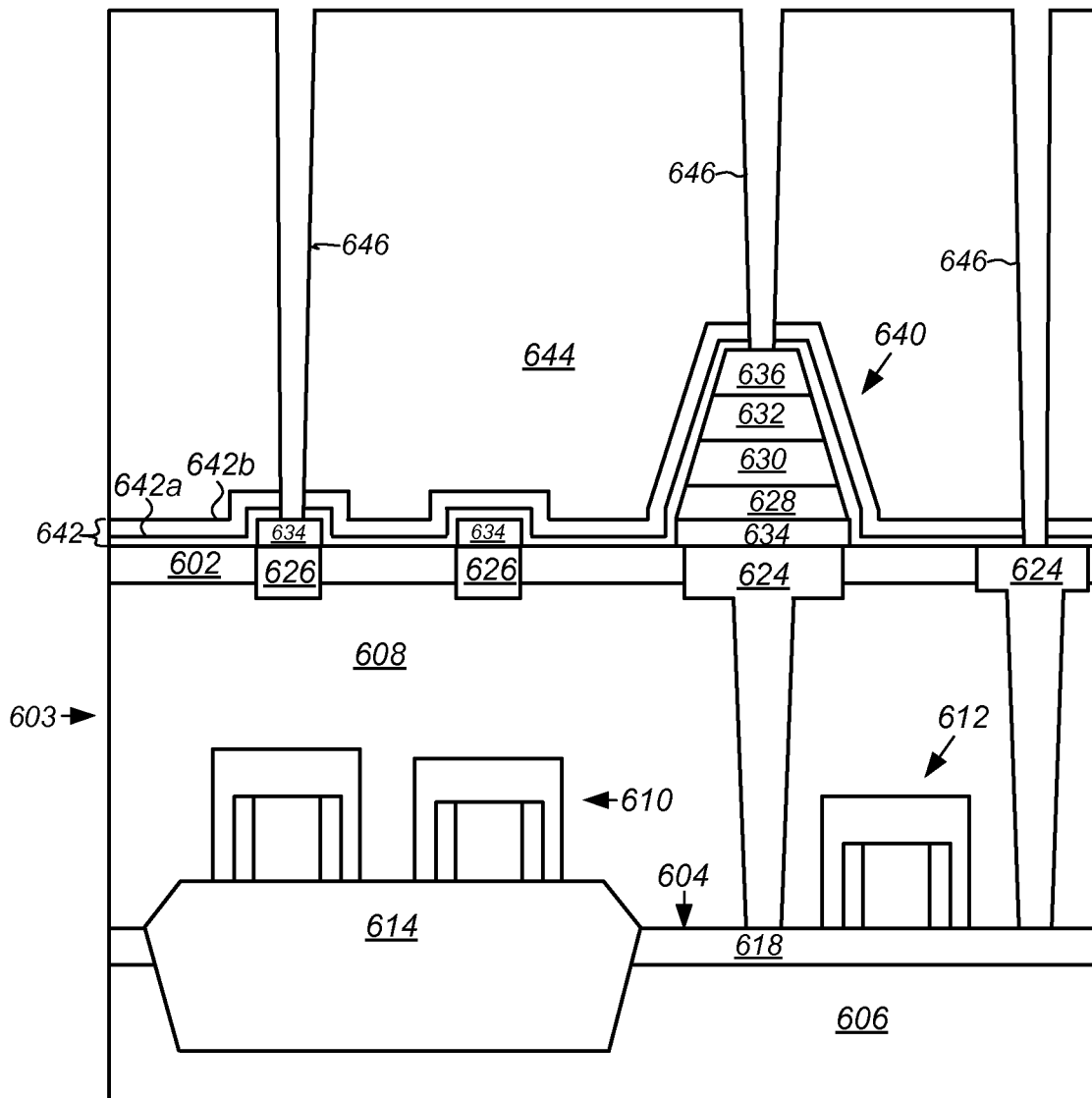


FIG. 6K

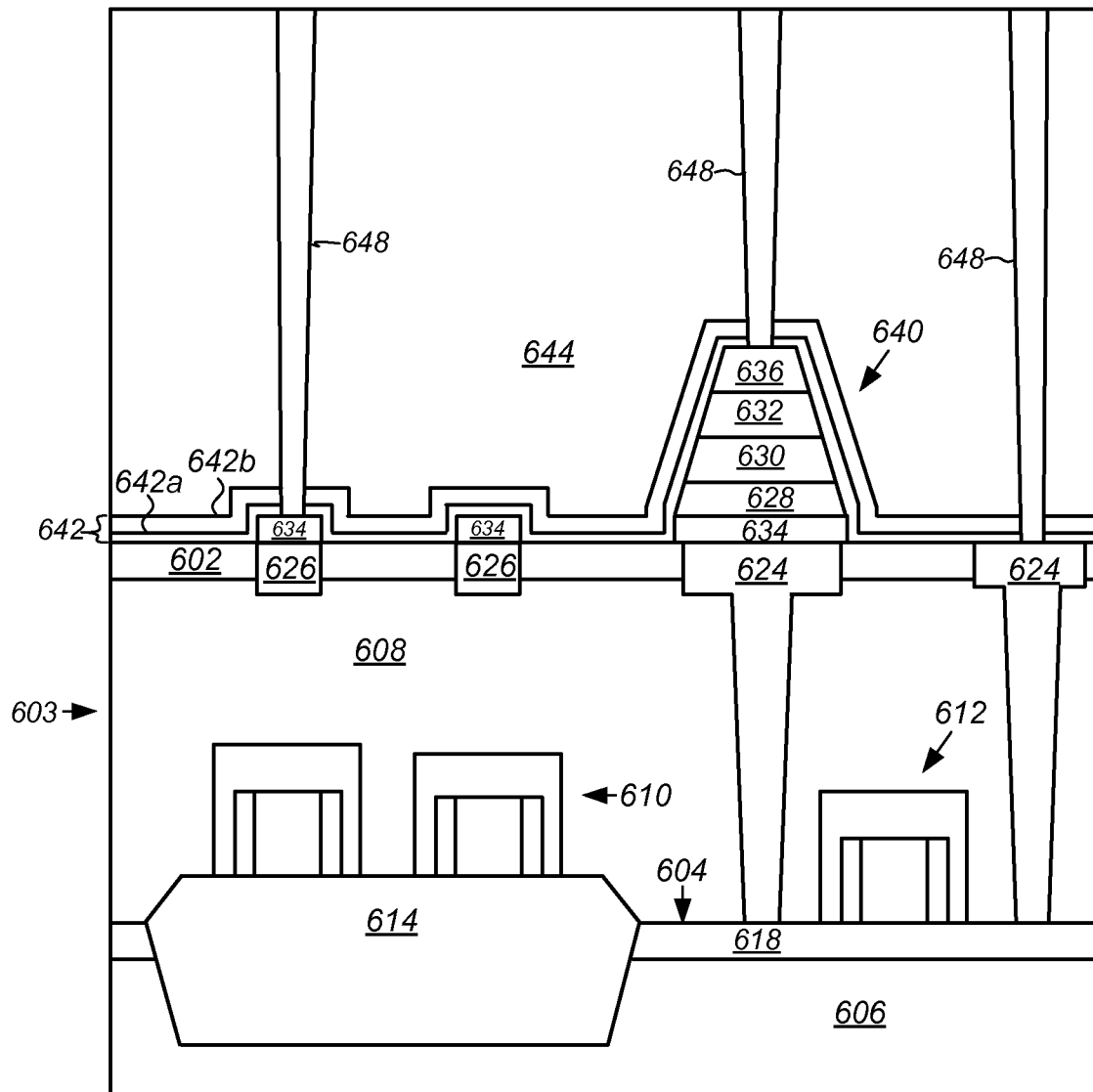


FIG. 6L

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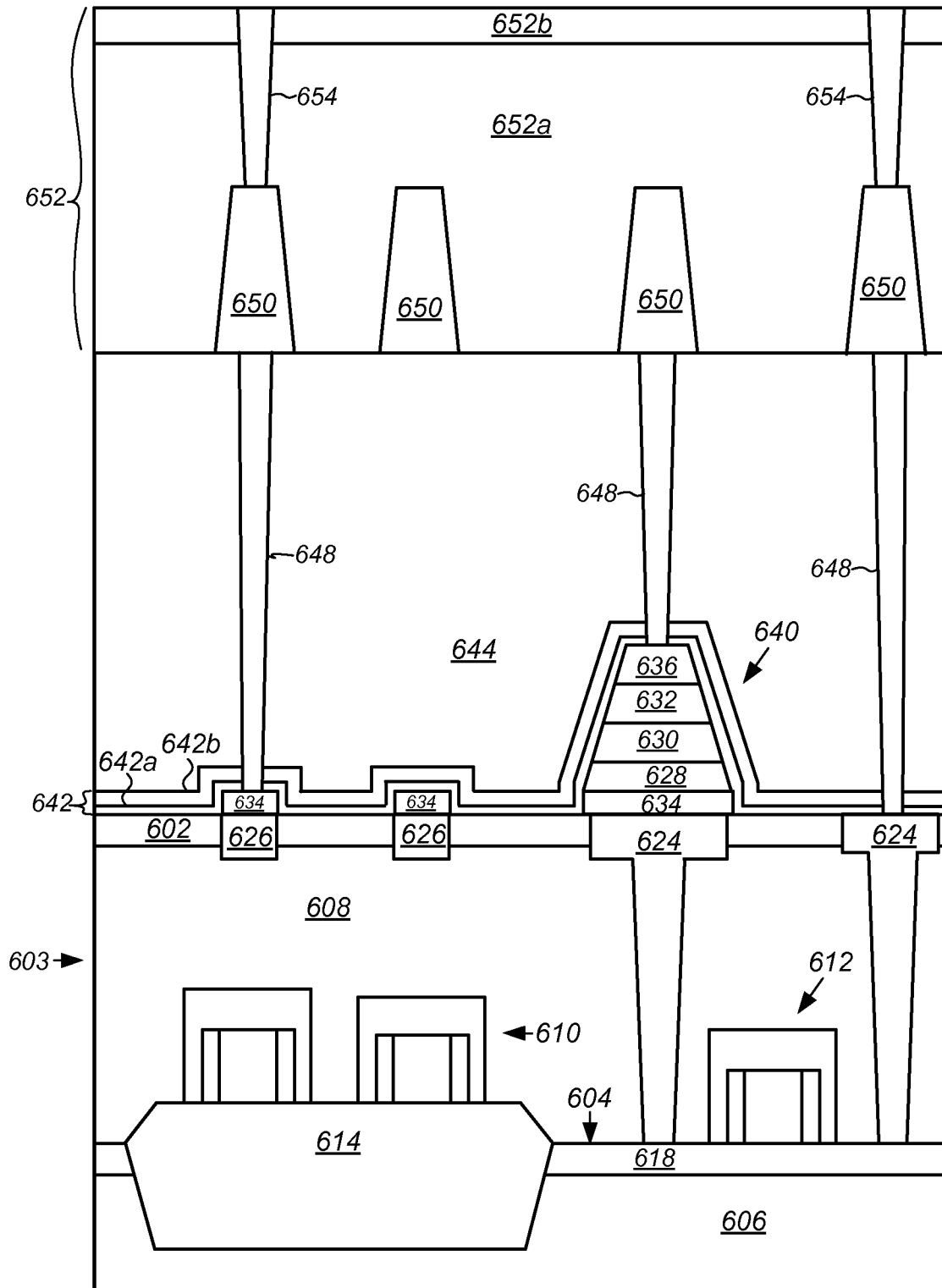


FIG. 6M

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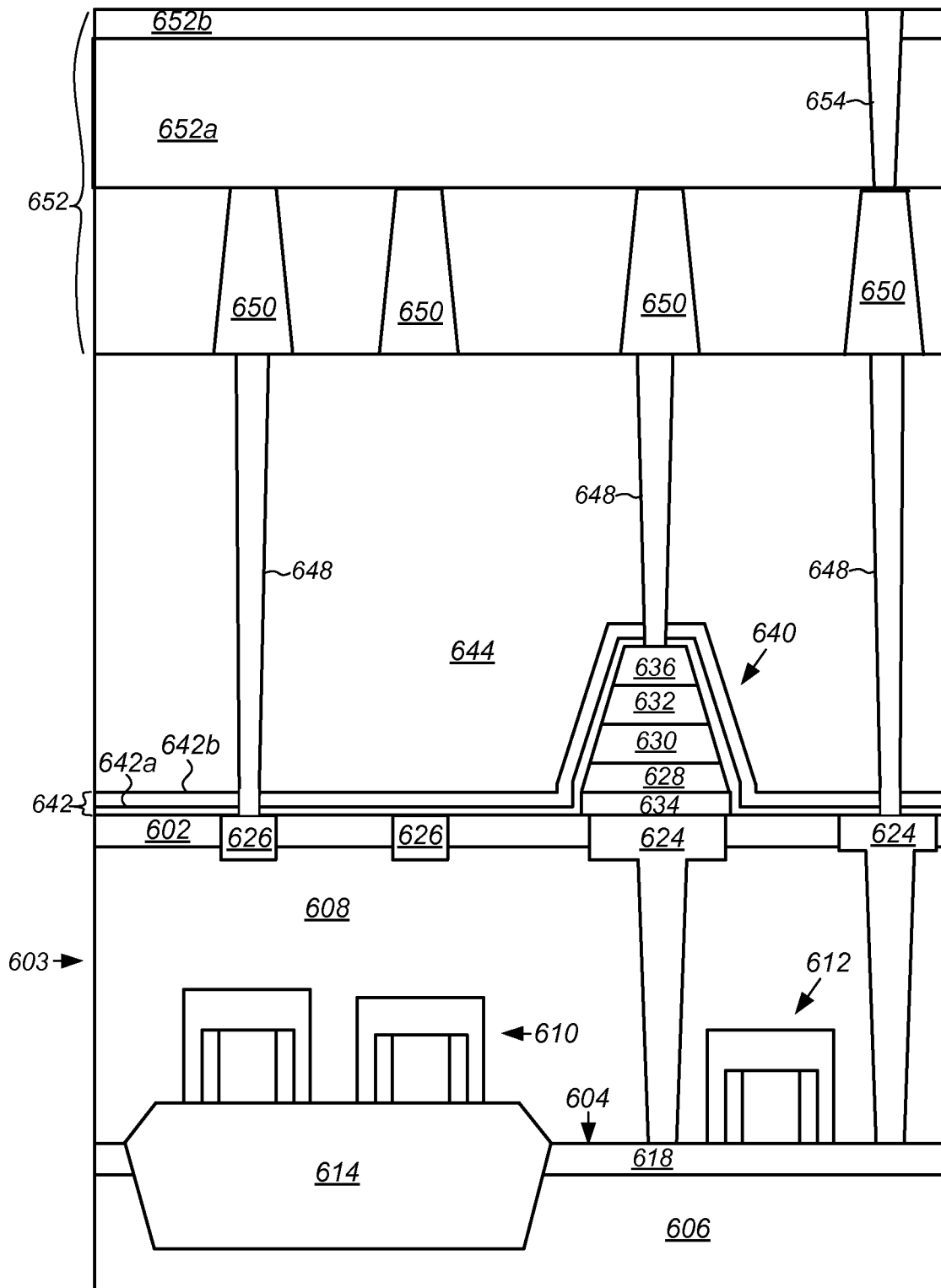


FIG. 7

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2014/040886

A. CLASSIFICATION OF SUBJECT MATTER IPC(8) - H01L 21/8242 (2014.01) CPC - H01L 27/11502 (2014.02) According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC(8) - H01L 21/02, 8239, 8242, 27/105, 108 (2014.01) USPC - 257/E21.009, E21.253, E21.664; 438/3, 240 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched CPC - H01L 21/31122, 27/11502, 11507, 11509, 11514, 28/55, 75 (2014.02) Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) Orbit, Google Patents, Google Scholar		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2008/0081380 A1 (CELLI et al) 03 April 2008 (03.04.2008) entire document	14-18
Y		1-13, 19-21
Y	US 2010/0295149 A1 (SUMMERFELT et al) 25 November 2010 (25.11.2010) entire document	1-13, 19-21
Y	US 2011/0062550 A1 (UDAYAKUMAR et al) 17 March 2011 (17.03.2011) entire document	7-13
A	US 2010/0224961 A1 (SUMMERFELT et al) 09 September 2010 (09.09.2010) entire document	1-21
A	US 2009/0057736 A1 (UDAYAKUMAR et al) 05 March 2009 (05.03.2009) entire document	1-21
A	US 2011/0079878 A1 (AGGARWAL et al) 07 April 2011 (07.04.2011) entire document	1-21
A	US 2005/0239218 A1 (AGGARWAL et al) 27 October 2005 (27.10.2005) entire document	1-21
A	US 6,730,950 B1 (SESHADRI et al) 04 May 2004 (04.05.2004) entire document	1-21
☐ Further documents are listed in the continuation of Box C. ☐		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 11 September 2014		Date of mailing of the international search report 04 NOV 2014
Name and mailing address of the ISA/US Mail Stop PCT, Attn: ISA/US, Commissioner for Patents P.O. Box 1450, Alexandria, Virginia 22313-1450 Facsimile No. 571-273-3201		Authorized officer: Blaine R. Copenheaver PCT Helpdesk: 571-272-4300 PCT OSP: 571-272-7774