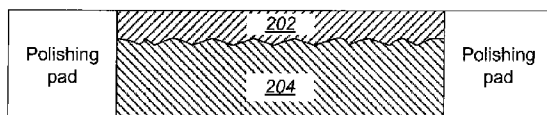
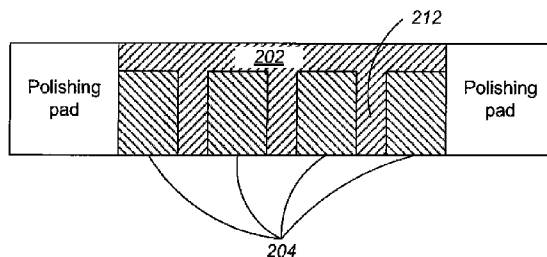
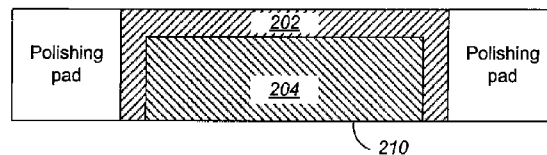
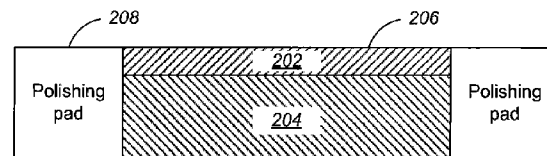




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(19) **United States**(12) **Patent Application Publication**
Benvegna et al.(10) **Pub. No.: US 2011/0209412 A1**(43) **Pub. Date: Sep. 1, 2011**(54) **METHOD OF MAKING POLISHING PAD
ASSEMBLY WITH GLASS OR CRYSTALLINE
WINDOW**(60) Provisional application No. 60/710,682, filed on Aug.
22, 2005.**Publication Classification**(76) Inventors: **Dominic J. Benvegna**, La Honda,
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Jose, CA (US); **Bogdan Swedek**,
Cupertino, CA (US)(51) **Int. Cl.**
B24D 7/12 (2006.01)
B24D 18/00 (2006.01)(52) **U.S. Cl.** **51/297; 51/308; 51/298**(21) Appl. No.: **13/103,772**(22) Filed: **May 9, 2011****Related U.S. Application Data**(60) Division of application No. 12/572,100, filed on Oct.
1, 2009, now Pat. No. 7,938,714, which is a continua-
tion of application No. 11/945,987, filed on Nov. 27,
2007, now Pat. No. 7,614,933, which is a continuation
of application No. 11/213,675, filed on Aug. 26, 2005,
now Pat. No. 7,306,507.(57) **ABSTRACT**

Methods and apparatus for providing a chemical mechanical polishing pad. The pad includes a polishing layer having a top surface and a bottom surface. The pad includes an aperture having a first opening in the top surface and a second opening in the bottom surface. The top surface is a polishing surface. The pad includes a window that includes a first portion made of soft plastic and a crystalline or glass like second portion. The window is transparent to white light. The window is situated in the aperture so that the first portion plugs the aperture and the second portion is on a bottom side of the first portion, wherein the first portion acts a slurry-tight barrier.



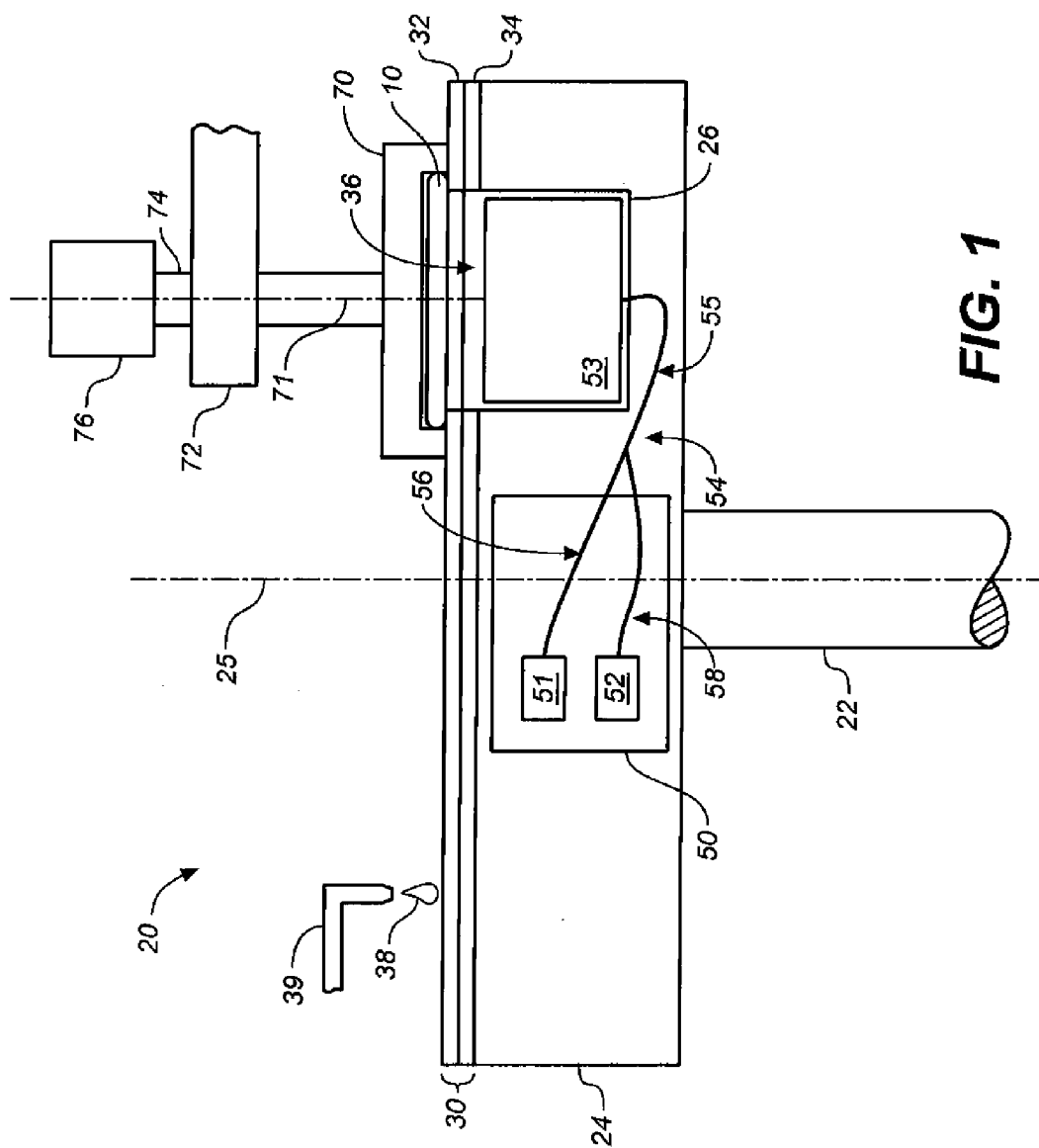


FIG. 1

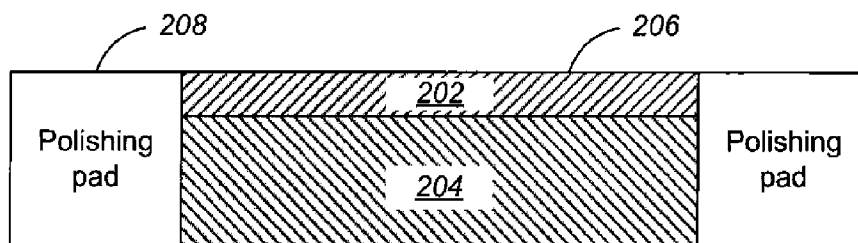


FIG. 2A

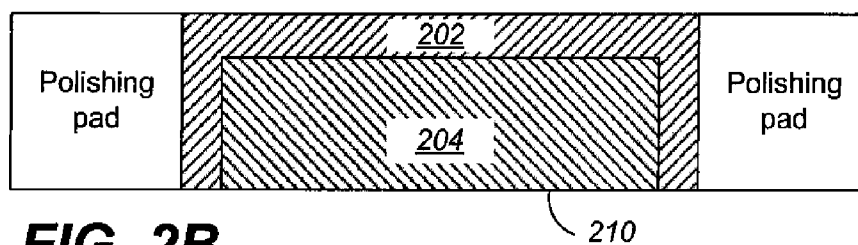


FIG. 2B

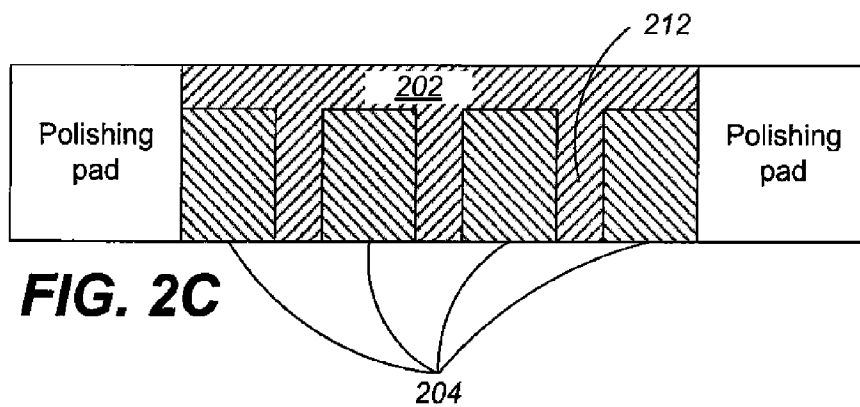


FIG. 2C

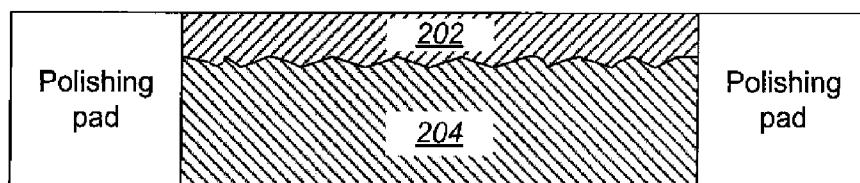
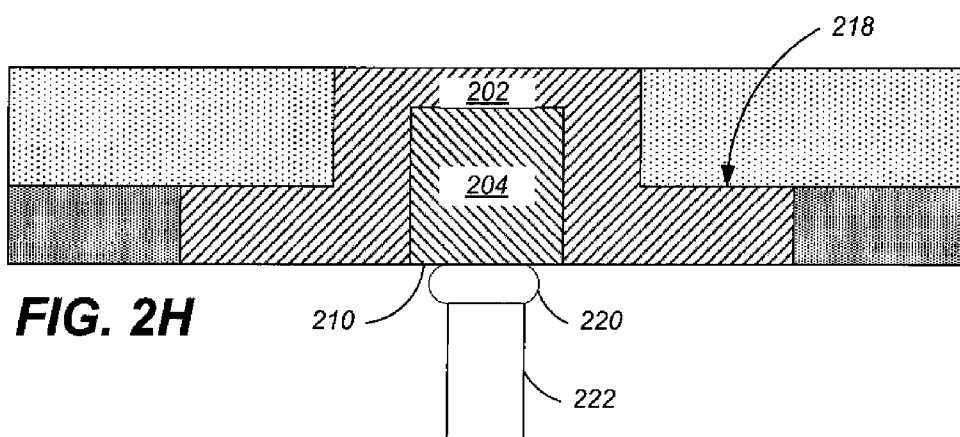
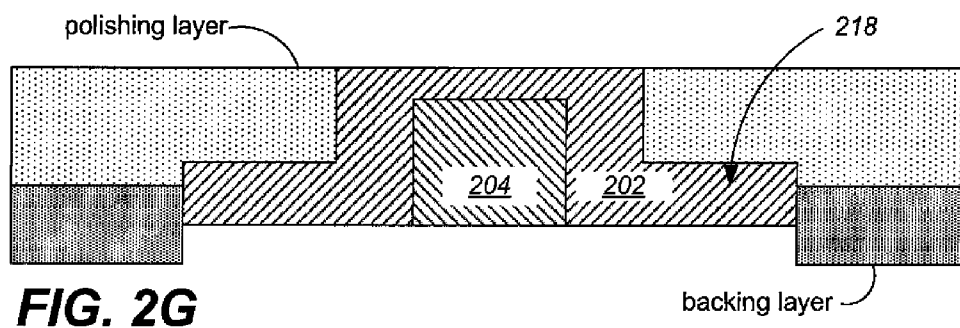
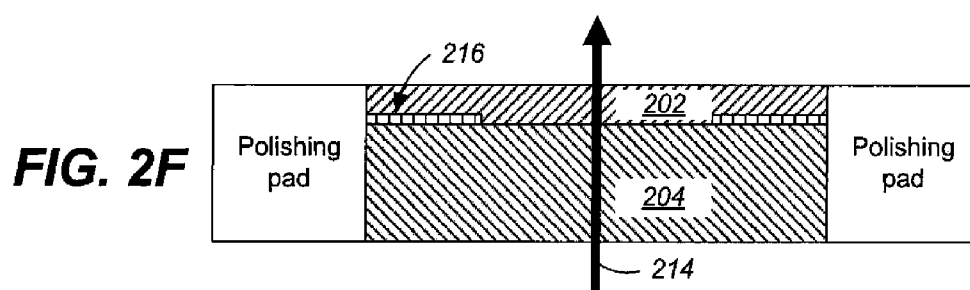
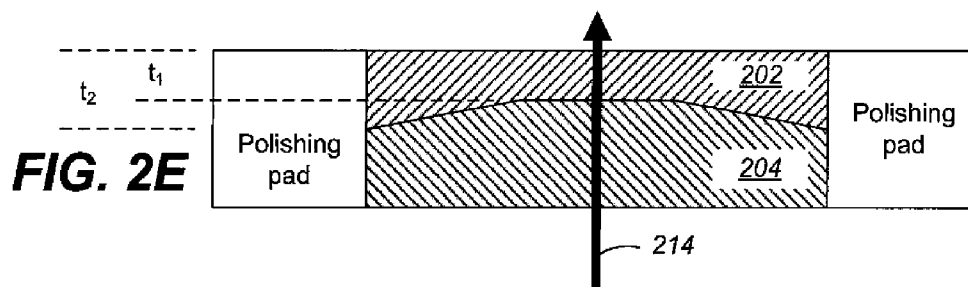
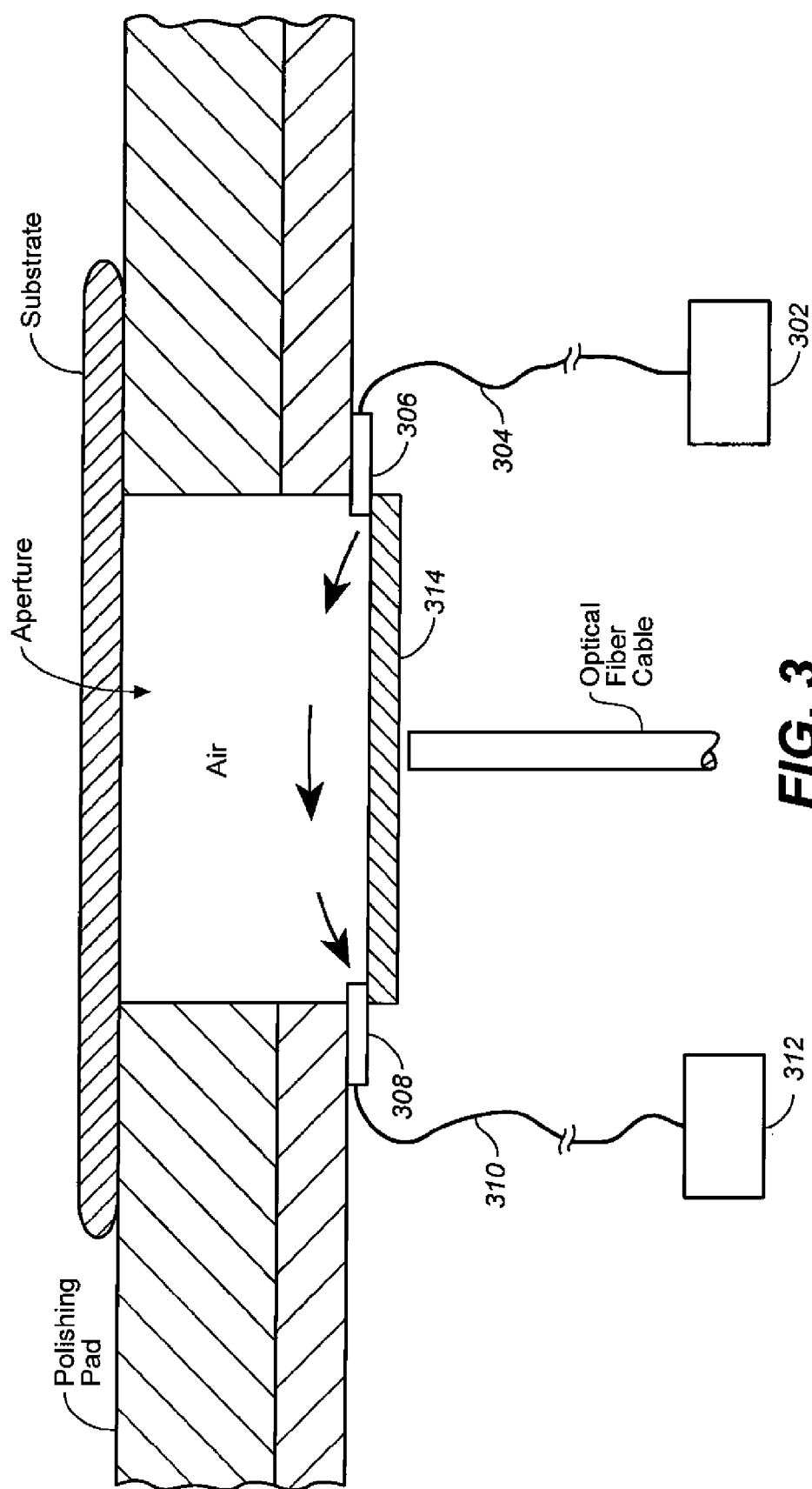


FIG. 2D





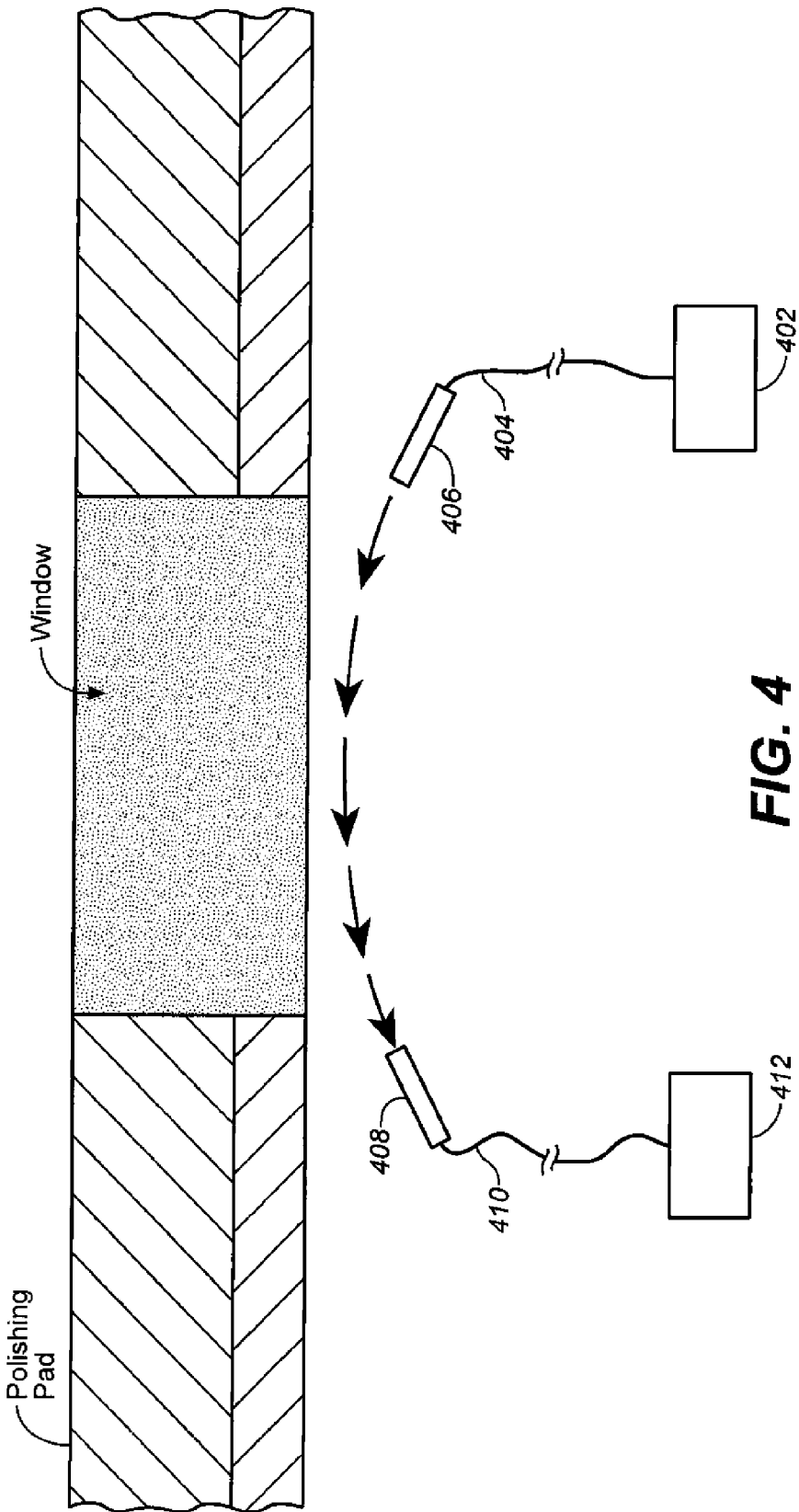


FIG. 4

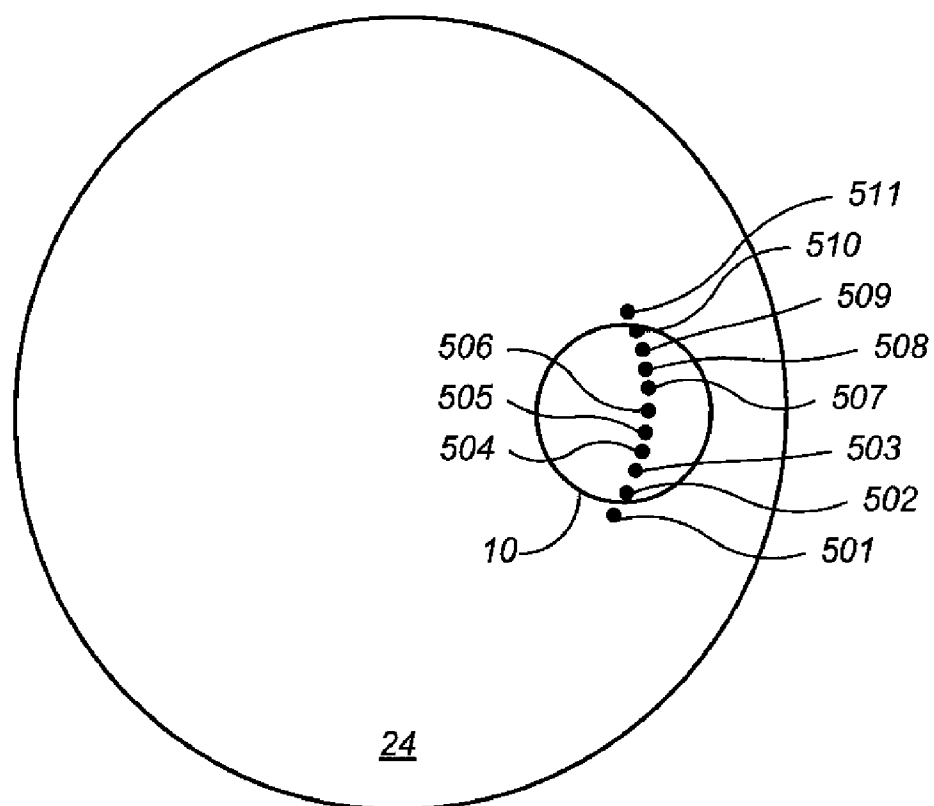


FIG. 5

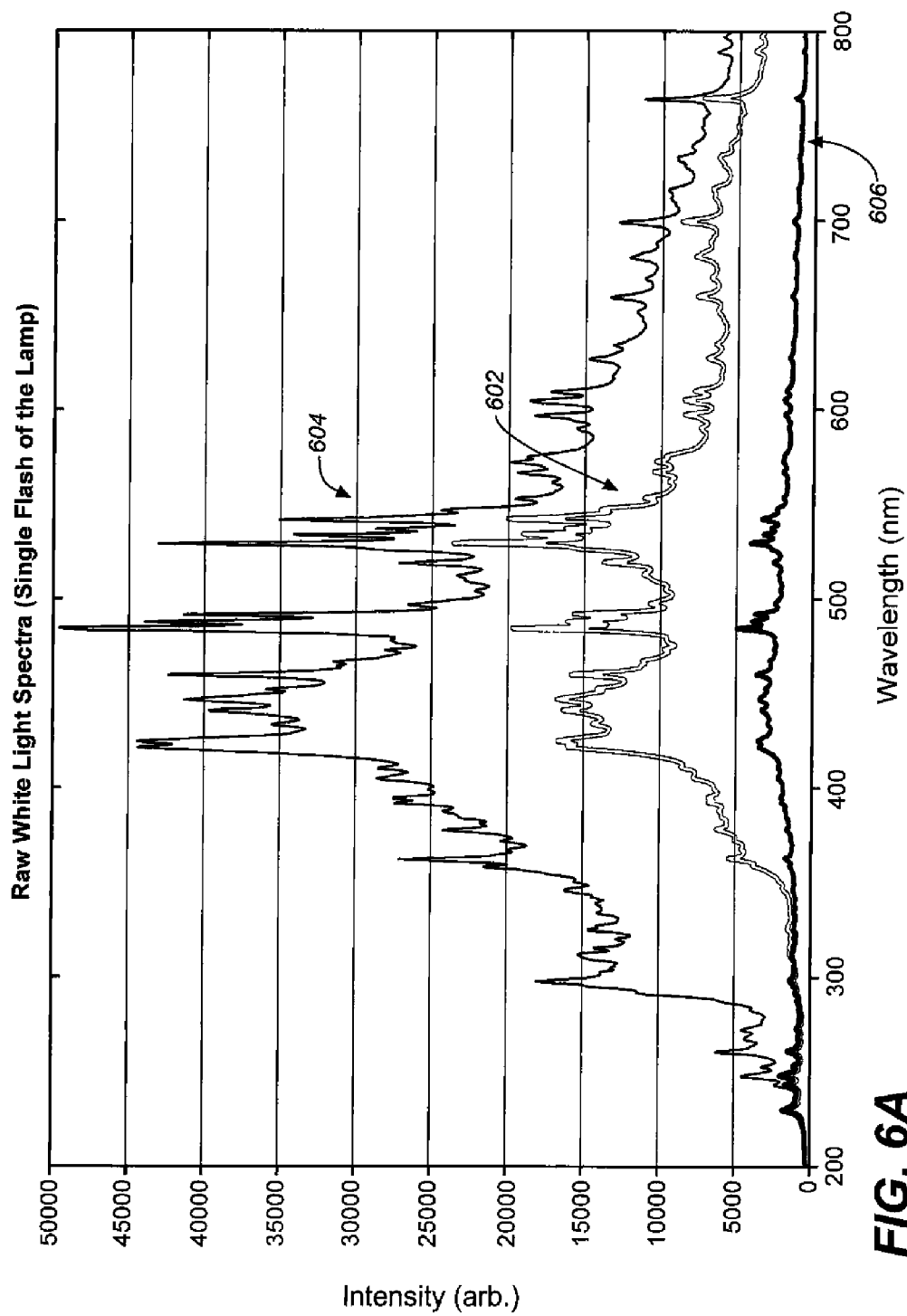


FIG. 6A

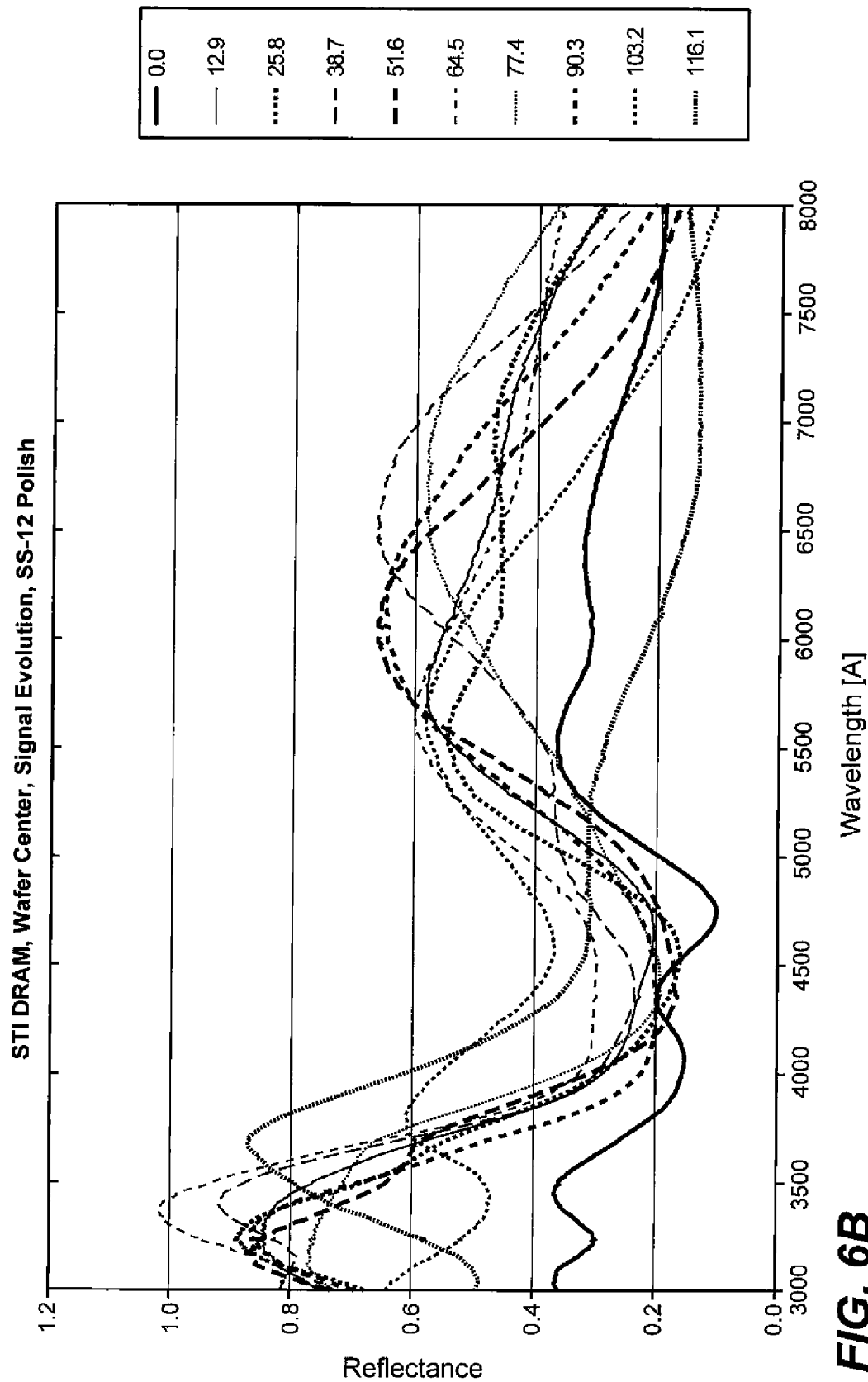
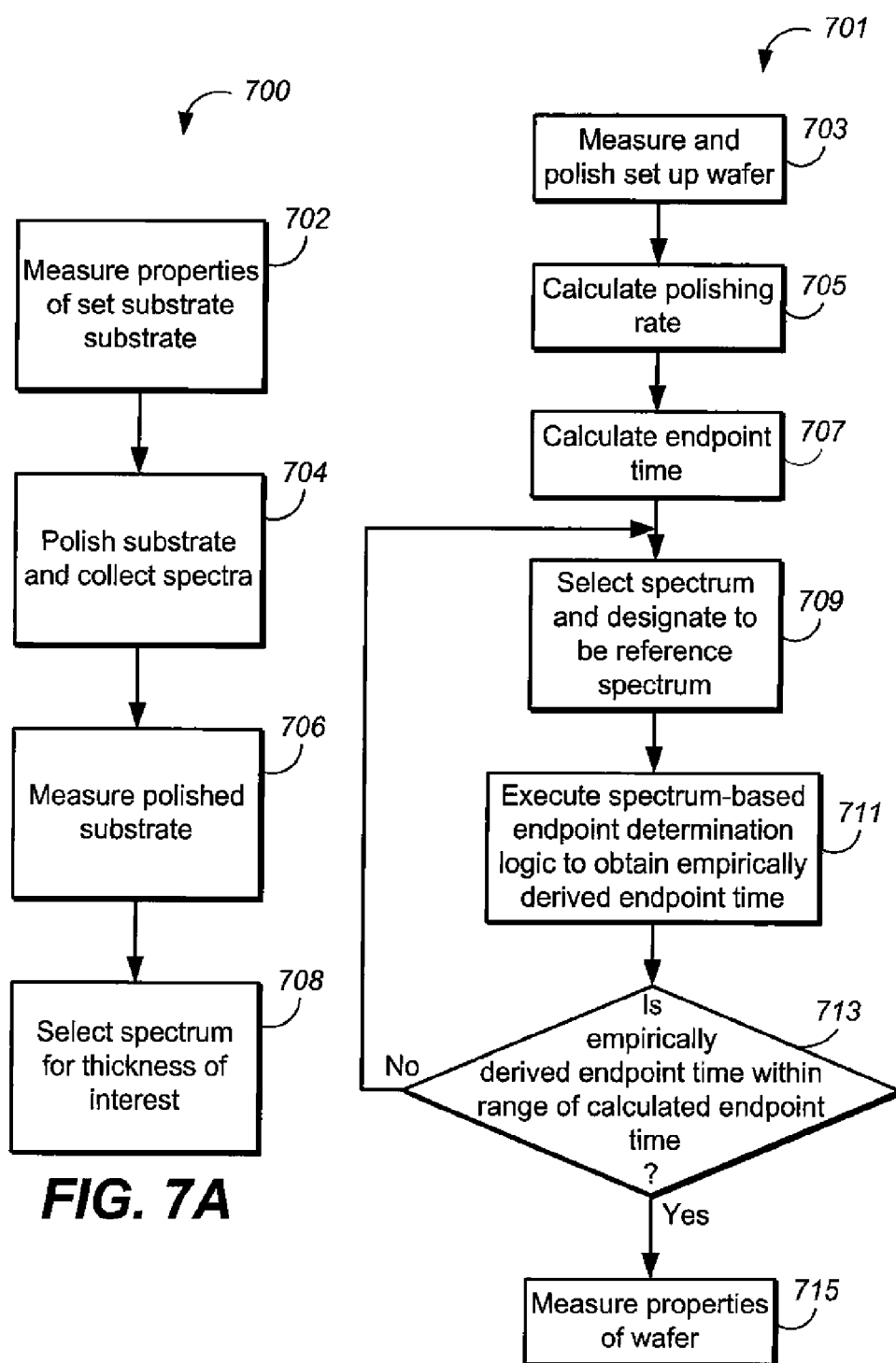
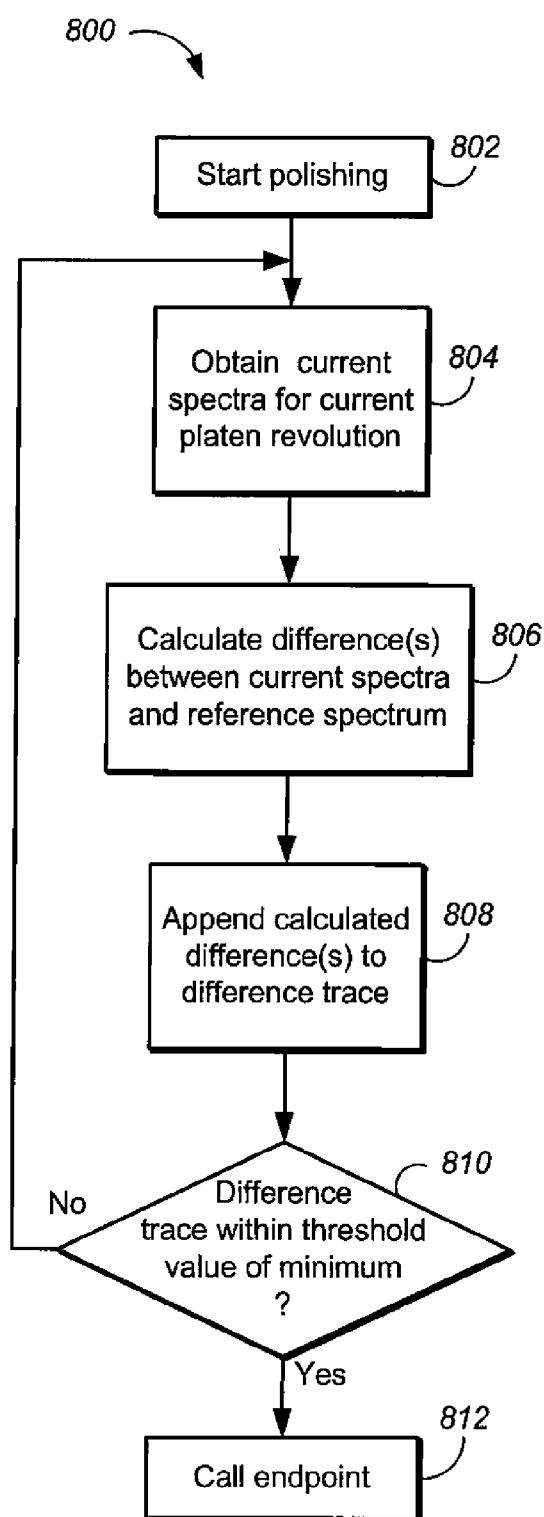


FIG. 6B



**FIG. 8A**

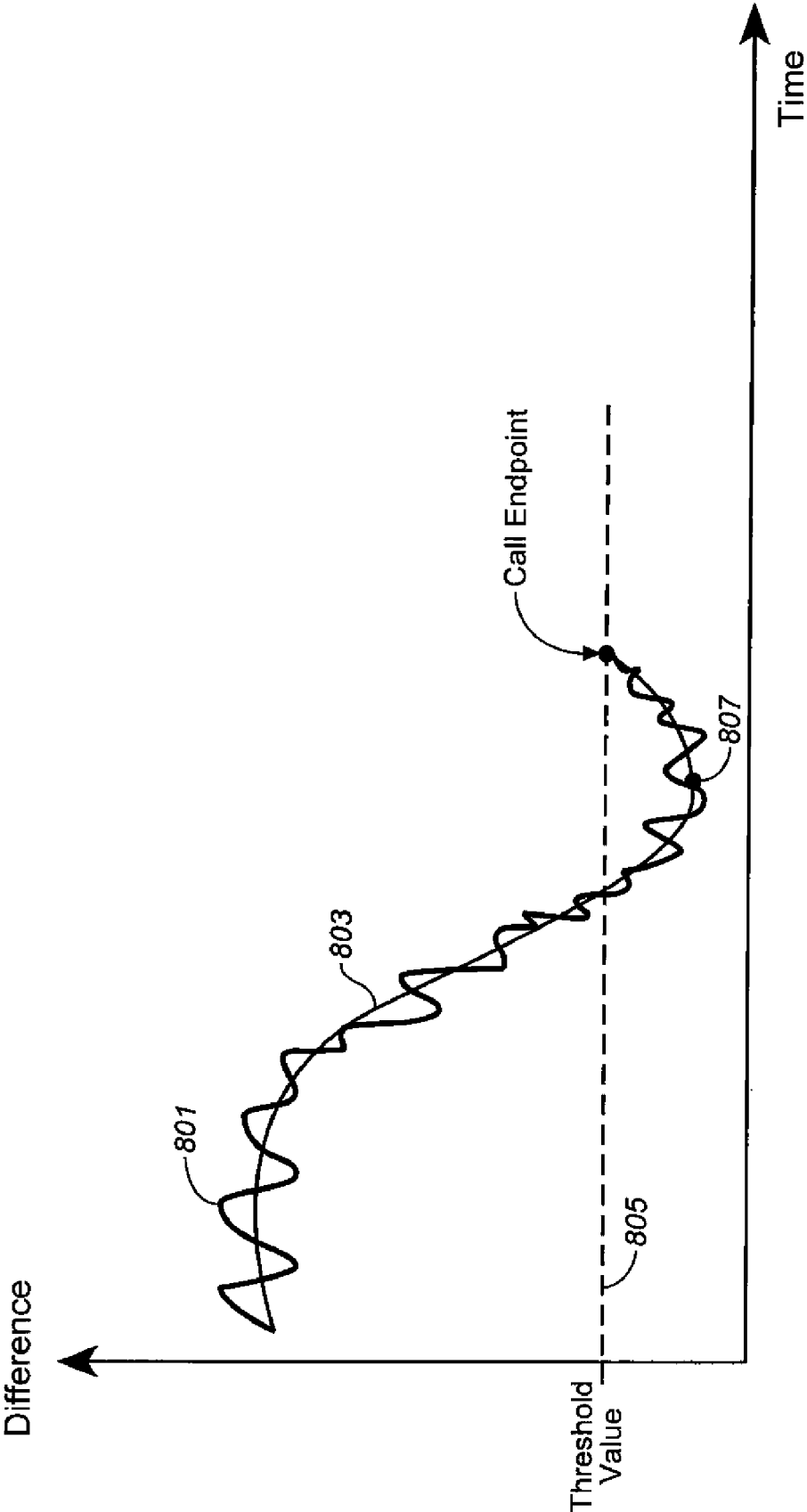
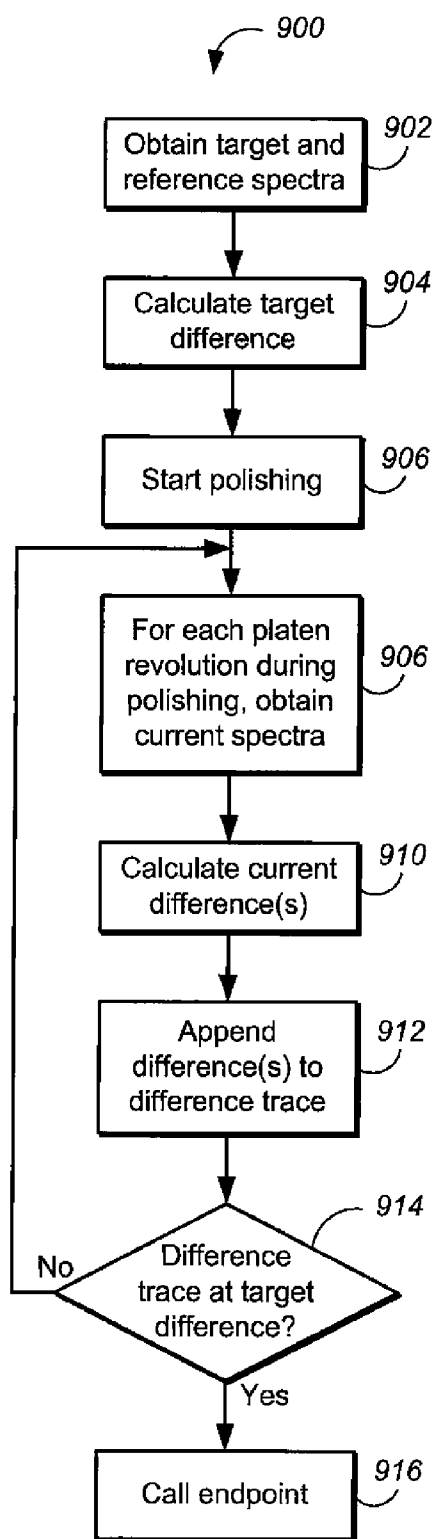
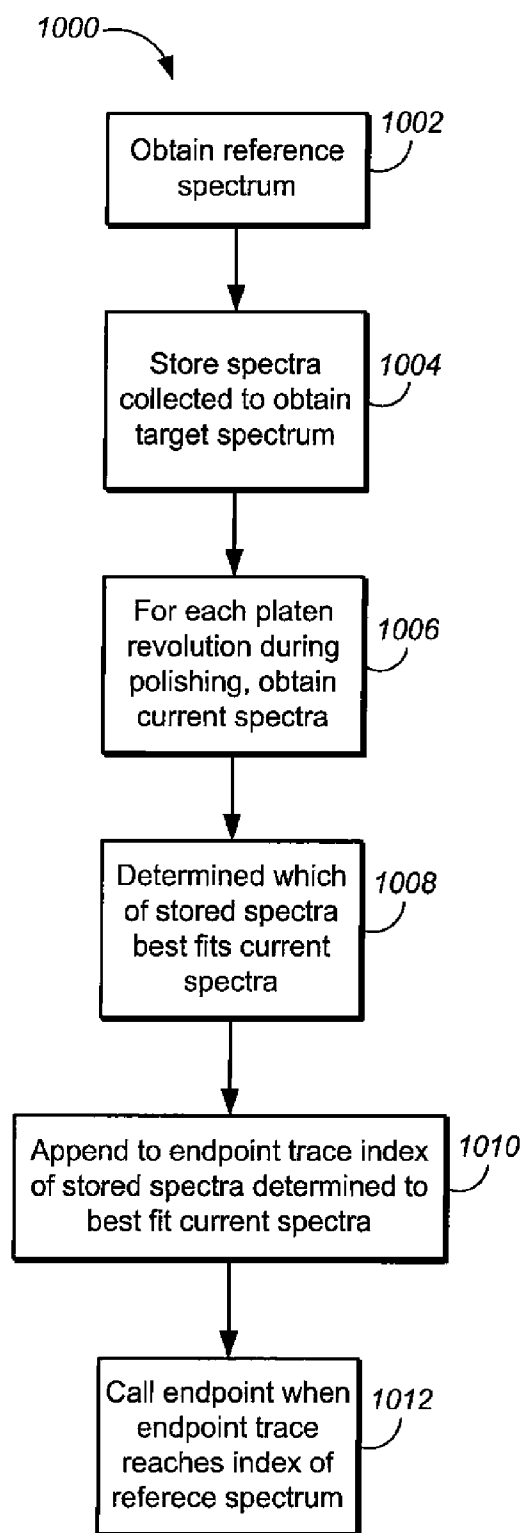


FIG. 8B

**FIG. 9A****FIG. 10A**

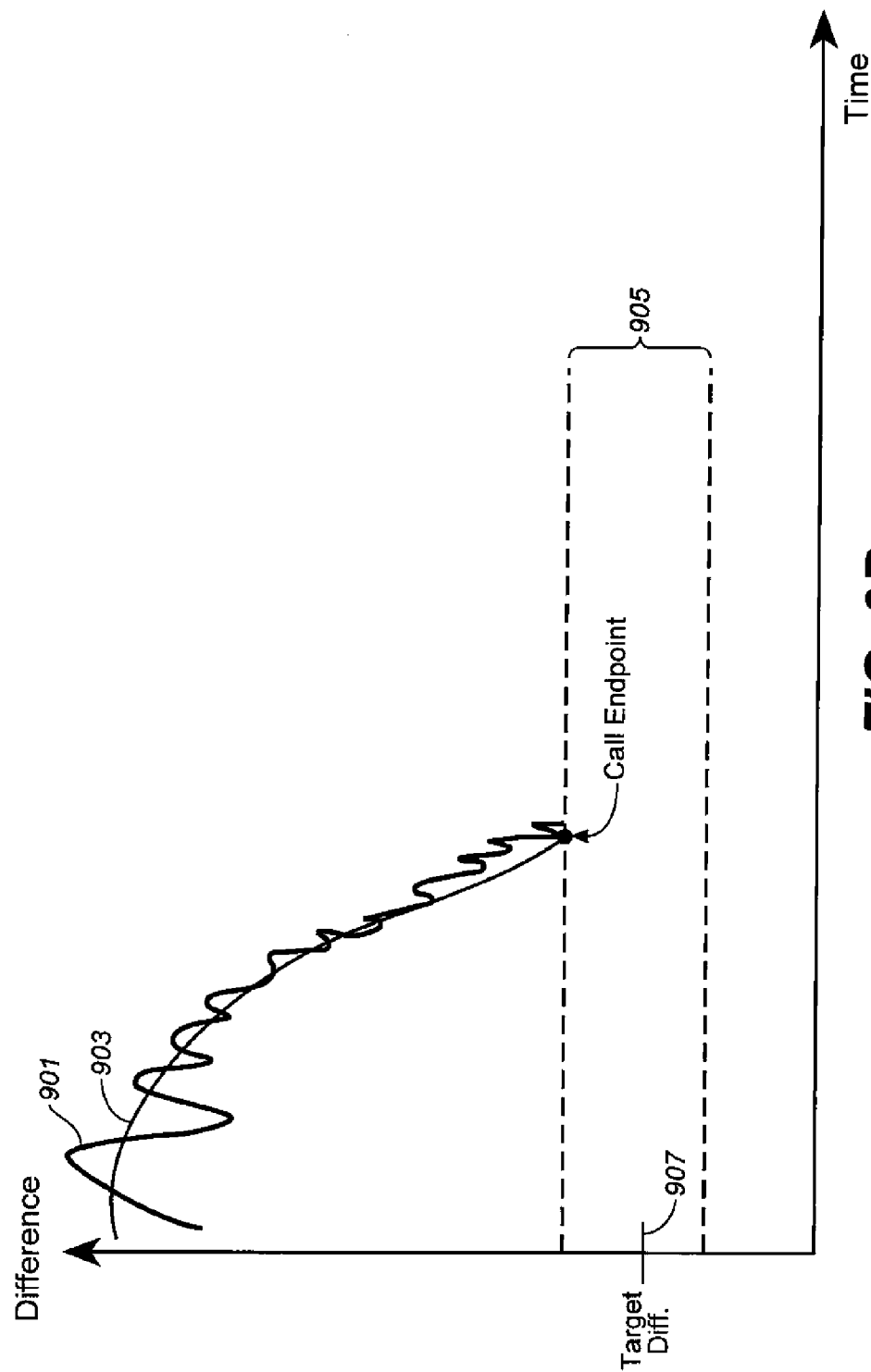


FIG. 9B

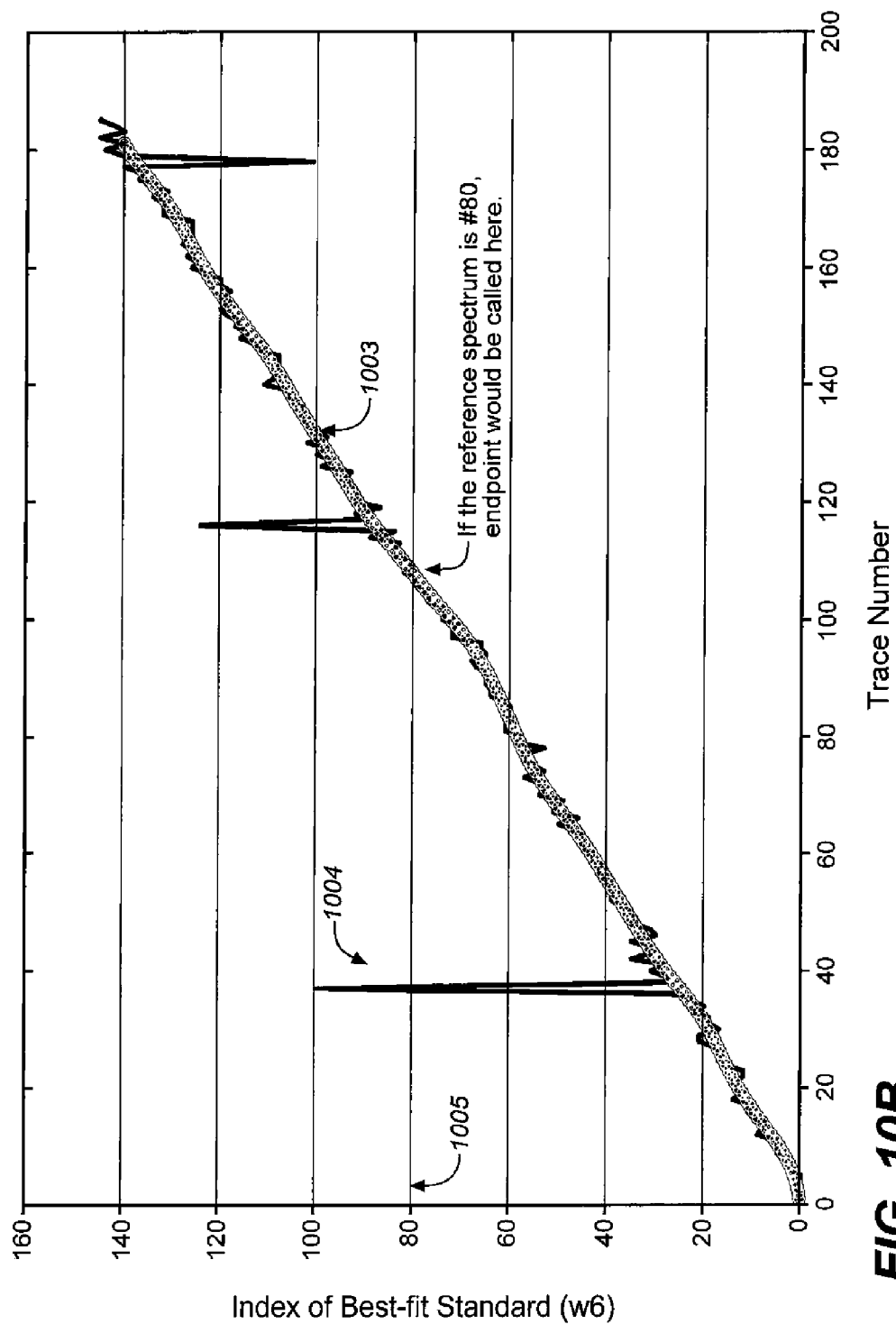
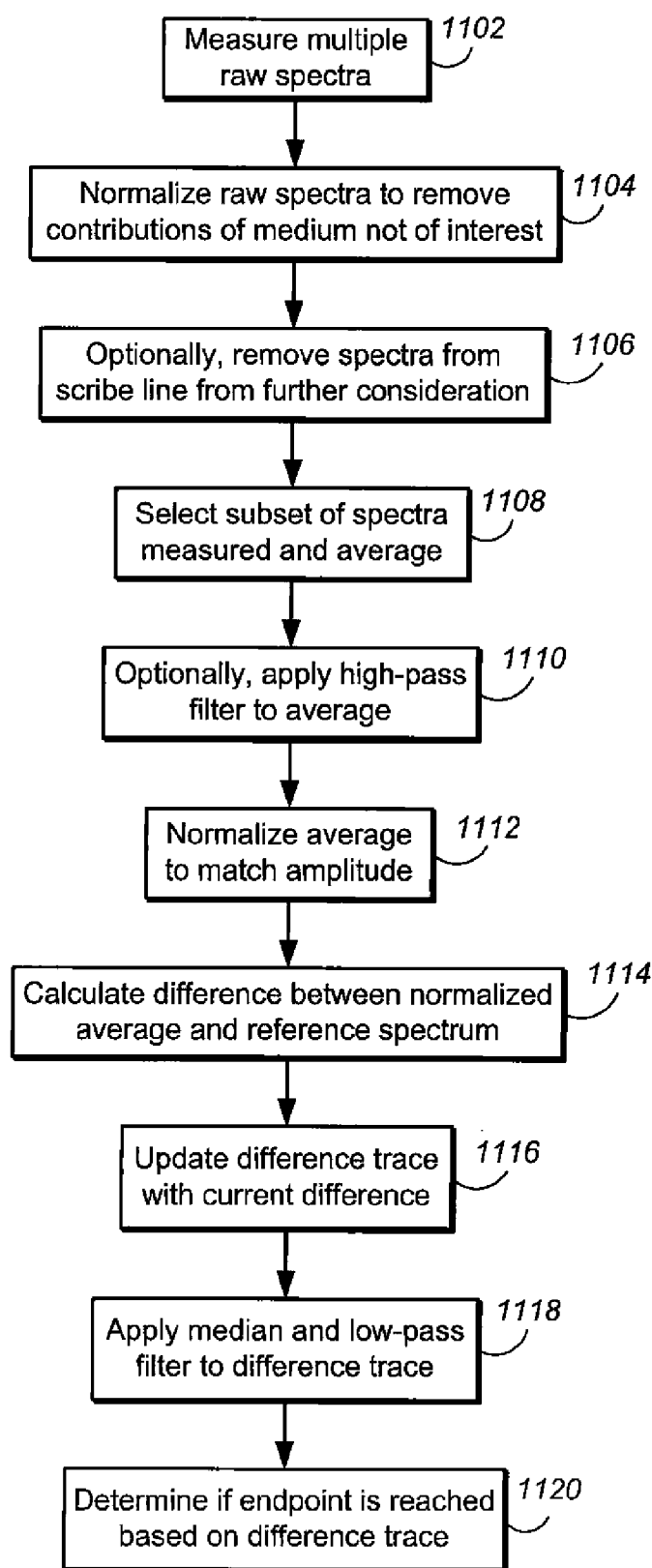


FIG. 10B

**FIG. 11**

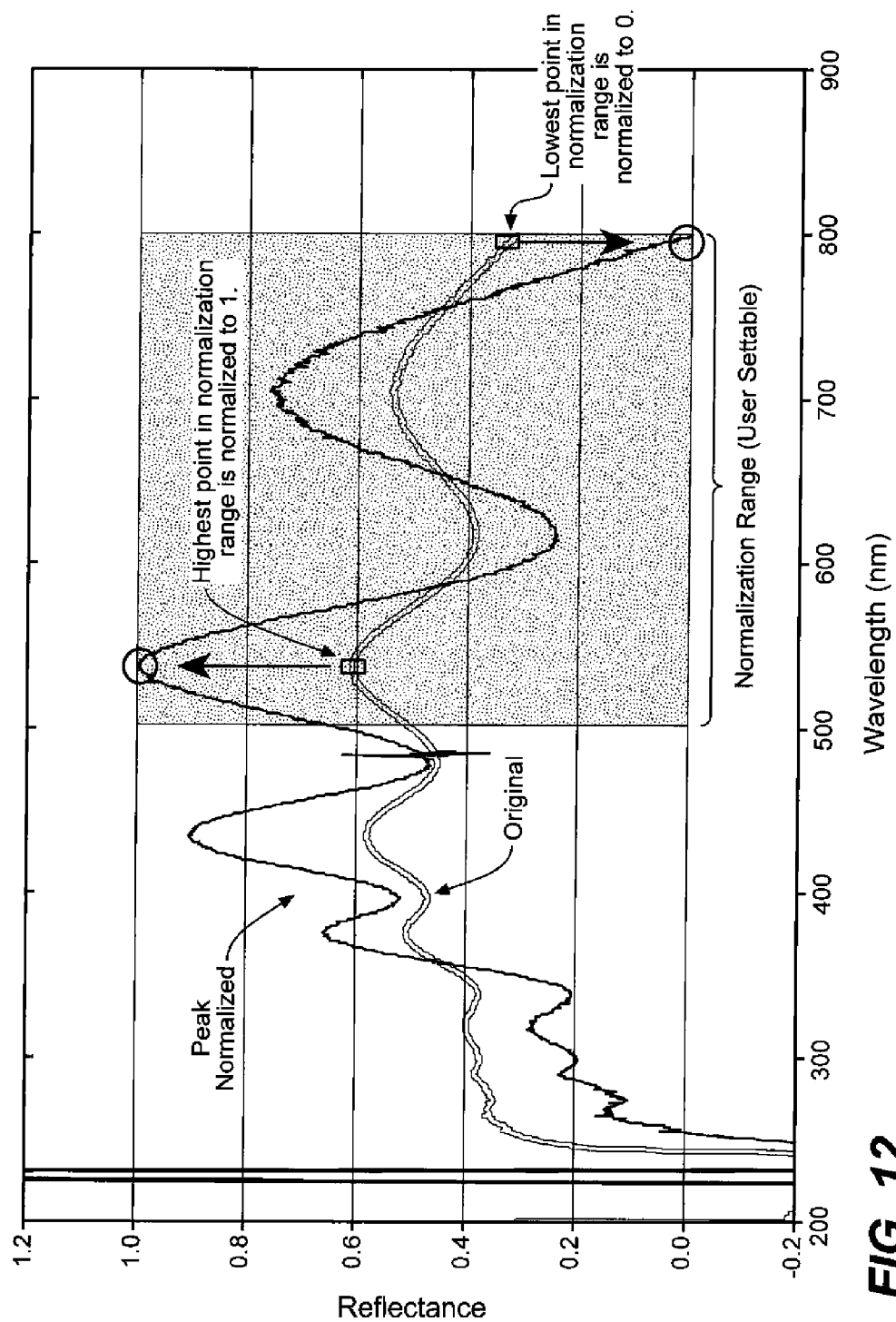


FIG. 12

METHOD OF MAKING POLISHING PAD ASSEMBLY WITH GLASS OR CRYSTALLINE WINDOW

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a divisional application and claims the benefit of priority under 35 U.S.C. Section 120 of U.S. application Ser. No. 12/572,100, filed Oct. 1, 2009, which is a continuation of U.S. application Ser. No. 11/945,987, filed Nov. 27, 2007, which is continuation of U.S. application Ser. No. 11/213,675, filed Aug. 26, 2005, which claims priority to U.S. Provisional Application Ser. No. 60/710,682, filed Aug. 22, 2005. The disclosure of each prior application is considered part of and is incorporated by reference in the disclosure of this application.

BACKGROUND

[0002] The present invention relates to generally to chemical mechanical polishing of substrates.

[0003] An integrated circuit is typically formed on a substrate by the sequential deposition of conductive, semiconductive, or insulative layers on a silicon wafer. One fabrication step involves depositing a filler layer over a non-planar surface and planarizing the filler layer. For certain applications, the filler layer is planarized until the top surface of a patterned layer is exposed. A conductive filler layer, for example, can be deposited on a patterned insulative layer to fill the trenches or holes in the insulative layer. After planarization, the portions of the conductive layer remaining between the raised pattern of the insulative layer form vias, plugs, and lines that provide conductive paths between thin film circuits on the substrate. For other applications, such as oxide polishing, the filler layer is planarized until a predetermined thickness is left over the non planar surface. In addition, planarization of the substrate surface is usually required for photolithography.

[0004] Chemical mechanical polishing (CMP) is one accepted method of planarization. This planarization method typically requires that the substrate be mounted on a carrier or polishing head. The exposed surface of the substrate is typically placed against a rotating polishing disk pad or belt pad. The polishing pad can be either a standard pad or a fixed abrasive pad. A standard pad has a durable roughened surface, whereas a fixed-abrasive pad has abrasive particles held in a containment media. The carrier head provides a controllable load on the substrate to push it against the polishing pad. A polishing slurry is typically supplied to the surface of the polishing pad. The polishing slurry includes at least one chemically reactive agent and, if used with a standard polishing pad, abrasive particles.

[0005] One problem in CMP is determining whether the polishing process is complete, i.e., whether a substrate layer has been planarized to a desired flatness or thickness, or when a desired amount of material has been removed. Overpolishing (removing too much) of a conductive layer or film leads to increased circuit resistance. On the other hand, underpolishing (removing too little) of a conductive layer leads to electrical shorting. Variations in the initial thickness of the substrate layer, the slurry composition, the polishing pad condition, the relative speed between the polishing pad and the substrate, and the load on the substrate can cause variations in the material removal rate. These variations cause

variations in the time needed to reach the polishing endpoint. Therefore, the polishing endpoint cannot be determined merely as a function of polishing time.

SUMMARY

[0006] In one general aspect, the invention features an assembly for chemical mechanical polishing. The assembly includes a polishing pad having a polishing surface. The assembly includes a solid window situated in the polishing pad to provide optical access through the polishing pad. The solid window includes a first portion made from polyurethane and a second portion made from quartz. The first portion has a surface that is co planar with the polishing surface of the polishing pad.

[0007] In another general aspect, the invention features a polishing pad that includes a polishing layer having a top surface and a bottom surface. The pad includes an aperture having a first opening in the top surface and a second opening in the bottom surface. The top surface is a polishing surface. The pad includes a window that includes a first portion made of soft plastic and a crystalline or glass like second portion. The window is transparent to white light. The window is situated in the aperture so that the first portion plugs the aperture and the second portion is on a bottom side of the first portion, wherein the first portion acts a slurry-tight barrier.

[0008] In another general aspect, the invention features a method of making a polishing pad. The method includes placing mass of crystalline or glass like material in a mold of a polishing pad window, the mass being transparent to white light. The method includes dispensing a liquid precursor of a soft plastic material into the mold, the soft plastic material being transparent to white light. The method includes curing the liquid precursor to form a window that includes a first portion made of soft plastic material and a crystalline or glass like second portion. The method includes placing the window in a mold of a polishing pad. The method includes dispensing a liquid precursor of a polishing pad material into the mold of the polishing pad. The method includes curing the liquid precursor of the polishing pad material to produce the polishing pad, wherein the window is situated in the mold of the polishing pad so that, when the polishing pad is produced, the window is situated in the polishing pad so that the first portion acts a slurry-tight barrier.

[0009] In another general aspect, the invention features a method of making a polishing pad. The method includes placing mass of crystalline or glass like materials in a mold of a polishing pad window, the mass being transparent to white light. The method includes dispensing a liquid precursor of a soft plastic material into the mold, the soft plastic material being transparent to white light. The method includes curing the liquid precursor to form a window that includes a first portion made of soft plastic material and a crystalline or glass like second portion. The method includes forming a polishing layer that includes an aperture, the polishing layer having a top surface and a bottom surface, the aperture having a first opening in the top surface and a second opening in the bottom surface, the top surface being a polishing surface. The method includes inserting the window in the aperture, the window being situated in the aperture so that the first portion plugs the aperture and the second portion is on a bottom side of the first portion, wherein the first portion acts a slurry-tight barrier.

[0010] In another general aspect, the invention features a method of making a polishing pad. The method includes forming a first portion of a polishing pad window, the first

portion having a recess and being transparent to white light. The method includes inserting a mass of crystalline or glass like material into the recess, the mass being transparent to white light. The method includes forming a polishing layer that includes an aperture, the polishing layer having a top surface and a bottom surface, the aperture having a first opening in the top surface and a second opening in the bottom surface, the top surface being a polishing surface. The method includes inserting the window in the aperture, the window being situated in the aperture so that the first portion plugs the aperture and the second portion is on a bottom side of the first portion, wherein the first portion acts a slurry-tight barrier.

[0011] As used in the instant specification, the term substrate can include, for example, a product substrate (e.g., which includes multiple memory or processor dies), a test substrate, a bare substrate, and a gating substrate. The substrate can be at various stages of integrated circuit fabrication, e.g., the substrate can be a bare wafer, or it can include one or more deposited and/or patterned layers. The term substrate can include circular disks and rectangular sheets.

[0012] Possible advantages of implementations of the invention can include one or more of the following. Endpoint determination can be made virtually without consideration of variations in polishing rate. Factors that affect polishing rate, for example, consumables, generally need not be considered. A flushing system can be less likely to dry out slurry on a substrate surface being polished. A polishing pad window can enhance the accuracy and/or precision of endpoint determination.

[0013] The details of one or more embodiments of the invention are set forth in the accompanying drawings and the description below. Other features, aspects, and advantages of the invention will become apparent from the description, the drawings, and the claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0014] FIG. 1 shows a chemical mechanical polishing apparatus.

[0015] FIGS. 2A-2H show implementations of a polishing pad window.

[0016] FIG. 3 shows an implementation of a flushing system.

[0017] FIG. 4 shows an alternative implementation of the flushing system.

[0018] FIG. 5 is an overhead view of a polishing pad and shows locations where in-situ measurements are taken.

[0019] FIG. 6A shows a spectrum obtained from in-situ measurements.

[0020] FIG. 6B illustrates the evolution of spectra obtained from in-situ measurements as polishing progresses.

[0021] FIG. 7A shows a method for obtaining a target spectrum.

[0022] FIG. 7B shows a method for obtaining a reference spectrum.

[0023] FIGS. 8A and 8B show a method for endpoint determination.

[0024] FIGS. 9A and 9B show an alternative method for endpoint determination.

[0025] FIGS. 10A and 10B show another alternative method for endpoint determination.

[0026] FIG. 11 shows an implementation for determining an endpoint.

[0027] FIG. 12 illustrates peak-to-trough normalization of a spectrum.

[0028] Like reference numbers and designations in the various drawings indicate like elements.

DETAILED DESCRIPTION

[0029] FIG. 1 shows a polishing apparatus 20 operable to polish a substrate 10. The polishing apparatus 20 includes a rotatable disk-shaped platen 24, on which a polishing pad 30 is situated. The platen is operable to rotate about axis 25. For example, a motor can turn a drive shaft 22 to rotate the platen 24. The polishing pad 30 can be detachably secured to the platen 24, for example, by a layer of adhesive. When worn, the polishing pad 30 can be detached and replaced. The polishing pad 30 can be a two-layer polishing pad with an outer polishing layer 32 and a softer backing layer 34.

[0030] Optical access 36 through the polishing pad is provided by including an aperture (i.e., a hole that runs through the pad) or a solid window. The solid window can be secured to the polishing pad, although in some implementations the solid window can be supported on the platen 24 and project into an aperture in the polishing pad. The polishing pad 30 is usually placed on the platen 24 so that the aperture or window overlies an optical head 53 situated in a recess 26 of the platen 24. The optical head 53 consequently has optical access through the aperture or window to a substrate being polished. The optical head is further described below.

[0031] The window can be, for example, a rigid crystalline or glassy material, e.g., quartz or glass, or a softer plastic material, e.g., silicone, polyurethane or a halogenated polymer (e.g., a fluoropolymer), or a combination of the materials mentioned. The window can be transparent to white light. If a top surface of the solid window is a rigid crystalline or glassy material, then the top surface should be sufficiently recessed from the polishing surface to prevent scratching. If the top surface is near and may come into contact with the polishing surface, then the top surface of the window should be a softer plastic material. In some implementations the solid window is secured in the polishing pad and is a polyurethane window, or a window having a combination of quartz and polyurethane. The window can have high transmittance, for example, approximately 80% transmittance, for monochromatic light of a particular color, for example, blue light or red light. The window can be sealed to the polishing pad 30 so that liquid does not leak through an interface of the window and the polishing pad 30.

[0032] In one implementation, the window includes a rigid crystalline or glassy material covered with an outer layer of a softer plastic material. The top surface of the softer material can be coplanar with the polishing surface. The bottom surface of the rigid material can be coplanar with or recessed relative to the bottom surface of the polishing pad. In particular, if the polishing pad includes two layers, the solid window can be integrated into the polishing layer, and the bottom layer can have an aperture aligned with the solid window.

[0033] Assuming that the window includes a combination of a rigid crystalline or glassy material and a softer plastic material, no adhesive need be used to secure the two portions. For example, in one implementation, no adhesive is used to couple the polyurethane portion to the quartz portion of the window. Alternatively, an adhesive that is transparent to white light can be used or an adhesive can be applied so that light passing through the window does not pass through the adhesive. By way of example, the adhesive can be applied only to the perimeter of the interface between the polyurethane and

quartz portion. A refractive index gel can be applied to a bottom surface of the window.

[0034] A bottom surface of the window can optionally include one or more recesses. A recess can be shaped to accommodate, for example, an end of an optical fiber cable or an end of an eddy current sensor. The recess allows the end of the optical fiber cable or the end of the eddy current sensor to be situated at a distance, from a substrate surface being polished, that is less than a thickness of the window. With an implementation in which the window includes a rigid crystalline portion or glass like portion and the recess is formed in such a portion by machining, the recess is polished so as to remove scratches caused by the machining. Alternatively, a solvent and/or a liquid polymer can be applied to the surfaces of the recess to remove scratches caused by machining. The removal of scratches usually caused by machining reduces scattering and can improve the transmittance of light through the window.

[0035] FIG. 2A-2H show various implementations of the window. As shown in FIG. 2A, the window can have two portions, a polyurethane portion **202** and a quartz portion **204**. The portions are layers, with the polyurethane portion **202** situated on top of the quartz portion **204**. The window can be situated in the polishing pad so that the top surface **206** of the polyurethane layer is coplanar with a polishing surface **208** of the polishing pad.

[0036] As shown in FIG. 2B, the polyurethane portion **202** can have a recess in which the quartz portion is situated. A bottom surface **210** of the quartz portion is exposed.

[0037] As shown in FIG. 2C, the polyurethane portion **202** can include projections, for example, projection **212**, that project into the quartz portion **204**. The projections can act to reduce the likelihood that the polyurethane portion **202** will be pulled away from the quartz portion **204** due to friction from the substrate or retaining ring.

[0038] As shown in FIG. 2D, the interface between the polyurethane portion **202** and quartz portion **204** can be a rough surface. Such a surface can improve the strength of the coupling of the two portions of the window, also reducing the likelihood the polyurethane portion **202** will be pulled away from the quartz portion **204** due to friction from the substrate or retaining ring.

[0039] As shown in FIG. 2E, the polyurethane portion **202** can have non-uniform thickness. The thickness at a location that would be in the path **214** of a light beam is less than the thickness at a location that would not be in the path **214** of the light beam. By way of example, thickness t_1 is less than thickness t_2 . Alternatively, the thickness can be less at the edges of the window.

[0040] As shown in FIG. 2F, the polyurethane portion **202** can be attached to the quartz portion **204** by use of an adhesive **216**. The adhesive can be applied so that it would not be in the path **214** of the light beam.

[0041] As shown in FIG. 2G, the polishing pad can include a polishing layer and a backing layer. The polyurethane portion **202** extends through the polishing layer and at least partially into the backing layer. The hole in the backing layer can be larger in size than the hole in the polishing layer, and the section of the polyurethane in the backing layer can be wider than the section of the polyurethane in the polishing layer. The polishing layer thus provides a lip **218** which overhangs the window and which can act to resist a pulling of the polyurethane portion **202** away from the quartz portion

204. The polyurethane portion **202** conforms to the holes of the layers of the polishing pad.

[0042] As shown in FIG. 2H, refractive index gel **220** can be applied to the bottom surface **210** of the quartz portion **204** so as to provide a medium for light to travel from a fiber cable **222** to the window. The refractive index gel **220** can fill the volume between the fiber cable **222** and the quartz portion **204** and can have a refractive index that matches or is between the indices of refraction of the fiber cable **222** and the quartz portion **204**.

[0043] In implementations where the window includes both quartz and polyurethane portions, the polyurethane portion should have a thickness so that, during the life time of the polishing pad, the polyurethane portion will not be worn so as to expose the quartz portion. The quartz can be recessed from the bottom surface of the polishing pad, and the fiber cable **222** can extend partially into the polishing pad.

[0044] The above described window and polishing pad can be manufactured using a variety of techniques. The polishing pad's backing layer **34** can be attached to its outer polishing layer **32**, for example, by adhesive. The aperture that provides optical access **36** can be formed in the pad **30**, e.g., by cutting or by molding the pad **30** to include the aperture, and the window can be inserted into the aperture and secured to the pad **30**, e.g., by an adhesive. Alternatively, a liquid precursor of the window can be dispensed into the aperture in the pad **30** and cured to form the window. Alternatively, a solid transparent element, e.g., the above described crystalline or glass like portion, can be positioned in liquid pad material, and the liquid pad material can be cured to form the pad **30** around the transparent element. In either of the later two cases, a block of pad material can be formed, and a layer of polishing pad with the molded window can be scythed from the block.

[0045] With an implementation in which the window includes a crystalline or glass like first portion and a second portion made of soft plastic material, the second portion can be formed in the aperture of the pad **30** by applying the described liquid precursor technique. The first portion can then be inserted. If the first portion is inserted before the liquid precursor of the second portion is cured, then curing can bond the first and second portions. If the first portion is inserted after the liquid precursor is cured, then the first and second portions can be secured by using an adhesive.

[0046] The polishing apparatus **20** can include a flushing system to improve light transmission through the optical access **36**. There are different implementations of the flushing system. With implementations of the polishing apparatus **20** in which the polishing pad **30** includes an aperture instead of a solid window, the flushing system is implemented to provide a laminar flow of a fluid, e.g., a gas or liquid, across a top surface of the optical head **53**. (The top surface can be a top surface of a lens included in the optical head **53**.) The laminar flow of fluid across the top surface of the optical head **53** can sweep opaque slurry out of the optical access and/or prevent slurry from drying on the top surface and, consequently, improves transmission through the optical access. With implementations in which the polishing pad **30** includes a solid window instead of an aperture, the flushing system is implemented to direct a flow of gas at a bottom surface of the window. The flow of gas can prevent condensation from forming at the solid window's bottom surface which would otherwise impede optical access.

[0047] FIG. 3 shows an implementation of the laminar-flow flushing system. The flushing system includes a gas source

302, a delivery line **304**, a delivery nozzle **306**, a suction nozzle **308**, a vacuum line **310**, and a vacuum source **312**. The gas source **302** and vacuum source can be configured so that they can introduce and suction a same or a similar volume of gas. The delivery nozzle **306** is situated so that the laminar flow of gas is directed across the transparent top surface **314** of the in-situ monitoring module and not directed at the substrate surface being polished. Consequently, the laminar flow of gas does not dry out slurry on a substrate surface being polished, which can undesirably affect polishing.

[0048] FIG. 4 shows an implementation of the flushing system for preventing the formation of condensation on a bottom surface of the solid window. The system reduces or prevents the formation of condensation at the bottom surface of the polishing pad window. The system includes a gas source **402**, a delivery line **404**, a delivery nozzle **406**, a suction nozzle **408**, a vacuum line **410**, and a vacuum source **412**. The gas source **402** and vacuum source can be configured so that they can introduce and suction a same or a similar volume of gas. The delivery nozzle **406** is situated so that the flow of gas is directed at the bottom surface window in the polishing pad **30**.

[0049] In one implementation that is an alternative to the implementation of FIG. 4, the flushing system does not include a vacuum source or line. In lieu of these components, the flushing system includes a vent formed in the platen so that the gas introduced into the space underneath the solid window can be exhausted to a side of the platen or, alternatively, to any other location in the polishing apparatus that can tolerate moisture.

[0050] The above described gas source and vacuum source can be located away from the platen so that they do not rotate with the platen. In this case, a rotational coupler for convey gas is included each of the supply line and the vacuum line.

[0051] Returning to FIG. 1, the polishing apparatus **20** includes a combined slurry/rinse arm **39**. During polishing, the arm **39** is operable to dispense slurry **38** containing a liquid and a pH adjuster. Alternative, the polishing apparatus includes a slurry port operable to dispense slurry onto polishing pad **30**.

[0052] The polishing apparatus **20** includes a carrier head **70** operable to hold the substrate **10** against the polishing pad **30**. The carrier head **70** is suspended from a support structure **72**, for example, a carousel, and is connected by a carrier drive shaft **74** to a carrier head rotation motor **76** so that the carrier head can rotate about an axis **71**. In addition, the carrier head **70** can oscillate laterally in a radial slot formed in the support structure **72**. In operation, the platen is rotated about its central axis **25**, and the carrier head is rotated about its central axis **71** and translated laterally across the top surface of the polishing pad.

[0053] The polishing apparatus also includes an optical monitoring system, which can be used to determine a polishing endpoint as discussed below. The optical monitoring system includes a light source **51** and a light detector **52**. Light passes from the light source **51**, through the optical access **36** in the polishing pad **30**, impinges and is reflected from the substrate **10** back through the optical access **36**, and travels to the light detector **52**.

[0054] A bifurcated optical cable **54** can be used to transmit the light from the light source **51** to the optical access **36** and back from the optical access **36** to the light detector **52**. The bifurcated optical cable **54** can include a "trunk" **55** and two "branches" **56** and **58**.

[0055] As mentioned above, the platen **24** includes the recess **26**, in which the optical head **53** is situated. The optical head **53** holds one end of the trunk **55** of the bifurcated fiber cable **54**, which is configured to convey light to and from a substrate surface being polished. The optical head **53** can include one or more lenses or a window overlying the end of the bifurcated fiber cable **54** (e.g., as shown in FIG. 3). Alternatively, the optical head **53** can merely hold the end of the trunk **55** adjacent the solid window in the polishing pad. The optical head **53** can hold the above-described nozzles of the flushing system. The optical head **53** can be removed from the recess **26** as required, for example, to effect preventive or corrective maintenance.

[0056] The platen includes a removable in-situ monitoring module **50**. The in-situ monitoring module **50** can include one or more of the following: the light source **51**, the light detector **52**, and circuitry for sending and receiving signals to and from the light source **51** and light detector **52**. For example, the output of the detector **52** can be a digital electronic signal that passes through a rotary coupler, e.g., a slip ring, in the drive shaft **22** to the controller for the optical monitoring system. Similarly, the light source can be turned on or off in response to control commands in digital electronic signals that pass from the controller through the rotary coupler to the module **50**.

[0057] The in-situ monitoring module can also hold the respective ends of the branch portions **56** and **58** of the bifurcated optical fiber **54**. The light source is operable to transmit light, which is conveyed through the branch **56** and out the end of the trunk **55** located in the optical head **53**, and which impinges on a substrate being polished. Light reflected from the substrate is received at the end of the trunk **55** located in the optical head **53** and conveyed through the branch **58** to the light detector **52**.

[0058] In one implementation, the bifurcated fiber cable **54** is a bundle of optical fibers. The bundle includes a first group of optical fibers and a second group of optical fibers. An optical fiber in the first group is connected to convey light from the light source **51** to a substrate surface being polished. An optical fiber in the second group is connected to received light reflecting from the substrate surface being polished and convey the received light to a light detector. The optical fibers can be arranged so that the optical fibers in the second group form an X-like shape that is centered on the longitudinal axis of the bifurcated optical fiber **54** (as viewed in a cross section of the bifurcated fiber cable **54**). Alternatively, other arrangements can be implemented. For example, the optical fibers in the second group can form V-like shapes that are mirror images of each other. A suitable bifurcated optical fiber is available from Verity Instruments, Inc. of Carrollton, Tex.

[0059] There is usually an optimal distance between the polishing pad window and the end of the trunk **55** of bifurcated fiber cable **54** proximate to the polishing pad window. The distance can be empirically determined and is affected by, for example, the reflectivity of the window, the shape of the light beam emitted from the bifurcated fiber cable, and the distance to the substrate being monitored. In one implementation, the bifurcated fiber cable is situated so that the end proximate to the window is as close as possible to the bottom of the window without actually touching the window. With this implementation, the polishing apparatus **20** can include a mechanism, e.g., as part of the optical head **53**, that is operable to adjust the distance between the end of the bifurcated fiber cable **54** and the bottom surface of the polishing pad

window. Alternatively, the proximate end of the bifurcated fiber cable is embedded in the window.

[0060] The light source **51** is operable to emit white light. In one implementation, the white light emitted includes light having wavelengths of 200-800 nanometers. A suitable light source is a xenon lamp or a xenon-mercury lamp.

[0061] The light detector **52** can be a spectrometer. A spectrometer is basically an optical instrument for measuring properties of light, for example, intensity, over a portion of the electromagnetic spectrum. A suitable spectrometer is a grating spectrometer. Typical output for a spectrometer is the intensity of the light as a function of wavelength.

[0062] Optionally, the in-situ monitoring module **50** can include other sensor elements. The in-situ monitoring module **50** can include, for example, eddy current sensors, lasers, light emitting diodes, and photodetectors. With implementations in which the in-situ monitoring module **50** includes eddy current sensors, the module **50** is usually situated so that a substrate being polished is within working range of the eddy current sensors.

[0063] The light source **51** and light detector **52** are connected to a computing device operable to control their operation and to receive their signals. The computing device can include a microprocessor situated near the polishing apparatus, e.g., a personal computer. With respect to control, the computing device can, for example, synchronize activation of the light source **51** with the rotation of the platen **24**. As shown in FIG. 5, the computer can cause the light source **51** to emit a series of flashes starting just before and ending just after the substrate **10** passes over the in-situ monitoring module. (Each of points **501-511** depicted represents a location where light from the in-situ monitoring module impinged and reflected off.) Alternatively, the computer can cause the light source **51** to emit light continuously starting just before and ending just after the substrate **10** passes over the in-situ monitoring module.

[0064] With respect to receiving signals, the computing device can receive, for example, a signal that carries information describing a spectrum of the light received by the light detector **52**. FIG. 6A shows examples of a spectrum measured from light that is emitted from a single flash of the light source and that is reflected from the substrate. Spectrum **602** is measured from light reflected from a product substrate. Spectrum **604** is measured from light reflected from a base silicon substrate (which is a wafer that has only a silicon layer). Spectrum **606** is from light received by the optical head **53** when there is no substrate situated over the optical head **53**. Under this condition, referred to in the present specification as a dark condition, the received light is typically ambient light.

[0065] The computing device can process the above-described signal to determine an endpoint of a polishing step. Without being limited to any particular theory, the spectra of light reflected from the substrate **10** evolve as polishing progresses. FIG. 6B provides an example of the evolution as polishing of a film of interest progresses. The different lines of spectrum represent different times in the polishing. As can be seen, properties of the spectrum of the reflected light changes as a thickness of the film changes, and particular spectra are exhibited by particular thicknesses of the film. The computing device can execute logic that determines, based on one or more of the spectra, when an endpoint has

been reached. The one or more spectra on which an endpoint determination is based can include a target spectrum, a reference spectrum, or both.

[0066] As used in the instant specification, a target spectrum refers to a spectrum exhibited by the white light reflecting from a film of interest when the film of interest has a target thickness. By way of example, a target thickness can be 1, 2, or 3 microns. Alternatively, the target thickness can be zero, for example, when the film of interest is cleared so that an underlying film is exposed.

[0067] FIG. 7A shows a method **700** for obtaining a target spectrum. Properties of a substrate with the same pattern as the product substrate are measured (step **702**). The substrate which is measured is referred to in the instant specification as a “set-up” substrate. The set-up substrate can simply be a substrate which is similar or the same to the product substrate, or the set-up substrate could be one substrate from a batch. The properties can include a pre-polished thickness of a film of interest at a particular location of interest on the substrate. Typically, the thicknesses at multiple locations are measured. The locations are usually selected so that a same type of die feature is measured for each location. Measurement can be performed at a metrology station.

[0068] The set-up substrate is polished in accordance with a polishing step of interest and spectra of white light reflecting off a substrate surface being polished are collected during polishing (step **704**). Polishing and spectra collection can be performed at the above described polishing apparatus. Spectra are collected by the in-situ monitoring system during polishing. The substrate is overpolished, i.e., polished past an estimated endpoint, so that the spectrum of the light that reflected from the substrate when the target thickness is achieved can be obtained.

[0069] Properties of the overpolished substrate are measured (step **706**). The properties include post-polished thicknesses of the film of interest at the particular location or locations used for the pre-polish measurement.

[0070] The measured thicknesses and the collected spectra are used to select, from among the collected spectra, a spectrum determined to be exhibited by a thickness of interest (step **708**). In particular, linear interpolation can be performed using the measured pre-polish film thickness and post-polish substrate thicknesses to determine which of the spectra was exhibited when the target film thickness was achieved. The spectrum determined to be the one exhibited when the target thickness was achieved is designated to be the target spectrum for the batch of substrates.

[0071] Optionally, the spectra collected are processed to enhance accuracy and/or precision. The spectra can be processed, for example: to normalize them to a common reference, to average them, and/or to filter noise from them. Particular implementations of these processing operations are described below.

[0072] As used in the instant specification, a reference spectrum refers to a spectrum that is associated with a target film thickness. A reference spectrum is usually empirically selected for particular endpoint determination logic so that the target thickness is achieved when the computer device calls endpoint by applying the particular spectrum-based endpoint logic. The reference spectrum can be iteratively selected, as will be described below in reference to FIG. 7B. The reference spectrum is usually not the target spectrum. Rather, the reference spectrum is usually the spectrum of the

light reflected from the substrate when the film of interest has a thickness greater than the target thickness.

[0073] FIG. 7B shows a method 701 for selecting a reference spectrum for a particular target thickness and particular spectrum-based endpoint determination logic. A set up substrate is measured and polished as described above in steps 702-706 (step 703). In particular, spectra collected and the time at which each collected spectrum is measured is stored.

[0074] A polishing rate of the polishing apparatus for the particular set-up substrate is calculated (step 705). The average polishing rate PR can be calculated by using the pre and post-polished thicknesses T1, T2, and the actual polish time, PT, e.g., $PR = (T2 - T1) / PT$.

[0075] An endpoint time is calculated for the particular set-up substrate to provide a calibration point to test the reference spectrum, as discussed below (step 707). The endpoint time can be calculated based on the calculated polish rate PR, the pre-polish starting thickness of the film of interest, ST, and the target thickness of the film of interest, TT. The endpoint time can be calculated as a simple linear interpolation, assuming that the polishing rate is constant through the polishing process, e.g., $ET = (ST - TT) / PR$.

[0076] Optionally, the calculated endpoint time can be evaluated by polishing another substrate of the batch of patterned substrates, stopping polishing at the calculated endpoint time, and measuring the thickness of the film of interest. If the thickness is within a satisfactory range of the target thickness, then the calculated endpoint time is satisfactory. Otherwise, the calculated endpoint time can be re-calculated.

[0077] One of the collected spectra is selected and designated to be the reference spectrum (step 709). The spectrum selected is a spectrum of light reflected from the substrate when the film of interest has a thickness greater than and is approximately equal to the target thickness.

[0078] The particular endpoint determination logic is executed in simulation using the spectra collected for the set-up substrate and with the selected spectrum designated to be the reference spectrum (step 711). Execution of the logic yields an empirically derived but simulated endpoint time that the logic has determined to be the endpoint.

[0079] The empirically derived but simulated endpoint time is compared to the calculated endpoint time (step 713). If the empirically derived endpoint time is within a threshold range of the calculated endpoint time, then the currently selected reference spectrum is known to generate a result that matches the calibration point. Thus, when the endpoint logic is executed using the reference spectrum in a run-time environment, the system should reliably detect an endpoint at the target thickness. Therefore, the reference spectrum can be kept as the reference spectrum for run time polishing of the other substrates of the batch (step 718). Otherwise, steps 709 and 711 are repeated as appropriate.

[0080] Optionally, variables other than the selected spectrum can be changed for each iteration (i.e., each performance of steps 709 and 711). For example, the above-mentioned processing of the spectra (for example, filter parameters) and/or a threshold range from a minimum of a difference trace can be changed. The difference trace and the threshold range of a minimum of the difference trace are described below.

[0081] FIG. 8A shows a method 800 for using spectrum-based endpoint determination logic to determine an endpoint of a polishing step. Another substrate of the batch of patterned substrates is polished using the above-described polishing

apparatus (step 802). At each revolution of the platen, the following steps are performed.

[0082] One or more spectra of white light reflecting off a substrate surface being polished are measured to obtain one or more current spectra for a current platen revolution (step 804). The one or more spectra measured for the current platen revolution are optionally processed to enhance accuracy and/or precision as described above in reference to FIG. 7A and as described below in reference to FIG. 11. If only one spectrum is measured, then the one spectrum is used as the current spectrum. If more than one current spectra is measured for a platen revolution, then they are grouped, averaged within each group, and the averages are designated to be current spectra. The spectra can be grouped by radial distance from the center of the substrate. By way of example, a first current spectrum can be obtained from spectra measured as points 502 and 510 (FIG. 5), a second current spectrum can be obtained from spectra measured at points 503 and 509, a third current spectra can be obtained from spectra measured at points 504 and 508, and so forth. The spectra measured at points 502 and 510 are averaged to obtain a first current spectrum for the current platen revolution. The spectra measured at points 503 and 509 are averaged to obtain a second current spectrum for the current platen revolution. The spectra measured at points 504 and 508 are averaged to obtain a third current spectrum for the current platen revolution.

[0083] A difference between the one or more current spectra and a reference spectrum is calculated (step 806). The reference spectrum can be obtained as described above in reference to FIG. 7B. In one implementation, the difference is a sum of differences in intensities over a range of wavelengths. That is,

$$\text{Difference} = \sum_{\lambda=a}^b \text{abs}(I_{\text{current}}(\lambda) - I_{\text{reference}}(\lambda))$$

where a and b are the lower limit and upper limit of the range of wavelengths of a spectrum, respectively, and $I_{\text{current}}(\lambda)$ and $I_{\text{reference}}(\lambda)$ are the intensity of a current spectra and the intensity of the target spectra for a given wavelength, respectively.

[0084] Each calculated difference is appended to a difference trace (step 808). The difference trace is generally a plot of the calculated difference. The difference trace is updated at least once per platen revolution. (When multiple current spectra are obtained for each platen revolution, the difference trace can be updated more than once per platen revolution.)

[0085] Optionally, the difference trace can be processed, for example, smoothing the difference trace by filtering out a calculated difference that deviates beyond a threshold from preceding one or more calculated differences.

[0086] Whether the difference trace is within a threshold value of a minimum is determined (step 810). After the minimum has been detected, the endpoint is called when the different trace begins to rise past a particular threshold value of the minimum. Alternatively, the endpoint can be called based on the slope of the difference trace. In particular, the slope of the difference trace approaches and becomes zero at the minimum of the difference trace. The endpoint can be called when the slope of the difference trace is within a threshold range of the slope that is near zero.

[0087] Optionally, window logic can be applied to facilitate the determination of step 808. Window logic suitable for use

is described in commonly assigned U.S. Pat. Nos. 5,893,796 and 6,296,548, which are incorporated by reference.

[0088] If the difference trace is NOT determined to have reached a threshold range of a minimum, polishing is allowed to continue and steps **804**, **806**, **808**, and **810** are repeated as appropriate. Otherwise, an endpoint is called and polishing is stopped (step **812**).

[0089] FIG. **8B** illustrates the above described method for determining endpoint. Trace **801** is the raw difference trace. Trace **803** is the smoothed difference trace. Endpoint is called when the smoothed difference trace **803** reaches a threshold value **805** above the minimum **807**.

[0090] As an alternative to using a reference spectrum, a target spectrum can be used in the method **800**. The difference calculation would be between a current spectrum and the target spectrum, and endpoint would be determined when the difference trace reaches a minimum.

[0091] FIG. **9A** shows an alternative method **900** for using a spectrum-based endpoint determination logic to determine an endpoint of a polishing step. A set-up substrate is polished and a target spectrum and reference spectrum are obtained (step **902**). These spectra can be obtained as described above in reference to FIGS. **7A** and **7B**.

[0092] A target difference is calculated (step **904**). The target difference is the difference between the reference spectrum and the target spectrum and can be calculated using the above-described difference equation.

[0093] Polishing of another substrate of the batch of substrates is started (step **906**). The following steps are performed for each platen revolution during polishing. One or more spectra of white light reflecting off a substrate surface being polished are measured to obtain one or more current spectra for a current platen revolution (step **908**). A difference between the current one or more spectra and the reference spectrum is calculated (step **910**). The calculated difference or differences (if there are more than one current spectrum) are appended to a difference trace (step **912**). Whether the difference trace is within a threshold range of the target difference is determined (step **914**). If the difference trace is NOT determined to have reached a threshold range of the target difference, polishing is allowed to continue and steps **908**, **910**, **912**, and **914** are repeated as appropriate. Otherwise, an endpoint is called and polishing is stopped (step **916**).

[0094] FIG. **9B** illustrates the above described method for determining endpoint. Trace **901** is the raw difference trace. Trace **903** is the smoothed difference trace. Endpoint is called when the smooth difference trace **903** is within a threshold range **905** of a target difference **907**.

[0095] FIG. **10A** shows another method **1000** for determining an endpoint of a polishing step. A reference spectrum is obtained (step **1002**). The reference spectrum is obtained as described above in reference to FIG. **7B**.

[0096] The spectra collected from the process of obtaining the reference spectrum are stored in a library (step **1004**). Alternatively, the library can include spectra that are not collected but theoretically generated. The spectra, including the reference spectrum, are indexed so that each spectrum has a unique index value. The library can be implemented in memory of the computing device of the polishing apparatus.

[0097] A substrate from the batch of substrates is polished, and the following steps are performed for each platen revolution. One or more spectra are measured to obtain a current spectra for a current platen revolution (step **1006**). The spec-

tra are obtained as described above. The spectra stored in the library which best fits the current spectra is determined (step **1008**). The index of the library spectrum determined to best fits the current spectra is appended to an endpoint index trace (step **1010**). Endpoint is called when the endpoint trace reaches the index of the reference spectrum (step **1012**).

[0098] FIG. **10B** illustrates the above described method for determining endpoint. Trace **1014** is the raw index trace. Trace **1016** is the smoothed difference trace. Line **1018** represents the index value of the reference spectrum. Multiple current spectra can be obtained in each sweep of the optical head beneath the substrate, e.g., a spectra for each radial zone on the substrate being tracked, and an index trace can be generated for each radial zone.

[0099] FIG. **11** shows an implementation for determining an endpoint during a polishing step. For each platen revolution, the following steps are performed. Multiple raw spectra of white light reflecting off a substrate surface being polished are measured (step **1102**).

[0100] Each measured raw spectra is normalized to remove light reflections contributed by mediums other than the film or films of interest (step **1104**). Normalization of spectra facilitates their comparison to each other. Light reflections contributed by media other than the film or films of interest include light reflections from the polishing pad window and from the base silicon layer of the substrate. Contributions from the window can be estimated by measuring the spectrum of light received by the in-situ monitoring system under a dark condition (i.e., when no substrates are placed over the in-situ monitoring system). Contributions from the silicon layer can be estimated by measuring the spectrum of light reflecting off a bare silicon substrate. The contributions are usually obtained prior to commencement of the polishing step.

[0101] A measured raw spectrum is normalized as follows:

$$\text{normalized spectrum} = (A - \text{Dark}) / (Si - \text{Dark})$$

where A is the raw spectrum, Dark is the spectrum obtained under the dark condition, and Si is the spectrum obtained from the bare silicon substrate.

[0102] Optionally, the collected spectra can be sorted based on the region of the pattern that has generated the spectrum, and spectra from some regions can be excluded from the endpoint calculation. In particular, spectra that are from light reflecting off scribe lines can be removed from consideration (step **1106**). Different regions of a pattern substrate usually yield different spectra (even when the spectra were obtained at a same point of time during polishing). For example, a spectrum of the light reflecting off a scribe line in a substrate is different from the spectrum of the light reflecting off an array of the substrate. Because of their different shapes, use of spectra from both regions of the pattern usually introduces error into the endpoint determination. However, the spectra can be sorted based on their shapes into a group for scribe lines and a group for arrays. Because there is often greater variation in the spectra for scribe lines, usually these spectra can be excluded from consideration to enhance precision.

[0103] A subset of the spectra processed thus far is selected and averaged (step **1108**). The subset consists of the spectra obtained from light reflecting off the substrate at points of a region on the substrate. The region can be, for example, region **512** or region **413** (FIG. **5**).

[0104] Optionally, a high-pass filter is applied to the measured raw spectra (step **1110**). Application of the high pass filter typically removes low frequency distortion of the aver-

age of the subset of spectra. The high-pass filter can be applied to the raw spectra, their average, or to both the raw spectra and their average.

[0105] The average is normalized so that its amplitude is the same or similar to the amplitude of the reference spectrum (step 1112). The amplitude of a spectrum is the peak-to-trough value of the spectrum. Alternatively, the average is normalized so that its reference spectrum is the same or similar to a reference amplitude to which the reference spectrum has also been normalized.

[0106] A difference between the normalized average and a reference spectrum is calculated (step 1114). The reference spectrum is obtained as described in reference to FIG. 7B. The difference is calculated using the above-described equation for calculating differences between spectra.

[0107] A difference trace is updated with the current difference (step 1116). The difference trace exhibits calculated differences between normalized averages and the reference spectrum as a function of time (or platen revolution).

[0108] A median and low-pass filter is applied to the updated difference trace (step 1118). Application of these filters typically smoothes the trace (by reducing or eliminating spikes in the trace).

[0109] Endpoint determination is performed based on the updated and filtered difference trace (step 1120). The determination is made based on when the difference trace reaches a minimum. The above described window logic is used to make the determination.

[0110] More generally, the signal processing steps of steps 1104-1112 can be used to improve endpoint determination procedures. For example, instead of generation of a difference trace, the normalized average spectra could be used to select a spectra from a library to generate an index trace, as described above in reference to FIG. 10A.

[0111] FIG. 12 illustrates the normalization of step 1112. As can be seen, only a portion of a spectrum (or an average of spectra) is considered for normalization. The portion considered is referred to in the instant specification as a normalization range and, furthermore, can be user selectable. Normalization is effected so that the highest point and the lowest point in the normalization range are normalized to 1 and 0, respectively. The normalization is calculated as follows:

$$g = (1 - 0) / (r_{max} - r_{min})$$

$$h = 1 - r_{max} * g$$

$$N = R + g + h$$

[0112] where, g is a gain, h is an offset, r_{max} is the highest value in the normalization range, r_{min} is the lowest value in the normalization range, N is the normalized spectrum, and R is the pre normalized spectrum.

[0113] Embodiments of the invention and all of the functional operations described in this specification can be implemented in digital electronic circuitry, or in computer software, firmware, or hardware, including the structural means disclosed in this specification and structural equivalents thereof, or in combinations of them. Embodiments of the invention can be implemented as one or more computer program products, i.e., one or more computer programs tangibly embodied in an information carrier, e.g., in a machine-readable storage device or in a propagated signal, for execution by, or to control the operation of, data processing apparatus, e.g., a programmable processor, a computer, or multiple processors or computers. A computer program (also known as a

program, software, software application, or code) can be written in any form of programming language, including compiled or interpreted languages, and it can be deployed in any form, including as a stand-alone program or as a module, component, subroutine, or other unit suitable for use in a computing environment. A computer program does not necessarily correspond to a file. A program can be stored in a portion of a file that holds other programs or data, in a single file dedicated to the program in question, or in multiple coordinated files (e.g., files that store one or more modules, subprograms, or portions of code). A computer program can be deployed to be executed on one computer or on multiple computers at one site or distributed across multiple sites and interconnected by a communication network.

[0114] The processes and logic flows described in this specification can be performed by one or more programmable processors executing one or more computer programs to perform functions by operating on input data and generating output. The processes and logic flows can also be performed by, and apparatus can also be implemented as, special purpose logic circuitry, e.g., an FPGA (field programmable gate array) or an ASIC (application-specific integrated circuit).

[0115] The above described polishing apparatus and methods can be applied in a variety of polishing systems. Either the polishing pad, or the carrier head, or both can move to provide relative motion between the polishing surface and the substrate. For example, the platen may orbit rather than rotate. The polishing pad can be a circular (or some other shape) pad secured to the platen. Some aspects of the endpoint detection system may be applicable to linear polishing systems, e.g., where the polishing pad is a continuous or a reel-to-reel belt that moves linearly. The polishing layer can be a standard (for example, polyurethane with or without fillers) polishing material, a soft material, or a fixed-abrasive material. Terms of relative positioning are used; it should be understood that the polishing surface and substrate can be held in a vertical orientation or some other orientation.

[0116] Particular embodiments of the invention have been described. Other embodiments are within the scope of the following claims. For example, the actions recited in the claims can be performed in a different order and still achieve desirable results.

What is claimed is:

1. A method of making a polishing pad, the method comprising:

placing a body of crystalline or glass like material in a mold of a polishing pad window;
dispensing a liquid precursor of a soft plastic material into the mold;
curing the liquid precursor to form a transparent window that includes a soft plastic first portion and a crystalline or glass second portion;
placing the window in a mold of a polishing pad;
dispensing a liquid precursor of a polishing pad material into the mold of the polishing pad; and
curing the liquid precursor of the polishing pad material to produce the polishing pad, wherein the window is situated in the mold of the polishing pad so that, when the polishing pad is produced, the window is situated in the polishing pad so the first portion has a surface that is coplanar with a polishing surface of the polishing pad and the first portion acts a slurry-tight barrier.

2. The method of claim 1, wherein the body of crystalline or glass like material is quartz.

3. The method of claim 1, wherein the liquid precursor comprises a urethane.

4. The method of claim 1, wherein dispensing the liquid precursor of the soft plastic material comprises covering a non-planar surface on the body.

5. The method of claim 4, wherein dispensing the liquid precursor of the soft plastic material comprises filling a recess in the body.

6. The method of claim 4, wherein curing the liquid precursor forms the transparent window with the first portion having a greater thickness at edges of the window.

7. The method of claim 1, wherein dispensing the liquid precursor of the soft plastic material comprises covering sides of the body.

8. A method of making a polishing pad, the method comprising:

placing a body of crystalline or glass materials in a mold of a polishing pad window;

dispensing a liquid precursor of a soft plastic material into the mold;

curing the liquid precursor to form a transparent window that includes a soft plastic first portion and a crystalline or glass second portion;

forming a polishing layer that includes an aperture, the polishing layer having a top surface and a bottom surface, the aperture having a first opening in the top surface and a second opening in the bottom surface, the top surface being a polishing surface; and

inserting the window in the aperture, the window being situated in the aperture so that the first portion has a surface that is coplanar with the polishing surface and the first portion plugs the aperture and acts a slurry-tight barrier and the second portion is on a bottom side of the first portion.

9. The method of claim 8, wherein the body of crystalline or glass like material is quartz.

10. The method of claim 8, wherein the liquid precursor comprises a urethane.

11. The method of claim 8, wherein dispensing the liquid precursor of the soft plastic material comprises covering a non-planar surface on the body.

12. The method of claim 11, wherein dispensing the liquid precursor of the soft plastic material comprises filling a recess in the body.

13. The method of claim 11, wherein curing the liquid precursor forms the transparent window with the first portion having a greater thickness at edges of the window.

14. The method of claim 8, wherein dispensing the liquid precursor of the soft plastic material comprises covering sides of the body.

15. The method of claim 8, comprising attaching a side surface of each of the first portion and the second portion to the polishing pad with an adhesive.

16. The method of claim 15, comprising applying an adhesive to one of the first portion or the second portion prior to inserting the window into the aperture.

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