



Contents

Summary	v
Zusammenfassung	vii
Acknowledgements	xi
1 Vertical Integration of High-Performance Processor-Memory Stacks: Motivation & Conception	1
1.1 Driving Forces and Enabling Technologies	1
1.1.1 Performance Benefits of Vertical Area Array Electrical Interconnects	1
1.1.2 Enabling Technologies: Vertical Interconnects - Substrate Thinning - Alignment & Bonding	3
1.1.3 Vertical Integration Product Roadmap	6
1.2 Thermal Management Concepts and Limitations	7
1.2.1 Power Dissipation Characteristics of IC-Dies	7
1.2.2 Thermal Response of IC-Dies	8
1.2.3 Established Heat Removal Concepts	9
1.2.4 Back-side Heat Removal Limits of Vertical Integrated Chip Stacks	10
1.2.5 Interlayer Thermal Management	12
1.3 Convective Interlayer Heat Removal - a Scalable Concept	12
1.3.1 Implementation Concepts: Via Sealing and Pressure Balanced Package	13
1.3.2 Internal Flow Heat Transfer Characteristics: a Sensitivity Analysis at constant Geometrical Ratio	14
1.3.3 Modular Heat and Mass Transfer Building Blocks	17
1.3.4 Electro-Thermal Co-design / Optimization Framework	22
1.4 Scope and Organization of the Thesis	22
2 Multi-Scale Modeling with Porous-Media Approach for Heat and Mass Transfer Design	25
2.1 Detailed Conjugate Heat and Mass Transfer	25
2.1.1 Fluid Flow Basics of NEWTONIAN Viscous Media	25
2.1.2 Heat Conduction and Energy Conservation	26
2.1.3 Limitations of Detailed Chip Stack Modeling	27
2.2 Multi-Scale Modeling: Heat and Mass Transfer in Porous Media	27
2.2.1 Volume Averaging of Porous Media	28
2.2.2 From DARCY Flow to the Extended NAVIER-STOKES Equation	29
2.2.3 Heat Transfer through a Porous Medium	30
2.2.4 Porous - Solid Domain Interaction	30
2.2.5 3D Solid to 2D Porous Media Field-Coupling	32
2.3 Parameter Extraction from Efficient Sub-Domain Modeling with Periodic Boundary Conditions	35
2.3.1 Sub-Domain Model using Periodic Boundary Conditions	37
2.3.2 Parameter Set of Individual Heat Transfer Geometries in Symmetry Direction	41
2.3.3 Parameter Set for Pin-Fin Arrays at Arbitrary Angle-of-Attack	48
3 Eutectic Bonding, Test Cavities, and Experimental Apparatus for Characterization	61
3.1 Eutectic AuSn 80/20 Thin Film Bonding: Low Thermal Resistance, Leak Tight Interface	61
3.1.1 Solder Technologies for Structural and Thermal Interfaces	61
3.1.2 Formic Acid Assisted Thermo-Compression Bonding	64
3.1.3 Thin Film Solder Bond-Line Formation	66
3.1.4 Thermodynamic Stability of Under Bump Metallizations	69
3.1.5 Solder Process Qualification	72
3.2 Water Coolant Compatible Multi-Metal Layer System	75
3.3 Single-Cavity, Double-Side Heated Test Vehicle	78
3.3.1 Test Vehicle with Uniform Power Dissipation and Heat Transfer Geometry	78
3.3.2 Test Vehicle with Non-Uniform Power Dissipation and Heat Transfer Geometry	79



Contents

3.4	Multi-Cavity Test Vehicle: Pyramid-Chip-Stack	81
3.5	Single-Phase Test Loop with Spatially Resolved Infrared Imaging	83
4	Experimental Results and Validation of Modeling Framework	85
4.1	Uniform Single Cavity Experiment: Unit-Cell Shape Efficiency	85
4.1.1	Experimental Sequence and Extrapolation of Datasets	86
4.1.2	Hydrodynamic Characteristics of Unit-Cells	88
4.1.3	Heat Transfer Characteristics of Unit-Cells	92
4.1.4	Flow Transition Augmented Heat Transfer	95
4.1.5	Performance at Pressure or Pumping Power Constraints	95
4.2	Non-Uniform Single Cavity Experiment to Validate Multi-Scale Concept	99
4.2.1	Hydrodynamic and Spatially Resolved Thermal Measurements	100
4.2.2	Field-Coupled Porous Media Model Representing Non-Uniform Cavities	102
4.2.3	Validation of Multi-Scale Concept with Detailed Conjugate Heat and Mass Transfer Model of the Parallel Plate Test Vehicle	102
4.2.4	Validation of Multi-Scale Modeling Concept with Experimental Results	104
4.3	Thermally Communicating Fluid Cavities: Interlayer Cooled Pyramid Chip Stack	111
4.3.1	Field-Coupled Porous Media Model Representing Pyramid-Chip-Stack	111
4.3.2	Validation of Multi-Scale Modeling Concept with Experimental Results	112
4.3.3	Tier-to-Tie Thermal Crosstalk	113
4.3.4	Benchmarking of Fluid Delivery Architecture: Two-port vs. Four-port	116
5	Interlayer Cooling Design-Rules, Conclusions and Outlook	117
5.1	Interlayer Cooled Chip Stacks: Performance and Characteristics	117
5.1.1	Benchmark: Uniform, Two-port Interlayer Cooling vs. Back-Side Heat Removal	117
5.1.2	Fluid Manifold Design: Pressure Penalty and Mass Flow Maldistribution	118
5.1.3	Critical Hot-Spot Dimension: Hot-Spot Temperature Mitigation by Heat Spreading in Thin Dies	119
5.1.4	Thermal Transients: Time Constant and Retardation	120
5.2	Advanced Interlayer Cooling: Design-Rules and Recommendations	122
5.2.1	Unit-Cell Shape Menu and Interlayer Cooling Performance Scaling at Uniform Heat Flux	122
5.2.2	Power Map aware Heat Removal: Heat Transfer Structure Modulation - Fluid Focusing - Fluid Delivery Architectures - Tier-to-Tier Crosstalk	123
5.2.3	Electro-Thermal Co-Design: Interlayer Cooling Aware Floorplanning	124
5.2.4	Interlayer Cooling Performance Evolution	125
5.3	Future Research Agenda	126
5.3.1	Interlayer Cooling Implementation: Reliable Packaging Technology	126
5.3.2	Advanced Heat and Mass Transfer	127
5.3.3	Extended Modeling Frame Work	127
A	Power Map Contrast specific Pin Shape Optimization	129
A.1	Advanced Pin Shapes	129
A.2	Pin Shape Selection with Respect to Power Map Contrast	131
B	Implementation of Porous-Media and Field-Coupling: ANSYS CFX	135
B.1	Definition File Manipulation: CFX Command Line	135
B.2	Mass Transport in the quasi Two-Dimensional Porous Domain	135
B.3	Heat Transfer by Porous Domain Field-Coupling	137
C	Abbreviations	139
D	List of Symbols	141
	Bibliography	145
	List of Publications	153