

# ELECTRICALLY CONDUCTIVE ADHESIVE FILM AND DICING-DIE BONDING FILM USING THE SAME

## Technical Field

[0001] The present invention relates to an electrically conductive adhesive film and a dicing-die bonding film using the same.

## Background Art

[0002] In general, a semiconductor device is produced by a step of forming a die mounting material for bonding a semiconductor element (chip) onto an element-supporting part of a lead frame or onto a circuit electrode part of an insulating substrate, a step of mounting the semiconductor element onto the surface of the die mounting material on the lead frame or the circuit electrode to bond the semiconductor element to the element-supporting part of the lead frame or to the circuit electrode part of the insulating substrate, a wire-bonding step in which an electrode part of the semiconductor element is electrically bonded with a terminal part of the lead frame or with a terminal part of the insulating substrate, and a molding step in which the thus assembled semiconductor device is coated with a resin.

[0003] A bonding material is used for bonding a semiconductor element to an element-supporting part of a lead frame or to a circuit electrode part of an insulating substrate. For example, a lead solder comprising 85 % by mass or more of lead having a high melting point and heat resistance has been widely used as a bonding material for power semiconductors such as IGBT and MOS-FET. However, hazardousness of lead has become a problem in recent years, and there is an increasing demand for lead-free bonding materials.

[0004] Also, SiC power semiconductors have features such that lower loss and operation at higher speed and higher temperatures compared with Si power semiconductors can be realized, and SiC power semiconductors are therefore considered to be a next-generation power semiconductor. Such SiC power semiconductors are theoretically capable of operations at 200 °C or higher, but improvement of the heat resistance of the surrounding materials including bonding materials is desired so as to actually realize high output and high density of systems such as inverters.

[0005] Under these circumstances, various lead-free, high-melting-point bonding materials have been valued in recent years. Au-based alloys such as Au-Sn-based alloys and Au-Ge-based alloys disclosed in Patent Document 1, for example, can be mentioned as such high-melting-point lead-free bonding materials, and these alloy materials are noticed as having good electrical conductivity and thermal conductivity and being chemically stable. However, since such Au-based alloy materials which contain a noble metal are expensive, and since expensive high-temperature vacuum reflow machines are necessary for attaining higher mounting reliability, Au-based alloy materials are not yet in practical use.

[0006] Also, there is a problem such that many lead-free solders have poor wettability compared with lead solders. Due to this poor wettability, there is a higher risk that the solder will not wet over the die pad part and that bonding defects such as insufficient soldering will occur when using a lead-free solder as a bonding material. Since the problem of wettability particularly tends to become worse as the melting point of a lead-free solder increases, it was difficult to attain both heat resistance and mounting reliability at the same time.

[0007] In order to solve these problems, studies on diffusion sintering-type solders such as Cu-based and Sn-based solders have been pursued as described

in Patent Documents 2 and 3. Since these diffusion sintering-type solders have a low melting point in a state before sintering and the mounting temperature can therefore be reduced, and since diffusion sintering-type solders will irreversibly have a high melting point in a state after the diffusion sintering reaction, diffusion sintering-type solders are expected to attain both heat resistance and mounting reliability at the same time, which was difficult with conventional lead-free solders. However, since diffusion sintering-type solders also have the problems of wettability as with conventional lead-free solders, the risk of insufficient soldering cannot be avoided when bonding a large surface area. Also, since diffusion sintering-type solders in a state of a sintered body are hard and brittle, there are problems of poor stress relaxation properties and low thermal fatigue resistance. Sufficient bonding reliability therefore has not yet been attained.

[0008] A flux such as a carboxylic acid or an alcohol is generally added to many lead solders and lead-free solders so as to remove the oxide film formed on a metal. However, these flux components easily absorb moisture and easily bleed out, and the absorbed moisture and the bleed-out are known to adversely affect the reflow resistance reliability (MSL) after moisture absorption in a sealed semiconductor element package. Flux is therefore generally washed off after the solder reflow mounting, but said treatment has problems of consuming time and the treatment of the washing wastewater. On the other hand, reduction of the added amount of the flux component, such as a carboxylic acid or an alcohol, that causes moisture absorption and bleed-out so as to avoid the aforementioned problems will cause another problem such that removing capability of the oxide film becomes poor and that sufficient electrical conductivity and other properties cannot be exerted. The problems therefore have not yet been fully solved.

## Document List

### Patent Documents

[0009]

Patent Document 1: Japanese Laid-Open Patent Publication No. 2006-032888

Patent Document 2: Japanese Laid-Open Patent Publication No. 2007-152385

Patent Document 3: Japanese Laid-Open Patent Publication No. 2002-263880

## Summary of Invention

### Technical Problem

[0010] It is therefore an object of the present invention to provide an electrically conductive adhesive film which is suitable for use as an electrically conductive bonding material for bonding a semiconductor chip (particularly a power device) onto an element-supporting part of a lead frame or onto a circuit electrode part of an insulating substrate, for example, and which is capable of forming, between a semiconductor chip and an element-supporting part of a lead frame or a circuit electrode part of an insulating substrate, a bonding layer that excels both in heat resistance after bonding and sintering and in mounting reliability while being lead-free. It is also an object of the present invention to provide a dicing-die bonding film using said electrically conductive adhesive film.

### Solution to Problem

[0011] As a result of intensive study, the inventors of the present invention found that an electrically conductive adhesive film suitable for use as an electrically conductive bonding material capable of forming, between a semiconductor chip (particularly a power device) and an element-supporting part of a lead frame or a circuit electrode part of an insulating substrate, for

example, a bonding layer that is lead-free and excels both in heat resistance after bonding and sintering and in mounting reliability can be obtained particularly by combining a metal particle (Q) with a resin (M) and at least one of a prescribed organic phosphine (A) and a prescribed sulfide-based compound (B) and by limiting the storage elastic modulus and the thermal weight loss ratio within prescribed ranges, respectively. The present invention was completed based on said finding.

[0012] The embodiments of the present invention are as follows.

[1] An electrically conductive adhesive film comprising:

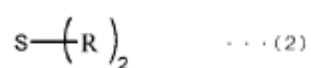
a metal particle (Q);

a resin (M); and

at least one of an organic phosphine (A) represented by the general formula (1) below and a sulfide-based compound (B) represented by the general formula (2) below,

wherein the electrically conductive adhesive film has a storage elastic modulus at 1 Hz measured in a state after sintering of 20 GPa or less and a thermal weight loss ratio when heated for 2 hours at 250 °C under a nitrogen atmosphere of less than 1 %

[Chemical formula 1]



in the general formulas (1) and (2), each R independently represents an organic group, and R may be the same or different with each other.

[2] The electrically conductive adhesive film as described in [1], wherein at least one R in each of the general formulas (1) and (2) is an aryl group.

[3] The electrically conductive adhesive film as described in [1] or [2], wherein, in the general formulas (1) and (2), each R independently comprises, in its

moiety, one or more group selected from a vinyl group, an acrylic group, a methacrylic group, a maleic acid ester group, a maleic acid amide group, a maleic acid imide group, a primary amino group, a secondary amino group, a thiol group, a hydrosilyl group, a hydroboron group, a phenolic hydroxyl group and an epoxy group.

[4] The electrically conductive adhesive film as described in any one of [1] to [3], wherein the organic phosphine (A) comprises p-styryl diphenyl phosphine.

[5] The electrically conductive adhesive film as described in any one of [1] to [4], wherein the sulfide-based compound (B) comprises at least one of bis(acryloylthiophenyl)sulfide and bis(methacryloylthiophenyl)sulfide.

[6] The electrically conductive adhesive film as described in any one of [1] to [5], wherein a loss tangent ( $\tan \delta$ ) defined by a ratio ( $G'' / G'$ ) of a loss elastic modulus ( $G''$ ) to a storage elastic modulus ( $G'$ ) at 60 °C and 1 Hz in a B-stage state is 1.4 or higher.

[7] The electrically conductive adhesive film as described in any one of [1] to [6], wherein the resin (M) comprises a thermosetting resin (M1), and the metal particle (Q) comprise a first metal particle (Q1) made of a single metal selected from the group of copper, nickel, aluminum and tin or an alloy comprising two or more metals selected from said group.

[8] The electrically conductive adhesive film as described in [7], wherein the thermosetting resin (M1) comprises a maleic acid imide compound including two or more units of an imide group in a single molecule.

[9] The electrically conductive adhesive film as described in [7], wherein the thermosetting resin (M1) comprises an epoxy resin including a molecular backbone derived from a glycidyl ether of an aliphatic diol.

[10] The electrically conductive adhesive film as described in [8] or [9], wherein the thermosetting resin (M1) further comprises a phenol novolac resin.

[11] The electrically conductive adhesive film as described in any one of [7] to [10], wherein the metal particle (Q) is a mixture comprising the first metal particle (Q1) and a second metal particle (Q2) based on a metal component different from the first metal particle (Q1), and

the first metal particle (Q1) and the second metal particle (Q2) comprise a metal component capable of mutually forming an intermetallic compound.

[12] The electrically conductive adhesive film as described in [11], wherein the second metal particle (Q2) is made of a single metal selected from the group of copper, nickel, aluminum, tin, zinc, titanium, silver, gold, indium, bismuth, gallium and palladium or an alloy comprising two or more metals selected from said group.

[13] A dicing-die bonding film, comprising the electrically conductive adhesive film as described in any one of [1] to [12] adhered to a dicing tape.

#### Effects of Invention

[0013] According to the present invention, the electrically conductive adhesive film comprises a metal particle (Q), a resin (M), and at least one of a prescribed organic phosphine (A) and a prescribed sulfide-based compound (B), and the electrically conductive adhesive film has a storage elastic modulus at 1 Hz measured in a state after sintering of 20 GPa or less and a thermal weight loss ratio when heated for 2 hours at 250 °C under a nitrogen atmosphere of less than 1 %. Thus, an electrically conductive adhesive film suitable for use as an electrically conductive bonding material capable of forming, between a semiconductor chip (particularly a power device) and an element-supporting part of a lead frame or a circuit electrode part of an insulating substrate, for

example, a bonding layer that is lead-free and excels both in heat resistance after bonding and sintering and in mounting reliability, and a dicing-die bonding film using the electrically conductive adhesive film can be provided thereby.

#### Brief Description of Drawings

[0014]

[Fig. 1] Fig. 1 is a cross-sectional diagram showing the layer structure of a dicing-die bonding film of an embodiment of the present invention.

[Fig. 2] Fig. 2 is a diagram showing a state in which a dicing-die bonding film of the present invention is adhered to a semiconductor.

[Fig. 3] Fig. 3 is a diagram for explaining the dicing step.

[Fig. 4] Fig. 4 is a diagram for explaining the pick-up step.

[Fig. 5] Fig. 5 is a diagram for explaining the die-bonding step.

[Fig. 6] Fig. 6 is a diagram showing a cross-section of a resin-molded semiconductor element (device).

#### Description of the Embodiments

[0015] Hereinafter, embodiments of the electrically conductive adhesive film and the dicing-die bonding film using the same according to the present invention will be described in detail.

[0016] <Electrically conductive adhesive film>

The electrically conductive adhesive film of the present embodiments comprises a metal particle (Q), a resin (M) and at least one of a prescribed organic phosphine (A) and a prescribed sulfide-based compound (B). Also, the electrically conductive adhesive film may further comprise various additives as necessary.

Unless otherwise mentioned, "metal particle" here mean not only a metal particle made of a single metal component, but also alloy particle made of two or more metal components.

[0017] [1] Metal particle (Q)

In the electrically conductive adhesive film of the present embodiments, the metal particle (Q) preferably comprises a first metal particle (Q1) made of a single metal selected from the group of copper (Cu), nickel (Ni), aluminum (Al) and tin (Sn) or an alloy comprising two or more metals selected from said group. Such a first metal particle (Q1) is favorable as the metal particle (Q) of the electrically conductive adhesive film since this excels in electrical conductivity and thermal conductivity, is relatively inexpensive, and is unlikely to cause ion migration. The metal particle (Q) may be made solely of the first metal particle (Q1) or may be a mixture comprising one or more further metal particle in addition to the first metal particle (Q1).

[0018] Preferably, the metal particle (Q) is a mixture comprising the first metal particle (Q1) and second metal particle (Q2) based on a metal component different from the first metal particle (Q1), and the first metal particle (Q1) and the second metal particle (Q2) contain a metal component capable of mutually forming an intermetallic compound. By having the first metal particle (Q1) and the second metal particle (Q2) contain a metal capable of mutually forming an intermetallic compound, a high-melting intermetallic compound can be formed in a state after sintering even though the overall metal particle (Q) is a metal or an alloy with a low melting point in a state before sintering. As a result, by using such the metal particle, low mounting temperature can be realized while exerting excellent heat resistance after sintering whereby the properties do not deteriorate even at the mounting temperature or higher temperatures.

[0019] The combinations of metal component capable of forming such the intermetallic compound can be freely selected as necessary, and examples include combinations based on Cu-Sn, Ni-Sn, Ag-Sn, Cu-Zn, Ni-Zn, Ni-Ti, Sn-Ti, and Al-Ti. It is preferable that one metal component corresponding to these combinations capable of forming an intermetallic compound is contained in each of the first metal particle (Q1) and the second metal particle (Q2) by one metal component per one combination. A combination comprising Sn having a low melting point is preferable when the mounting temperature needs to be reduced as much as possible. A combination based on Cu-Sn or Ni-Sn, in particular, is more preferable.

[0020] The second metal particle (Q2) is merely required to comprise a metal component that is based on a metal component different from the first metal particle (Q1) and that is capable of forming an intermetallic compound with the first metal particle (Q1), and there is no particular limitation. But the second metal particle (Q2) is preferably made of a single metal selected from the group of copper (Cu), nickel (Ni), aluminum (Al), tin (Sn), zinc (Zn), titanium (Ti), silver (Ag), gold (Au), indium (In), bismuth (Bi), gallium (Ga) and palladium (Pd) or an alloy comprising two or more metals selected from said group. Specifically, when the first metal particle (Q1) is Cu particle, for example, the second metal particle (Q2) is a metal particle capable of forming an intermetallic compound with Cu, preferably Sn particles or Sn-containing alloy particle, for example.

[0021] In addition, preferably, at least one of the first metal particle (Q1) and the second metal particle (Q2) is an alloy particle comprising two or more metal components. The melting point of the overall metal particle (Q) can be further reduced if at least one of the first metal particle (Q1) and the second metal particle (Q2) is an alloy particle. Examples of such an alloy particle preferably

include an alloy comprising at least two metals selected from copper (Cu), nickel (Ni), aluminum (Al), tin (Sn), zinc (Zn), titanium (Ti), silver (Ag), gold (Au), indium (In), bismuth (Bi), gallium (Ga) and palladium (Pd). Specifically, those obtained by adding Zn, Bi, Ag, In, Ga, Pd, or the like to Sn or the like to obtain an alloy and then producing a particle thereof in advance can be mentioned as such an alloy particle.

[0022] The content of the first metal particle (Q1) relative to 100 % by mass of the metal particle (Q) is preferably from 10 to 100 % by mass, more preferably from 30 to 80 % by mass. In addition, the content of the second metal particle (Q2) relative to 100 % by mass of the metal particle (Q) is preferably from 0 to 90 % by mass, more preferably from 20 to 70 % by mass. Also, the metal particle (Q) may further comprise one or more of the other metal particle (Qn) made of a single metal or alloy as necessary in addition to the first metal particle (Q1) and the second metal particle (Q2). The content of the further metal particle is preferably 50 % by mass or less relative to 100 % by mass of the metal particle (Q).

[0023] In terms of reducing environmental load, the metal particle (Q) is preferably substantially free of Pb (lead), Hg (mercury), Sb (antimony) and As (arsenic). The total content of these components is preferably less than 0.1 % by mass relative to 100 % by mass of the metal particle (Q).

[0024] Also, the shape of the metal particle (Q) is not particularly limited, and a spherical particle, a dendritic particle, a scale-like particle, a spike-like particle, and the like can be used as necessary. Also, although the particle size of the metal particle (Q) is not particularly limited, the metal particle (Q) preferably has an average particle size (D50) of 20  $\mu\text{m}$  or less. A relatively thin (e.g. 40  $\mu\text{m}$  or less) electrically conductive adhesive film can be formed by limiting the particle size of the metal particle (Q) to said range. Also, when

using the first metal particle (Q1) and the second metal particle (Q2), the average particle size (D50) of the first metal particle (Q1) is more preferably 20  $\mu\text{m}$  or less and the average particle size (D50) of the second metal particle (Q2) is more preferably less than 7  $\mu\text{m}$ , for example. An average particle size (D50) in the present invention is a value calculated based on a measurement by the laser diffraction scattering particle size distribution measurement method. Conditions for measuring the average particle size (d50) will be explained later in the section concerning the examples.

[0025] The content of the metal particle (Q) in the electrically conductive adhesive film of the present embodiments is preferably from 70 to 96 % by mass, more preferably from 80 to 94 % by mass. By limiting the content of the metal particle (Q) within this range, formability when forming the electrically conductive adhesive film can be enhanced, handleability as a film can also be improved, and excellent electrical conductivity can further be exerted after adhesion and sintering.

[0026] [2] Resin (M)

The resin (M) used in the electrically conductive adhesive film of the present embodiments preferably comprises a thermosetting resin (M1). The thermosetting resin (M1) contained in the electrically conductive adhesive film has functions of contributing to the film properties (formability, handleability, etc.) in a state before sintering, and relaxing the stress and the like between the semiconductor element and the substrate (lead frame, etc.) caused by thermal cycle in a state after sintering.

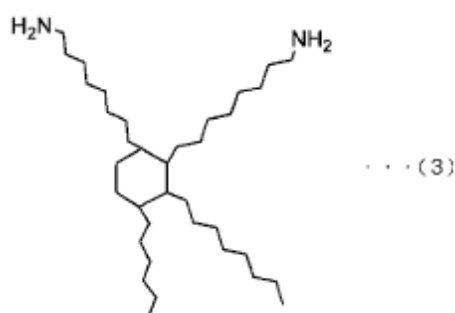
[0027] The thermosetting resin (M1) preferably comprises a maleic acid imide resin comprising a maleic acid imide compound containing two or more units of an imide group in a single molecule (this resin may hereinafter be called a "maleimide resin") or an epoxy resin including a molecular backbone

derived from a glycidyl ether of an aliphatic diol, more preferably a maleic acid imide resin, more preferably a maleic acid imide resin, particularly from the viewpoint of heat resistance, and the film properties when being mixed with the metal particle (Q). In particular, since a thermosetting resin (M1) comprising one of the aforementioned resins excels in stress relaxation properties, thermal fatigue resistance of the electrically conductive adhesive film after sintering can be improved. As a result, an electrically conductive adhesive film comprising such a thermosetting resin (M1) is capable of overcoming the drawbacks in terms of thermal fatigue resistance, i.e., being hard and brittle, which were the problems of conventional all-metal lead-free solders.

[0028] A maleic acid imide resin can be obtained by condensing maleic acid or its anhydride with a diamine or a polyamine, for example. A maleic acid imide resin comprising a backbone derived from an aliphatic amine having a carbon atom number of 10 or more is preferable from the viewpoint of stress relaxation properties, and a maleic acid imide resin having a carbon atom number of 30 or more and a backbone represented by the structural formula (3) below, in particular, is more preferable. Also, a maleic acid imide compound preferably has a number average molecular weight of 3000 or more.

[0029]

[Chemical formula 2]



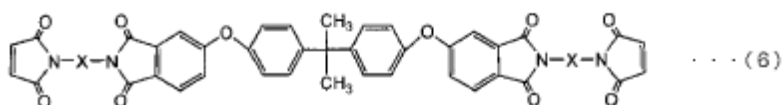
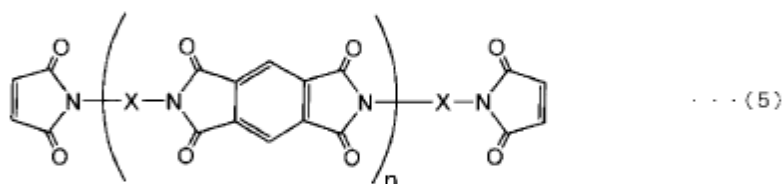
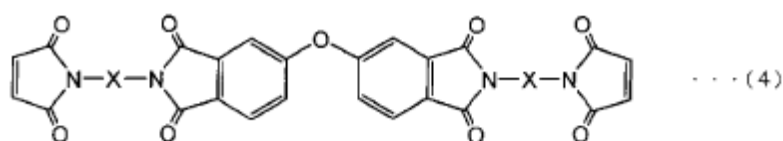
[0030] Molecular weight, glass transition temperature  $T_g$ , and the like of a maleic acid imide resin may be adjusted by comprising an acid component

other than maleic acid such as a backbone derived from benzenetetracarboxylic acid or its anhydride, hydroxyphthalic acid bis(ether) or its anhydride, or the like. A phenol novolac resin, a radical generator, or the like is preferably used as a curing agent for the maleic acid imide resin.

[0031] Also, bismaleimide resins represented by the following structural formulas (4) to (6), for example, can be suitably used as such a maleic acid imide resin.

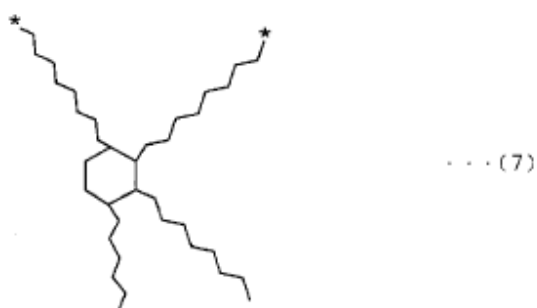
[0032]

[Chemical formula 3]



[0033] In the formula (5),  $n$  is an integer from 1 to 10. Also, in the formulas (4) to (6), the moiety represented by "X" is a backbone " $C_{36}H_{72}$ " represented by the following structural formula (7). In the formula (7), "\*" means the bonding position with N.

[Chemical formula 4]



[0034] Ethylene glycol-modified epoxy resin, propylene glycol-modified epoxy resin, butanediol-modified epoxy resin, and the like, for example, can be mentioned as the epoxy resins including a molecular backbone derived from a glycidyl ether of an aliphatic diol. These epoxy resins are preferable from the viewpoint of flexibility. Also, such epoxy resins are preferably used as a mixture with a bisphenol A-type epoxy resin, a bisphenol F-type epoxy resin, a phenoxy resin which is an epoxy resin having a large molecular weight, or the like from the viewpoint of balancing adhesive strength and flexibility.

[0035] Acid anhydrides, phenol novolac resins, amines, imidazole-based compounds, dicyandiamides, and the like can be selected as the curing agent for the aforementioned epoxy resin. Among these examples, phenol novolac resins and imidazole-based compounds are preferable.

[0036] The thermosetting resin (M1) preferably further comprises a phenol novolac resin. By using the aforementioned maleic acid imide resin or epoxy resin in combination with a phenol novolac resin, for example, the phenol novolac resin functions as a curing agent, and adhesion of the electrically conductive adhesive film is furthermore improved.

[0037] The content of the resin (M) in the electrically conductive adhesive film of the present embodiments is preferably from 4 to 30 % by mass, more preferably from 6 to 20 % by mass. By limiting the content of the resin (M) within the aforementioned range, the electrically conductive adhesive film excels in film properties (formability, handleability, etc.) in a state before sintering, and excels in relaxing the stress and the like between the semiconductor element and the substrate (lead frame, etc.) caused by thermal cycle in a state after sintering. The resin (M) may consist of a single type of resin or two or more resins may be mixed. Also, resins other than the aforementioned resins may be further contained as necessary.

[0038] [3] Organic phosphine (A) and sulfide-based compound (B)

The electrically conductive adhesive film of the present embodiments comprises at least one of an organic phosphine (A) represented by the general formula (1) below and a sulfide-based compound (B) represented by the general formula (2) below.

[Chemical formula 5]



In the general formulas (1) and (2), each R independently represents an organic group, and R may mutually be the same or different.

[0039] In the electrically conductive adhesive film of the present embodiments, these compounds have a function as a flux which helps remove the oxide film on the surface of the metal particle (Q), and particularly effectively acts on metals that are easily oxidized, such as Cu, Sn, Ni and Al. Also, compared with fluxes such as carboxylic acids and alcohols that have conventionally been used in general, these compounds are very less likely to absorb moisture and excel in moisture absorption resistance.

[0040] In the general formulas (1) and (2), each R is preferably independently selected from an alkyl group, an aryl group, an organic group including a functional group, an organic group including a heteroatom, and an organic group including an unsaturated bond, and at least one of R is preferably an aryl group.

[0041] The alkyl group may be linear, branched or cyclic, and may comprise a substituent. The alkyl group is preferably linear or branched. Also, the alkyl group preferably has a carbon atom number of 3 or more, more preferably 4 to 18, even more preferably 6 to 15. Specifically, propyl, butyl, pentyl, hexyl,

heptyl, octyl, nonyl, decyl, stearyl and isostearyl groups, and the like can be mentioned as such an alkyl group.

[0042] The aryl group may comprise a substituent and preferably has a carbon atom number of 6 to 10. Phenyl, tolyl, xylyl, cumenyl, 1-naphthyl groups and the like, for example, can be mentioned as such an aryl group.

[0043] The organic group including a functional group preferably has a carbon atom number of 1 to 10, more preferably 1 to 6, even more preferably 1 to 3. Also, chloro, bromo and fluoro groups, and the like can be mentioned as the functional group contained in the organic group. Also, specifically, chloroethyl, fluoroethyl, chloropropyl, dichloropropyl, fluoropropyl, difluoropropyl, chlorophenyl and fluorophenyl groups, and the like can be mentioned as such an organic group including a functional group.

[0044] The organic group including a heteroatom preferably has a carbon atom number of 3 or more, more preferably 4 to 18, even more preferably 6 to 15. Also, nitrogen, oxygen and sulfur atoms, and the like can be mentioned as the heteroatom contained in the organic group. Also, specifically, dimethylamino, diethylamino, diphenylamino, methylsulfoxide, ethylsulfoxide and phenylsulfoxide groups, and the like can be mentioned as such an organic group including a heteroatom.

[0045] The organic group including an unsaturated bond preferably has a carbon atom number of 3 or more, more preferably 4 to 18, even more preferably 6 to 15. Specifically, propenyl, propynyl, butenyl, butynyl, oleyl, phenyl, vinylphenyl and alkylphenyl groups, and the like can be mentioned as such an organic group including an unsaturated bond. It is more preferable that a vinylphenyl group, among said groups, is contained.

[0046] Additionally, in the general formulas (1) and (2), it is preferable that each R independently comprises, in its moiety, one or more group selected from

vinyl, acrylic, methacrylic, maleic acid ester, maleic acid amide, maleic acid imide, primary amino, secondary amino, thiol, hydrosilyl, hydroboron, phenolic hydroxyl and epoxy groups. It is more preferable that a vinyl, acrylic, methacrylic or secondary amino group, among said groups, is contained.

[0047] Specifically, the organic phosphine (A) preferably comprises p-styryl diphenyl phosphine. This type of compound is favorable in terms of the low bleed-out property obtained by containing a highly reactive vinyl group.

[0048] Also, the sulfide-based compound (B) preferably comprises at least one of bis(hydroxyphenyl)sulfide, bis(acryloylthiophenyl)sulfide, 2-methylthiophenothiazine, bis(2-methacryloylthioethyl)sulfide and bis(methacryloylthiophenyl)sulfide. More preferably, at least one of bis(acryloylthiophenyl)sulfide and bis(methacryloylthiophenyl)sulfide is contained. These compounds are favorable in terms of the low bleed-out property obtained by containing a highly reactive phenolic hydroxyl group, acrylic group or methacrylic group. Among such compounds, those containing an acrylic group or a methacrylic group is the most favorable.

[0049] In addition, each of the organic phosphine (A) and the sulfide-based compound (B) can be used alone or be used in combination. The adhesive power of the electrically conductive adhesive film of the present embodiments can be enhanced by having the electrically conductive adhesive film of the present embodiments comprise both of the organic phosphine (A) and the sulfide-based compound (B).

[0050] Also, when the thermosetting resin (M1) contains a maleimide resin, such an organic phosphine (A) and a sulfide-based compound (B) also function as a thermosetting resin component since they are capable of forming a copolymer with a maleimide resin. In addition, since the organic phosphine (A) and the sulfide-based compound (B) are less likely to absorb moisture, have

sufficiently high molecular weight, and are polymerizable, bleed-out can be effectively prevented when they are used as a flux component. Therefore, by using such an organic phosphine (A) or a sulfide-based compound (B) in place of an alcohol or a carboxylic acid, which easily absorbs moisture, the risk of bleed-out can be reduced and sufficient reliability, particularly reflow resistance after moisture absorption, can be secured even without washing the flux off.

[0051] Also, the organic phosphine (A) and the sulfide-based compound (B) preferably have a number average molecular weight of 260 or more from the viewpoint of inhibiting the bleed-out at the time of sintering or the like. Bleed-out can be furthermore reduced by reacting the organic phosphine (A) and the sulfide-based compound (B) with the maleimide resin to cause curing, as mentioned above, in addition to limiting the number average molecular weight of the organic phosphine (A) and the sulfide-based compound (B) to 260 or more. As a result, surface contamination of substrates (lead frame and the like) caused by the bleed-out can be prevented and the package reliability can be improved.

[0052] The content of the organic phosphine (A) in the electrically conductive adhesive film of the present embodiments is preferably from 0.5 to 10.0 % by mass, more preferably from 1.0 to 5.0 % by mass. Sufficient metal oxide film-removing property can be exerted by limiting said content to this range.

[0053] The content of the sulfide-based compound (B) in the electrically conductive adhesive film of the present embodiments is preferably from 0.5 to 8.0 % by mass, more preferably from 1.0 to 4.0 % by mass. Sufficient metal oxide film-removing property can be exerted by limiting said content to this range.

[0054] When the electrically conductive adhesive film of the present embodiments comprises both of the organic phosphine (A) and the sulfide-

based compound (B), the total content is preferably from 0.5 to 10.0 % by mass, more preferably from 1.0 to 5.0 % by mass.

[0055] Each of the organic phosphine (A) and the sulfide-based compound (B) can be used alone or be used in a combination of two or more types.

[0056] [4] Other components

The electrically conductive adhesive film of the present embodiments may comprise various additives in addition to the aforementioned components within a range that does not deviate from the object of the present invention. Such additives can be suitably selected as necessary, and examples include dispersing agents, radical polymerization initiators, leveling agents and plasticizers.

[0057] The electrically conductive adhesive film of the present embodiments has form of a film. Therefore, it can be more easily handled compared with conventional solders and electrically conductive pastes at the time of bonding a power semiconductor element to a substrate, for example. Specifically, the overall wafer can be divided when the electrically conductive adhesive film of the present embodiments is adhered to the back surface of a wafer on which a power semiconductor is formed and the wafer is divided into each element to produce chips (dicing step). Since just the right amount of an electrically conductive adhesive film can be formed onto the entire back surface of the elements (wafer), problems of conventional solders such as insufficient wetting and running off can be avoided and good mounting can be performed. Also, since an electrically conductive adhesive film is formed in advance with a prescribed thickness, the height of the element after die-bonding can be easily controlled with precision compared with conventional solders and electrically conductive pastes.

[0058] The method for producing the electrically conductive adhesive film of the present embodiments is not particularly limited, and the electrically conductive adhesive film can be produced by a known method. A method in which appropriate amounts of the aforementioned components are weighed and mixed by a known method, and the obtained mixture is formed into a film by a known method can be mentioned, for example. Examples of such the mixing method include mixing by agitation using rotating blades, and mixing with the use of a homogenizer, a planetary mixer or a kneader. Also, examples of the forming method include a method in which a varnish obtained by dissolving or dispersing the aforementioned mixture in a solvent is applied onto a substrate and then dried, a melt-application method in which the electrically conductive adhesive film is melted at high temperatures and then applied onto a substrate, a method in which the electrically conductive adhesive film is pressed at a high pressure together with the substrate, an extrusion method in which the electrically conductive adhesive film is melted, extruded with the use of an extruder and then drawn, and a printing method in which a screen mesh (screen printing) or a metal plate (gravure printing) is filled with the aforementioned varnish so as to transfer the same.

[0059] Thickness of the electrically conductive adhesive film is preferably from 5 to 100  $\mu\text{m}$ , more preferably from 20 to 50  $\mu\text{m}$ . Sufficient adhesive power can be obtained while suppressing electric resistance and heat resistance by limiting the thickness of the electrically conductive adhesive film to the aforementioned range.

[0060] Also, the electrically conductive adhesive film of the present embodiments has a storage elastic modulus at 1 Hz measured in a state after sintering of 20 GPa or less. Adequate flexibility can be obtained and excellent properties in terms of thermal fatigue resistance evaluated by the thermal cycle

test (TCT) can be exerted while exerting strong adhesive power by limiting the storage elastic modulus to the aforementioned range. Also, the storage elastic modulus is preferably from 1000 to 20000 MPa, more preferably from 5000 to 20000 MPa. The measurement method of the storage elastic modulus will be explained later in the section concerning examples.

[0061] The electrically conductive adhesive film preferably has a thermal weight loss ratio of less than 1 % when heated for 2 hours at 250 °C under a nitrogen atmosphere. By limiting the thermal weight loss ratio to the aforementioned range, resin, in large part, would not thermally decompose when the electrically conductive adhesive film is sintered, and reliability can be secured by the excellent low bleed-out property. The measurement method of the thermal weight loss ratio will be explained later in the section concerning examples.

[0062] When the electrically conductive adhesive film of the present embodiments is analyzed by DSC (differential scanning calorimetry), it is preferable that at least one endothermic peak is observed in the temperature range of from 100 to 250 °C in a state before sintering (unsintered state), and that the endothermic peak disappears in a state after sintering (sintered state).

[0063] At least one endothermic peak observed in the aforementioned temperature range in an unsintered state indicates the melting point of the metal or alloy comprising at least one metal component. In other words, said endothermic peak indicates that when an unsintered electrically conductive adhesive film is heated (sintered) within the aforementioned temperature range, a specific metal component melts and wets over the surface of the object to which the electrically conductive adhesive film is adhered, which is advantageous for low-temperature mounting. In contrast, no endothermic peak is observed within the aforementioned temperature range in a sintered state,

and this means that the melting point of the metal component (or alloy) of the metal or alloy comprising at least one metal component does not exist within the aforementioned temperature range. In other words, this means that a metal which has once melted forms after sintering an intermetallic compound having a high melting point by an intermetallic diffusion reaction, and that excellent heat resistance is obtained as a result.

[0064] This type of electrically conductive adhesive film enables sintering (mounting) at low temperatures, and, at the same time, exhibits excellent heat resistance after sintering (after mounting) and does not cause any defects even when carrying out wire bonding by using a high-melting-point lead-free solder or reflow treatment. The heat resistance temperature of the electrically conductive adhesive film is preferably 250 °C or higher, more preferably 300 °C or higher. Also, the mounting temperature suitable for mounting a semiconductor chip or the like with the use of the electrically conductive adhesive film is preferably from 100 to 250 °C, more preferably from 100 to 200 °C.

[0065] DSC 7000X, a product of Hitachi High-Tech Science Corp. and the like, for example, can be mentioned as a DSC measurement apparatus. The measurement conditions are as follows: measurement temperature range: room temperature to 350 °C, temperature increase rate: 5 °C/min., nitrogen flow rate: 20 mL/min., and the measurement is performed with the use of an aluminum sample pan.

[0066] Also, the electrically conductive adhesive film of the present embodiments preferably has a loss tangent ( $\tan \delta$ ) defined by the ratio ( $G''/G'$ ) of a loss elastic modulus ( $G''$ ) to a storage elastic modulus ( $G'$ ) measured at 60 °C and 1 Hz in a B-stage state of 1.4 or higher. A higher  $\tan \delta$  under the aforementioned conditions indicates that the electrically conductive adhesive

film excels in flexibility. The measurement and calculation methods of the loss elastic modulus ( $G''$ ), storage elastic modulus ( $G'$ ) and  $\tan \delta$  will be explained later in the section concerning examples. Here, a B-stage state means a state in which 80 % or more of the pre-curing calorific value, measured by DSC, derived from the thermosetting resin component is maintained.

[0067] Furthermore, by adhering the electrically conductive adhesive film of the present embodiments to a dicing tape to obtain a dicing-die bonding film, an electrically conductive adhesive film and a dicing tape can be simultaneously adhered to a wafer, and the processing steps can be simplified thereby.

[0068] The aforementioned embodiments will be explained by reference to the figures.

Fig. 1 is a cross-sectional diagram showing a dicing-die bonding film 10 of the present invention. The dicing-die bonding film 10 mainly is composed of a dicing tape 12 and an electrically conductive adhesive film 13. The dicing-die bonding film 10 is one example of a tape for semiconductor processing, and the film may be cut in advance (pre-cut) into prescribed shapes in accordance with the used step or apparatus, may be cut for each semiconductor wafer, or may be have the form of a long roll.

[0069] The dicing tape 12 is composed of a supporting substrate 12a and a pressure-sensitive adhesive layer 12b formed thereon.

A release-treated PET film 11 covers the dicing tape 12 and protects the pressure-sensitive adhesive layer 12b and the electrically conductive adhesive film 13.

[0070] The supporting substrate 12a is preferably radiolucent. Specifically, plastic, rubber, and the like are normally used, but the material is not particularly limited as long as it is radiolucent.

[0071] The base resin composition of the pressure-sensitive adhesive of the pressure-sensitive adhesive layer 12b is not particularly limited, and an ordinary radiation-curable pressure-sensitive adhesive is used. An acrylic pressure-sensitive adhesive including a functional group, such as a hydroxyl group, reactive with an isocyanate group is preferable. Although there is no particular limitation, an acrylic pressure-sensitive adhesive having an iodine number of 30 or less and a radiation-curable carbon-carbon double bond structure is preferable.

[0072] As mentioned above, the electrically conductive adhesive film 13 of the present embodiments particularly preferably has a structure comprising a metal particle (Q), a resin (M), and at least one of a prescribed organic phosphine (A) and a prescribed sulfide-based compound (B) in terms of attaining excellent heat resistance and mounting reliability at the time of bonding a semiconductor power element to a metal lead frame, and of low environmental load.

[0073] (Method for using dicing-die bonding film)

The dicing-die bonding film 10 of the present embodiments can be suitably used in the production of a semiconductor device.

[0074] First, the release-treated PET film 11 is removed from the dicing-die bonding film 10, the electrically conductive adhesive film 13 is adhered to a semiconductor wafer 1, and the side part of the dicing tape 12 is fixed with a ring frame 20 as shown in Fig. 2. The ring frame 20 is an example of dicing frames. The electrically conductive adhesive film 13 is laminated onto a part of the dicing tape 12 to which the semiconductor wafer 1 is bonded. There is no electrically conductive adhesive film 13 on the part of the dicing tape 12 that is in contact with the ring frame 20.

[0075] Thereafter, as shown in Fig. 3, the under surface of the dicing tape 12 is fixed by suction on the suction stage 22, and the semiconductor wafer 1 is diced into prescribed sizes by using a dicing blade 21 so as to produce a plurality of semiconductor chips 2.

[0076] Then, as shown in Fig. 4, while the dicing tape 12 is fixed by the ring frame 20, the tape push-up ring 30 is moved upwards to bend the center part of the dicing tape 12 upwards, and the dicing tape 12 is irradiated with radiation such as ultraviolet ray so as to weaken the adhesive power of the adhesive layer 12b that constitutes the dicing tape 12. Subsequently, the push-up pin 31 is moved upwards at positions corresponding to each semiconductor chip, and the semiconductor chips 2 are picked up by the suction collet 32.

[0077] Thereafter, as shown in Fig. 5, the picked up semiconductor chip 2 is adhered to a support component such as a lead frame 4 or to another semiconductor chip 2 (die-bonding step), and the electrically conductive adhesive film is sintered.

[0078] Then, as shown in Fig. 6, a semiconductor device is obtained through steps such as Al wire attachment and resin molding.

[0079] Embodiments of the present invention have been explained above, but the present invention is not limited to the aforementioned embodiments and includes various embodiments encompassed by the concept of the present invention and the claims. Also, various modifications may be made within the scope of the present invention.

## Examples

[0080] The present invention will be further explained in detail below based on examples. However, the present invention is not limited by the examples.

[0081] <Raw materials>

Abbreviations for the raw materials used are indicated as follows.

[Metal particle (Q)]

<First metal particle (Q1)>

· Spherical copper powder: MA-C05K, a product of Mitsui Mining & Smelting Co., Ltd., average particle size (D50): 5  $\mu\text{m}$

<Second metal particle (Q2)>

· Spherical tin powder: ST-3, a product of Mitsui Mining & Smelting Co., Ltd., average particle size (D50): 7  $\mu\text{m}$

[0082] The average particle size (D50) of the metal particles was measured by a laser diffractometer (SALD-3100, product of Shimadzu Corp.).

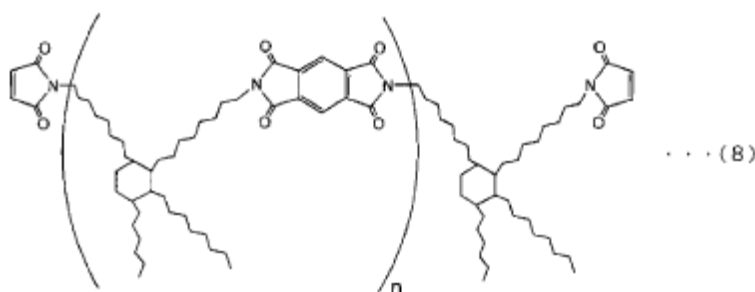
[0083] [Thermosetting resin (M1)]

· Maleimide resin

Mixture obtained by mixing BMI-3000 with, as a polymerization initiator, Perbutyl<sup>®</sup> O in a mass ratio of 100 : 5

BMI-3000: Bismaleimide resin represented by the following structural formula (8), a product of DESIGNER MOLECULES INC, number-average molecular weight: 3000. In the formula (8) below, n is an integer from 1 to 10. The backbone derived from an aliphatic amine has a carbon atom number of 36.

[Chemical formula 6]



· Phenol novolac resin

H-4: a product of Meiwa Plastic Industries, Ltd.

· Epoxy resin 1

Mixture obtained by mixing YD-128, YD-013, YP-50 and 2PHZ in a mass ratio of 15 : 5 : 10 : 1

YD-128: Bisphenol A-type liquid epoxy resin, a product of Nippon Steel & Sumikin Chemical Co., Ltd.

YD-013: Bisphenol A-type solid epoxy resin, a product of Nippon Steel & Sumikin Chemical Co., Ltd. (The same applies hereinafter.)

YP-50: Phenoxy resin, a product of Nippon Steel & Sumikin Chemical Co., Ltd. (The same applies hereinafter.)

2PHZ: 2-phenyl-4,5-dihydroxymethylimidazole, a product of Shikoku Chemicals Corp. (The same applies hereinafter.)

· Epoxy resin 2

Mixture obtained by mixing EP4000L, YD-013, YP-50 and 2PHZ in a mass ratio of 20 : 5 : 5 : 1

EP4000L: Propylene glycol-modified epoxy resin, a product of ADEKA Corp.

· Phenol novolac resin

H-4: a product of Meiwa Plastic Industries, Ltd.

[0084] [Flux]

· Organic phosphine

DPPST®: diphenylphosphino styrene, a product of Hokko Chemical Industry Co., Ltd.

· Sulfide-based compound 1

Bis(4-hydroxyphenyl)sulfide, a product of Tokyo Chemical Industry Co., Ltd.

· Sulfide-based compound 2

Bis(4-methacryloylthiophenyl)sulfide, a product of Sumitomo Seika Chemicals Company, Ltd.

[0085]

· Tetraethylene glycol: a product of Tokyo Chemical Industry Co., Ltd.

· Abietic acid: a product of Tokyo Chemical Industry Co., Ltd.

[0086] [Dicing tape]

· A dicing tape was obtained by applying a pressure-sensitive adhesive composition onto a supporting substrate so that the thickness of the pressure-sensitive adhesive composition after drying would be 5  $\mu\text{m}$ , and then drying the same for 3 minutes at 120 °C.

Pressure-sensitive adhesive composition: A mixture obtained by mixing n-octylacrylate (product of Osaka Organic Chemical Industry Ltd.), 2-hydroxyethylacrylate (product of Osaka Organic Chemical Industry Ltd.), methacrylic acid (product of Tokyo Chemical Industry Ltd.), and, as a polymerization initiator, benzoyl peroxide (product of Tokyo Chemical Industry Co., Ltd.) in a mass ratio of 200 : 10 : 5 : 2 was dispersed in an appropriate amount of toluene, and an acrylic resin solution including a functional group was obtained by adjusting the reaction temperature and time. Then, 2 parts by mass of CORONATE L (product of Tosoh Corp.) was added as a polyisocyanate relative to 100 parts by weight of the acrylic resin solution, an appropriate amount of toluene was further added as an additional solvent, and the mixture was agitated to obtain a pressure-sensitive adhesive composition.

Supporting substrate: A supporting substrate was obtained by melting resin beads made of low-density polyethylene (NOVATEC LL, product of Japan Polyethylene Corp.) at 140 °C, and forming the same into a long film with a thickness of 100  $\mu\text{m}$  with the use of an extruder.

[0087] <Production of electrically conductive adhesive film>

(Example 1)

In Example 1, the materials shown in Table 1, among the aforementioned materials, were mixed so as to prepare a mixture of 91.5 % by mass of the metal particle (Q), 5.5 % by mass of the resin (M), and 3 % by mass

of the flux, then toluene was added thereto as a solvent to obtain a slurry, and the slurry was thinly applied onto a mold release-treated PET film after agitation using a planetary mixer, then dried for 2 minutes at 120 °C to obtain an electrically conductive adhesive film with a thickness of 40 μm. The metal particle (Q) used here consisted solely of a spherical copper powder used as the first metal particle (Q1).

[0088] (Example 2)

In Example 2, an electrically conductive adhesive film was obtained in the same manner as in Example 1 except that metal particle (Q) was prepared so that the proportion of the spherical copper powder as the first metal particle (Q1) would be 60 % by mass and that the proportion of the spherical tin powder as the second metal particle (Q2) would be 40 % by mass in 100 % by mass of the metal particle (Q).

[0089] (Example 3)

In Example 3, an electrically conductive adhesive film was obtained in the same manner as in Example 1 except that a maleimide resin was used as the resin (M) and an organic phosphine was used as the flux, respectively and that metal particle (Q) was prepared so that the proportion of the spherical copper powder as the first metal particle (Q1) would be 60 % by mass and that the proportion of the spherical tin powder as the second metal particle (Q2) would be 40 % by mass in 100 % by mass of the metal particle (Q).

[0090] (Example 4)

In Example 4, an electrically conductive adhesive film was obtained in the same manner as in Example 3 except that the sulfide-based compound 2 was used as the flux.

[0091] (Example 5)

In Example 5, an electrically conductive adhesive film was obtained in the same manner as in Example 4 except that a flux prepared was used so that the proportion of the organic phosphine would be 25 % by mass and that the proportion of the sulfide-based compound 2 would be 75 % by mass.

[0092] (Example 6)

In Example 6, an electrically conductive adhesive film was obtained in the same manner as in Example 5 except that a resin (M) prepared was used so that the proportion of the maleimide resin 3 would be 95 % by mass and that the proportion of the phenol novolac resin would be 5 % by mass.

[0093] (Comparative Examples 1 and 2)

In Comparative Examples 1 and 2, electrically conductive adhesive films were obtained in the same manner as in Example 1 except that the materials shown in Table 1, among the aforementioned materials, were mixed so as to prepare mixtures of 85 % by mass of the metal particle (Q), 8 % by mass of the resin (M), and 7 % by mass of the flux.

[0094] (Comparative Example 3)

In Comparative Example 3, an electrically conductive adhesive film was produced in the same manner as in Example 1 except that the materials shown in Table 1, among the aforementioned materials, were used. However, the coating film after drying was in the form of a very brittle and hard solid with no stickiness or adhesiveness, and could not be used as an electrically conductive adhesive film.

[0095] <Production of dicing-die bonding film>

The thus obtained electrically conductive adhesive films of the examples and comparative examples were adhered to a dicing tape to obtain dicing-die bonding films (electrically conductive adhesive film / pressure-sensitive adhesive composition / supporting substrate).

[0096] <Evaluation>

The properties below were evaluated with respect to the thus obtained electrically conductive adhesive films and dicing-die bonding films of the examples and comparative examples. The evaluation conditions for each property are as described below. The results are shown in Table 1.

[0097] [Storage elastic modulus (flexibility)]

The electrically conductive adhesive films of the examples and comparative examples were placed on a Teflon® sheet, sintered by heating for 2 hours at 250 °C under a nitrogen atmosphere, and then cut into strips with a size of 5 mm x 30 mm so as to obtain measurement samples. Then, the storage elastic modulus at room temperature of these measurement samples was measured under shear conditions of a frequency of 1 Hz and a strain amount of 0.3 % with the use of a viscoelastometer DMA (E4000, product of UBM).

[0098] [Thermal weight loss ratio (stability)]

The thermal weight loss ratio of the electrically conductive adhesive films of the examples and comparative examples when heated for 2 hours at 250 °C under a nitrogen atmosphere was measured with the use of a thermogravimetric/differential thermal analyzer TG-DTA (DTG60, product of Shimadzu Corporation).

[0099] [Presence or absence of PKG delamination (moisture absorption resistance)]

The dicing-die bonding films of the examples and comparative examples were bonded to the surfaces of Si wafers with an Au-plated backside at 100 °C, then the wafers were diced into 5 mm squares to obtain diced chips (Au plating / Si wafer / electrically conductive adhesive film). Each chip was die-bonded onto an Ag-plated metal lead frame at 140 °C, subsequently sintered for 3 hours at 230 °C, and then sealed with an epoxy-based molding

resin (KE-G300, product of Kyocera Chemical Corp.) so as to cover the chip to obtain measurement samples.

The obtained measurement samples were subjected to MSL-Lv1 and 2 of the reflow test after moisture absorption in conformity with JEDEC J-STD-020D1 (based on lead-free solder) under the conditions below. Then, whether or not inner delamination occurred was observed with the use of an ultrasonic imaging apparatus (Fine SAT, product of Hitachi Power Solutions Co., Ltd.). No PKG delamination after MSL-Lv2, at the least, was determined to be acceptable in the present examples.

(Moisture absorption conditions)

· MSL-Lv1: 168 hours at 85 °C, 85 % RH

· MSL-Lv2: 168 hours at 85 °C, 60 % RH

(Reflow classification temperature)

· 260 °C in both of MSL-Lv1 and 2

[0100] [Shear adhesion (adhesion / heat resistance)]

The dicing-die bonding films of the examples and comparative examples were bonded to the surfaces of Si wafers with an Au-plated backside at 100 °C, then the wafers were diced into 5 mm squares to obtain diced chips (Au plating / Si wafer / electrically conductive adhesive film). Each chip was die-bonded onto an Ag-plated metal lead frame at 140 °C, then sintered for 3 hours at 230 °C so as to obtain measurement samples.

Shear adhesion of the electrically conductive adhesive films before and after the thermal cycle test (hereinafter "TCT") was measured with respect to the obtained measurement samples.

(Adhesive power before TCT)

A die shear tester (multi-purpose bond tester series 4000, product of Nordson Advanced Technology) was used, and the scratch tool of the bond

tester was hit against the side of the semiconductor chip of the obtained measurement samples at 100  $\mu\text{m/s}$ , and the stress when the chip/lead frame bond was broken was measured as the shear adhesion at 260 °C. A shear adhesion before TCT of 3 MPa or more was determined to be the acceptable level in the present examples.

(Adhesive power after TCT)

Next, a thermal cycle test (TCT) was performed on the obtained measurement samples by subjecting the samples to 200 cycles of a treatment in a temperature range of from -40 to +150 °C. The shear adhesion of the treated samples was measured in the same manner as in the aforementioned test concerning the adhesive power before TCT. A shear adhesion after TCT of 1 MPa or more was determined to be the acceptable level in the present examples.

[0101] [Volume resistivity (electrical conductivity)]

The electrically conductive adhesive films of the examples and comparative examples were placed on a Teflon® sheet and sintered for 3 hours at 230 °C so as to obtain measurement samples. Then, resistivity of the measurement samples was measured by the four probe method in accordance with JIS-K7194-1994 so as to calculate the volume resistivity. Loresta-GX, a product of Mitsubishi Chemical Analytech Co., Ltd., was used for measuring the resistivity. The reciprocal of the volume resistivity is the electrical conductivity, and a lower volume resistivity indicates excellent electrical conductivity. A volume resistivity of 1000  $\mu\Omega\cdot\text{cm}$  or less was determined to be the acceptance line in the present examples.

[0102] [ $\tan \delta$  (flexibility)]

The electrically conductive adhesive films of the examples and comparative examples semi-cured to the B-stage state by the aforementioned drying step for 2 minutes at 120 °C were laminated by thermocompression

bonding into a thickness of 1 mm so as to obtain measurement samples with a plate diameter of 8 mm $\phi$ . Then, the loss tangent ( $\tan \delta$ ) at 60 °C of these measurement samples was measured under shear conditions of a frequency of 1 Hz and a strain amount of 0.3 % with the use of a dynamic viscoelastometer ARES (product of Rheologica).

[0103] [Table 1]

|                                         |                                                    |                                                         | Example 1                    | Example 2                                       | Example 3                                       | Example 4                                       | Example 5                                       | Example 6                                       | Comparative Example 1        | Comparative Example 2        | Comparative Example 3            |
|-----------------------------------------|----------------------------------------------------|---------------------------------------------------------|------------------------------|-------------------------------------------------|-------------------------------------------------|-------------------------------------------------|-------------------------------------------------|-------------------------------------------------|------------------------------|------------------------------|----------------------------------|
|                                         | Metal particle (Q)                                 | First metal particle (Q1)<br>Second metal particle (Q2) | Spherical copper powder<br>— | Spherical copper powder<br>Spherical tin powder | Spherical copper powder<br>Spherical tin powder | Spherical copper powder<br>Spherical tin powder | Spherical copper powder<br>Spherical tin powder | Spherical copper powder<br>Spherical tin powder | Spherical copper powder<br>— | Spherical copper powder<br>— | Spherical copper powder<br>—     |
| Constituent components of adhesive film | Resin (M)                                          | Flux                                                    | Epoxy resin 2                | Epoxy resin 2                                   | Maleimide resin                                 | Maleimide resin                                 | Maleimide resin                                 | Maleimide resin                                 | Epoxy resin 1                | Epoxy resin 1                | Epoxy resin 1                    |
|                                         |                                                    |                                                         |                              |                                                 |                                                 |                                                 |                                                 | Phenol novolac resin                            |                              |                              |                                  |
| Evaluation results                      | Storage elastic modulus [GPa]                      | Thermal weight loss ratio [%]                           | 5                            | 19                                              | 9                                               | 11                                              | 11                                              | 18                                              | <u>21</u>                    | <u>25</u>                    |                                  |
|                                         |                                                    |                                                         | <1                           | <1                                              | <1                                              | <1                                              | <1                                              | <1                                              | <u>2</u>                     | <u>3</u>                     |                                  |
|                                         | PKG delamination                                   | After MSL-Lv.2                                          | No delamination              | No delamination                                 | No delamination                                 | No delamination                                 | No delamination                                 | No delamination                                 | <u>Delamination</u>          | <u>Delamination</u>          | <u>Impossible to form a film</u> |
|                                         |                                                    | After MSL-Lv.1                                          | Delamination                 | Delamination                                    | No delamination                                 | No delamination                                 | No delamination                                 | No delamination                                 | Delamination                 | Delamination                 |                                  |
|                                         | Shear adhesion [MPa]                               | Before TCT                                              | 9                            | 14                                              | 15                                              | 18                                              | 19                                              | 24                                              | 4                            | 3                            |                                  |
|                                         |                                                    | After TCT                                               | 8                            | 9                                               | 17                                              | 23                                              | 23                                              | 25                                              | <u>0</u>                     | <u>0</u>                     |                                  |
|                                         | Volume resistivity [ $\mu\Omega \cdot \text{cm}$ ] |                                                         | 600                          | 200                                             | 40                                              | 100                                             | 40                                              | 50                                              | 300                          | 700                          |                                  |
|                                         |                                                    | tan $\delta$                                            | 1.4                          | 1.3                                             | 2.0                                             | 2.3                                             | 2.1                                             | 2.4                                             | 10.0                         | 10.1                         |                                  |

\* In the table, the results in bold and underlined indicate those outside the appropriate range of the present invention and those that did not reach the acceptable level in the examples. Also, "%" means "% by mass".

[0104] From the results above, it was confirmed that the electrically conductive adhesive films of Examples 1 to 6 exhibited notable effects that were not achieved by prior art, both heat resistance and mounting reliability after bonding and sintering, by comprising a metal particle (Q), a resin (M), and at least one of a prescribed organic phosphine (A) and a prescribed sulfide-based compound (B), and by having a storage elastic modulus at 1 Hz measured in a state after sintering of 20 GPa or less and a thermal weight loss ratio when heated for 2 hours at 250 °C under a nitrogen atmosphere of less than 1 %.

[0105] In contrast, because the electrically conductive adhesive films of Comparative Examples 1 and 2 did not contain either of the prescribed organic phosphine (A) or the prescribed sulfide-based compound (B) specified in the present invention, the electrically conductive adhesive films of Comparative Examples 1 and 2 had both inferior heat resistance after bonding and sintering and mounting reliability compared with the inventive Examples 1 to 6. Specifically, in Comparative Examples 1 and 2, PKG delamination occurred even after MSL-Lv2 in the moisture absorption resistance test, which confirmed particularly poor moisture absorption resistance. Also, the shear adhesion notably deteriorated after TCT, which confirmed that the electrically conductive adhesive films of Comparative Examples 1 and 2 also had poor thermal impact resistance.

[0106] The volume resistivity of Comparative Example 1 is lower than that of Example 1, and it may appear that Comparative Example 1 excels in electrical conductivity. However, since delamination already occurred in the measurement sample of Comparative Example 1 after MSL-Lv2 in the moisture absorption resistance test, and since the resistance becomes infinite in such a state, Comparative Example 1 cannot be considered to excel in electrical

conductivity from a practical point of view. Also, the adhesive power of the measurement sample of Comparative Example 1 notably deteriorated after TCT.

In other words, an electrically conductive adhesive film which excels in heat resistance and moisture absorption resistance, which is capable of stable conduction, and which therefore has a high mounting reliability, even if the electrical conductance of the film itself is a little low, as with Example 1, is understood to be desirable from a practical point of view.

[0107] Also, although the mixture of the metal particle (Q), resin (M) and flux prepared in Comparative Example 3 has the same compounding ratio as Example 1, since neither one of the prescribed organic phosphine (A) and the prescribed sulfide-based compound (B) specified in the present invention was contained in Comparative Example 3, the mixture did not hold together and a sheet could not be formed. In other words, it was confirmed that good sheet formation is possible even when the content of the metal particles (Q) is increased by comprising at least one of the prescribed organic phosphine (A) and the prescribed sulfide-based compound (B) specified in the present invention (Examples 1 to 6).

#### List of Reference Signs

[0108]

- 1: semiconductor wafer,
- 1a: backside Au plating layer,
- 2: semiconductor chip,
- 4: metal lead frame,
- 4a: Ag plating layer
- 5: molding resin
- 6: Al wire

10: dicing-die bonding film  
11: release-treated PET film  
12: dicing tape  
12a: supporting substrate  
12b: pressure-sensitive adhesive layer  
13: electrically conductive adhesive film  
20: ring frame  
21: dicing blade  
22: suction stage  
30: tape push-up ring  
31: push-up pin  
32: suction collet

## Claims

1. An electrically conductive adhesive film comprising:

a metal particle (Q);

a resin (M); and

at least one of an organic phosphine (A) represented by the general formula (1) below and a sulfide-based compound (B) represented by the general formula (2) below,

wherein the electrically conductive adhesive film has a storage elastic modulus at 1 Hz measured in a state after sintering of 20 GPa or less and a thermal weight loss ratio when heated for 2 hours at 250 °C under a nitrogen atmosphere of less than 1 %

[Chemical formula 1]



in the general formulas (1) and (2), each R independently represents an organic group, and R may be the same or different with each other.

2. The electrically conductive adhesive film according to claim 1, wherein at least one R in each of the general formulas (1) and (2) is an aryl group.

3. The electrically conductive adhesive film according to claim 1 or 2, wherein, in the general formulas (1) and (2), each R independently comprises, in its moiety, one or more group selected from a vinyl group, an acrylic group, a methacrylic group, a maleic acid ester group, a maleic acid amide group, a maleic acid imide group, a primary amino group, a secondary amino group, a

thiol group, a hydrosilyl group, a hydroboron group, a phenolic hydroxyl group and an epoxy group.

4. The electrically conductive adhesive film according to any one of claims 1 to 3, wherein the organic phosphine (A) comprises p-styryl diphenyl phosphine.

5. The electrically conductive adhesive film according to any one of claims 1 to 4, wherein the sulfide-based compound (B) comprises at least one of bis(acryloylthiophenyl)sulfide and bis(methacryloylthiophenyl)sulfide.

6. The electrically conductive adhesive film according to any one of claims 1 to 5, wherein a loss tangent ( $\tan \delta$ ) defined by a ratio ( $G'' / G'$ ) of a loss elastic modulus ( $G''$ ) to a storage elastic modulus ( $G'$ ) at 60 °C and 1 Hz in a B-stage state is 1.4 or higher.

7. The electrically conductive adhesive film according to any one of claims 1 to 6, wherein the resin (M) comprises a thermosetting resin (M1), and the metal particle (Q) comprise a first metal particle (Q1) made of a single metal selected from the group of copper, nickel, aluminum and tin or an alloy comprising two or more metals selected from said group.

8. The electrically conductive adhesive film according to claim 7, wherein the thermosetting resin (M1) comprises a maleic acid imide compound including two or more units of an imide group in a single molecule.

9. The electrically conductive adhesive film according to claim 7, wherein the thermosetting resin (M1) comprises an epoxy resin including a molecular backbone derived from a glycidyl ether of an aliphatic diol.

10. The electrically conductive adhesive film according to claim 8 or 9, wherein the thermosetting resin (M1) further comprises a phenol novolac resin.

11. The electrically conductive adhesive film according to any one of claims 7 to 10, wherein the metal particle (Q) is a mixture comprising the first metal particle (Q1) and a second metal particle (Q2) based on a metal component different from the first metal particle (Q1), and

the first metal particle (Q1) and the second metal particle (Q2) comprise a metal component capable of mutually forming an intermetallic compound.

12. The electrically conductive adhesive film according to claim 11, wherein the second metal particle (Q2) is made of a single metal selected from the group of copper, nickel, aluminum, tin, zinc, titanium, silver, gold, indium, bismuth, gallium and palladium or an alloy comprising two or more metals selected from said group.

13. A dicing-die bonding film, comprising the electrically conductive adhesive film according to any one of claims 1 to 12 adhered to a dicing tape.