General Disclaimer

One or more of the Following Statements may affect this Document

- This document has been reproduced from the best copy furnished by the organizational source. It is being released in the interest of making available as much information as possible.

- This document may contain data, which exceeds the sheet parameters. It was furnished in this condition by the organizational source and is the best copy available.

- This document may contain tone-on-tone or color graphs, charts and/or pictures, which have been reproduced in black and white.

- This document is paginated as submitted by the original source.

- Portions of this document are not fully legible due to the historical nature of some of the material. However, it is the best reproduction available from the original submission.
Plasma Variables and Tribological Properties of Coatings in Low Pressure (0.1 – 10.0 torr) Plasma Systems

R. Avni and T. Spalvins
Lewis Research Center
Cleveland, Ohio

Prepared for the
Eleventh International Conference on Metallurgical Coatings sponsored by the American Vacuum Society
San Diego, California, April 9–13, 1984
PLASMA VARIABLES AND TRIBOLOGICAL PROPERTIES OF COATINGS IN
LOW PRESSURE (0.1 - 10.0 torr) PLASMA SYSTEMS

R. Avni* and T. Spalvins
National Aeronautics and Space Administration
Lewis Research Center
Cleveland, Ohio 44135

SUMMARY

The interactions of plasma's particle fluxes such as positive ions, excited metastables and radicals (atoms and molecules) and radiation flux, with the substrate surface prior and during the deposition process is reviewed. The concept of plasma layer and the near-to-surface plasma region is introduced phenomenologically as the dialog between the plasma and the substrate surface.

Experimental evidence of the interactions between plasma and substrate such as: adsorption, morphological changes, defect formation, sputtering, chemical etching, and secondary electron emission is discussed as promoting and enhancing the surface chemistry, thus influencing the tribological properties of the deposited flux. Phenomenological correlations of rate of deposition, flux composition, microhardness and wear with the plasma layer variables give an insight to the formation of chemical bonding between the deposited flux and the substrate surface.

INTRODUCTION

A solid substrate immersed into an electrodeless plasma system is exposed to a number of processes according to the kinetic energy and the mass of free particles populating the discharge and hitting its surface. A continuous "dialog" takes place between plasma's energetic particles and the substrate surface prior and during the deposition of the coating films. The aim in this work is a detailed treatment of this "dialog" known as plasma-surface interactions (PSI) with respect to the coating process and its tribological behavior.

The behavior of the substrate in a plasma system is shown as a luminous region in figure 1(a) to (c). Under the same plasma (of propylene and argon mixtures) conditions on similar graphite substrate, the luminous region called here plasma layer (PL) shows the following qualitative features:

(1) The thickness of the PL is largest for the biased substrate at minus 100 V (fig. 1(c)) when compared to substrate floated (fig. 1(a)) or grounded (fig. 1(b)).

*Ben Gurion University of the Negev, Beer Sheva, Israel and NRC-NASA Research Associate.
(11) The PL luminosity is higher than the luminosity in the plasma bulk (PB) indicating that in the near-to-surface region occurs an enhanced excitation or/and ionization process.

(111) The PL wraps around the negatively biased (fig. 1(c)) and the grounded substrates (fig. 1(b)) while on the floated (fig. 1(a)) is formed only on the surface facing the direction of the gas flow.

The related PSI controlling film deposition and etching and its tribological qualities are schematically divided in four regions according to their phenomenological behavior, as shown in figure 2, namely:

1. The plasma bulk (PB) in which homogeneous reactions as excitation, ionization, dissociation of monomers and formation of polymerized species take place (refs. 1 to 7). The mechanisms and the kinetics of formation of ions, excited metastables and radicals (refs. 8 to 15) and their transport to the substrate surface are an important step in the understanding of the deposition phenomena. The energetic particle fluxes from the PB and its radiation impinging on the solid, exchange energy with the surface, neutralize and create in the substrate a distinct region of neutralization or the altered layer (AL) (refs. 16 to 18).

2. In the AL two main processes (refs. 16 to 18) occur as a result of the impact of PB's energetic particles and radiation with the surface, namely,

(1) energy transfer to the surface electrons resulting in the ejection of secondary electrons back into the PB and,

(11) momentum transfer to the lattice by collisions with nuclei.

The consequences of cascade collisions are among others: backscattering, sputtering of atoms into the PB, lattice damage, chemical potential gradients (segregation), and surface chemistry.

From the motion of electrons and atoms inside and outside the AL, two more regions may be identified; the substrate bulk (SB) and the plasma layers (PL).

3. The SB supplies the atoms by segregation to the AL mainly due to the chemical potential gradient ($\psi_{PB}$).

4. The PL a very near-to-the surface-region in which sputtered and etched atoms and molecules and secondary electrons from AL interact with the particles populating the PL from one side while from the other side the new population of the PL interact with the AL.

Both PL and AL being the connections between PB and SB are discussed in detail with regard to their chemical-interactions-mechanisms and the influence on the tribological behavior of the deposited films.

**REACTIONS IN THE AL AND PL**

The schematics of the four regions and the respective particle fluxes are shown in figure 2. The PB electrons with concentration $N_{ePB}$, average energy
and distribution functions $f(e_{PB})$ reach first the substrate surface and force on it a negative potential with respect to the PB potential. Part of the electrons flux, $j_{e_{PB}}$, will be repelled by the negative potential. Positive ions with concentration $n_{iPB}$ will reach the surface through a space charge region - the sheath - with a flux $j_{IS}$ imposed by the Bohm criteria (ref. 19) with energies $\geq T_{ePB}$ (the electrons temperature). In the sheath $j_{IS}$ gain acceleration by the high electric fields $E_s$ and hit the substrate surface. The ions flux reaching the surface will be neutralized (ref. 18) and adsorbed in the AL. Hagstrum (ref. 16) has shown experimentally in figure 3 for He$^+$, Ne$^+$, and Ar$^+$ ions to neutralize with a probability higher than 0.99 on a tungsten surface. The amount of reflected ions (fig. 3) is smaller than 0.01 from their incoming flux, $j_{IS}$. Fluxes of excited neutrals i.e., excited metastable states, $j_{ms}$ and excited radicals, $j_{R}$ (fig. 2) reach as well the surface releasing their energy in the AL after being partly trapped or adsorbed. The AL adsorbs the energy and the momentum of the incoming flux of excited energetic particles.

The Altered Layer (AL)

Hagstrum (refs. 16 and 17), Kaminsky (ref. 18), Behrish (ref. 20), Taglauer (ref. 21), and partly Winters (ref. 15) summarized the neutralization mechanisms of ions and excited particles on a solid surface as:

(1) Interactions with electrons in the conductance band resulting with de-excitation by an Auger process or/and a de-excitation by a resonance process, which yield the emission of secondary electrons ($\gamma$). The $\gamma$ ejection is by a potential or/and a kinetic process. Figures 4(a) and (b) show the energy distribution function of the $\gamma$ electrons by potential ejection and the $\gamma$ yield by a kinetic ejection, respectively.

(11) Interactions with the atom nuclei in the lattice by a momentum transfer i.e., nuclear or cascade collisions lead to the motion of lattice atoms. Taglauer (ref. 21) has shown that for projectile rows with energy higher than 100 eV the energy loss to the lattice in a binary collision is constant. The energy needed to overcome both the binding and the threshold energies of an atom in the lattice, such that sputtering of atoms from the surface lattice can take place at projectile energy below 100 eV. Under ion irradiation, atoms and electrons are cautiously removed from the surface leaving vacancies behind it. In the AL migration of atoms from SB reach the surface, due to a chemical potential, leaving the surface in a high mobile state (ref. 22).

Hart et al., (ref. 23) bombarded Cu contaminated Si surfaces with Ne$^+$ (20 keV) or Ar$^+$ (0.8 keV) and estimated the Cu sputtered atoms from a depth of about 10 nm; Kornelsen (ref. 24) measured penetration of heavy ions (0.25 - 16 keV range) in W as being above 5 mm while Winters (ref. 15) estimated the AL depth in a plasma system as being about 3 nm. Depending on the projectile mass, energy and angle of impact, the thickness of AL may vary between 3 to 10 nm conditioned as well by the surface conditions. In a plasma-deposition
system it can be stated that Al plays the important role in the chemical bonding between the surface and the first atomic layers of the deposited films. The chemical bonding which is in the range of several eV (ref. 2) results with a better adhesion (ref. 2) a higher resistance to wear (refs. 25 and 26), withstands mechanical stresses higher than \( R_{0} = 5 \times 10^{8} \ \text{Nm}^{-2} \) (ref. 2) and sometimes have lower friction coefficients (refs. 26 to 28). Enhanced surface chemistry is shown in figure 5(a) for ion nitriding of steels, in figure 5(b) for surface boridation of Ti and steels, and in figure 5(c) for surface plasma etching.

Szabo and Wilhelmi (ref. 28(a)) in figure 5(a) after plasma nitriding the steel samples in NH\(_{3}\), exposed it to Ar\(^+\) bombardment and beside Fe the sputtered particles (detected by SIMS) were FeNH\(_2\) and FeNH\(_3\). Their chemical bond was not destroyed by Ar\(^+\) during the sputtering process. Raveh et al., (ref. 28(b)) in figure 5(b) plasma bonded Ti and steel samples. The boride compounds were crystallite-6 Ti\(_3\)B\(_4\) and FeB + Fe\(_2\)B, respectively. The formation of these chemical compounds during plasma boridation is closely followed by the measured microhardness at higher VHN values corresponding at a higher rate of formation of either Ti\(_3\)B\(_4\) or FeB. Coburn et al., (ref. 28(c)) show the almost linear correlation between the sputtering of dimers (metal oxide) and their bond energy. At higher bond energy higher sputter ratio of MO\(^+\)/M\(^+\) \( \cdot \) was obtained.

Table 1 shows friction coefficient values for metal-ceramic and ceramic-ceramic pairs as obtained in plasma systems.

The coefficient of friction values as measured on a pin-on-disc tribotester (refs. 25 to 28) indicate for metal-ceramic couples a low coefficient of friction and even lower values were obtained in ceramic-ceramic couples deposited onto steel substrates (ref. 25). These values were related by Bunshah (ref. 25) to the values of volume wear loss, i.e., low coefficient of friction go hand in hand with low wear rate. For example (ref. 25) a volume wear loss below \( 1.0 \times 10^{-5} \ \text{mm}^{-2} \) as obtained for TiC - TiN couples for a run distance of 500 m under a load of 0.4 kgf. For comparison, in the same test, Bunshah (ref. 25) reported for steel-steel couple coefficient of friction values between 0.4 - 0.65 and the corresponding volume wear loss was above \( 5 \times 10^{-3} \ \text{mm}^{-2} \) i.e., several orders of magnitude higher. It is our belief that this tribological behavior is correlated to the Al chemistry as discussed in section 3.2.

The Plasma Layer (PL)

The fluxes of ions, \( J_{IS} \), excited metastables (atoms and molecules), \( J_{MS} \), radicals, \( J_{RS} \), and radiation \( J_{RAD} \) bombarding a surface generate secondary electrons, \( J_{ES} \), (\( \gamma_{1} \), \( \gamma_{M} \), and \( \gamma_{R} \), respectively) sputtered atoms, \( J_{SPU} \), reflected neutrals (after being trapped in the surface), \( J_{REF} \), and etched molecules, \( J_{ETCH} \), as schematically shown in figure 2.

The yield of secondary electrons, \( (\gamma) \) from the impact of Ar\(^+\) at 600 eV, for example, is \( \gamma_{1} = 1 \times 10^{-6} \) (\( a \geq 10 \)) from a metallic surface (ref. 3) and \( a < 10 \) from a nonmetallic surface (ref. 3). The yield value \( \gamma_{M} \) from the impact of Ar excited metastables (11.55 eV) is about of the same order of magnitude as \( \gamma_{1} \) (ref. 18). The maximum of \( \gamma_{1} \) energy distribution
function from Ar is below 10 eV as shown in figure 4(a). The γ electrons released from the surface are accelerated by the high electric field, $E_s$, in the sheath, towards the PB. The calculated average values (ref. 29) of $E_s$, the energy of positive ions, $E_{1s}$, bombarding the surface and the energy of γ electrons, $E_{es}$, from a graphite surface in an inductive RF plasma are shown in figure 6. Due to $E_s$ the high energy secondary electron beam (HEEB) with energy $E_{es}$, anisotropic energy distribution function, $F_{es}(E_{es})$, and flux $J_{es}$ undergoes collision with particle populating the near to substrate plasma region. The HEEB electrons lost their energy in such collisions along $Z$, a distance from the solid's surface, until equalizes the average energy of the electrons in the PB. Along $Z$ a boundary condition is formed between the PL and the PB, (ref. 29) i.e.,

$$E_{es}(Z=AL) = \int_{Z=0}^{Z=AL} E_{es} F_{es}(E_{es}, E_{1s}, Z, P, W) dE_{es} = E_{ePB}$$

with $AL$ the thickness of the PL, $P$, and $W$ the total gas pressure in the plasma system and net input power, respectively. The excitation and ionization of the particles populating the PL by the HEEB's electrons can be compared to some processes produced by the interaction with PB electrons (refs. 29 and 30). The ionization rate, $dn_1/dt$ is expressed as:

$$\frac{dn_1}{dt} = S J_{es} q_{es} \left(1 + \frac{a_1 n^2 k_1 AL}{J_{es} q_{es}}\right)$$

where $q_{es}$ is the efficiency of ionization by HEEB's electrons, $S$ is the PL cross section, $a_1$ the ionization degree by the PB electrons, $n$ the concentration of particles in the plasma (for one ionization step $n_0 = n_1 = a_1 n$), and $k_1$ the rate coefficient of ionization by PB electrons. Figure 7 shows the ratio of $(dn_1/dt)_PL/(dn_1/dt)_PB$ being about two orders of magnitude higher for the interaction with HEEB's than with the PB electrons. The thickness values of the PL, $AL$, were evaluated theoretically (ref. 30) and measured by emission spectroscopy is shown in figure 8. The relative spectral intensity (emission) ratio for the same particle, $I_{PL}/I_{PB}$, in PL and PB is shown in figure 9; the contribution of HEEB electrons (in the PL) to particle excitation to a higher electronic quantum level is greater than the contribution of PB electrons for the same quantum level. As stated before the fluxes of ions, excited metastables and radicals, bombarding a surface enhance its chemistry. The ion enhanced surface chemistry is illustrated in figures 10(a) and (b) for plasma chemical etching of silicon and aluminum, respectively. Film deposition and chemical etching in the same plasma system are contradictory occurring processes. An example is shown in figures 11(a) to (c) for the deposition of microcrystalline Si films from a RF plasma of SiCl$_4$ + H$_2$ + Ar on a graphite substrate (fig. 11(a)) the chlorine contamination of the deposited Si films (fig. 11(b)) and Si etching rate by Cl atoms under Ar$^+$ irradiation (fig. 11(c)). Another example of correlation between deposition and etching rates is shown in figure 12 for Si and S10$_2$ in CF$_4$ + H$_2$ plasmas.

To estimate the amount of material sputtered, and chemically etched with the material deposited the following was performed: Grounded Si single
crystal was introduced in an argon induced microwave plasma at 100 W in pressure range from 10^{-2} to 2.0 torr. Table II compares the sputtering, etching, and deposition fluxes (cm^{-2} s^{-1}) and rates (nm/s). Microwave plasmas of Ar, Ar + F_2 and Ar + Cl_2 were used for evaluating the sputtering and the etching from the grounded Si single crystal. For deposition, SiF_4, SiCl_4, and SiCl_4 + H_2 were added instead of F_2 and Cl_2, respectively. The dissociation of SiF_4, SiCl_4, and SiCl_4 + H_2 in the microwave plasma results with the formation of F_2, Cl_2, and HCl, respectively. Although about the same partial pressures and fluxes of F_2 and Cl_2 were obtained, the addition of SiF_4, SiCl_4, and SiCl_4 + H_2 to Ar microwave plasma, enhances the deposition of microcrystalline Si fluxes well above the sputtering and etching phenomena.

In the PL, as schematically shown in figure 2, clusters should be formed prior to nucleation and the deposition process. Direct evidence for cluster formation in the PL was not found. Nevertheless indirect evidence is supplied in table III which compares the ionization and polymerization degrees is the PB with the PL for a rf plasma of 16 vol. C_3H_6 in Ar. Normalized to a given concentration of C_3H_6 monomers in the plasma, the ionization and polymerization (Σ C > 3) degrees are higher by 10^2 and 10 respectively, is the PL (at a distance of 0.1 cm from the substrate surface) than in the PB, as a result of the interactions with the HEEB's electrons charged particles. With long range dipole, moments attract and attach excited large polymer molecules, enhancing the formation of clusters (ref. 31) in the PL nearest to the substrate surface.

An example is shown in figure 13 where ion bombardment of Xe^+ or Ar^+ on clean Si surface sputter away silicon cluster ion and (SiH^+) with a distribution from 2 to 10 atoms in the cluster (ref. 31(a)).

SURFACE CHEMICAL REACTIONS AND TRIBOLOGICAL BEHAVIOR

Chemical Reactions Not in a Plasma Environment

Exposures of metallic surfaces, like Ni (refs. 32 to 34), Fe (ref. 32) Cu (ref. 35), Al (ref. 36) among others, to oxygen produce a well defined chemisorbed layer which changes into the oxide as the surface concentration of O_2 is increased. Dissociative chemisorption (O_2 + 20) produces a coverage of about 0.4 monolayers where the oxygen atoms sit is fourfold sites at a distance of 0.9 A above the Ni plane (ref. 33). The chemisorption followed by an oxide nucleation stage causes the surface to reconstruct with the formation of a nickel oxide structure (refs. 33 and 34). The oxygen-nickel reaction becomes very slow after the formation of 2 to 3 layers of oxide.

Ammonia is used instead of N_2 molecule in nitriding stainless steels at temperatures about 500° C (ref. 37) merely because it is easier to dissociate NH_3 to NH_2 and NH radicals on the hot metal surfaces. Nitride layers as thick as several μm were formed during nitriding periods beyond 15 hr (ref. 37).

The probability for the dissociation of N_2 ions on a cold metal surface (Ni, W or Mo) reaches unity for N_2 kinetic energies around ~100 ev
although the dissociation energy of the \( \text{N}_2 \) molecule to \( \text{N} \) atoms is only 9.6 eV. Figure 14(a) and (b) show the probability for dissociation and the chemisorption of \( \text{N} \) atoms forming a nitride layer of approximately 30 to 100 Å thick (ref. 15). Figure 16(a) shows the probability that \( \text{N} \) atoms from \( \text{N}_2 \) would remain trapped in the metal surface was about 0.2, 1.0, 80 percent of the atoms from \( \text{N}_2 \) dissociation were reflected back.

Another form of chemical reactions with metal surfaces is the etching phenomena. For example \( \text{XeF}_2 \) which behaves like \( \text{F} \) atoms has been shown (ref. 13) to spontaneously etch at ambient temperature, Si, Ta, Mo, Ti, and W or other materials producing volatile fluorides. Fluorine molecules etch Si (ref. 13) while chlorine molecules etch Al (ref. 39) at sufficient pressure to obtain a good surface coverage (40%). Figure 15 shows the fluorination of Si as measured by a quartz crystal microbalance; first \( \text{F}_2 \) produces an adsorbed layer, following by the formation of unsaturated fluoride like \( \text{SiF}_2 \) (ref. 41) and finally \( \text{SiF}_4 \) desorbs from the surface.

Even for a pure metal the phenomena described above are highly complex and according to Dearnaley (ref. 42) and Bagus (ref. 43) depends more upon solid-state physical mechanism than on chemistry. It is influenced by mechanical stress, clustering, island formation, nucleation, motion of anions and cations, coulombic attractions and the presence of defects. Winters et al., (refs. 13 and 15) concluded from the high reactivity of nitrogen atoms compared to the nitrogen molecule that "radicals frequently chemisorb on surfaces which appear inert to the parent molecule."

Chemical Reaction in a Plasma

The reaction between the surface and a parent molecule or atom is mainly exothermic as shown in table IV for boron, nitrogen, and carbon on various metallic surfaces. In order to have the reaction proceed as a large activation energy is needed as shown in table V for SI and \( \text{SiO}_2 \). The need for activation energy is avoided by dissociating the parent molecule in the gas state, by producing excited radicals and positive ions. The plasma system supplies the dissociation, fragmentation, excitation, polymerization, and ionization of the parent monomer as shown in figures 16(a) and (b) for hydrocarbons and tetrachlorosilane, respectively. These excited radicals, atoms and positive ions react spontaneously (refs. 10 to 12) with the surface and probably produce the chemical bond necessary to the adhesion of the deposited film to the substrate surface, or interface (refs. 27 and 28).

Tribological Behavior of Refractory Coatings

To improve the frictional and wear properties of contacting surfaces it is customary in tribological practice to increase the surface and subsurface hardness. Hardened surfaces improve abrasive and adhesive wear resistance through the reduction of the real area of contact and by reducing the chemical activity between the materials at the rubbing interfaces. The fact remains that increasing the coating hardness of the flow strength of the coating increases and subsequently prevents deformation.
In recent years the plasma or low pressure glow discharge deposition techniques such as reactive sputtering and ion plating have emerged in various modes to supplement the well known case hardening, flame spraying, electroplating, PVD and CVD techniques. These ion assisted deposition techniques offer a great potential in tailoring the synthesis and deposition of refractory coatings for friction and wear control or both (refs. 28, and 44 to 51). Of the many refractory compounds nitrides and carbides are most widely investigated for tribological control (refs. 25, and 52 to 55).

During reactive sputtering or ion plating stable and metastable nitride and carbide compounds are formed by adjusting the partial pressure of the reactive gas such as N₂ or C₂H₂ respectively during the deposition. As a result, the change in stoichiometric composition of the respective compounds directly affects the hardness. Characteristic bulk and coating microhardness values reported in the literature are listed in table VI. Certainly, this large disparity in the hardness values is also reflected in the coefficient of friction as these coatings are tested in a pin-on-disc tribotester. Distinct differences in the coefficient of friction are reported depending whether both the steel disk and steel pin or only one of the tribo-components most likely the disk is coated. The high divergence in the coefficient of friction for steel/steel (0.45 - 0.55), ceramic coatings/steel (0.2 - 0.25), or ceramic coatings/ceramic coatings (0.08 - 0.18) systems are shown in figure 17.

At present TiN is by far the most widely investigated and used coating for tribological applications. A proposed phase diagram for titanium-nitrogen is shown in figure 18. The high variation in hardness values for TiNX from 1500 to 4000 kg/mm² can be related to the stoichiometric composition. It is interesting to note that the variation in hardness can be related to the stoichiometric and mixed phase structure and this is also reflected in a distinct color change (from light to dark yellow). This relationship is shown in figure 19, where hardness and color are shown as a direct function of the atomic ratio x = N/Ti. The maximum hardness of 4000 kg/mm² exists over an atomic ratio (x) within the range of 0.55 to 0.7 and consists of a mixed phase structure. The stoichiometric TiN film where X = 1 exhibits a microhardness of about 2000 kg/mm² which corresponds very closely to the bulk value. No systematic correlation of the change in atomic ratio to the friction and wear characteristics has been reported.

The mode of wear and friction behavior of the nitride and carbide coatings is affected by their adherence and coherence. Adhesive loss results in flaking and cohesive failure of the coating results in chipping. Of the many parameters which determine the operation of the coating when external loads are applied as in tribo-contact, the residual stress consideration suggests that the \( E\sigma \) product (\( E = \) Young's Modulus, \( \sigma = \) coefficient of thermal expansion) is a significant parameter in the choice of the coating/substrate system. Coatings possessing \( E\sigma \) products that more closely match those of the substrate are the preferred ones, since lower flow/substrate interfacial shear stresses are induced during the frictional testing.

CONCLUSIONS

The understanding of film deposition processes in plasma systems is still in its infancy. The deposition "models" described have a phenomenologically
qualitative character. There is insufficient information on plasma surface interactions, chiefly due to the fact that few experiments have been done with known fluxes of radicals on well-defined surfaces and little is known about synergetic effects in plasma. The bondings to the surfaces (chemical, Van der Waals and electrostatic) which dominates the tribological behavior of the film are still poorly defined. It would be most desirable to perform well defined surface experiments inside a plasma system.

REFERENCES

9. G. Turban; Plenary Lecture at the 6th ISPC, Proc., Vol. 1, (as in 8).


**TABLE I. - FRICTION COEFFICIENT DATA WITHOUT LUBRICATION AT LOW HUMIDITY (≤50 PERCENT) IN PLASMA SYSTEMS**

<table>
<thead>
<tr>
<th>Material pair</th>
<th>Friction coefficient</th>
<th>Deposition method</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Metal-ceramic</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>304 - TiN</td>
<td>0.75</td>
<td>ARE (25)</td>
</tr>
<tr>
<td>304 - TiC</td>
<td>0.42</td>
<td>ARE (25)</td>
</tr>
<tr>
<td>HSS - TiN</td>
<td>0.18</td>
<td>Ion-Plated (26a)</td>
</tr>
<tr>
<td>440C-Mo$_2$B$_5$</td>
<td>0.20</td>
<td>Sputtering (27)</td>
</tr>
<tr>
<td>440C-Mo$_2$Si$_2$</td>
<td>0.55</td>
<td>Sputtering (27)</td>
</tr>
<tr>
<td>Rene'41-TiC</td>
<td>0.4</td>
<td>Sputtering (27)</td>
</tr>
<tr>
<td>440C-Mo$_2$C</td>
<td>0.25</td>
<td>Sputtering (28)</td>
</tr>
<tr>
<td>440C-TiB$_2$</td>
<td>0.2</td>
<td>Sputtering (28)</td>
</tr>
<tr>
<td><strong>Ceramic-ceramic</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>TiC - TiN</td>
<td>0.05 - 0.2</td>
<td>ARE (25)</td>
</tr>
<tr>
<td>TiN - TiN</td>
<td>0.65</td>
<td>ARE (25)</td>
</tr>
<tr>
<td>TiN-(Ti$_2$N-TiN)</td>
<td>0.1 - 0.3</td>
<td>ARE (25)</td>
</tr>
</tbody>
</table>
TABLE II. - FLUXES AND RATES OF SPUTTERING, ETCHING AND DEPOSITION OF SILICON IN A MICROWAVE (2.45 GHz) PLASMA:

[Kinetic energy of Ar+ = 600eV, \(N_{1}Ar^{+} = 10^{11} \text{cm}^{-3}\), \(3Ar^{+} = 3.4 \times 10^{16} \text{cm}^{-2} \text{s}^{-1}\); \(J_{F_{2}}\) and \(J_{C_{12}}\) about \(10^{16} \text{cm}^{-2} \text{s}^{-1}\); \(5 \times 10^{-2} \leq P \leq 2.0 \text{torr}\); Si substrate grounded.]

<table>
<thead>
<tr>
<th>Plasma Flux (10^{16} \text{cm}^{-2} \text{s}^{-1})</th>
<th>Sputter Ar</th>
<th>Etch Ar+F_2</th>
<th>Etch Ar+C_2</th>
<th>Deposition Ar+SIF_4</th>
<th>Deposition Ar+SICl_4</th>
<th>Deposition Ar+SICl_4+H_2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rate (\text{nms}^{-1})</td>
<td>---</td>
<td>0.08</td>
<td>0.03</td>
<td>0.2</td>
<td>0.22</td>
<td>1.55</td>
</tr>
</tbody>
</table>

\(a\)Fluxes calculated (refs. 13 and 15); Rates (refs. 14 and 15) on Si single crystal.

\(5\) Vol \% SiF_4 in Ar (unpublished)

\(5\) Vol \% SiCl_4 in Ar (ref. 12) and, \(5\) Vol \% SiCl_4 + 15 Vol \% H_2 in Ar (ref. 12) deposit film microcrystalline Si at 0.5 and 2.9 torr.

TABLE III. - IONIZATION AND POLYMERIZATION DEGREES IN A RF PROPYLENE - ARGON PLASMA IN PB AND PL.

[Graphite Substrate Grounded: \(1 < P < 5\) torr.; 150 watt.]

<table>
<thead>
<tr>
<th>PB</th>
<th>PL</th>
</tr>
</thead>
<tbody>
<tr>
<td>(N_{1}/n^{a})</td>
<td>(3 \times 10^{-5})</td>
</tr>
<tr>
<td>(n \text{Polym}/n^{a})</td>
<td>(2 \times 10^{-5})</td>
</tr>
</tbody>
</table>

\(a\)concentration of \(C_{3}H_{6}\) in the gas mixture (16 Vol \% \(C_{3}H_{6}/Ar\).
TABLE IV. - FREE ENERGY OF FORMATION AT 500° C

[Handbook of Refractory Compounds, G. V. Samsonov and I. M. Vintskii IFI/Plenum NY (1980).]

<table>
<thead>
<tr>
<th>Boriding</th>
<th>Nitriding</th>
<th>Carburizing</th>
</tr>
</thead>
<tbody>
<tr>
<td>AF 773 K kcal.mole⁻¹</td>
<td>Tl+1/2 N₂ → TIN -63.0</td>
<td>Tl + C → TiC -41.9</td>
</tr>
<tr>
<td>Ti+2B → TiB₂ -68.0</td>
<td>V + 1/2 N₂ → VN -43.5</td>
<td>V + C → VC -11.3</td>
</tr>
<tr>
<td>2Ti+3B → Ti₂B₅ -99.5</td>
<td>B+1/2 N₂ → 2Cr₃N -26.5</td>
<td>7Cr+3C → Cr₇C₃ -46.4</td>
</tr>
<tr>
<td>V + 2B → VB₂ -60.0</td>
<td>B+1/2 N₂ → BN -18.5</td>
<td>2Fe+C → Fe₂C +2.0</td>
</tr>
<tr>
<td>Cr+2B → CrB₂ -30.2</td>
<td>A1+1/2 N₂ → BN -59.8</td>
<td>4B+C → B₄C -10.9</td>
</tr>
<tr>
<td>3Si+2N₂ → Si₃N₄ -117.8</td>
<td></td>
<td>Si+C → SiC -11.5</td>
</tr>
</tbody>
</table>

TABLE V. - ACTIVATION ENERGIES FOR SILICON AND SILICON DIOXIDE ETCHING BY FLUORINE IN A PLASMA SYSTEM


<table>
<thead>
<tr>
<th>Experimental conditions</th>
<th>Temperature range °C</th>
<th>Si etching activation energy</th>
<th>SiO₂ etching reaction probability at 25° C</th>
</tr>
</thead>
<tbody>
<tr>
<td>CF₄ + 0.2 plasma</td>
<td>300 - 500</td>
<td>1.1 + 0.2</td>
<td>2.4 x 10⁻⁵</td>
</tr>
<tr>
<td>CF₄ + 4 O₂ plasma</td>
<td>300 - 550</td>
<td>2.7 + 0.4</td>
<td></td>
</tr>
<tr>
<td>CF₄ plasma</td>
<td>300 - 500</td>
<td>3.1 + 0.4</td>
<td></td>
</tr>
<tr>
<td>F₂ plasma in the afterglow</td>
<td>240 - 400</td>
<td>2.5 + 0.1</td>
<td>1.66 x 10⁻³ Si(F)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2.1 x 10⁻⁵ SiO₂(F)</td>
</tr>
</tbody>
</table>
### TABLE VI. - MICROHARDNESS VALUES FOR NITRIDES AND CARBIDES

<table>
<thead>
<tr>
<th>Material</th>
<th>Vickers Hardness kg/mm²</th>
<th>Bulk</th>
<th>Films</th>
</tr>
</thead>
<tbody>
<tr>
<td>TiN</td>
<td>2000</td>
<td>1500-4000</td>
<td></td>
</tr>
<tr>
<td>ZrN</td>
<td>1500</td>
<td>700-3600</td>
<td></td>
</tr>
<tr>
<td>HfN</td>
<td>1600</td>
<td>1850-2400</td>
<td></td>
</tr>
<tr>
<td>VN</td>
<td>1500</td>
<td>600-2000</td>
<td></td>
</tr>
<tr>
<td>NbN</td>
<td>1400</td>
<td>1100-3000</td>
<td></td>
</tr>
<tr>
<td>TaN</td>
<td>1000</td>
<td>--------</td>
<td></td>
</tr>
<tr>
<td>Si₃N₄</td>
<td>1000-2000</td>
<td>2000-3000</td>
<td></td>
</tr>
<tr>
<td>TiC</td>
<td>3500</td>
<td>2770-4150</td>
<td></td>
</tr>
<tr>
<td>VC</td>
<td>2500</td>
<td>1900-2850</td>
<td></td>
</tr>
<tr>
<td>WC</td>
<td>2050</td>
<td>1800-2800</td>
<td></td>
</tr>
<tr>
<td>TaC</td>
<td>2200</td>
<td>1280-2200</td>
<td></td>
</tr>
</tbody>
</table>
Figure 1. - Luminous zone around a graphite substrate immersed in a RF plasma. (C$_3$H$_6$ + Ar at 500 watts power input).
Figure 2. - Schematic representation of plasma surface interaction.

Figure 3. - Coefficient of reflection of rare-gas ions from a clean tungsten surface (ref. 16).
Figure 4. - Secondary electrons ejected from a tungsten surface by rare gases and alkali ions.

(a) Energy distribution function (potential ejection). Tungsten; 10-eV ions.

(b) Yield (kinetic ejection). Molybdenum.
Figure 5. - Secondary ion mass spectrometry obtained for plasma nitriding of steels.

Figure 6. - Plasma bonding of stainless steel.
Figure 7. - Sputtering of dimers as a function of dimer bond energy. $P_{Ar} = 6 \times 10^{-2}$ torr; $RF$, 100 W, 13.56 MHz.

Figure 8. - Calculated values in sheath.
Figure 9. - Crosssection and ionization rate ratios in PL and PB.

Figure 10. - Spectral intensity versus distance in the PL from surface. Pressure, 1.0 torr; power, 100 W.
Figure 11. Spectral intensity ratios versus gas pressure, Power, 100 W.

Figure 12. Ion enhanced chemistry on silicon etching by Ar$^+$ + XeF$_2$.
Figure 13 - Ion-assisted gas-surface chemistry using $\text{Ar}^+$ and $\text{F}_2$ on aluminum (volatile reaction product). $\text{Ar}^+$ energy, 450 eV; $\text{Ar}^+$ current, 3.0 $\mu$A; $\text{F}_2$ flow, 0 (t < 270 sec); and $\text{F}_2$ flow, 2x10^{-2} mol/sec (t > 270 Sec).
Figure 14. - Silicon deposition, chlorine contamination, and its ion enhanced etching.
Figure 15. Deposition and etching rates in a CF₄ + H₂ plasma (ref. 14).

Figure 16. Silicon clusters sputtered out by Xe⁺ and Ar⁺ ions (ref. 17).
Figure 4. - Surface chemistry of nitrogen ions $\text{N}_2^+$ (ref. 15).

(a) $\text{N}_2^+$ dissociation to N atoms.

(b) N contained in the surface, WN (30-100 A); tungsten.

Figure 18. - Surface chemistry of F$_2$ on silicon (ref. 15).
Figure 19. Formation of active species from the microwave plasmas of 16 vol % C$_{6}$H$_{6}$ + Ar and 5 vol % SICl$_{4}$ + 20 vol % H$_{2}$ + Ar.
Figure 20. - Coefficient of friction as a function of coated and bare pin and disc combinations during tribo-testing. Steels, 440C and 52100; ceramic coatings, carbides and nitrides.

Figure 21. - Proposed phase diagram for titanium-nitrogen.
Figure 22. - Microhardness, color and phases of TiN_x as a function of nitrogen stoichiometric composition.