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**KWON et al.**

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(2013.01); *H01L 2224/16145* (2013.01); *H01L*  
*2224/48145* (2013.01); *H01L 2225/06506*  
(2013.01); *H01L 2225/06513* (2013.01); *H01L*  
*2225/06541* (2013.01)

(57) **ABSTRACT**

An apparatus includes a first substrate having a first land and a second substrate having a second land. A first molding compound is disposed between the first substrate and the second substrate. A first semiconductor chip is disposed on the first substrate and in contact with the first molding portion. A first connector contacts the first land and a second connector contacts the second land. The second connector is disposed on the first connector. A volume of the second connector is greater than a volume of the first connector. A surface of the first semiconductor chip is exposed. The first molding compound is in contact with the second connector, and at least a portion of the second connector is surrounded by the first molding compound.

### Related U.S. Application Data

(60) Continuation of application No. 13/934,942, filed on Jul. 3, 2013, now Pat. No. 9,042,115, which is a division of application No. 12/910,415, filed on Oct. 22, 2010, now Pat. No. 8,508,954.

(30) **Foreign Application Priority Data**

Dec. 17, 2009 (KR) ..... 10-2009-0126345  
 Jun. 4, 2010 (KR) ..... 10-2010-0052827

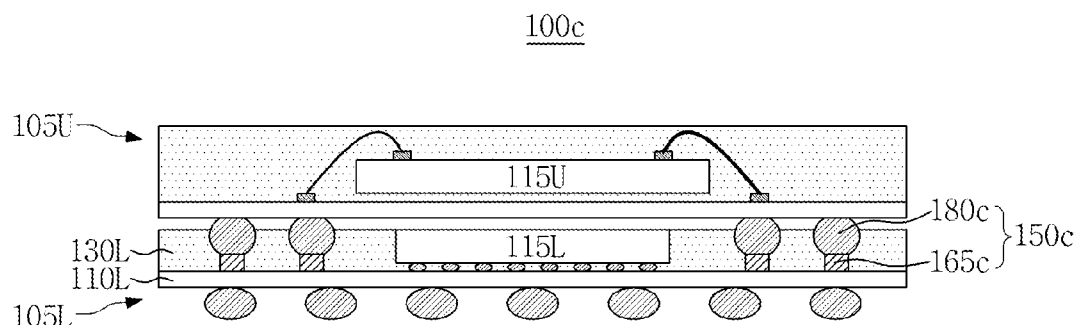


FIG. 1A

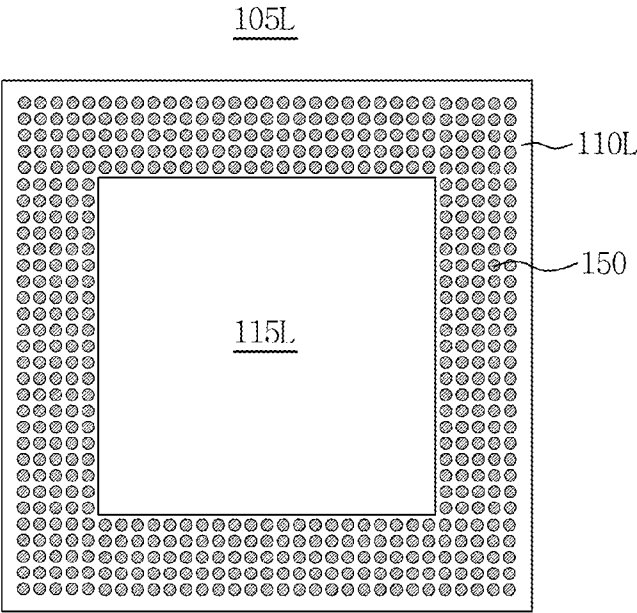


FIG. 1B

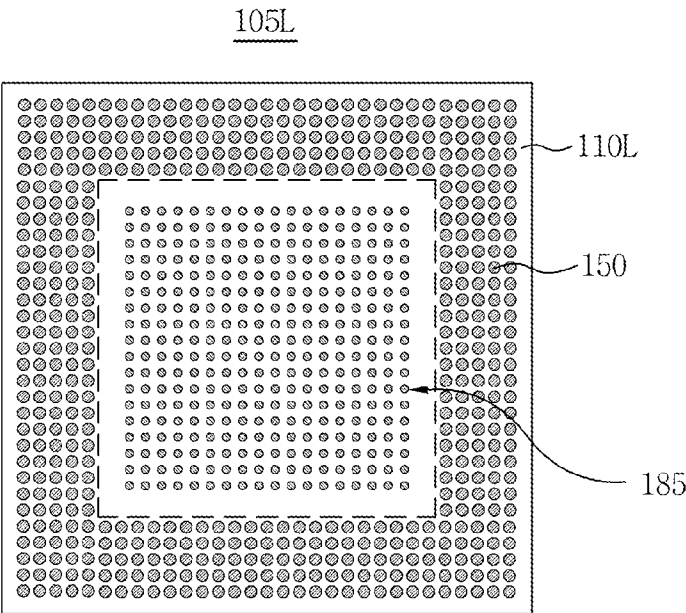


FIG. 2A

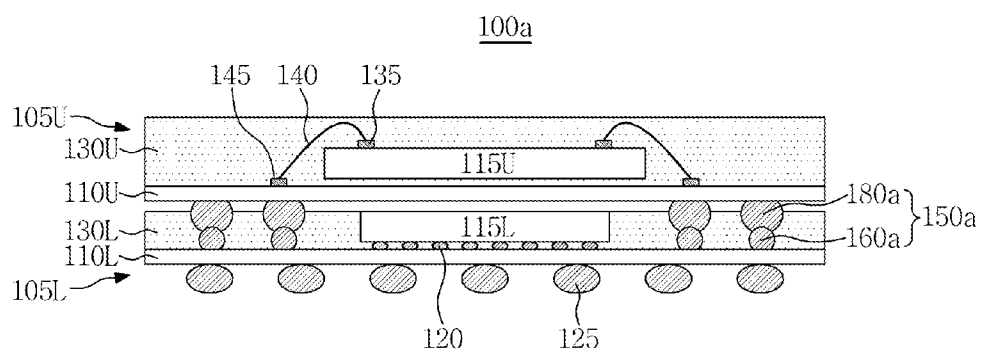


FIG. 2B

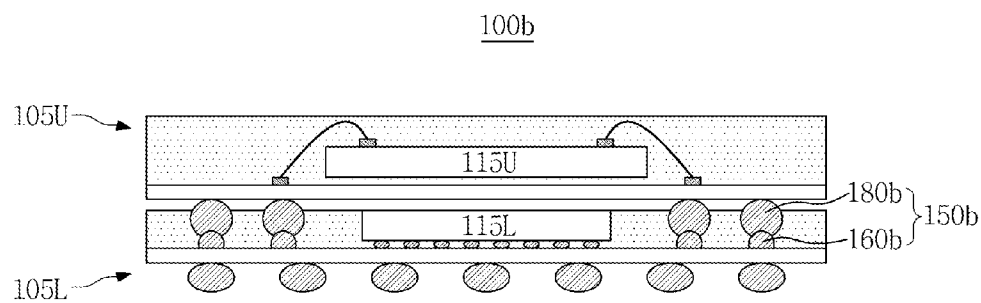


FIG. 2C

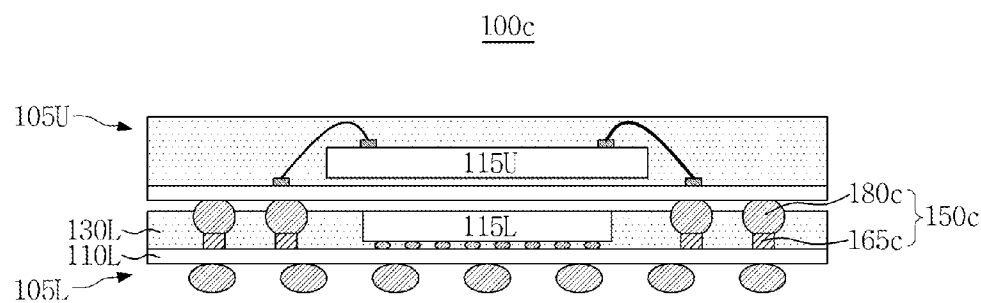


FIG. 2D

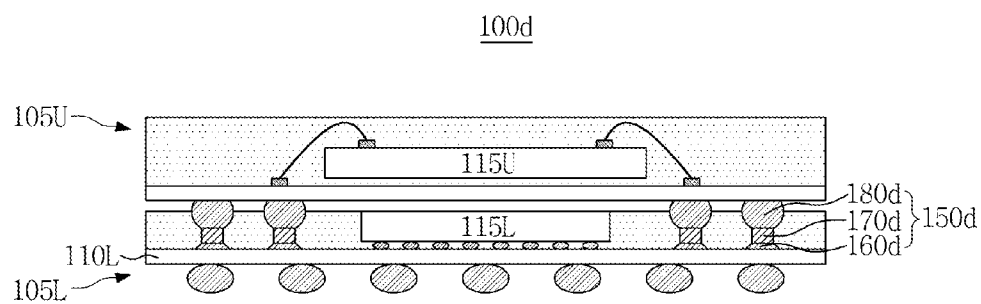


FIG. 2E

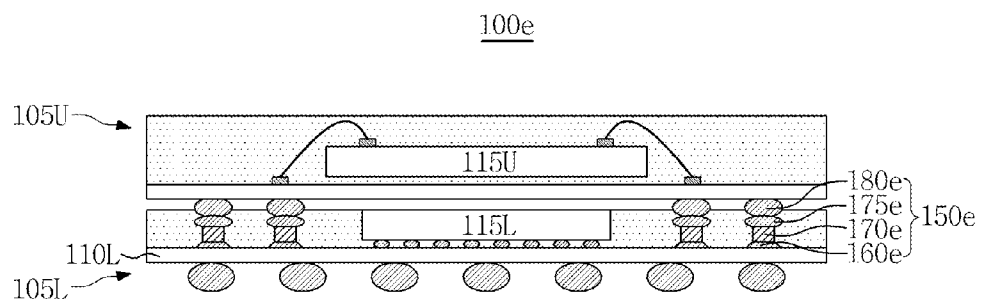


FIG. 2F

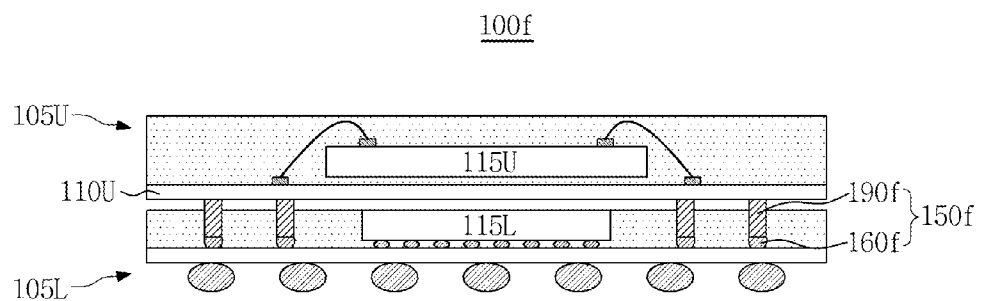


FIG. 2G

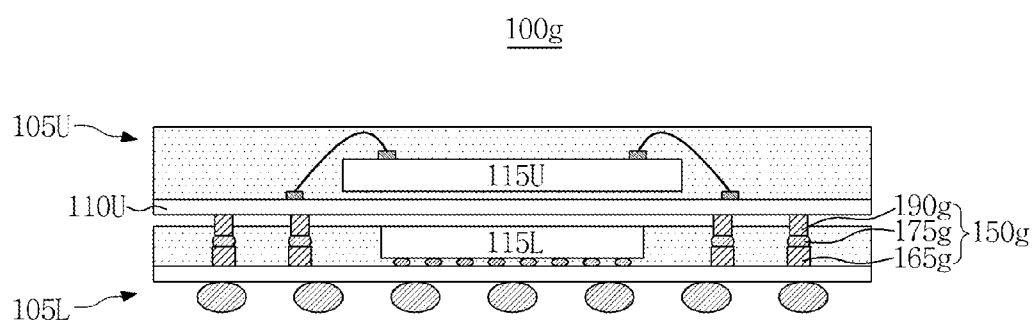


FIG. 2H

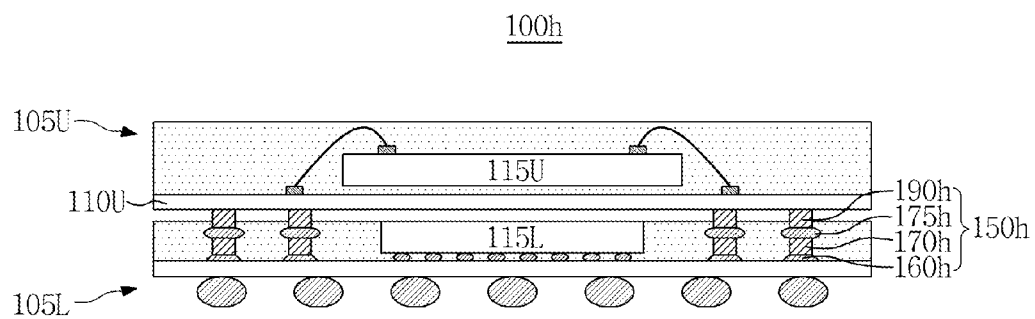


FIG. 3A

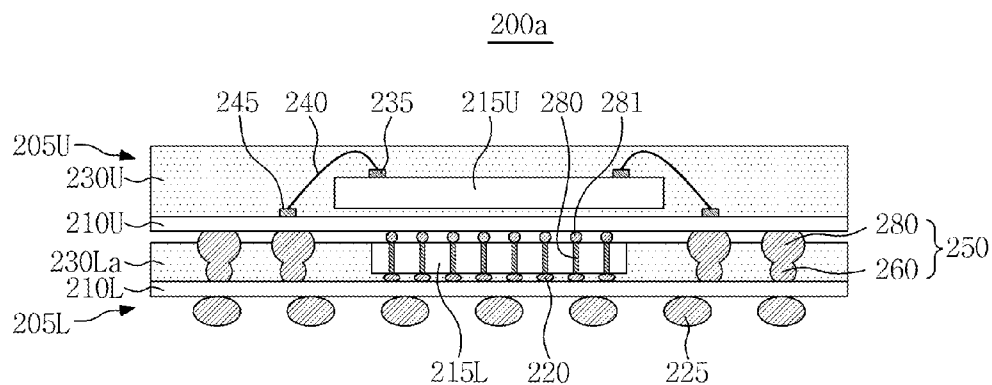


FIG. 3B

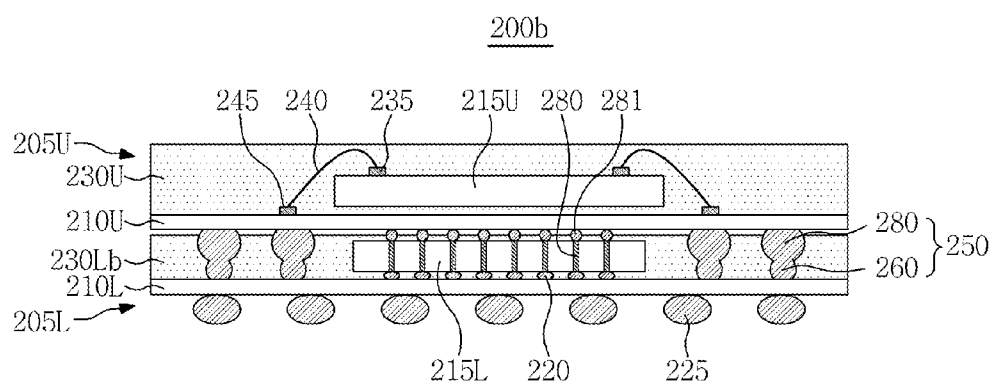


FIG. 4

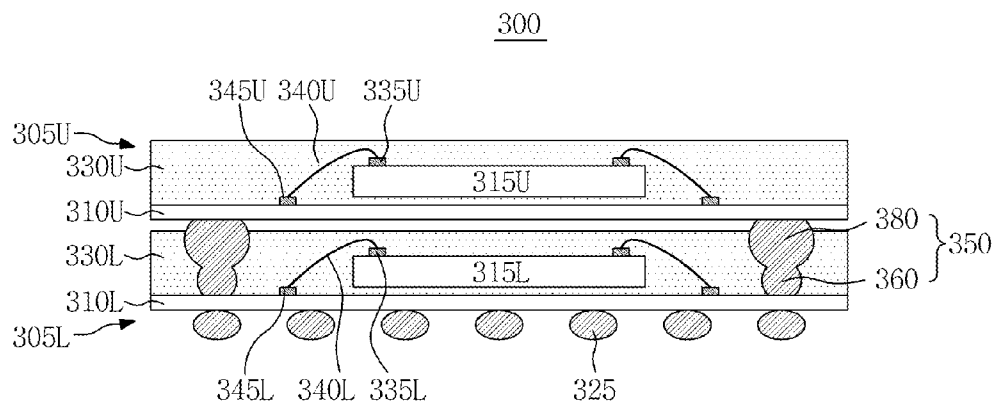


FIG. 5A

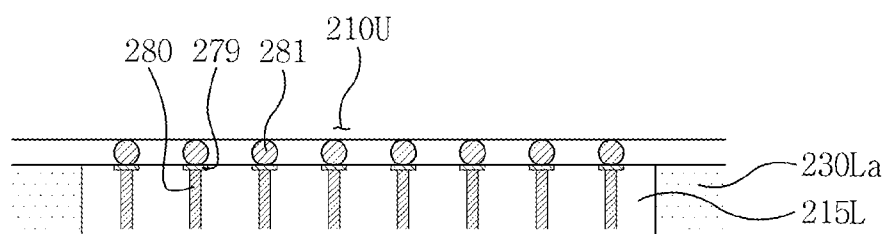


FIG. 5B

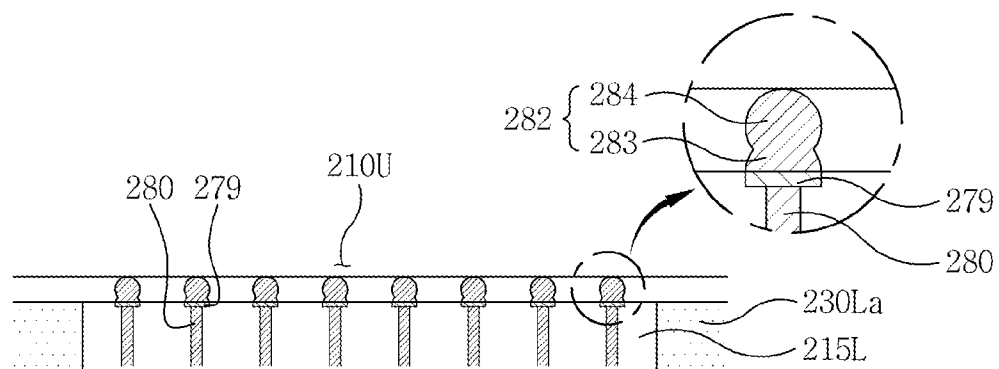


FIG. 5C

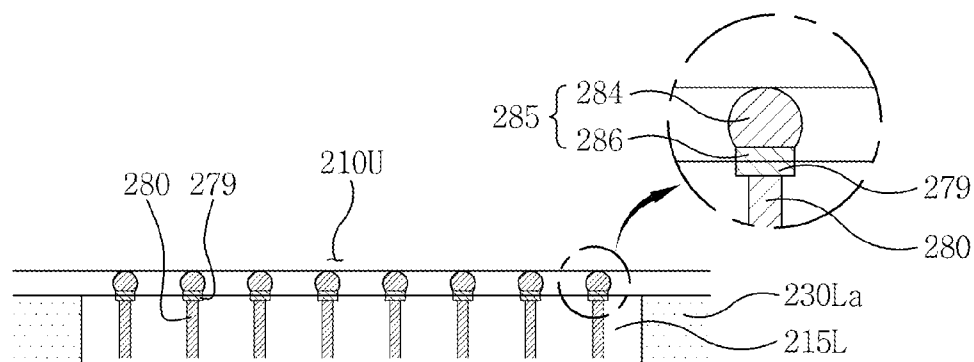


FIG. 5D

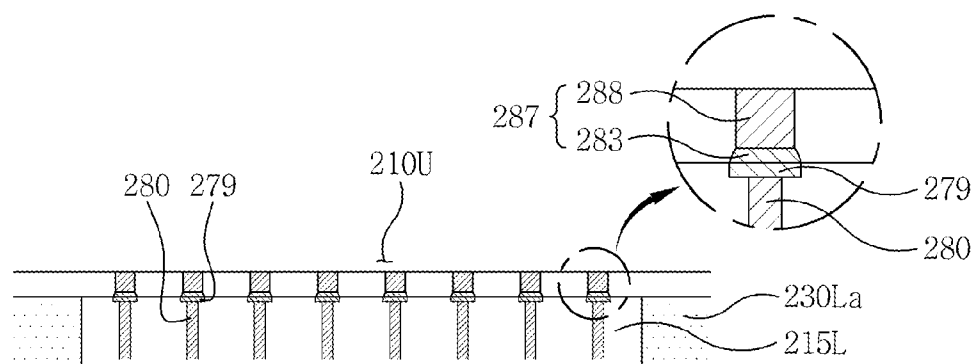




FIG. 6A

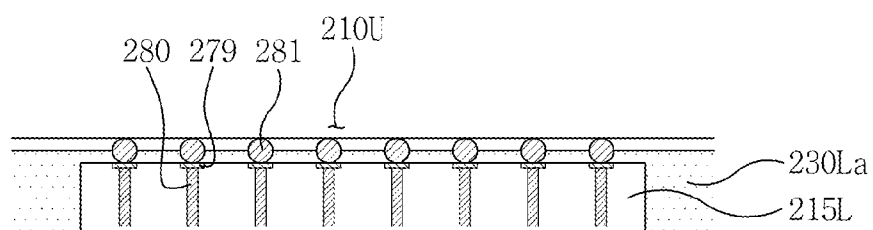


FIG. 6B

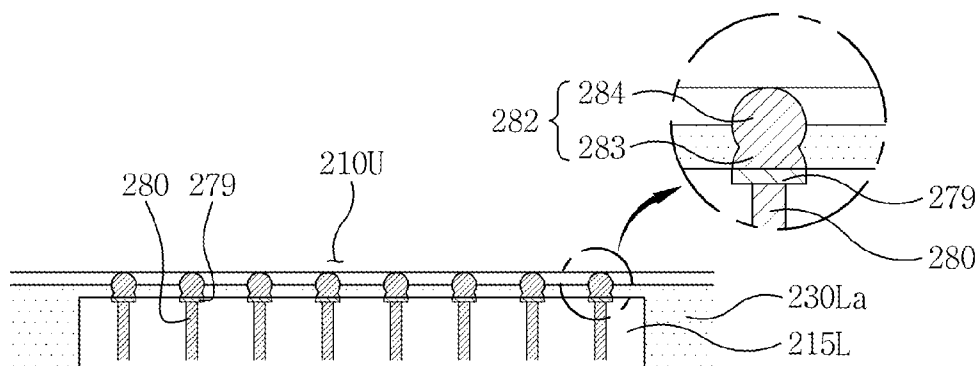


FIG. 6C

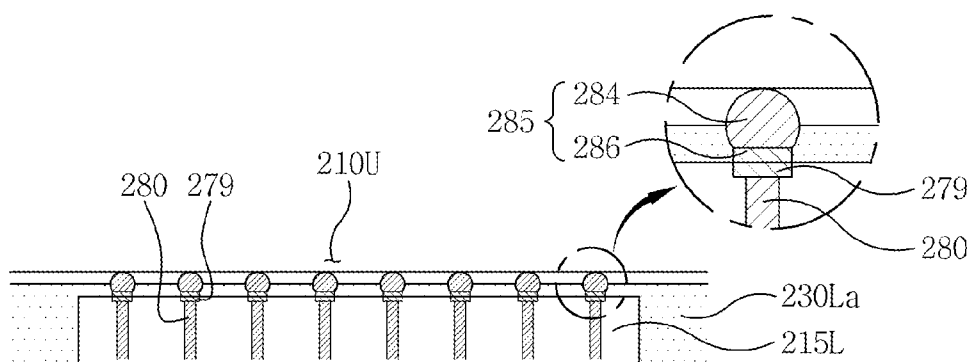


FIG. 6D

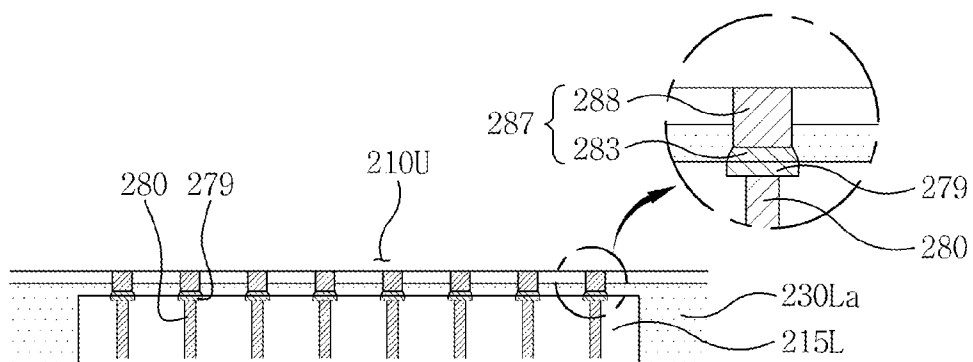


FIG. 7A

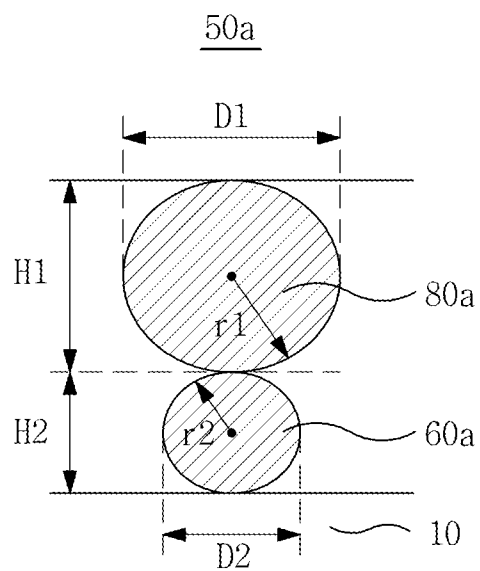


FIG. 7B

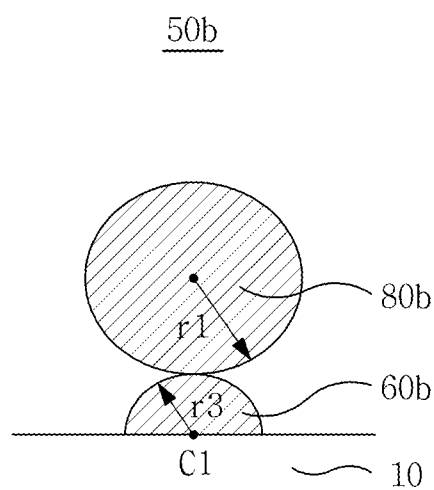


FIG. 7C

50c

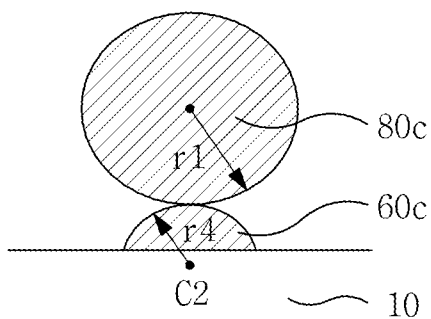


FIG. 7D

50d

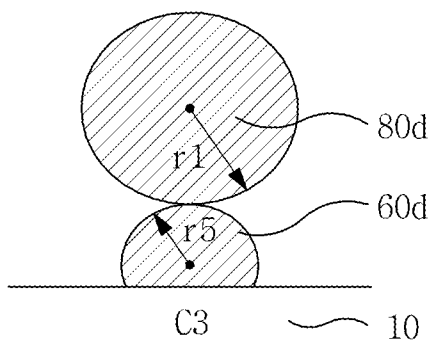


FIG. 8A

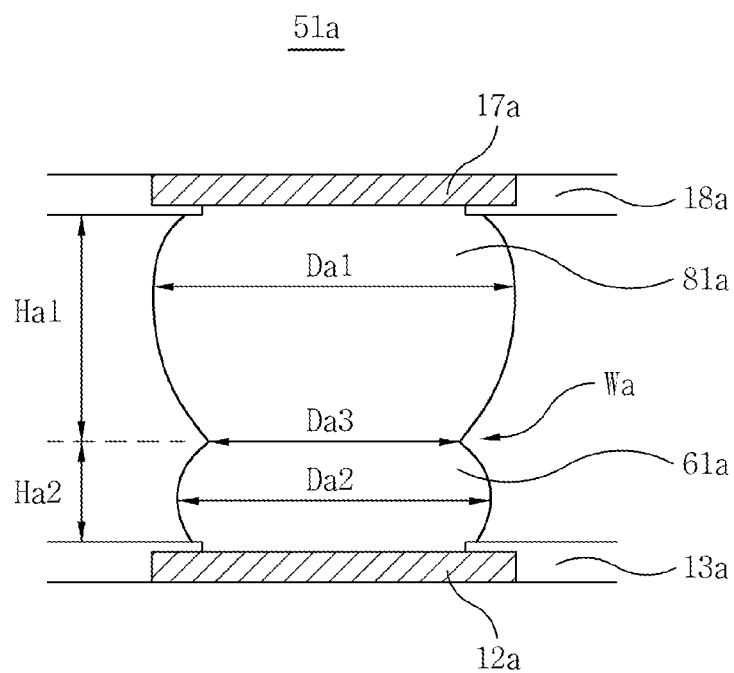


FIG. 8B

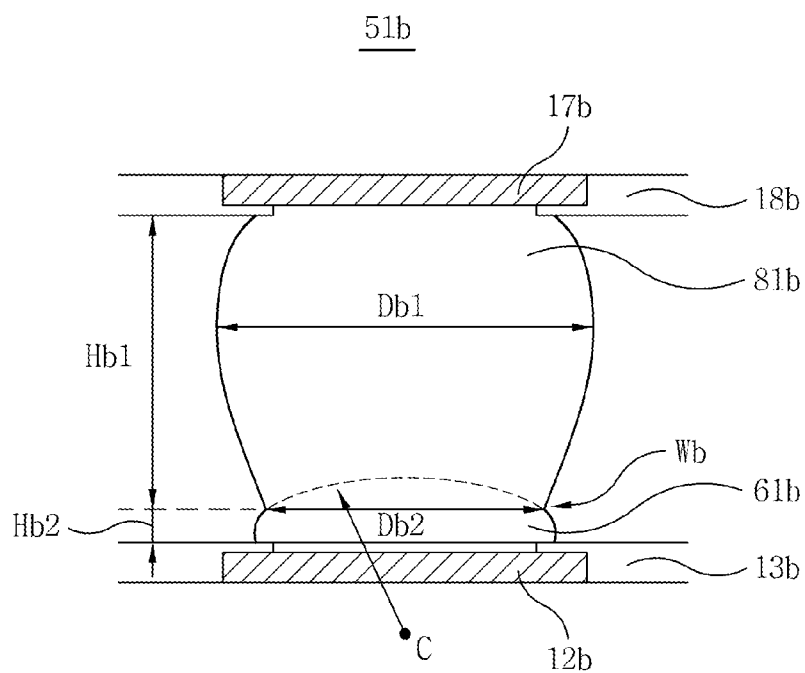


FIG. 8C

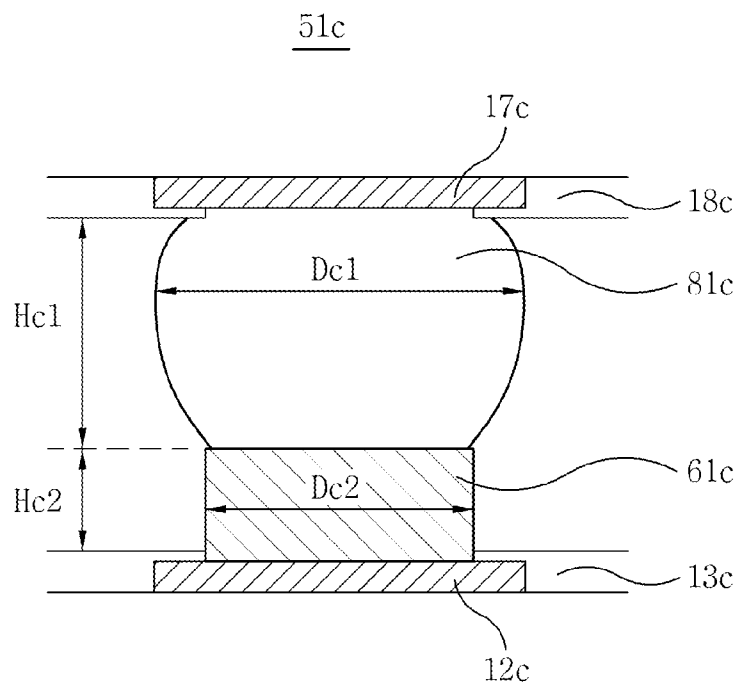


FIG. 8D

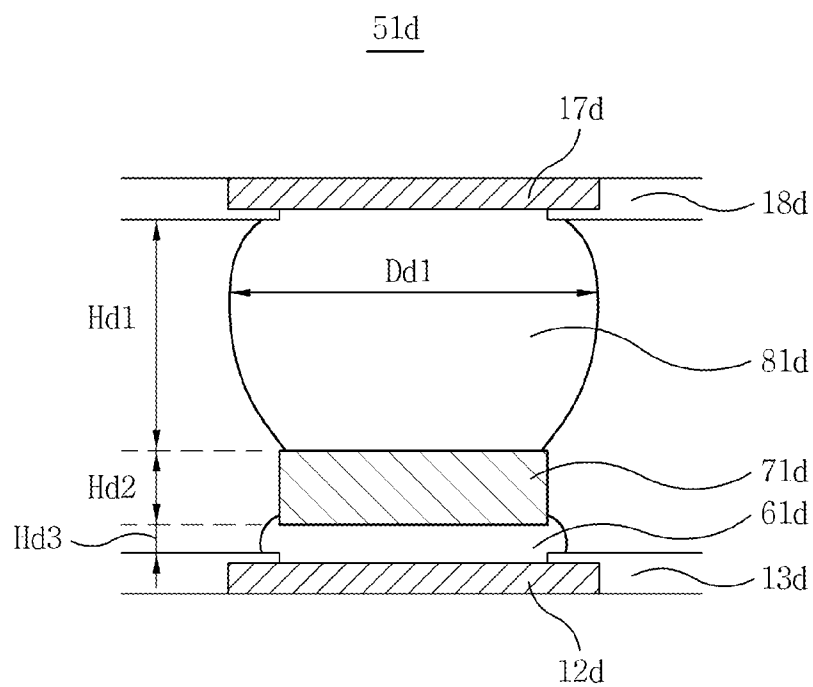


FIG. 8E

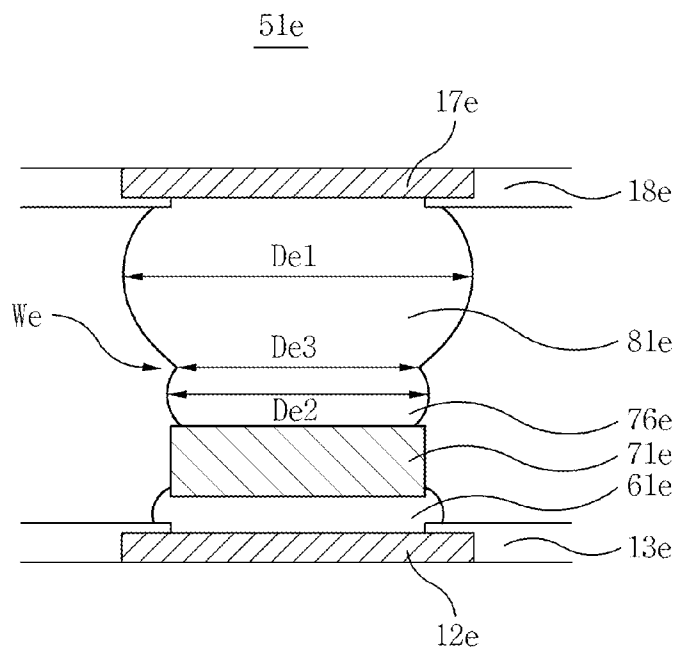


FIG. 8F

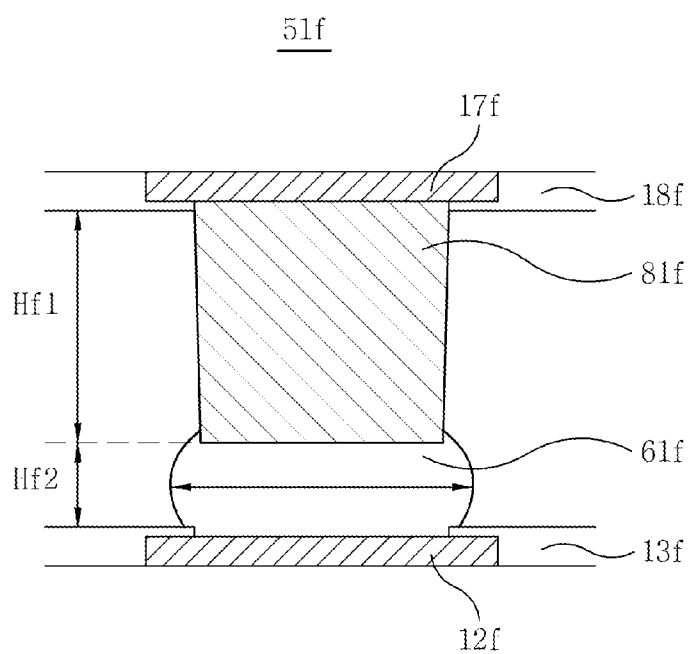


FIG. 8G

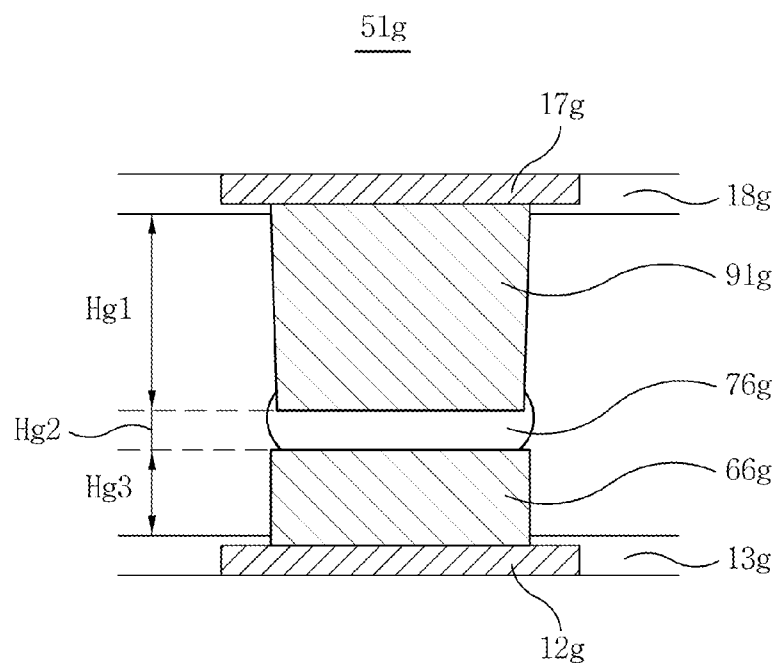


FIG. 8H

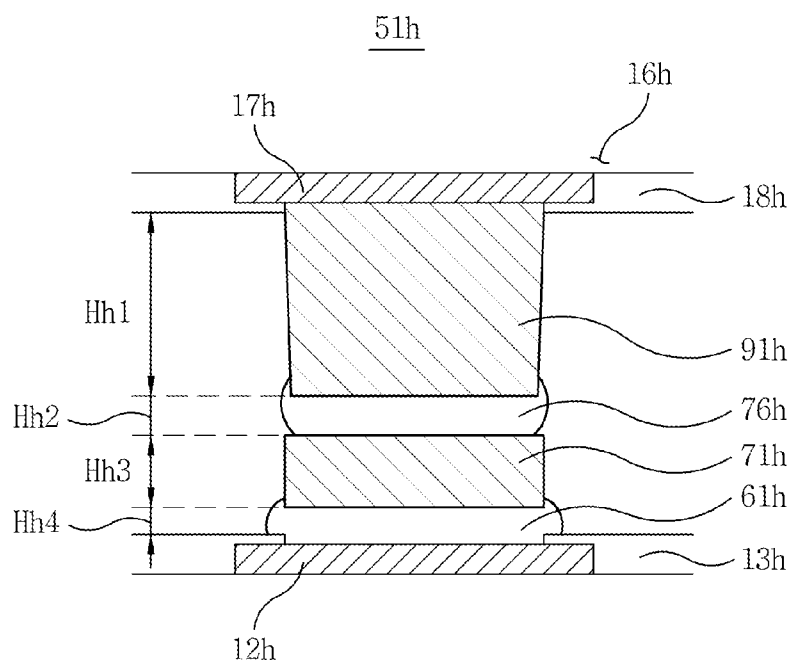




FIG. 8I

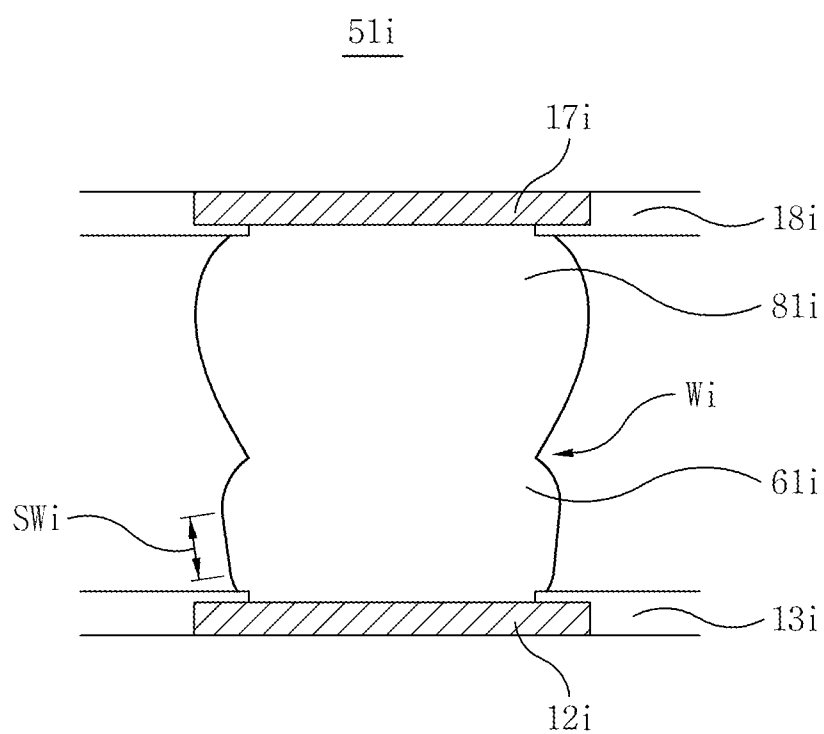


FIG. 9A

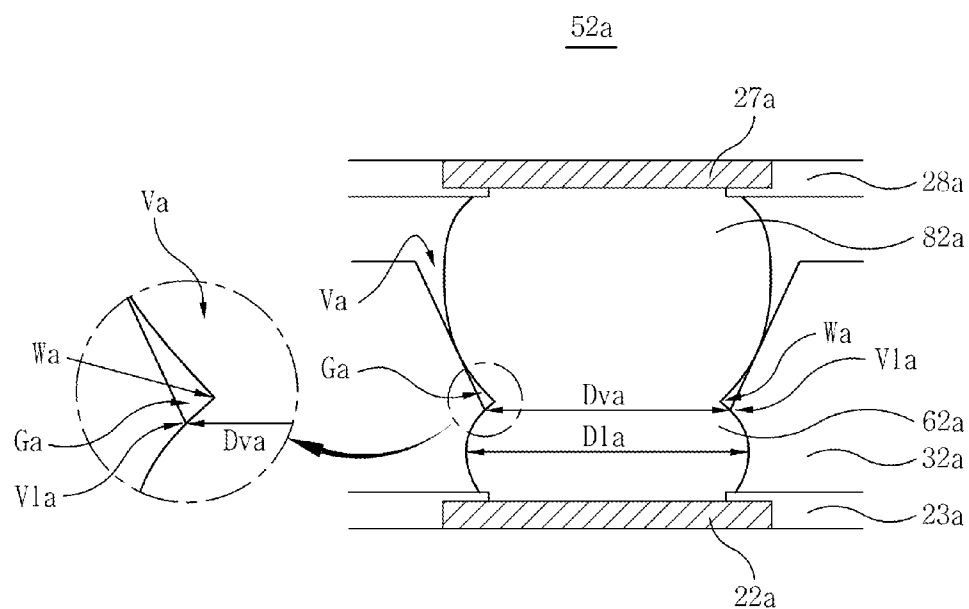


FIG. 9B

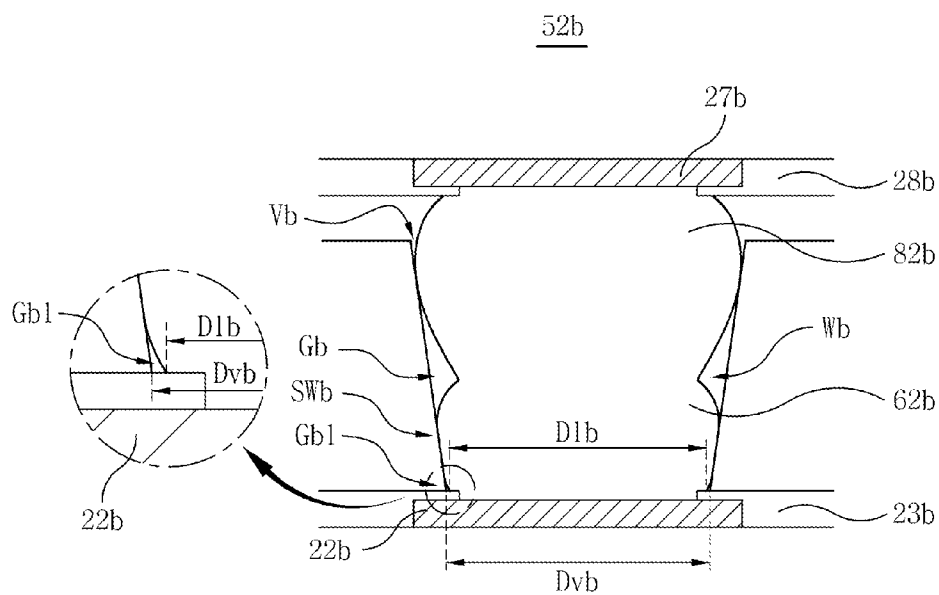


FIG. 9C

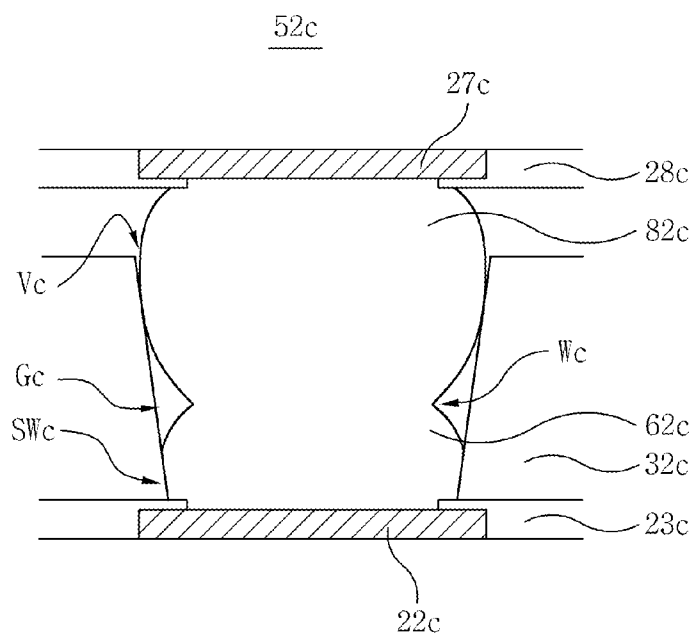


FIG. 9D

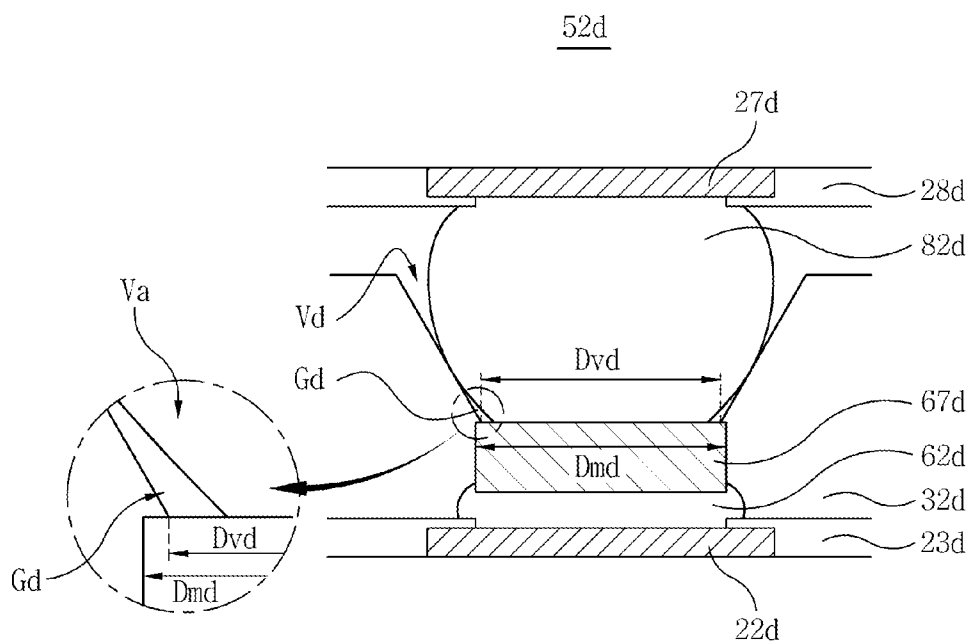


FIG. 9E

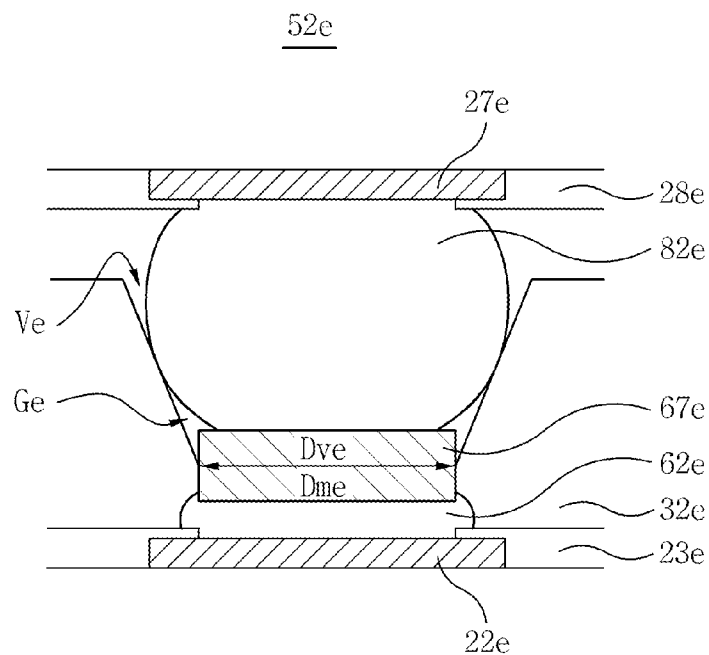


FIG. 9F

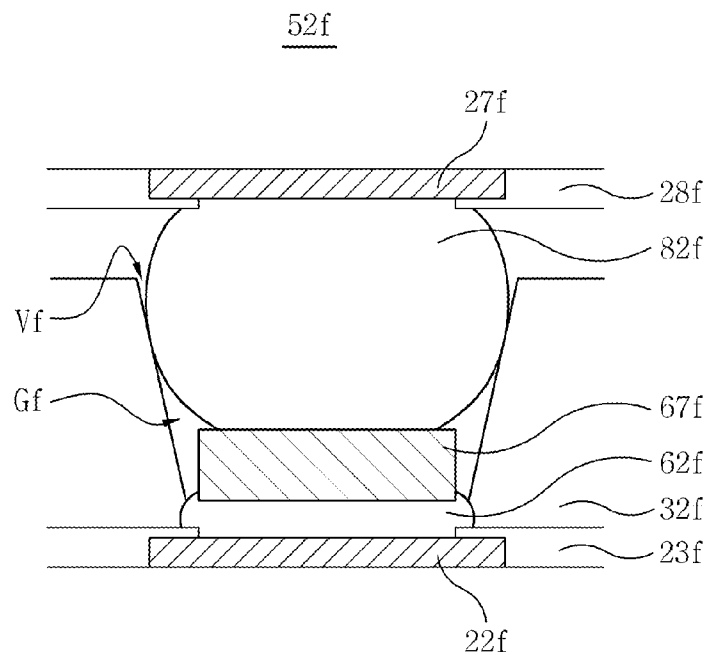


FIG. 9G

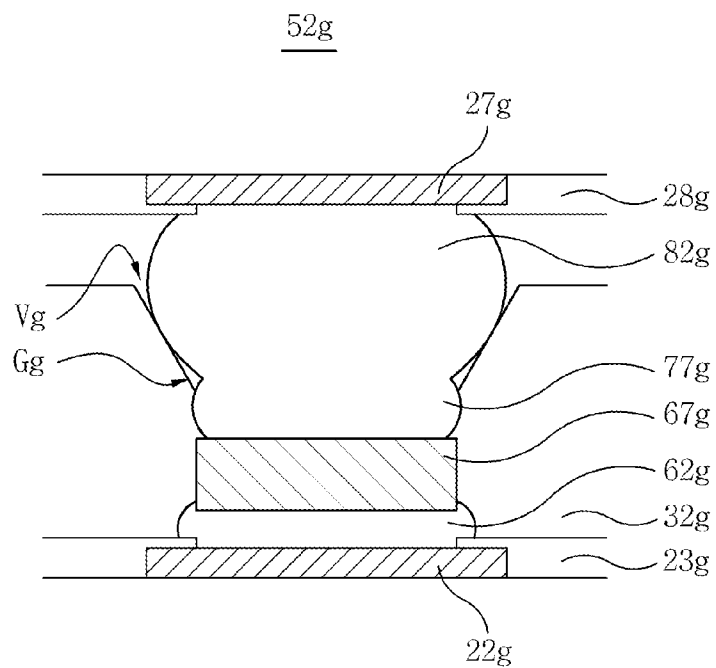


FIG. 9H

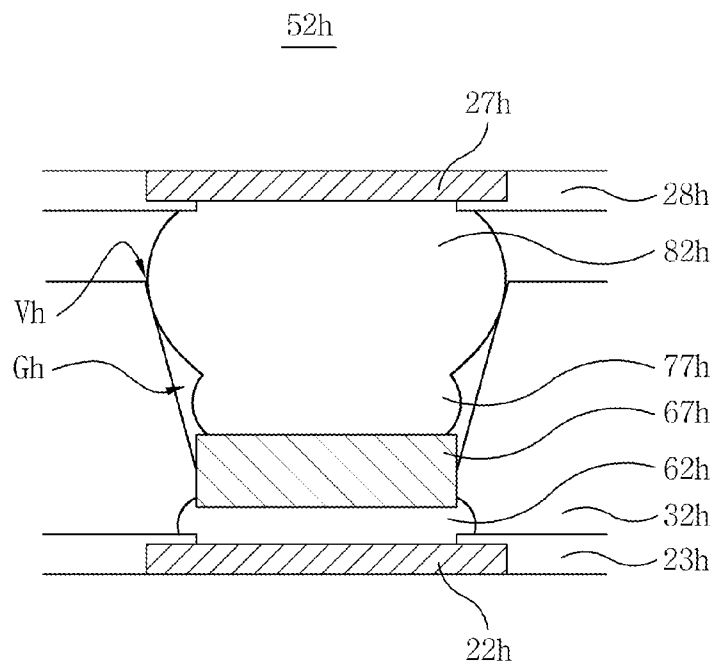


FIG. 9I

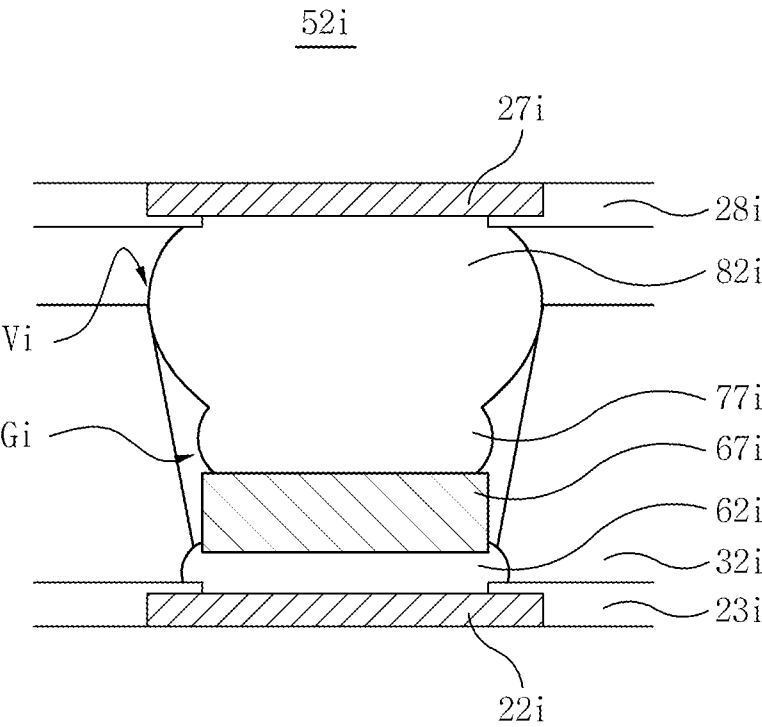


FIG. 10A

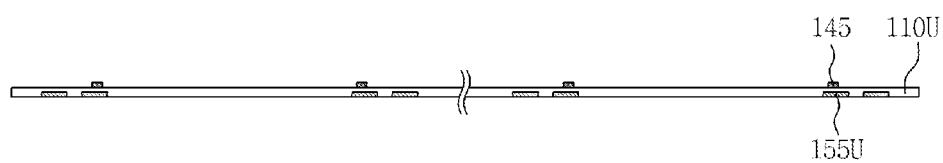


FIG. 10B

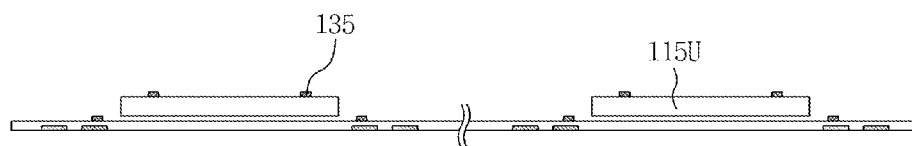


FIG. 10C

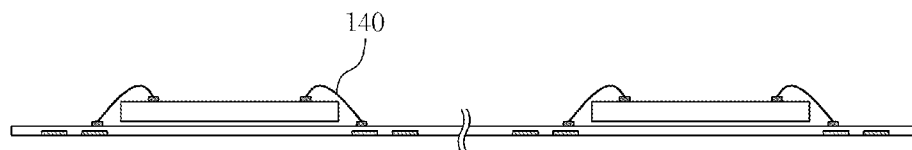


FIG. 10D



FIG. 10E

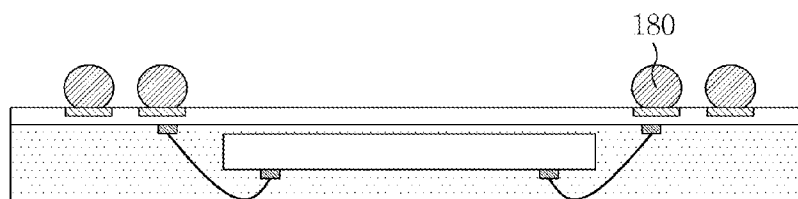


FIG. 10F

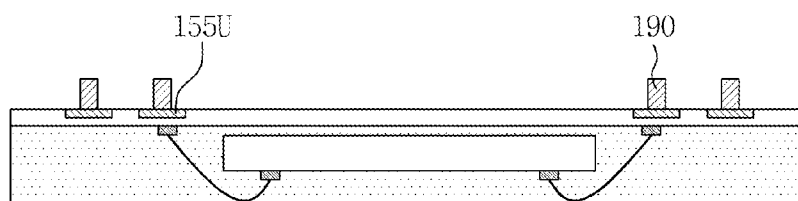




FIG. 11A

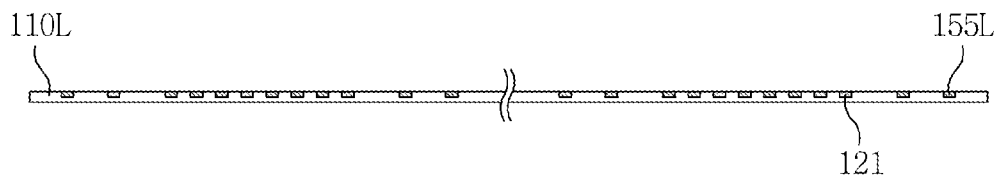


FIG. 11B

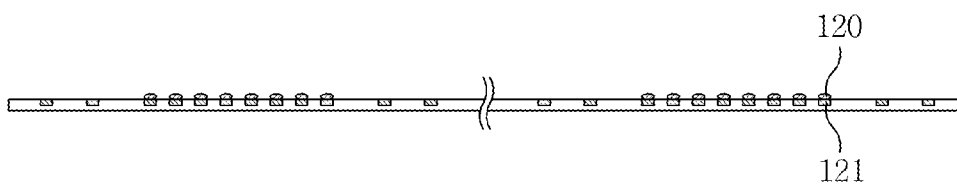


FIG. 11C

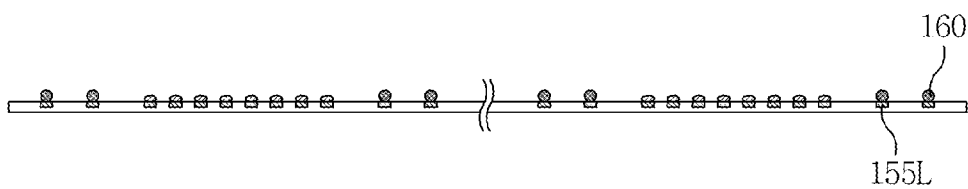


FIG. 11D

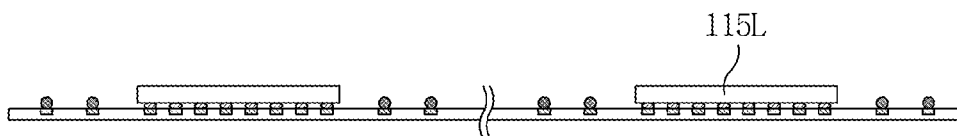


FIG. 11E

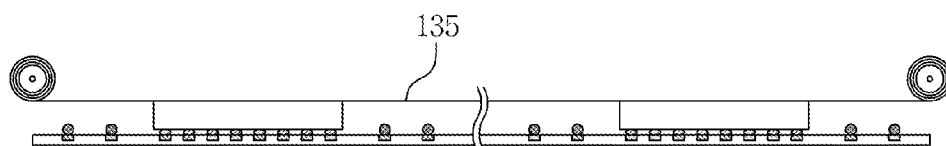


FIG. 11F

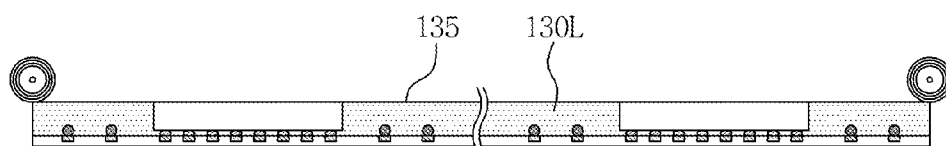


FIG. 11G

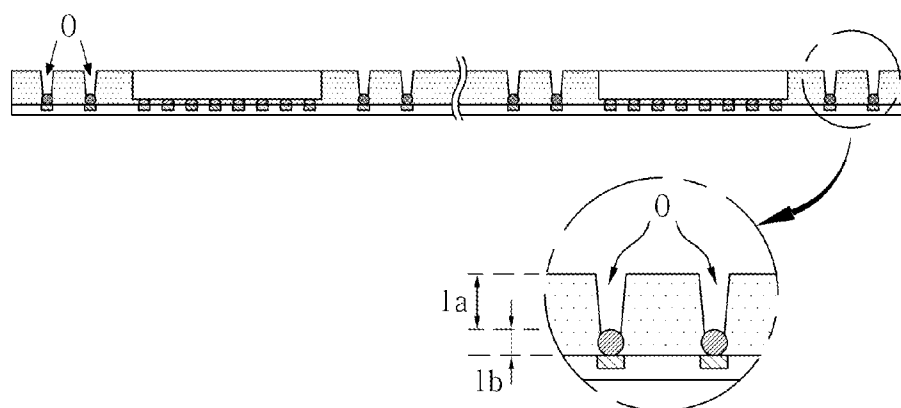


FIG. 11H

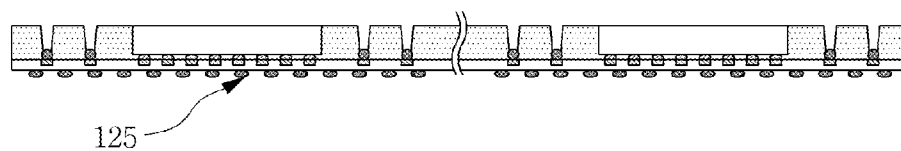


FIG. 11I

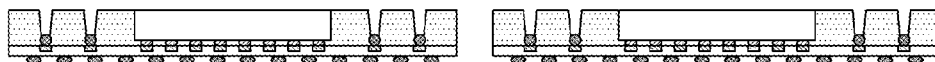


FIG. 11J

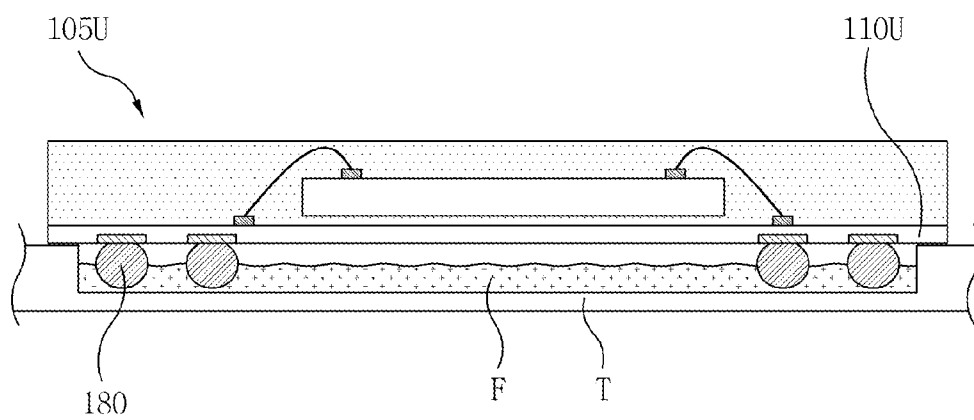


FIG. 11K

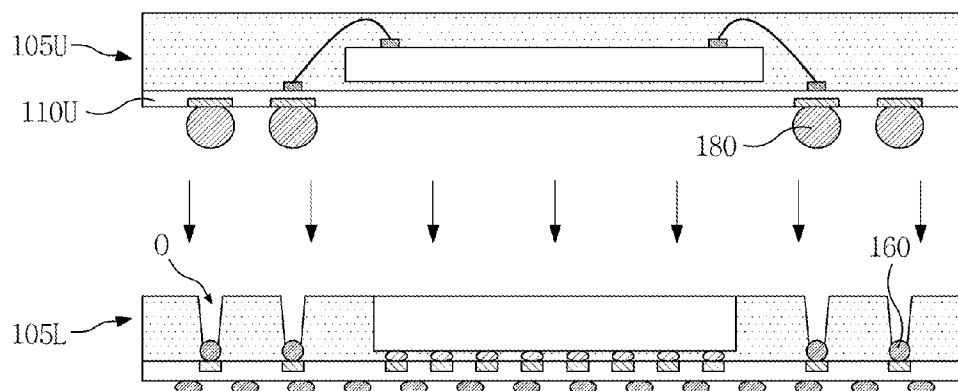


FIG. 11L

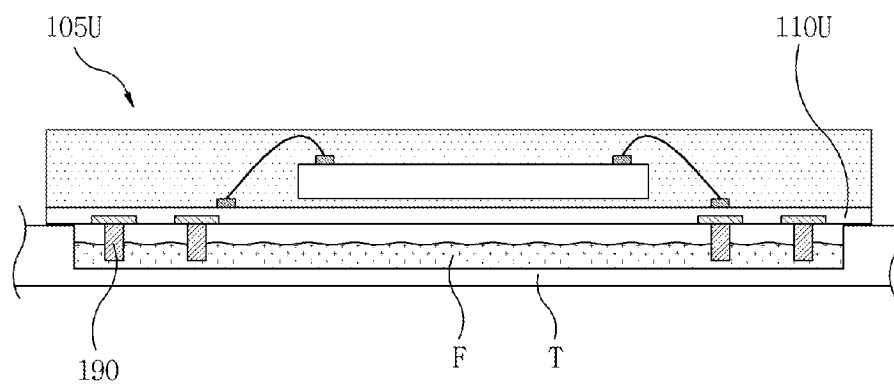


FIG. 12A

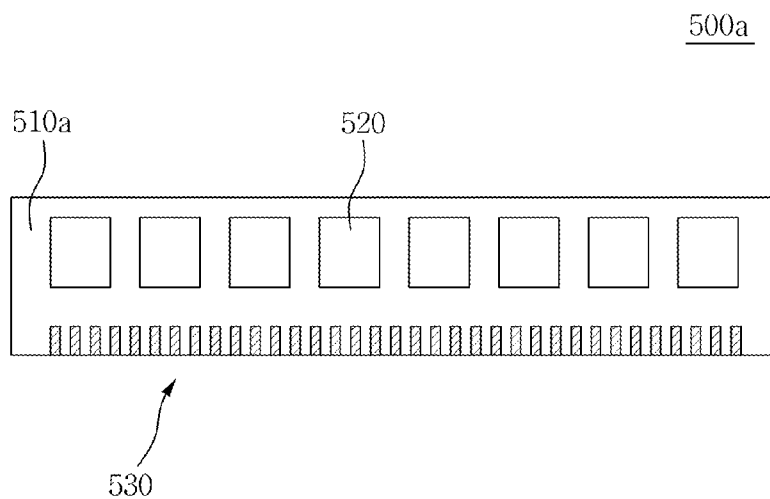


FIG. 12B

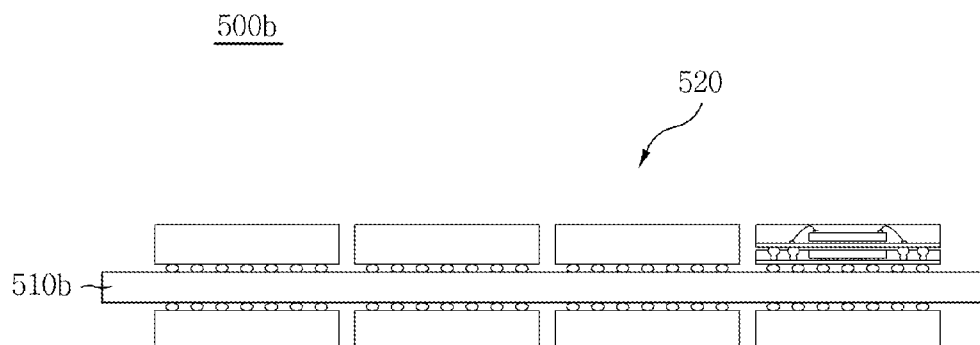
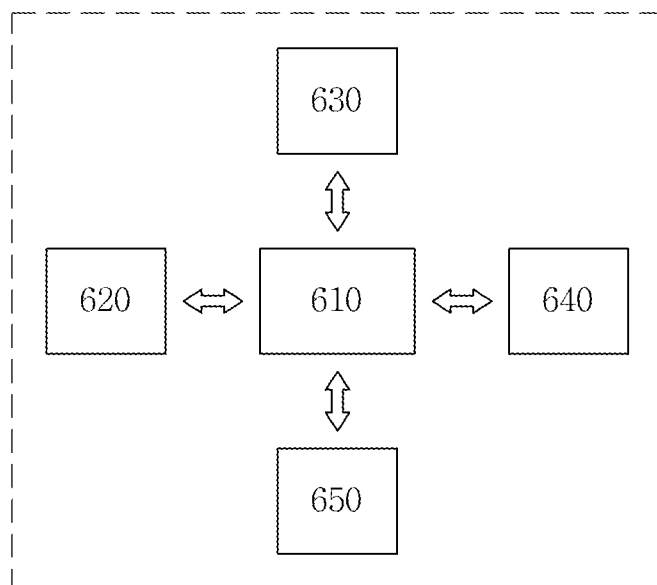


FIG. 13

600

# **STACKED SEMICONDUCTOR PACKAGES, METHODS FOR FABRICATING THE SAME, AND /OR SYSTEMS EMPLOYING THE SAME**

## **CROSS-REFERENCE TO RELATED APPLICATIONS**

**[0001]** This application is a Continuation application of U.S. application Ser. No. 13/934,942, filed Jul. 3, 2013, now allowed, which is a divisional application of U.S. application Ser. No. 12/910,415, filed Oct. 22, 2010, now U.S. Pat. No. 8,508,954 issued Aug. 13, 2013, which claims priority to Korean Patent Applications No. 10-2009-0126345 filed on Dec. 17, 2009 and No. 10-2010-0052827 filed on Jun. 4, 2010, the entire disclosures of each of which are incorporated herein by reference.

## **BACKGROUND**

**[0002]** 1. Technical Field

**[0003]** The present disclosure relates to stacked semiconductor packages, and more particularly to stacked semiconductor packages and methods of fabricating the same.

**[0004]** 2. Description of Related Art

**[0005]** Package on Package (PoP) is an integrated circuit packaging technique to allow vertically combining discrete logic and memory ball grid array (BGA) packages. Two or more packages are stacked with an interface to route signals between them. This allows higher density, for example in the mobile telephone/PDA market. In the PoP, two or more memory packages can be stacked on top of each other. Alternatively, a memory package can be stacked on a logic package. Using the PoP technique, space in the motherboard can be saved.

## **SUMMARY**

**[0006]** Example embodiments relate to stacked semiconductor chip packages, methods of the fabrication the same and/or systems employing the same.

**[0007]** According to an exemplary embodiment, an apparatus comprises a first substrate comprising a first land and a second substrate comprising a second land, a first molding compound disposed between the first substrate and the second substrate, a first semiconductor chip disposed on the first substrate and in contact with the first molding portion, and a first connector contacting the first land and a second connector contacting the second land, the second connector disposed on the first connector, wherein a volume of the second connector is greater than a volume of the first connector, a surface of the first semiconductor chip is exposed, and the first molding compound is in contact with the second connector, and at least a portion of the second connector is surrounded by the first molding compound.

**[0008]** The first connector can be disposed in the first molding compound.

**[0009]** A portion of the second connector may not be disposed in the first molding compound.

**[0010]** The apparatus may further comprise a second semiconductor chip disposed on the second substrate.

**[0011]** The apparatus may further comprise a second molding compound in contact with the second semiconductor chip.

**[0012]** The first and second substrates may comprise a PCB or a ceramic substrate.

**[0013]** The first and second connectors can be configured to transmit power or signals.

**[0014]** The first semiconductor chip may comprise a logic device, and the second semiconductor chip comprises a memory device.

**[0015]** The first connector and the second connector can be solder balls.

**[0016]** The first semiconductor chip may comprise a plurality of vertical TSVs therein.

**[0017]** The apparatus may further comprise a third connector disposed between the first connector and the second connector.

**[0018]** According to an exemplary embodiment, an electronic system comprises a control unit, an input unit configured to transmit an electrical signal to the control unit, an output unit configured to receive the electrical signal from the control unit and to output a processing result of the electronic system, a storage unit configured to store data to be processed or already processed by the control unit, and a communication unit configured to receive the electrical signal from the control unit and to transmit or to receive the electrical signal to or from another electronic system, wherein at least one of the control unit, the input unit, the output unit, the storage unit, and the communication unit includes the apparatus comprising a first substrate comprising a first land and a second substrate comprising a second land, a first molding compound disposed between the first substrate and the second substrate, a first semiconductor chip disposed on the first substrate and in contact with the first molding portion, and a first connector contacting the first land and a second connector contacting the second land, the second connector disposed on the first connector, wherein a volume of the second connector is greater than a volume of the first connector, a surface of the first semiconductor chip is exposed, and the first molding compound is in contact with the second connector, and at least a portion of the second connector is surrounded by the first molding compound.

**[0019]** The control unit may comprise at least one of a central processing unit (CPU), a main control unit (MCU), a semiconductor module.

**[0020]** The input unit may comprise at least one of a keyboard, a keypad, a mouse, a touch pad, or an image recognizer.

**[0021]** The output unit may comprise at least one of a monitor, a printer, or a beam emitter.

**[0022]** The storage unit may comprise at least one of a semiconductor memory device, a magnetic storage device, and optical storage device, or a server having a data storage function.

**[0023]** The communication unit may comprise at least one of a wired transceiving device, a wireless transceiving device, or an infrared (IR) port.

**[0024]** The electronic system can be at least one of a computer, a network server, a networking printer, a scanner, a wireless controller, a mobile communication terminal, a switching system, or any electronic device capable of programmed operations.

**[0025]** According to an exemplary embodiment, a method may comprise disposing a first semiconductor chip on a first substrate, disposing a first connector on a land of the first substrate, placing a first molding compound on the first substrate and in contact with the first semiconductor chip and the first connector, exposing a surface of the first substrate, and forming an opening through the first molding compound to expose a portion of the first connector.

**[0026]** The method may further comprise disposing a second connector and a second semiconductor chip on a second substrate, and coupling the first connector to the second connector.

**[0027]** The second connector can have a larger volume than the first connector.

**[0028]** The method may further comprise placing a second molding compound in contact with the second semiconductor chip and the second connector.

**[0029]** The method may further comprise dipping the second connector into solder flux.

**[0030]** The first and second connectors can be solder balls.

**[0031]** The second connector can have a larger radius than the first connector.

**[0032]** According to an exemplary embodiment, a method comprises disposing a first semiconductor chip and a first solder ball on a first substrate, placing a molding compound on the first substrate and in contact with the first semiconductor chip and the first solder ball, forming an opening through the molding compound to expose a portion of the first connector, disposing a second semiconductor chip and a second solder ball on a second substrate, and coupling the first solder ball to the second solder ball, wherein a radius of the first solder ball is greater than a radius of the second solder ball.

**[0033]** The method may further comprise exposing a surface of the first substrate.

**[0034]** The second solder ball can have a larger volume than the first solder ball.

**[0035]** The method may further comprise placing a second molding compound in contact with the second semiconductor chip and the second solder ball.

**[0036]** The method may further comprise dipping the second solder ball into solder flux.

#### BRIEF DESCRIPTION OF THE DRAWINGS

**[0037]** Exemplary embodiments of the present invention can be understood in more detail from the following descriptions taken in conjunction with the accompanying drawings, in which:

**[0038]** FIG. 1A is a schematic plan view of a lower semiconductor package according to an embodiment of the inventive concepts;

**[0039]** FIG. 1B is a schematic plan view of a lower semiconductor package according to an embodiment of the inventive concepts;

**[0040]** FIGS. 2A through 2H are schematic longitudinal sectional views of an apparatus according to embodiments of the inventive concepts;

**[0041]** FIGS. 3A and 3B are schematic longitudinal sectional views of apparatuses including chip connectors according to embodiments of the inventive concepts;

**[0042]** FIG. 4 is schematic longitudinal sectional view of an apparatus according to an embodiment of the inventive concepts;

**[0043]** FIGS. 5A through 5D are schematic longitudinal sectional views of chip connectors and connection structures thereof according to embodiments of the inventive concepts;

**[0044]** FIGS. 6A through 6D are schematic longitudinal sectional views of chip connectors and connection structures thereof according to embodiments of the inventive concepts;

**[0045]** FIGS. 7A through 7D are schematic longitudinal sectional views of various inter-package connectors according to embodiments of the inventive concepts;

**[0046]** FIGS. 8A through 8I are schematic diagrams of real shapes of various connectors of package stack structures according to the general inventive concepts;

**[0047]** FIGS. 9A through 9I are schematic diagrams of shapes of various connectors and via holes of package stack structures according to the general inventive concepts;

**[0048]** FIGS. 10A through 10F are schematic longitudinal sectional views illustrating a process of forming an upper package in a method of fabricating a stack structure of semiconductor packages according to the general inventive concepts;

**[0049]** FIGS. 11A through 11L are schematic longitudinal sectional views illustrating a method of fabricating a stack structure of semiconductor packages according to the general inventive concepts;

**[0050]** FIGS. 12A and 12B are schematic diagrams of semiconductor modules including a stack structure of semiconductor packages according to the general inventive concepts; and

**[0051]** FIG. 13 is a schematic diagram of an electronic system including a stack structure of semiconductor packages according to the general inventive concepts.

#### DETAILED DESCRIPTION OF THE EMBODIMENTS

**[0052]** Example embodiments of inventive concepts will be described with reference to accompanying drawings.

**[0053]** Although a few example embodiments of inventive concepts are shown and described, it would be appreciated by those of ordinary skill in the art that changes may be made in these example embodiments without departing from the principles and spirit of example embodiments, the scope of which is defined in the claims and their equivalents.

**[0054]** It will be understood that when an element or layer is referred to as being “on” another element or layer, the element or layer can be directly on another element or layer or intervening elements or layers. In contrast, when an element is referred to as being “directly on” another element or layer, there are no intervening elements or layers present. Like numbers refer to like elements throughout. As used herein, the term “and/or” includes any and all combinations of one or more of the associated listed items.

**[0055]** The terminology used herein is for the purpose of describing particular embodiments only and is not intended to be limiting of the invention. As used herein, the singular forms “a”, “an” and “the” are intended to include the plural forms as well, unless the context clearly indicates otherwise. It will be further understood that the terms “comprises” and/or “comprising,” when used in this specification, specify the presence of stated features, integers, steps, operations, elements, and/or components, but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, and/or groups thereof.

**[0056]** It will be understood that, although the terms first, second, third, etc., may be used herein to describe various elements, components, regions, layers and/or sections, these elements, components, regions, layers and/or sections should not be limited by these terms. These terms are only used to distinguish one element, component, region, layer or section from another region, layer or section. Thus, a first element, component, region, layer or section discussed below could be termed a second element, component, region, layer or section without departing from the teachings of example embodiments.



[0057] Example embodiments of inventive concepts are described herein with reference to cross-section illustrations that are schematic illustrations of example embodiments (and intermediate structures) of inventive concepts. As such, variations from the shapes of the illustrations as a result, for example, of manufacturing techniques and/or tolerances, are to be expected. Thus, example embodiments should not be construed as limited to the particular shapes of regions illustrated herein but are to include deviations in shapes that result, for example, from manufacturing.

[0058] FIG. 1A is a schematic plan view of a lower semiconductor package according to an embodiment of the inventive concepts. In FIG. 1A, a lower semiconductor chip is disclosed. FIG. 1B is a schematic plan view of a lower semiconductor package according to an exemplary embodiment. In FIG. 1B, a lower semiconductor chip is not disclosed.

[0059] Referring to FIG. 1A, a lower semiconductor package 105L may include a lower package substrate 110L, a lower semiconductor chip 115L disposed on the lower package substrate 110L, and a plurality of inter-package connectors 150 disposed around the lower semiconductor chip 115L. Referring to FIG. 1B, the dotted lines indicate a location configured to receive the lower semiconductor chip 115L. According to an embodiment, the lower semiconductor package 105L may include a plurality of flip chip landing pads 185 disposed between the lower package substrate 110L and the lower semiconductor chip 115L. The flip chip landing pads 185 can be surrounded by the plurality of inter-package connectors 150. The flip chip landing pads 185 may be electrically connected to other elements such as, for example, through silicon vias (TSVs), through silicon via plugs and/or conductive chip bumps.

[0060] FIGS. 2A through 2H are schematic longitudinal sectional views of an apparatus according to embodiments of the inventive concepts.

[0061] Referring to FIG. 2A, an apparatus 100a includes a lower semiconductor package 105L, an upper semiconductor package 105U, and inter-package connectors 150a configured to electrically connect the lower and upper semiconductor packages 105L and 105U. The upper semiconductor package 105U is stacked on the lower semiconductor package 105L. A portion of the inter-package connectors 150a may be a part of the lower semiconductor package 105L. Another portion of the inter-package connectors 150a may be a part of the upper semiconductor package 105U.

[0062] The lower semiconductor package 105L may include a lower package substrate 110L, a lower semiconductor chip 115L disposed on a top surface of the lower package substrate 110L, a lower molding compound 130L, and conductive solder balls 125 disposed on a bottom surface of the lower package substrate 110L. The lower semiconductor package 105L may be formed using, for example, a flip-chip technique. The lower package substrate 110L may comprise, for example, a printed circuit board (PCB) or a ceramic substrate.

[0063] The lower semiconductor chip 115L may comprise a logic device, such as a microprocessor. The lower semiconductor chip 115L may be disposed on one surface of the lower package substrate 110L. The lower semiconductor chip 115L may be electrically connected to the solder balls 125 through conductive chip bumps 120. The conductive chip bumps 120 may be disposed on the top surface of the lower semiconductor substrate 110L. That is, the lower semiconductor chip

115L may include a flip-chip connection structure having a grid array according to an embodiment of the inventive concepts.

[0064] The conductive chip bumps 120 may be interposed between the lower package substrate 110L and the lower semiconductor chip 115L. The conductive chip bumps 120 may electrically connect the lower package substrate 110L and the lower semiconductor chip 115L. The conductive chip bumps 120 may include a solder material. Thus, the conductive chip bumps 120 may be formed using, for example, a soldering process.

[0065] The conductive solder balls 125 are configured to electrically connect the apparatus 100a to a module board or a main circuit board.

[0066] The lower molding compound 130L covers the conductive chip bumps 120. An adhesive may be formed around the conductive chip bumps 120. For example, the adhesive can be disposed between the lower semiconductor chip 115L and the lower package substrate 110L. The lower molding compound 130L surrounds a lateral surface of the lower semiconductor chip 115L. For example, the lower semiconductor chip 115L may be adhered to the top surface of the lower semiconductor package 105L using the adhesive, and the lower molding compound 130L may surround the lateral surface of the lower semiconductor chip 115L.

[0067] In an embodiment, the adhesive may be included in the lower molding compound 130L. In an embodiment, the lower molding compound 130L may surround lateral surfaces of the inter-package connectors 150a. In an embodiment, a top surface of the lower semiconductor chip 115L may not be covered with the lower molding compound 130L. In other words, the top surface of the lower semiconductor chip 115L is exposed. In an embodiment, a top surface of the lower molding compound 130L is coplanar with the top surface of the lower semiconductor chip 115L. In an embodiment, since a thickness of the lower semiconductor package 105L is reduced, a thickness of the apparatus 100a is also reduced. Since the top of the lower semiconductor chip 115L is exposed, heat can be dissipated without being interrupted by the epoxy molding compound (EMC). As such, heat radiation property can be improved. Since the lower semiconductor package 105L has a better tolerance or resistance against a high-temperature process as compared to the one covered by the EMC, the lower semiconductor package 105L may have a better tolerance or resistance against warpage or distortion so that the flatness of the lower semiconductor package 105L and the lower semiconductor chip 115L can be improved.

[0068] Since physical pressure may be directly applied to top surface of the lower semiconductor chip 115L without passing through a molding material, a grid array technique or a multilayered molding technique can be stably performed. When the thickness of the lower molding compound 130L is reduced, the entire height of the inter-package connectors 150a may be reduced. Since the inter-package connectors 150a are formed using a soldering process (e.g., a reflow process), when the entire height of the inter-package connectors 150a is reduced, the maximum horizontal width of the inter-package connectors 150a may be reduced. This is because structures formed using the soldering process may be substantially spherical. When the maximum horizontal width of the inter-package connectors 150a is reduced, a volume of the inter-package connectors 150a may be reduced. As such, an interval or pitch between the inter-package connectors

**150a** may be reduced. Thus, when the thickness of the lower molding compound **130L** is reduced, more numbers of the inter-package connectors **150a** may be formed in a given area. According to an embodiment of the inventive concepts, the apparatus **100a** having finer and more equally distanced inter-package connectors **150a** may be formed.

[0069] The upper semiconductor package **105U** may include an upper package substrate **110U** and an upper semiconductor chip **115U**. The upper package substrate **110U** may comprise, for example, a PCB or a ceramic substrate.

[0070] The upper semiconductor chip **115U** may comprise a memory device, such as a dynamic random access memory (DRAM) device or a flash memory device. The upper semiconductor chip **115U** may have a greater horizontal width than the lower semiconductor chip **115L**. When the upper semiconductor chip **115U** is wider than the lower semiconductor chip **115L** in a horizontal direction, since an area occupied by the inter-package connectors **150a** may be increased, the stack structure **100a** of the semiconductor packages may be formed to a smaller size. When the area occupied by the inter-package connectors **150a** is increased, a larger number of the inter-package connectors **150a** may be formed. Alternatively, when a same number of the inter-package connectors **150a** is formed, the stack structure **100a** of the semiconductor packages may be reduced.

[0071] The upper semiconductor chip **115U** may be disposed on a top surface of the upper package substrate **110U**. The upper semiconductor chip **115U** may be electrically connected to the upper package substrate **110U** through bonding pads **135**, bonding wires **140**, and wire pads **145**.

[0072] The bonding pads **135** may be formed on a top surface of the upper semiconductor chip **115U**. The wire pads **145** may be formed on the top surface of the upper package substrate **110U**. The bonding wires **140** may electrically connect the bonding pads **135** with the wire pads **145**, respectively.

[0073] The upper semiconductor chip **115U** may be covered with an upper molding compound **130U**.

[0074] The inter-package connectors **150a** may physically or electrically connect the lower semiconductor package **105L** with the upper semiconductor package **105U**. The inter-package connectors **150a** may include lower connectors **160a** and upper connectors **180a**, respectively. The lower and upper connectors **160a** and **180a** may include a solder material.

[0075] The upper semiconductor chip **115U** may have a larger horizontal width than the lower semiconductor chip **115L**. According to an embodiment of the inventive concepts, the inter-package connectors **150a** may be formed above or on a top surface of the lower package substrate **110L** where the lower semiconductor chip **115L** is formed. The inter-package connectors **150a** may be formed below or on a bottom surface of the upper package substrate **110U** where the upper semiconductor chip **115U** is not formed. Thus, the inter-package connectors **150a** may be affected by the size of the lower semiconductor chip **115L**. An area standard of the stack structure **100a** of the semiconductor packages may be determined based on semiconductor standard rules such as the Joint Electron Device Engineering Council (JEDEC) rules. Thus, when the lower semiconductor chip **115L** is greater in size than the upper semiconductor chip **115U**, restrictions of a space, where the inter-package connectors **150a** may be formed, may be increased with reduced efficiency. According to an embodiment of the inventive concepts, when the upper semiconductor chip **115U** is greater in

size than the lower semiconductor chip **115L**, spatial restrictions may be reduced, and efficiency may be improved. Therefore, according to an embodiment of the inventive concepts, the upper semiconductor chip **115U** may be formed to be greater in size than the lower semiconductor chip **115L**. Referring to FIG. 2B, an apparatus **100b** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150b** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The inter-package connectors **150b** may include lower connectors **160b** and upper connectors **180b**. The lower and upper connectors **160b** and **180b** may comprise a solder material. The lower connectors **160b** may have a hemispherical shape.

[0076] Referring to FIG. 2C, an apparatus **100c** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150c** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The upper semiconductor package **105U** is stacked on the lower semiconductor package **105L**. The inter-package connectors **150c** may include bottom connectors **165c** and upper connectors **180c**. Each of the bottom connectors **165c** may be formed as a mesa or pillar shape. For example, each of the bottom connectors **165c** may be formed as a circular, cylindrical or polygonal pillar shape.

[0077] The bottom connectors **165c** may be attached to a top surface of the lower package substrate **110L**. For example, the bottom connectors **165c** may comprise metal. The bottom connectors **165c** may be formed using, for example, a casting process, a deposition process, a bonding process, or a plating process.

[0078] A metallic barrier layer may be formed on the surfaces of the bottom connectors **165c**. For example, main bodies of the bottom connectors **165c** may comprise copper (Cu), and a nickel (Ni) barrier layer may be formed on the surfaces of the bottom connectors **165c**.

[0079] Although it is illustrated that the upper connectors **180c** are greater in size than the bottom connectors **165c**, the present inventive concepts is not limited thereto.

[0080] The processes of forming the bottom connectors **165c** as a mesa shape on the top surface of the lower package substrate **110L** may be less affected by a distance between the bottom connectors **165c** than a soldering process. Thus, the bottom connectors **165c** may be formed in various shapes. For instance, each of the bottom connectors **165c** may have a smaller horizontal size and a greater vertical size than the one shown in FIG. 2C. In this case, only small portions of the upper connectors **180c** may be formed below the surface of the lower molding compound **130L**. In other words, the center of the upper connector **180c** may be formed above a top surface of the lower molding compound **130L**. Although it is illustrated that each of the upper connectors **180c** has an almost circular sectional shape, the inventive concepts is not limited thereto. For example, each of the upper connectors **180c** may have an elliptical sectional shape. The upper connectors **180c** may include a solder material.

[0081] Referring to FIG. 2D, an apparatus **100d** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150d** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The upper semiconductor package **105U** is stacked on the lower semiconductor package **105L**. The inter-package connectors **150d** may

include lower connectors **160d**, intermediate connectors **170d**, and upper connectors **180d**. Each of the lower connectors **160d** may have a spherical shape or a hemispherical shape. An imaginary center of each of the lower connectors **160d** may be formed above or below the top surface of the lower package substrate **110L**. The intermediate connectors **170d** may have a mesa shape and attached to top surfaces of the lower connectors **160d**. The intermediate connectors **170d** may comprise copper (Cu). A metallic barrier layer, for example, a nickel (Ni) barrier layer, may be formed on the surfaces of the intermediate connectors **170d**. The lower and upper connectors **160d** and **180d** may comprise a solder material.

**[0082]** Referring to FIG. 2E, an apparatus **100e** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150e** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The upper semiconductor package **105U** is stacked on the lower semiconductor package **105L**. The inter-package connectors **150e** may include lower connectors **160e**, intermediate connectors **170e**, intermediate adhesion parts **175e**, and upper connectors **180e**. The lower connectors **160e** and the intermediate connectors **170e** may be understood with reference to the descriptions of the lower connectors **160b** and **160d**, the bottom connectors **165c**, and the intermediate connectors **170d** shown in FIGS. 2B through 2D. The intermediate adhesion parts **175e** may be formed on the intermediate connectors **170e**. Although each of the intermediate adhesion parts **175e** has an elliptical sectional shape, the inventive concepts is not limited thereto. For example, each of the intermediate adhesion parts **175e** may have a spherical or hemispherical shape. In this case, the shape of the intermediate adhesion parts **175e** may be understood with reference to the descriptions of the lower connectors **160b** and **160d** shown in FIGS. 2B and 2D. In an embodiment, the center of the intermediate adhesion parts **175e** may be formed above or below top surfaces of the intermediate connectors **170e**. The lower connectors **160e**, the intermediate adhesion parts **175e**, and the upper connectors **180e** may include a solder material.

**[0083]** Referring to FIG. 2F, an apparatus **100f** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150f** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The upper semiconductor package **105U** is stacked on the lower semiconductor package **105L**. The inter-package connectors **150f** may include lower connectors **160f** and package bumps **190f**. The lower connectors **160f** may be understood with reference to FIG. 2A and the description thereof. Each of the package bumps **190f** may comprise a metal and may have a stud, stick, or pillar shape. The package bumps **190f** may be fabricated using an additional process and attached or fixed to the upper package substrate **110U**. The package bumps **190f** may comprise copper (Cu). A metallic barrier layer comprising, for example, a nickel (Ni) barrier layer, may be formed on the surfaces of the package bumps **190f**. The lower and upper connectors **160d** and **180d** may include a solder material.

**[0084]** Referring to FIG. 2G, an apparatus **100g** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150g** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The upper semiconductor package **105U** is stacked on the lower semiconductor

package **105L**. The inter-package connectors **150g** may include bottom connectors **165g**, intermediate adhesion parts **175g**, and package bumps **190g**. The bottom connectors **165g**, the intermediate connectors **175g**, and the package bumps **190g** may be understood with reference to FIGS. 2C through 2G and the descriptions thereof.

**[0085]** Referring to FIG. 2H, an apparatus **100h** may include a lower semiconductor package **105L**, an upper semiconductor package **105U**, and inter-package connectors **150h** configured to electrically connect the lower and upper semiconductor packages **105L** and **105U**. The upper semiconductor package **105U** is stacked on the lower semiconductor package **105L**. The inter-package connectors **150h** may include lower connectors **160h**, intermediate connectors **170h**, intermediate adhesion parts **175h**, and package bumps **190h**. The lower connectors **160h**, the intermediate connectors **170h**, the intermediate adhesion parts **175h**, and the package bumps **190h** may be understood with reference to FIGS. 2B through 2G and the descriptions thereof.

**[0086]** FIGS. 3A and 3B are schematic longitudinal sectional views of apparatuses including chip connectors according to embodiments of the inventive concepts.

**[0087]** Referring to FIG. 3A, an apparatus **200a** may include a lower semiconductor package **205L** including a lower semiconductor chip **215L** having chip connectors **281**, an upper semiconductor package **205U**, and inter-package connectors **250** configured to electrically connect the lower and upper semiconductor packages **205L** and **205U**. The upper semiconductor package **205U** is stacked on the lower semiconductor package **205L**. The lower semiconductor package **205L** may include a lower molding compound **230La**, which exposes a top surface of the lower semiconductor chip **215L**. The chip connectors **281** may be disposed on the top surface of the lower semiconductor chip **215L** and physically and/or electrically connected to a bottom surface of the upper package substrate **210U**. The chip connectors **281** may electrically connect the lower and upper semiconductor chips **215L** and **215U**. The lower semiconductor chip **215L** may include through silicon vias (TSVs) **280** formed vertically passing through the main body. The TSVs **280** may electrically connect the chip bumps **220** and the chip connectors **281**. Although it is illustrated that the chip connectors **281** are aligned with the chip bumps **220**, the chip connectors **281** may not be aligned with the chip bumps **220**. In an exemplary embodiment, redistribution interconnections may be formed on the lower semiconductor chip **215L** to electrically connect the chip bumps **281** and the TSVs **280**.

**[0088]** The chip connectors **281** may transmit a clock signal, command signals, an address signal, and/or data signals. The inter-package connectors **250** may transmit supply voltages, ground voltages, and/or test signals. In an exemplary embodiment, the chip connectors **281** may transmit the supply voltages or ground voltages, and the inter-package connectors **250** may transmit the effective signals. According to an exemplary embodiment, the chip connectors **281** may transmit the ground voltages, and the inter-package connectors **250** may transmit the supply voltages. According to an exemplary embodiment, when the lower semiconductor chip **215L** is a logic device and the upper semiconductor chip **215U** is a memory device, the chip connectors **281** may electrically connect shielding ground interconnections of the lower semiconductor chip **215L** with ground interconnection lines of the upper semiconductor chip **215U**. The shielding ground interconnections may be disposed between signal

transmission lines in logic devices. The shielding ground interconnections may prevent or reduce interference of electric signals transmitted through the signal transmission lines. In an exemplary embodiment, the ground voltages may be transmitted through the inter-package connectors **250**. In an exemplary embodiment, the chip connectors **281** and the inter-package connectors **250** may perform different signal transmission functions.

[0089] The chip connectors **281** may comprise a solder material.

[0090] Referring to FIG. 3B, an apparatus **200b** may include a lower semiconductor package **205L** including a lower semiconductor chip **215L** having chip connectors **281**, an upper semiconductor package **205U**, and inter-package connectors **250** configured to electrically connect the lower and upper semiconductor packages **205L** and **205U**. The upper semiconductor package **205U** is stacked on the lower semiconductor package **205L**. The lower semiconductor package **205L** may include a lower molding compound **230Lb**, which covers a top surface of the lower semiconductor chip **215L**. The lower molding compound **230Lb** may surround bottom surfaces and/or lateral surfaces of the chip connectors **281**. In other words, the lower molding compound **230Lb** exposes a portion of the chip connectors **281**.

[0091] FIG. 4 is schematic longitudinal sectional view of an apparatus according to an embodiment of the inventive concepts.

[0092] Referring to FIG. 4, an apparatus **300** may include a lower semiconductor package **305L** including a lower package substrate **310L** and a lower semiconductor chip **315L**, an upper semiconductor package **305U**, and inter-package connectors **350** configured to electrically connect the lower and upper semiconductor packages **305L** and **305U**. The upper semiconductor package **305U** is stacked on the lower semiconductor package **305L**. The lower package substrate **310L** and the lower semiconductor chip **315L** may be electrically connected to each other by a bonding wire **340L**. Each of the lower and upper semiconductor packages **305L** and **305U** may include a memory device according to an exemplary embodiment. That is, each of the lower and upper semiconductor chips **315L** and **315U** may be a memory device. In an exemplary embodiment, each of the inter-package connectors **350** may include a lower connector **360** and an upper connector **380**. That is, each of the inter-package connectors **350** may include a stack structure of at least two components. In an exemplary embodiment, the lower connectors **360** may be smaller than the upper connectors **380**. In an exemplary embodiment, the boundary (or, the cusp or waist) between the lower connector **360** and the upper connector **380** can be disposed below the top surface of the lower semiconductor chip **315L**. According to an exemplary embodiment, when the size of the lower connectors **360** is reduced and the size of the upper connectors **380** is increased, the arrangement of the inter-package connectors **350** may be finer such that the distance between each inter-package connector **350** is closer.

[0093] The apparatus described with reference to FIG. 4 may be applied also to the various apparatuses **100b** to **100h**, **200a** and **200b** described with reference to FIGS. 2B to 3B. In other words, each of the various package connectors **150a** to **150h**, **250**, and **250** of FIGS. 2A through 3B may include upper components and lower components, and the lower components may be formed below the top surfaces of the lower semiconductor chips. The upper components may include upper connectors **180a** to **180e** and **280** or package

bumps **190f** to **190h**. The lower components may selectively include lower connectors **160a**, **160b**, **160d** to **160f**, **160h**, and **260**, bottom connectors **165c** and **165g**, intermediate connectors **170d** to **170e** and **170h**, and/or intermediate adhesion parts **175e** and **175g**, and **175h**. In an embodiment, when the greatest height of the lower components is lower than a height of the top surface of the lower semiconductor chip **315L**, the greatest height of the upper components may be increased. As the height of the upper components increases, a process of forming the apparatuses **100b** to **100h**, **200a**, and **200b** of the semiconductor packages may be stabilized.

[0094] FIGS. 5A through 5D are schematic longitudinal sectional views of chip connectors and connection structures thereof according to embodiments of the inventive concepts. FIGS. 5A through 5D illustrate that the chip connectors are formed between lower semiconductor chips and upper package substrates, and top surfaces of the lower semiconductor chips are exposed.

[0095] Referring to FIG. 5A, chip connectors **281** may comprise a single spherical body between a lower semiconductor chip **215L** and an upper package substrate **210U**. The chip connectors **281** may comprise a solder material. According to an exemplary embodiment, a lateral surface of the lower semiconductor chip **215L** may be surrounded by a molding compound **230**, and a top surface of the lower semiconductor chip **215L** may be exposed. The chip connectors **281** may be electrically connected to TSVs **280**. The chip connectors **281** may be electrically connected to the TSVs **280** by redistribution interconnections **279**. From a plan view, the redistribution interconnections **279** may have, for example, a pad, bar, or line shape. The pads may electrically connect at least two chip connectors **281** or TSVs **280**. The chip connectors **281**, the redistribution interconnections **279**, and/or the TSVs **280** of FIG. 5A may be applied to apparatuses **100a** to **100h** of FIGS. 2A through 2H. That is, apparatuses **100a** to **100h** may further include the chip connectors **281**, the redistribution interconnections **279**, and/or the TSVs **280**.

[0096] Referring to FIG. 5B, chip connectors **282** including lower chip connectors **283** and upper chip connectors **284** may be formed between the lower semiconductor chip **215L** and the upper package substrate **210L**. The lower chip connectors **283** and the upper chip connectors **284** may include a solder material. The lower chip connectors **283** may be understood with reference to the lower connectors **160a**, **160b**, **160d**, **160e**, **160f**, and **160h** shown in FIGS. 2A, 2B, 2D, 2F, and 2H. The upper chip connectors **284** may be understood with reference to the upper connectors **180a** to **180e** of FIGS. 2A through 2E. In an exemplary embodiment, redistribution interconnections **279** and TSVs **280** may be formed.

[0097] Referring to FIG. 5C, chip connectors **285** including bottom chip connectors **286** and upper chip connectors **284** may be formed between the lower semiconductor chip **215L** and the upper package substrate **210U**. The bottom chip connectors **286** may be formed as a mesa or pillar shape. The bottom chip connectors **286** may be attached to one surface of the lower semiconductor chip **215L**. The bottom chip connectors **286** may comprise metal. The bottom chip connectors **286** may be understood with reference to the bottom connectors **165c**, **165d**, **165e**, **165g**, and **165h** shown in FIGS. 2C, 2D, 2E, and 2H. The upper chip connectors **284** may be understood with reference to the upper connectors **180a** to

180e of FIGS. 2A through 2E and FIG. 5B. In an exemplary embodiment, redistribution interconnections 279 and TSVs 280 may be formed.

[0098] Referring to FIG. 5D, chip connectors 287 including lower chip connectors 283 and chip connection bumps 288 may be formed between the lower semiconductor chip 215L and the upper package substrate 210U. The lower chip connectors 283 may be understood with reference to the lower connectors 160a, 160b, 160d, 160e, 160f, and 160h of FIGS. 2A, 2B, 2D, 2E, 2F, and 2H and FIG. 5B. The chip connection bumps 288 may comprise, for example, metal. The chip connection bumps 288 may have a stud, stick, or pillar shape. The chip connection bumps 288 may be fabricated using an additional process and fixed to the upper package substrate 210U. The chip connection bumps 288 may be understood with reference to the package bumps 190f, 190g, and 190h of FIGS. 2F, 2G, and 2H. In an exemplary embodiment, redistribution interconnections 279 and TSVs 280 may be formed.

[0099] FIGS. 6A through 6D are schematic longitudinal sectional views of chip connectors and connection structures thereof according to embodiments of the inventive concepts. FIGS. 6A through 6D illustrate that the chip connectors are formed between lower semiconductor chips and upper package substrates, and top surfaces of the lower semiconductor chips are partially or wholly covered with a lower molding compound. Various chip connectors that will now be illustrated and described may have similar structural shapes as the inter-package connectors 150a to 150h of FIGS. 2A through 2H and/or the chip connectors 281, 282, 285, and 287 of FIGS. 5A through 5D. According to exemplary embodiments, the sizes of the chip connectors may be variously determined according to design rules.

[0100] Referring to FIGS. 6A through 6D, the lower molding compound 230La may cover a top surface of the lower semiconductor chip 215L. Thus, bottom and lateral surfaces of the chip connectors 281, 282, 285, and 287 may be partially or wholly surrounded by the lower molding compound 230La. In an exemplary embodiment, the bottom and/or lateral surfaces of the chip connectors 281, 282, 285, and 287 may be partially exposed from the lower molding compound 230La. According to an exemplary embodiment, redistribution interconnections 279 and TSVs 280 may be formed.

[0101] FIGS. 7A through 7D are schematic longitudinal sectional views of various inter-package connectors according to embodiments of the inventive concepts. The substantially round or circular shapes are shapes of various inter-package connectors and/or chip connectors before a reflow process is performed.

[0102] The various connectors may refer to any one or portion of the various inter-package connectors and chip connectors shown in FIGS. 1A through 6D.

[0103] Referring to FIG. 7A, a connector 50a may include a lower connector 60a and an upper connector 80a. In an exemplary embodiment, the upper connector 80a may have a greater volume than the lower connector 60a. In an exemplary embodiment, a vertical height H1 of the upper connector 80a may be greater than a vertical height H2 of the lower connector 60a. In an exemplary embodiment, a horizontal width D1 of the upper connector 80a may be greater than a horizontal width D2 of the lower connector 60a. From a plan view or cross-sectional view, the horizontal widths D1 and D2 may be understood as diameters of the upper connector 80a and the lower connector 60a, respectively. In an exemplary embodiment, a radius or curvature r1 of the upper connector 80a may

be greater than a radius or curvature r2 of the lower connector 60a. The lower connector 60a and the upper connector 80a may include a solder material. Thus, the lower connector 60a and the upper connector 80a may be formed using a soldering process, and the upper and lower connectors 80a and 60a may have a spherical or hemispherical shape.

[0104] Referring to FIG. 7B, a connector 50b may include a lower connector 60b and an upper connector 80b, and the upper connector 80b may have a greater volume than the lower connector 60b. An imaginary center C1 of the lower connector 60b may be disposed at the same level as a bottom surface 10. The imaginary center C1 may be interpreted as the center of an imaginary radius or curvature r3 of the lower connector 60b. The lower connector 60b and the upper connector 80b may include a solder material. In an exemplary embodiment, the lower connector 60b may have a hemispherical shape.

[0105] Referring to FIG. 7C, a connector 50c may include a lower connector 60c and an upper connector 80c. In an exemplary embodiment, the upper connector 80c may have a greater volume than the lower connector 60c. An imaginary center C2 of the lower connector 60c may be at a lower level than a bottom surface 10. The imaginary center C2 may be interpreted as the center of an imaginary radius or curvature r4 of the lower connector 60c.

[0106] Referring to FIG. 7D, a connector 50d may include a lower connector 60d and an upper connector 80d, and the upper connector 80d may have a greater volume than the lower connector 60d. An imaginary center C3 of the lower connector 60d may be at a higher level than the bottom surface 10. The imaginary center C3 may be interpreted as the center of an imaginary radius or curvature r5 of the lower connector 60d.

[0107] According to embodiments of the inventive concepts, the upper connectors 80a to 80d may be formed to be higher, wider, and larger than the lower connectors 60a to 60d. The lower connectors 60a to 60d may be formed using a screen print process or soldering process according to an exemplary embodiment. The upper connectors 80a and 80b may be formed using a soldering process according to an exemplary embodiment. According to an exemplary embodiment, a process of connecting the upper connectors 80a to 80d and the lower connectors 60a to 60d may be performed within a via hole formed using a laser drilling process. The formation of the via hole may include selectively removing a molding compound to partially expose surfaces of the lower connectors 60a to 60d. The laser drilling process may enable to form finer and more equal distanced via holes than the screen print process. Therefore, a laser drilling process may be performed to enable elaborate arrangement of the connectors 50a. As the size of the lower connectors 60a to 60d decreases, the screen print process may not contribute toward elaborately arranging the lower connectors 60a to 60d, and as the size of the upper connectors 80a to 80d increases, the laser drilling process may contribute toward elaborately arranging the upper connectors 80a to 80d. Thus, the upper connectors 80a to 80d may have a greater size than the lower connectors 60a to 60d to make the connectors 50a to 50d more elaborate. For example, the connectors can be formed with substantially equal distances between them. For example, more numbers of connectors can be formed in a given area. In an exemplary embodiment, before performing a reflow process to connect the lower connectors 60a to 60d with the upper connectors 80a to 80d, respectively, the upper connectors 80a to 80d may

be dipped in a flux. A sufficient amount of flux may be applied to the surfaces of the upper connectors **80a** to **80d** so that the reflow process can be stably carried out. In other words, as the size of the upper connectors **80a** to **80d** increases, a larger amount of flux may be applied to the surfaces of the upper connectors **80a** to **80d**. Accordingly, the upper connectors **80a** to **80d** may be formed to the greatest possible size while minimizing a distance between the upper connectors **80a** to **80d**. In general, the upper package substrate **110U** may be uneven. During a semiconductor package fabrication process, the upper package substrate **110U** may not maintain flatness. That is, the upper package substrate **110U** may be bent. Thus, when the upper connectors **80a** to **80d** are not formed to have a sufficiently large size, a sufficient amount of flux may not be applied to the surfaces of the upper connectors **80a** to **80d**. Accordingly, the upper connectors **80a** to **80d** are formed to have a greater size than the lower connectors **60a** to **60d** according to exemplary embodiments of the inventive concepts.

**[0108]** FIGS. **8A** through **8I** are shapes of various connectors of package stack structures according to embodiments of the inventive concepts. Here, the shapes may be interpreted as finally formed shapes of respective components. The various connectors may refer to any one or portion of the various inter-package connectors and chip connectors shown in FIGS. **1A** through **6D**. Generally, these shapes of the connectors are generated after a reflow process. The reflow process can be used when a lower connector is formed on a substrate. The reflow process can be used when an upper connector is formed on a substrate. The reflow process can be used when the lower connector and the upper connector are combined.

**[0109]** Referring to FIG. **8A**, a connector **51a** may include a waist portion **Wa** and be formed to physically and/or electrically connect a lower land **12a** and an upper land **17a**. The waist portion **Wa** refers to a slender portion of the connector **51a**. The waist portion **Wa** may imaginarily and/or visually divide the connector **51a** into an upper part and a lower part. In other words, the waist portion **Wa** may divide the connector **51a** into an upper connector **81a** and a lower connector **61a**. The maximum width **Da1** of the upper connector **81a** may be more than the maximum width **Da2** of the lower connector **61a**. A width **Da3** of the waist portion **Wa** may be less than the maximum width **Da2** of the lower connector **61a**. Thus, the waist portion **Wa** refers to a portion having a smallest width **Da3**, which is interposed between the maximum width **Da2** of the lower connector **61a** and the maximum width **Da1** of the upper connector **81a**. A height **Ha1** of the upper connector **81a** may be defined as a distance between the surface of the upper land **17a** or an upper insulating material **18a**, which partially covers the upper land **17a**, and the waist portion **Wa**. A height **Ha2** of the lower connector **61a** may be defined as a distance between the surface of the lower land **12a** or a lower insulating material **13a**, which partially covers the lower land **12a**, and the waist portion **Wa**. The height **Ha1** of the upper connector **81a** may be greater than a height **Ha2** of the lower connector **61a**. In an embodiment, the upper connector **81a** may have a greater volume than the lower connector **61a**. In an embodiment, the maximum width **Da1** of the upper connector **81a** may be disposed above the middle of the upper connector **81a**. The waist portion **Wa** may be formed in the horizontal direction. The upper and lower connectors **81a** and **61a** may include a solder material. The upper and lower connectors **81a** and **61a** may have a spherical or hemispherical

cal shape. Thus, from a plan or cross-sectional view, the horizontal widths **Da1**, **Da2**, and **Da3** may refer to diameters of circles.

**[0110]** Referring to FIG. **8B**, a connector **51b** may include a waist portion **Wb** by which an upper connector **81b** is divided from a lower connector **61b**, and an imaginary center **C** of the lower connector **61b** may be disposed at a lower level than the surface of the lower land **61b**. A case where the imaginary center **C** of the lower connector **61b** may be disposed at a higher level than the surface of the lower land **61b** may be understood with reference to FIG. **8A**. The maximum width **Db1** of the upper connector **81b** may be greater than a width **Db2** of the waist portion **Wb**. A height **Hb1** of the upper connector **81b** may be greater than a height of the lower connector **61b**.

**[0111]** Referring to FIG. **8C**, a connector **51c** may include a mesa shape bottom connector **61c** and a spherical upper connector **81c**, and a height **Hc1** of the upper connector **81c** may be greater than a height **Hc2** of the bottom connector **61c**. The maximum width **Dc1** of the upper connector **81c** may be greater than a width **Dc2** of the bottom connector **61c**. A portion of the top surface of the mesa shape bottom connector **61c** may not contact the upper connector **81c**. That is, the mesa shape bottom connector **61c** may be exposed.

**[0112]** Referring to FIG. **8D**, a connector **51d** may include a spherical or hemispherical lower connector **61d**, a mesa shape intermediate connector **71d**, and a spherical upper connector **81d**. A height **Hd1** of the upper connector **81d** may be greater than a height **Hd2** of the intermediate connector **71d** or a height **Hd3** of the lower connector **61d**. In an embodiment, the height **He1** of the upper connector **81d** may be greater than the sum (**Hd2**+**Hd3**) of the height **Hd2** of the intermediate connector **71d** and the height **Hd3** of the lower connector **61d**. The maximum width **Dd1** of the upper connector **81d** may be greater than a width **Dd2** of the bottom connector **66d**. A portion of the top surface of the intermediate connector **71d** may not contact the upper connector **81d**. That is, the portion of the top surface of the intermediate connector **71d** can be exposed. A lower portion of a lateral surface of the intermediate connector **71d** may be partially covered with the lower connector **61d**.

**[0113]** Referring to FIG. **8E**, a connector **51e** may include a lower connector **61e**, an intermediate connector **71e**, an intermediate adhesion unit **76e**, and an upper connector **81e**. The upper connector **81e** and the intermediate adhesion unit **76e** may be visually distinguished from each other on the basis of a waist portion **We**. The maximum width of the upper connector **81e** may be greater than the maximum width **De2** of the intermediate adhesion unit **76e**. The greatest width of the intermediate adhesion unit **76e** may be greater than the width of the waist portion **We**. The heights of respective components may be variously determined. For example, although it is illustrated that the upper connector **81e** has a greatest height, the inventive concepts is not limited thereto. When the connector **51e** has a multilayered structure, the relative heights, widths, or sizes of respective components may be variously applied.

**[0114]** Referring to FIG. **8F**, a connector **51f** may include a lower connector **61f** and a bump portion **81f**. The bump portion **81f** may comprise a metal having a stud or pillar shape. A height **Hf1** of the bump portion **81f** may be greater than a height **Hf2** of the lower connector **61f**. A lower portion of a lateral surface of the bump portion **81f** may be covered with the lower connector **61f**. The lower connector **61f** may be

formed as a spherical or hemispherical shape. An imaginary center of the lower connector **61f** may be disposed above or below the surface of the lower land **12f**.

[0115] Referring to FIG. 8G, a connector **51g** may include a bottom connector **66g**, an intermediate adhesion unit **76g**, and a bump portion **91g**. A height **Hg1** of the bump portion **91g** may be greater than a height **Hg2** of the intermediate adhesion unit **76g** or a height **Hg3** of the bottom connector **66g**.

[0116] Referring to FIG. 8H, a connector **51h** may include a lower connector **61h**, an intermediate connector **71h**, an intermediate adhesion unit **76h**, and a bump portion **91h**. A height **Hh1** of the bump portion **91h** may be greater than a height **Hh2** of the intermediate adhesion unit **76h**, a height **Hh3** of the intermediate connector **71h**, or a height **Hh4** of the lower connector **61h**.

[0117] Referring to FIG. 8I, a connector **51i** may include a waist portion **Wi** by which an upper connector **81i** is divided from a lower connector **61i**, and the lower connector **61i** may include sidewalls having planar portions **SWi**. The planar portions **SWi** may correspond to portions of sidewalls of the lower connector **61i**. The planar portions **SWi** may extend to a bottom portion of the lower connector **61i**.

[0118] The upper lands **17a** to **17i** of FIGS. 8A through 8I may be included in the upper packages **105U** and **205U** of FIGS. 2A through 2H, 3A, and/or 3B, and the lower lands **12a** to **12h** may be included in the lower packages **105L** and **205L** or the lower semiconductor chips **115L** and **215L**.

[0119] FIGS. 9A through 9I are shapes of various connectors and via holes in an apparatus according to embodiments of the inventive concepts.

[0120] Referring to FIG. 9A, a connector **52a** may include a lower connector **62a** and an upper connector **82a**, and the upper connector **82a** may be formed within a via hole **Va** configured to partially expose the surface of the lower connector **62a**. A width **Dva** of a bottom end **V1a** of the via hole **Va** may be smaller than the maximum width **D1a** of the lower connector **62a**. A gap **Ga** may be formed between the via hole **Va** and the waist portion **Wa**.

[0121] Referring to FIG. 9B, a connector **52b** may include a lower connector **62b** and an upper connector **82b**, and the upper connector **82b** may be formed within a via hole **Vb** configured to substantially or completely expose the surface of the lower connector **62b**. The lower connector **62b** may include sidewalls having planar portions **SWb**. A width **Dvb** of a bottom end of the via hole **Vb** may be greater than a width **D1b** of a bottom end of the lower connector **62b**. Thus, a gap **Gb1** may be formed between the via hole **Vb** and a bottom portion of the lower connector **62b**.

[0122] Referring to FIG. 9C, a connector **52c** may include a lower connector **62c** and an upper connector **82c**, and the upper connector **82c** may be formed within a via hole **Vc** configured to substantially or completely expose the surface of the lower connector **62c**. The lower connector **62c** may include sidewalls having planar portions **SWc**. The planar portions **SWc** may extend to a bottom surface **23c**.

[0123] Gaps **Ga**, **Gb**, and **Gc** may be formed between the waist portions **Wa**, **Wb**, and **We** of the connectors **52a**, **52b**, and **52c** shown in FIGS. 9A through 9C and sidewalls of the via holes **Va**, **Vb**, and **Vc**. The sidewalls of the via holes **Va**, **Vb**, and **Vc** may be inclined such that the diameters of the via holes **Va**, **Vb**, and **Vc** may be reduced toward lower portions thereof. The sidewalls of the via holes **Va**, **Vb**, and **Vc** may be inclined at respectively different angles. For example, each of

the inclination sidewalls of the via holes **Va**, **Vb**, and **Vc** may be determined at an angle of about 10° to about 30° in consideration of intervals or pitches between the via holes **Va**, **Vb**, and **Vc** and other adjacent connectors. The via holes **Va**, **Vb**, and **Vc** may vertically penetrate molding compounds **32a**, **32b**, and **32c** and partially expose top and/or lateral surfaces of the lower connectors **62a**, **62b**, and **62c** or the surfaces of lower insulating materials **23a**, **23b**, and **23c**.

[0124] Referring to FIG. 9D, a connector **52d** may include a lower connector **62d**, a mesa shape connector **67d** and an upper connector **82d**, and the upper connector **82d** may be formed within a via hole **Vd** configured to partially expose the surface of the mesa shape connector **67d**. A width **Dvd** of a bottom end of the via hole **Vd** may be greater than a horizontal width **Dmd** of the mesa shape connector **67d**. A gap **Gd** may be formed on a portion of the surface of the mesa shape connector **67d**.

[0125] Referring to FIG. 9E, a connector **52e** may include a lower connector **62e**, a mesa shape connector **67e** and an upper connector **82e**, and the upper connector **82e** may be formed within a via hole **Ve** configured to partially expose a lateral surface of the mesa shape connector **67e**. A width **Dve** of a bottom end of the via hole **Ve** may be equal to a horizontal width of the mesa shape connector **67e**. A gap **Ge** may be formed between a portion of the lateral surface of the mesa shape connector **67e** and the sidewall of the via hole **Ve**.

[0126] Referring to FIG. 9F, an upper connector **82f** may include a lower connector **62f**, a mesa shape connector **67f** and an upper connector **82f**, and the upper connector **82f** may be formed within a via hole **Vf** configured to wholly expose a lateral surface of the mesa shape connector **67f**. The via hole **Vf** may partially expose a top surface of the lower connector **62f**. A gap **Gf** may be formed between a portion of the lateral surface of the mesa shape connector **67f** and a sidewall of the via hole **Vf**.

[0127] According to an embodiment, in FIGS. 9D through 9F, sidewalls of the via holes **Vd**, **Ve**, and **Vf** may be inclined such that the diameters of the via holes **Vd**, **Ve**, and **Vf** may be reduced toward lower portions thereof. The via holes **Vd**, **Ve**, and **Vf** may vertically penetrate molding compounds **32d**, **32e**, and **32f** and partially or wholly expose top and/or lateral surfaces of the mesa shape connectors **67d**, **67e**, and **67f**.

[0128] Referring to FIG. 9G, a connector **52g** may include a lower connector **62g**, a mesa shape connector **67g**, an intermediate connector **77g**, and an upper connector **82g**. The upper connector **82g** may be formed within a via hole **Vg** configured to partially expose the surface of the intermediate connector **77g**. A gap **Gg** may be formed between a portion of the surface of the intermediate connector **77g** and a sidewall of the via hole **Vg**.

[0129] Referring to FIG. 9H, a connector **52h** may include a lower connector **62h**, a mesa shape connector **67h**, an intermediate connector **77h**, and an upper connector **82h**. The upper connector **82h** may be formed within a via hole **Vh** configured to partially expose the surface of the mesa shape connector **67h**. The via hole **Vh** may further expose a portion of the lateral surface of the mesa shape connector **67h**. A gap **Gh** may be formed between the portion of the surface of the mesa shape connector **67h** and a sidewall of the via hole **Vh**.

[0130] Referring to FIG. 9I, a connector **52i** may include a lower connector **62i**, a mesa shape connector **67i**, an intermediate connector **77i**, and an upper connector **82i**. The upper connector **82i** may be formed within a via hole **Vi** configured to partially expose the surface of the lower connector **62i**. A



gap Gi may be formed between the portion of the surface of the lower connector 62i and a sidewall of the via hole Vi.

[0131] According to an embodiment, in FIGS. 9G through 9I, sidewalls of the via holes Vg, Vh, and Vi may be inclined such that the diameters of the via holes Vg, Vh, and Vi may be reduced toward lower portions thereof. The via holes Vg, Vh, and Vi may vertically penetrate molding compounds 32g, 32h, and 32i and partially or wholly expose the surface of the intermediate connector 77h, partially or wholly expose the surface of the mesa shape connector 67h, and partially or wholly expose the surface of the lower connector 62h. The gaps Gb1 and Ga to Gi may refer to air gaps.

[0132] FIGS. 10A through 10F are schematic longitudinal sectional views illustrating a process of forming an upper package according to an embodiment of the inventive concepts.

[0133] Referring to FIG. 10A, an upper package substrate 110U including upper lands 155U and wire pads 145 may be prepared. The upper lands 155U may be electrically connected to the wire pads 145, respectively. The upper lands 155U and the wire pads 145 may be formed using, for example, a screen printing process, a deposition process, a bonding process, or a plating process.

[0134] Referring to FIG. 10B, upper semiconductor chips 115U may be mounted on the upper package substrate 110U. An insulating adhesive may be interposed between the upper package substrate 110U and the upper semiconductor chips 115U. The upper semiconductor chips 115U may include bonding pads 135.

[0135] Referring to FIG. 10C, the bonding pads 135 may be electrically connected to the wire pads 145 using bonding wires 140.

[0136] Referring to FIG. 10D, an upper molding compound 130U may be formed to cover the upper semiconductor chips 115U and separated into the upper semiconductor chips 115U. The upper molding compound 130U may comprise an epoxy resin or polyimide. The separation of the upper molding compound 130U may be performed using, for example, a sawing process or a cutting process.

[0137] Referring to FIG. 10E, the upper semiconductor package 105U may be turned upside down, and upper connectors 180 may be formed on the upper lands 155U, respectively.

[0138] According to exemplary embodiments of the inventive concepts, referring to FIG. 10F, package bumps 190 may be formed on the upper lands 155U, respectively.

[0139] FIGS. 11A through 11I show a method of fabricating an apparatus according to embodiments of the inventive concepts.

[0140] Referring to FIG. 11A, lower lands 155L may be formed on a lower package substrate 110L. The lower lands 155L may be formed using a screen printing technique. Alternatively, the lower lands 155L may be formed using a deposition technique, a bonding technique, a plating technique, or an inkjet technique. In an embodiment, chip bump lands 121 may be formed using the same process as or a different process from the process of forming the lower lands 155L. That is, the lower lands 155L and the chip bump lands 121 may be formed on the lower package substrate 110L.

[0141] Referring to FIG. 11B, conductive chip bumps 120 may be formed on the lower package substrate 110L. The conductive chip bumps 120 may be formed using a screen printing process, an inkjet process, or a soldering process.

The conductive chip bumps 120 may be electrically connected to the chip bump lands 121, respectively.

[0142] Referring to FIG. 11C, lower connectors 160 may be formed on the lower lands 155L. The lower connectors 160 may be formed using, for example, a screen printing technique, an inkjet technique, or a soldering technique. The lower connectors 160 may be formed during the formation of the conductive chip bumps 120. In other words, the conductive chip bumps 120 and the lower connectors 160 may be formed simultaneously. Although FIG. 11C illustrates that the lower connectors 160 may be formed at about the same level with the conductive chip bumps 120, the present inventive concepts is not limited thereto. The lower connectors 160 may be formed at a sufficiently higher level than the conductive chip bumps 120. When the conductive chip bumps 120 and the lower connectors 160 are at the same level, the conductive chip bumps 120 and the lower connectors 160 are formed simultaneously. Also, when the conductive chip bumps 120 and the lower connectors 160 are at different levels, the conductive chip bumps 120 and the lower connectors 160 are formed using different processes.

[0143] Referring to FIG. 11D, lower semiconductor chips 115L may be mounted on the conductive chip bumps 120. The lower semiconductor chips 115L may be formed as a flip chip shape and may be logic devices. The lower connectors 160 may be formed before mounting the lower semiconductor chips 115L. For example, when the lower connectors 160 are formed using a screen printing technique, the lower connectors 160 may be formed before mounting the lower semiconductor chips 115L. However, when the lower connectors 160 are formed using a soldering technique, the formation of the lower connectors 160 may be formed after mounting the lower semiconductor chips 115L.

[0144] Referring to FIG. 11E, a molding control film 135 may be formed on the lower semiconductor chips 115L. The molding control film 135 may be closely adhered to top surfaces of the lower semiconductor chips 115L. A space may be ensured between the molding control film 135 and the lower package substrate 110L. A space may be ensured between the molding control film 135 and the surfaces of the lower connectors 160. The molding control film 135 may be a tape comprising, for example, cellulose, acetate, polyvinyl, or polyurethane.

[0145] Referring to FIG. 11F, the space between the molding control film 135 and the lower package substrate 110L may be filled with a lower molding compound 130L. The lower molding compound 130L may be formed to cover the lower connectors 160, surround a lateral surface of the lower semiconductor chip 115L, and fill a lower region of the molding control film 135. The lower molding compound 130L may be formed only around the conductive chip bumps 120. In other words, the lower molding compound 130L may only fill spaces between the lower package substrate 110L and the lower semiconductor chips 115L. That is, lateral surfaces of the lower semiconductor chips 115L may be exposed to the air. In an embodiment, the lower molding compound 130L may be an insulating adhesive. Alternatively, lower lateral surfaces of the lower semiconductor chips 115L may be surrounded by the lower molding compound 130L, while upper lateral surfaces thereof may be exposed to the air. In an embodiment, the lower molding compound 130L may cover the surfaces of the lower connectors 160. In other words, the



lower molding compound **130L** may fill half the space between the molding control film **135** and the lower package substrate **110L**.

[0146] Referring to FIG. 11G, the molding control film may be removed, and a laser drilling process may be performed to expose the surface of the lower connectors **160**. During the laser drilling process, the lower molding compound **130L** may be selectively removed, and openings **O** may be formed to partially or wholly expose the surfaces of the lower connectors **160**. A distance between top surfaces of the lower connectors **160** and a top surface of the molding compound **130L** may be greater than a distance between the surface of the lower package substrate **110L** and top surfaces of the lower connectors **160**. Alternatively, spaces of the openings **O** may be greater than volumes of the lower connectors **160**. When regarding the openings **O** as via holes, inner spaces of the via holes may be greater than the volumes of the lower connectors **160**. In an embodiment, the spaces of the openings **O** or the inner spaces of the via holes may be greater than the volumes of the lower connectors **160** in terms of any one of a vertical length, a horizontal maximum width, and a maximum diameter.

[0147] Referring to FIG. 11H, solder balls **125** may be formed on a bottom surface of the lower package substrate **110L**. The solder balls **125** may be electrically connected to the conductive chip bumps **120**, respectively. The solder balls **125** may be formed using a soldering process. According to embodiments of the inventive concepts, the process of forming the solder balls **125** may be performed before the laser drilling process.

[0148] Referring to FIG. 11I, the lower package substrate **110L** and the lower molding compound **130L** may be separated into single lower semiconductor packages **105L**. The separation process may be performed using, for example, a sawing process, a drilling process, or a cutting process.

[0149] Referring to FIG. 11J, the upper connectors **180** of the upper semiconductor package **105U** of FIG. 10E may be dipped in a solder flux **F** contained in a container **T**. In an embodiment, a top surface of the container **T** may be in contact with or close to the surface of the upper package substrate **110U**. The top surface of the container **T** may function to determine the depth of the solder flux **F** in which the upper connectors **180** are dipped. In an embodiment, when the upper connectors **180** have a sufficiently large size, the upper connectors **180** may be sufficiently dipped in the solder flux **F**. As the size of the upper connections **180** increases, the surface areas of the upper connections **180** dipped in the solder flux **F** also increase. As such, physical or electrical connection between the upper connectors **180** and the lower connectors **160** can be improved. The size or surface area of the upper connector **180** may refer to a height of the upper connectors **180** formed on the surface of the upper package substrate **110U**. According to an embodiment of the inventive concepts, the upper connectors **180** may be formed to a greater size or surface area than the lower connectors **160**. According to an embodiment, a connection structure that is more stable in physical and electrical aspects is provided. The upper package substrate **110U** may have a slightly or substantially twisted or bent shape. The upper package substrate **110U** may be bent during the fabrication. When the upper connectors **180** are not formed to have a sufficiently large size, some of the upper connectors **180** may not be dipped in the solder flux **F**, or the surface of the upper package substrate **110U** may contact the solder flux **F**. As such, the surface of the

upper package substrate **110U** can be stained. Therefore, when the upper connectors **180** are formed to have a sufficiently large size according to an embodiment of the inventive concepts, unstable factors due to the warpage of the upper package substrate **110U** may be sufficiently removed.

[0150] Referring to FIG. 11K, the upper semiconductor package **105U** and the lower semiconductor package **105L** may be stacked. The surfaces of the upper connectors **180** are sufficiently stained with the fluid **F**. In an embodiment, the lower connectors **160** and the upper connectors **180** may be heated and bonded to each other under pressure in the openings **O** and physically and electrically combined and/or connected with each other. Here, combining the lower and upper connectors **160** and **180** may be interpreted as integrally forming the lower and upper connectors **160** and **180**.

[0151] Referring to FIG. 11L, the package bumps **190** of the upper semiconductor package **105U** of FIG. 10F may be dipped in the solder flux **F**. Subsequent processes may be understood with reference to FIG. 11K.

[0152] During the soldering process, a solder material may have a spherical shape due to surface tension. Thus, when a component is described or illustrated as a spherical or hemispherical shape, the component may be formed using a soldering process. It will be understood by those skilled in the art with reference to the above drawings and the descriptions thereof that the lower and upper connectors **160** and **180** may be formed in various shapes.

[0153] FIGS. 12A and 12B are schematic diagrams of semiconductor modules including apparatuses formed according to embodiments of the inventive concepts.

[0154] Referring to FIGS. 12A and 12B, each of semiconductor modules **500a** and **500b** may include a module board **510a** or **510b** and a plurality of semiconductor devices **520** mounted on the module board **510a** or **510b**. At least one of the plurality of semiconductor devices **520** may include apparatuses according to embodiments of the inventive concepts. Each of the module boards **510a** and **510b** may be a PCB. The semiconductor module **500a** or **500b** may include a plurality of contact terminals **530** formed in a lateral surface of the module board **510a** or **510b**. Each of the contact terminals **530** may be electrically connected to the semiconductor devices **520**.

[0155] FIG. 13 is a schematic diagram of an electronic system including an apparatus according to embodiments of the inventive concepts.

[0156] Referring to FIG. 13, an electronic system **600** may include a control unit **610**, an input unit **620**, an output unit **630**, a storage unit **640**, and a communication unit **650** according to an exemplary embodiment.

[0157] The control unit **610** may control the electronic system **600** and respective components at one time. The control unit **610** may be a central processing unit (CPU) or a main control unit (MCU) and include the semiconductor module **500** according to embodiments of the inventive concepts. The control unit **610** may include a stack structure of semiconductor packages according to embodiments of the inventive concepts.

[0158] The input unit **620** may transmit an electrical command signal to the control unit **610**. The input unit **620** may comprise, for example, a keyboard, a keypad, a mouse, a touch pad, an image recognizer such as a scanner, or one of various input sensors. The input unit **620** may include a stack structure of semiconductor packages according to embodiments of the inventive concepts.

[0159] The output unit 630 may receive the electrical command signal from the control unit 610 and output a processing result of the electronic system 600. The output unit 630 may comprise, for example, a monitor, a printer, or a beam emitter. The output unit 630 may include a stack structure of semiconductor packages according to embodiments of the inventive concepts.

[0160] The storage unit 640 may be a component configured to temporarily or permanently store an electrical signal to be processed or already processed by the control unit 610. The storage unit 640 may be physically and electrically connected to or combined with the control unit 610. The storage unit 640 may comprise, for example, a semiconductor memory device, a magnetic storage device such as a hard disk, and optical storage device such as a compact disk, or a server having a data storage function. The storage unit 640 may include a stack structure of semiconductor packages according to embodiments of the inventive concepts.

[0161] The communication unit 650 may receive an electrical command signal from the control unit 610 and transmit or receive the electrical signal to or from another electronic system. The communication unit 650 may comprise, for example, a wired transceiving device such as a modem or a local area network (LAN) card, a wireless transceiving device such as a wireless broadband (WiBro) interface, or an infrared (IR) port. The communication unit 650 may include a stack structure of semiconductor packages according to embodiments of the inventive concepts.

[0162] The electronic system 600 according to embodiments of the inventive concepts may comprise, for example, a computer, a network server, a networking printer, a scanner, a wireless controller, a mobile communication terminal, a switching system, or any electronic device capable of programmed operations.

[0163] According to embodiments of the inventive concepts as described above, a stack structure of semiconductor packages may include inter-package connectors stably formed even when a distance between the inter-package connectors is substantially small.

[0164] Although the exemplary embodiments of the present invention have been described herein with reference to the accompanying drawings, it is to be understood that the present invention should not be limited to those precise embodiments and that various other changes and modifications may be affected therein by one of ordinary skill in the related art without departing from the scope or spirit of the invention. All such changes and modifications are intended to be included within the scope of the invention as defined by the appended claims.

1. (canceled)

2. An apparatus, comprising:

a first substrate including a first land;

a second substrate including a second land;

a first semiconductor chip on the first substrate;

a first molding compound between the first substrate and the second substrate, the first molding compound surrounding side surfaces of the first semiconductor chip;

a first connector on the first land; and

a second connector between the second land and the first connector,

a maximum width of the second connector being greater than a maximum width of the first connector, and the first connector being completely surrounded by the first molding compound.

3. The apparatus according to claim 2, wherein most of the second connector is surrounded by the first molding compound.

4. The apparatus according to claim 3, wherein more than a half of total vertical height of the second connector is surrounded by the first molding compound.

5. The apparatus according to claim 3, wherein an uppermost portion of the second connector protrudes from a top surface of the first molding compound.

6. The apparatus according to claim 2, wherein a top surface of the first molding compound is coplanar with a top surface of the first semiconductor chip.

7. The apparatus according to claim 6, further comprising: a space between a bottom surface of the second substrate and the top surfaces of the first semiconductor chip and the first molding compound.

8. The apparatus according to claim 2, wherein a volume of the second connector is greater than a volume of the first connector.

9. The apparatus according to claim 2, wherein a top surface of the first semiconductor chip is higher than an interface between the first connector and the second connector.

10. The apparatus according to claim 2, further comprising:

a third connector between the first connector and the second connector.

11. The apparatus according to claim 10, wherein the third connector is completely surrounded by the first molding compound.

12. The apparatus according to claim 11, wherein an interface between the third connector and the second connector is lower than a top surface of the first semiconductor chip.

13. An apparatus, comprising:

a lower substrate;

an upper substrate;

a lower land on a top surface of the lower substrate;

an upper land on a bottom surface of the upper substrate;

a semiconductor chip on the top surface of the lower substrate;

a lower molding compound between the top surface of the lower substrate and the bottom surface of the upper substrate;

a lower connector on the lower land; and

an upper connector on the upper land,

the lower connector being completely surrounded by the lower molding compound,

most of the upper connector being surrounded by the lower molding compound,

a maximum width of the upper connector being greater than a maximum width of the lower connector, and

a top surface of the lower molding compound being apart from the bottom surface of the upper substrate.

14. The apparatus according to claim 13, further comprising:

a through silicon via, the through silicon via vertically extending through the semiconductor chip.

15. The apparatus according to claim 14, further comprising:

a chip connector on the semiconductor chip, the chip connector being electrically connected to the through silicon via.

16. The apparatus according to claim 15, wherein a lower portion of the chip connector is surrounded by the lower molding compound.

**17.** An apparatus, comprising:  
a first substrate including a first land;  
a second substrate including a second land;  
a first semiconductor chip on a top surface of the first substrate;  
an second semiconductor chip on a top surface of the second substrate;  
a first molding compound between the top surface of the first substrate and a bottom surface of the second substrate, the first molding compound covering side surfaces of the first semiconductor;  
a second molding compound on the top surface of the second substrate, the second molding compound covering a top and side surfaces of the second semiconductor;  
a first connector contacting the first land; and  
a second connector contacting the second land, the first connector being completely surrounded by the first molding compound, more than half of vertical thickness of the second connector being surrounded by the first molding compound,  
a volume of the second connector being greater than a volume of the first connector, and

top surfaces of the first semiconductor chip and the first molding compound being exposed.

**18.** The apparatus according to claim **17**, wherein the second connector includes at least one of a mesa shaped metal, a stud shaped metal, and a pillar shaped metal.

**19.** The apparatus according to claim **17**, further comprising:

a flip chip landing pad between the first semiconductor chip and the top surface of the first substrate; and  
a chip bump between the flip chip landing pad and the first semiconductor chip.

**20.** The apparatus according to claim **17**, further comprising:

a wire pad on the top surface of the second substrate, the wire pad being electrically connected to the second land; and  
a bonding wire electrically connecting the second semiconductor chip and the wire pad.

**21.** The apparatus according to claim **17**, further comprising:

a solder ball on a bottom surface of the first substrate.

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