Unclassified
SECURITY CLASSIFICATION OF THIS PAGE

AD-A216 668

REPORT DOCUMENTATION PAGE

unclassified	1b RESTRICTIVE MARKINGS
2a SECURITY CLASSIFICATION AUTHORITY	3 DISTRIBUTION/AVAILABILITY OF REPORT: Approved for public release. Distribution unlimited.
2b DECLASSIFICATION/DOWNGRADING SCHEDULE	
4 PERFORMING ORGANIZATION REPORT NUMBER(S): Technical Report Number 16	5 MONITORING ORGANIZATION REPORT NUMBER(S): Office of Naval Research
6a NAME OF PERFORMING ORGANIZATION: University of Massachusetts; 6b OFFICE SYMBOL (If applicable)	7a NAME OF MONITORING ORGANIZATION: Office of Naval Research
6c ADDRESS (City, State, and ZIP Code): Dept. of Chemistry, Univ. of Massachusetts, Amherst, MA 01003	7b ADDRESS (City, State, and ZIP Code): 800 N. Quincy Street, Arlington, VA 22217
8a NAME OF FUNDING/SPONSORING ORGANIZATION: Office of Naval Research; 8b OFFICE SYMBOL (If applicable)	9 PROCUREMENT INSTRUMENT IDENTIFICATION NUMBER: N00014-86-K-0345
8c ADDRESS (City, State, and ZIP Code): 800 N. Quincy St., Arlington, VA 22217	10 SOURCE OF FUNDING NUMBERS: PROGRAM ELEMENT NO; PROJECT NO; TASK NO; WORK UNIT ACCESSION NO

11 TITLE (Include Security Classification)
Metal Coordination Polymers as Potential High-Energy Lithographic Resists (unclassified)

12 PERSONAL AUTHOR(S)
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13a TYPE OF REPORT	13b TIME COVERED	14 DATE OF REPORT (Year, Month, Day)	15 PAGE COUNT
Preprint	FROM _____ TO _____	89 05 15	10

16 SUPPLEMENTARY NOTATION
To appear in Volume 61 of Polymeric Materials Science and Engineering, Sept. 1989

17 COSATI CODES		
FIELD	GROUP	SUB-GROUP

18 SUBJECT TERMS (Continue on reverse if necessary and identify by block number)
metal coordination polymers, lithographic resists, cobalt polymers, chromium polymers, positive resists, beta-diketones

19 ABSTRACT (Continue on reverse if necessary and identify by block number)

Over the past few years we have developed a number of linear coordination polymers which have interesting properties. One type of study has centered on polymers which would provide sensitive lithographic resists based on the fact that the photoelectric effect interacts with nuclei approximately to the fourth power of the atomic number. We have prepared a number of uranyl carboxylate polymers which are very sensitive to gamma and electron beam radiation with G_s values higher than any currently available resist material [Archer, Hardiman, & Lee, 1987]. We have extended this work to cobalt and chromium coordination polymers as well. Coordination polymers of other metals are also under development.

20 DISTRIBUTION/AVAILABILITY OF ABSTRACT	21 ABSTRACT SECURITY CLASSIFICATION
☒ UNCLASSIFIED/UNLIMITED ☒ SAME AS RPT ☐ DTIC USERS	Unclassified
22a NAME OF RESPONSIBLE INDIVIDUAL: Dr. Kenneth Wynne	22b TELEPHONE (Include Area Code): (202) 9696-4409; 22c OFFICE SYMBOL

DD FORM 1473, 84 MAR — 83 APR edition may be used until exhausted. All other editions are obsolete.

SECURITY CLASSIFICATION OF THIS PAGE
Unclassified

OFFICE OF NAVAL RESEARCH

Contract No. N00014-86-K-0345

R & T Code 413c028

TECHNICAL REPORT NO. 16

METAL COORDINATION POLYMERS AS POTENTIAL HIGH-ENERGY LITHOGRAPHIC RESISTS

by

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Accepted for Publication
in

Polymeric Materials Science and Engineering
Volume 61, September 1989

May 15, 1989

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INTRODUCTION

High energy radiation can modify polymers by causing cross-linking and/or degradation. One particularly interesting application is the use of polymers as photo- or electron-resists in lithography (1). Higher density integrated circuit chips have allowed metal oxide semiconductor random access memory device capacity to increase by several orders of magnitude in the recent past with minimum feature size of less than one micron at present. Further reductions are in progress, but diffraction effects will eventually limit the resolution of visible and ultraviolet sensitive resists. However, higher energy electron beams, X-ray, gamma ray, and ion-beam systems can provide the necessary resolution required for submicron resolution. But organic polymers have limited sensitivity to higher energy radiation with G values (chemical events/100 eV absorbed) typically not much greater than one, though sulfur containing organic polymers with G values of about 10 are known. We are using a combination of high G value polymers together with heavy metal atoms (which provide an increased absorption of energy through the photoelectric effect's approximately Z^4 power dependence, where Z = atomic number (2), Figure 1) in order to develop polymers which are very sensitive to high energy radiation (3,4). Whereas the advantage of heavy metal atoms is quite apparent from the uranyl species which we have studied--G_s values of 50 and up even at 662 keV, in the usual 10 - 20 keV range of electron beam studies, 3d-transition-metal polymers should have a tremendous advantage over simple organic polymers. Therefore, in order to get the advantage of the heavier atoms together with the sensitivity of the organic polymers containing sulfide and sulfone bridges, we have synthesized several cobalt(III) coordination polymers, one of which was briefly described earlier (5,6). The general synthesis for three polymers derived from leucinatobis(2,4-pentanedionato)cobalt(III), $Co(leu)(acac)_2$, is shown in equations 1 to 3.

$$Co(NO_2)_6^{3-} + 2\ acac^- \longrightarrow \textit{trans}\text{-}[Co(acac)_2(NO_2)_2]^- + 4\ NO_2^- \quad (1)$$

where $acac^-$ is the anion of 2,4-pentanedione,

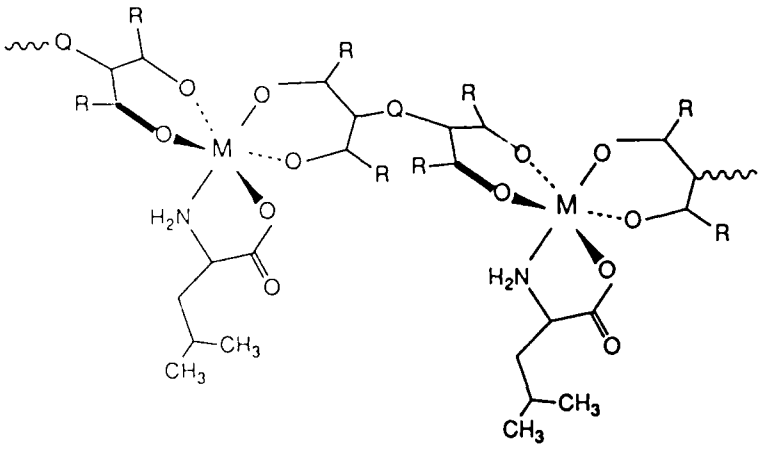
$$[Co(acac)_2(NO_2)_2]^- + leu^- \xrightarrow[\text{Norit A}]{} Co(leu)(acac)_2 + 2\ NO_2^- \quad (2)$$

where leu^- is the anion of leucine,

$$Co(leu)(acac)_2 + QCl_2 \longrightarrow [\text{-acacCo(leu)acac-Q-}]_n + 2\ HCl \quad (3)$$

where Q = S, S_2, or SO, and bridges the beta-diketones from adjacent units in the polymer chains. The corresponding sulfone polymer can be synthesized from the oxidation of the sulfoxide polymer with hydrogen peroxide.

$$[\text{-acacCo(leu)acac-SO-}]_n \xrightarrow[H_2O_2]{} [\text{-acacCo(leu)acac-}SO_2\text{-}]_n \quad (4)$$



Part of typical polymer chain, Q = S, SS, SO, SO_2, M = Co, R = CH_3

As noted below, the cobalt(III) coordination polymers have excellent G_S values, where G_S is the G value for scission. On the other hand, they appear to undergo cleavage only at the C-S and S-S bonds when irradiated at high energy, rather than at the cobalt centers [which would be expected in the ultraviolet region, where cobalt(III) to cobalt(II) charge transfer chemistry occurs for cobalt(III) beta-diketone complexes (7)]. In fact, other than the sulfoxo species, they all appear to have G_S values at least as high as any organic polymers. Coupled with the higher amount of energy absorbed for identical films and their good adhesion to silica-coated silicon, these species have excellent resist potential. In response to the concern of resist special-ists about residual metal ions, it is gratifying to note that no detectable free cobalt ions can be observed after several megarads of irradiation at high energies, either for the monomer or the polymer. This observation led us to consider the more volatile fluorinated chromium(III) beta-diketonates. Progress with the chromium species is also noted herein, though this work has not proceeded as far as the cobalt(III) studies.

EXPERIMENTAL

Solvents and ligands were carefully dried prior to use. Sulfur dichloride and sulfur monochloride were purified just prior to use by appropriate literature methods (8,9).

(S-Leucinato-*N*,*O*)bis(2,4-pentanedionato-*O*,*O'*)cobalt(III).--This neutral complex was prepared by the method of Laurie (10). Yields of 20 - 29% of pure Co(leu)$(acac)_2$ were obtained from the reaction between Na[*trans*-$(acac)_2(NO_2)$] and Na[S-(leu)] after column chromatography, rotary evaporation and recrystallization.

Anal. Calcd for $C_{16}H_{26}NO_6Co$: C, 49.6; H, 6.8; N, 3.6. Found: C, 49.5; H, 6.7; N, 3.6.

(S-Leucinato-*N*,*O*)bis[2,2,6,6-tetramethyl-3,5-heptanedionato-*O*,*O'*)cobalt(III).--An analogous reaction between the corresponding 2,2,6,6-tetramethylheptanedionate (or dipivaloylmethanate, dpm), but at much lower concentrations due to limited solubility in water, provided a 15% yield of the intermediate product and a 25% yield of the final Co(leu)$(dpm)_2$ product. FT-NMR carbon-13 results are in agreement with the formulation given.

Anal. Calcd for $C_{28}H_{50}NO_6Co$: C, 60.5; H, 9.1; N, 2.5. Found: C, 60.3; H, 9.0; N, 2.5.

Poly((S-leucinato-*N*,*O*)-u-[3,3'-dithiobis(2,4-pentanedionato-*O*,*O'*)]cobalt(III)).--The dropwise addition of 1.7460 g disulfur dichloride (12.93 mmol) in 6 mL dry dichloroethane to 5.0088 g Co(leu)$(acac)_2$ in 20 mL dimethylacetamide (DMAC) with 0.7095 g sodium carbonate (6.69 mmol) as a slurry in the dimethylacetam-ide solution under argon and with vigorous stirring. The mix-ture was stirred for 24 - 36 hr and then precipitated with diethyl ether. Alternatively, the solvent was

removed *in vacuo* at 45°C. The product was collected on a fritted funnel, washed with water, and dried *in vacuo* at 100°C; yield, 5.5 g; 95%. The polymer was fractionated (three times) by a DMAC/acetone or di-methyl sulfoxide/acetone solvent/nonsolvent precipitation to re-move low molecular-weight material.

Anal. Calcd for $[C_{16}H_{24}NO_6S_2Co]_n$: C, 42.8; H, 5.4; N, 3.1; S, 14.3. Found: C, 42.5; H, 5.1; N, 2.9; S, 14.2.

Poly((S-leucinato-*N,O*)]-u-[3,3'-thiobis(2,4-pentanediona-to-*O,O'*)]cobalt(III)).--The dropwise addition of 0.7592 g sulfur dichloride (7.37 mmol) in 6 mL dry dichloroethane to 2.8514 g $Co(acac)_2(leu)$ (7.36 mmol) in 60 mL dichloroethane or di-chloro-methane under argon with vigorous stirring. After 24 hr of stirring HCl and the solvent were removed *in vacuo*, washed with water, and dried *in vacuo* at 100°C; yield, 2.76 g; 90%. The polymer was fractionated by an acetone/water fractional precipitation.

Anal. Calcd. for $[C_{16}H_{24}NO_6SCo]_n$: C, 46.0; H, 5.8; N, 3.4; S, 7.7. Found (from $C_2H_4Cl_2$): C, 45.4; H, 5.7; N, 3.0; S, 7.3. Found (from CH_2Cl_2): C, 45.9; H, 5.6; N, 2.8; S, 7.5.

(The use of more polar solvents such as acetonitrile with an acid acceptor proved less satisfactory with SCl_2 than with S_2Cl_2 above.)

Poly(S-leucinato-*N,O*)-u-[3,3'-sulfoxobis(2,4-pentanediona-to-*O,O'*)]cobalt(III)}.--The dropwise addition of 0.9213 g thionyl chloride (7.74 mmol) in 4 mL dry dichloroethane to 2.9925 g $Co(acac)_2(leu)$ in 10 mL dimethylformamide and 15 mL dichloroethane under argon with vigorous stirring at 0°C. The mixture was then allowed to stir for at least 24 hr. The solvent and any residual HCl was removed at 45°C *in vacuo*, and the product was dried at 100°C; yield, 3.13 g; 93%. The polymer was fractionated with an acetone/water fractional precipitation.

Anal. Calcd for $[C_{16}H_{24}NO_7SCo]_n$: C, 44.3; H, 5.6; N, 3.2; S, 7.4. Found: C, 44.1; H, 5.3; N, 3.8; S, 6.9.

Poly(S-leucinato-*N,O*)-u-[3,3'-sulfonebis(2,4-pentanediona-to-*O,O'*)]cobalt(III)}.--The dropwise addition of 0.10 mL hydrogen peroxide to 0.0603 g fractionated sulfoxide polymer in 10 mL acetonitrile with vigorous stirring. The mixture was heated to 40°C and stirred for 24 hr. The solvent was removed *in vacuo* at 40°C, and the sample was then dried *in vacuo* at 100°C

Anal. Calcd for $[C_{16}H_{24}NO_8SCo]_n$: C, 42.8; H, 5.4; N, 3.1; S, 7.1. Found: C, 41.0; H, 5.6; N, 3.4; S, 6.9.

Poly((111-trifluoro-2,4-pentanedionato-*O,O'*)chromium(III)-u-[3,3'-thiobis(2,4-pentanedionato-*O,O'*)), Cr(tfa)($acac_2$S).--The synthesis of this polymer has been based on the reaction of $Cr(tfa)(acac)_2$, which was prepared by the method of Palmer, Fay and Piper (11) with SCl_2 (exact 1:1 mole ratio) in methylene chloride at -10°C. The infrared spectra and the intrinsic viscosity of 0.17 dL/g for the product are consistent with polymerization though the GPC results were less conclusive.

Physical Characterizations.--Gel permeation chromatography, viscosity, scribe-stripping, nuclear magnetic resonance, infrared, and ultraviolet-visible measurements were performed as reported earlier (12). Electron spin resonance spectroscopy measurements were made with an IBM ESP 300 instrument with quartz tubes sealed *in vacuo* prior to irradiation. To remove color centers from the quartz, one end of the tube was heated with a torch while the other was immersed in liquid nitrogen. The sample was then reversed and the process repeated.

Polymer Irradiation.--Samples of the polymers sealed *in vacuo* were exposed to cesium-137 gamma irradiation (662 KeV) at doses ranging from 0.02 to 0.07 Mrad/hr.

RESULTS AND DISCUSSION

Linear coordination polymers of cobalt(III) have been prepared from the reactions of Co(leu)(acac)$_2$ with SCl_2, S_2Cl_2, and $SOCl_2$. The solvents chosen for the different reactions have been determined from a knowledge of the reactivity of the sulfur halides, from the need for solubility throughout the polymerization reaction, and by trial and error. The sulfone polymer was prepared by hydrogen peroxide oxidation of the sulfoxide polymer. Several properties of the polymers are provided in Table 1.

Table 1. Linear cobalt(III) polymers derived from Co(leu)(acac)$_2$

Bridge[a]	M_n(GPC)[b]	M_n(NMR)[c]	Visc[d]	UV/Vis[e]	TGA[f]	Infrared[g]
-S-S-	34,000	≥13,000	0.11	280/553	180°C	h,i
-S-	13,500	≥15,000	0.10	279/546	160°C	h,i
-SO-	16,000	-	-	276/553	-	1025[h,i]
-SO_2-	17,000	≥10,000	0.084	279/548	190°C	1160[h,i]

[a]replaces gamma hydrogens of acac's; [b]NMP solvent; polystyrene standards; [c]based on FT-NMR of weak gamma proton signal in DMSO-d_6; [d]intrinsic viscosity, dL/g in NMP at 30°C; [e]nm, molar extinction coefficients about 10^4 and 10^2 $M^{-1}cm^{-1}$ per repeating unit; [f]temperature of first major weight loss; [g]cm^{-1}; [h]780 cm^{-1} monomer gamma C-H mode not observed; [i]1550 cm^{-1} peak replaces two peaks observed at 1570 and 1520 cm^{-1} in monomer.

The number-average molecular weights may be higher than the NMR values because the gamma proton signals (one proton per chain is expected) are still at the noise level after several thousand transients. However, the viscosity of the dithio polymer is more like that expected for the NMR molecular weight value than for the GPC one.

The irradiation of these cobalt polymers with 662 keV gamma rays provides approximate G_s values of 18, 10, 0.4, and 60 for the dithio, thio, sulfoxo, and sulfone polymers, respectively, when Charlesby's equation (13) is used along with GPC molecular weight results. Whereas these values might seem quite high, polybutylene sulfone (PBS) has been reported to have G_s values of 12.2 and 23.7 *in vacuo* and in air, respectively (14). However, since the mass absorption coefficient for the more massive cobalt unit is 3.6 times that of PBS, the value we have obtained is reasonable. The electron spin resonance spectra of the irradiated polymers suggest radicals centered primarily on the sulfur atoms, with about 5% delocalization to the cobalt centers based on the hyperfine structure of the dithio and thio polymers. No hyperfine splitting is observed for the sulfone polymer, and the monomer shows no ESR signal at all. This varifies the observation that no spectral change is observed for extensive cobalt-60 irradiation of the monomer in methanol solutions. Evidence for SH peaks about 2500 cm^{-1} has been obtained by Fourier transform infrared spectroscopy after irradiation. Also, a loss in the intensity of the symmetrical SO_2 stretch near 1160 cm^{-1} after irradiation has been observed for the sulfone polymer. These results coupled with our ability to make films of the dithio polymer on silicon wavers which have oxidized surfaces looks encouraging. Unfortunately, the films peel from the surface when treated with the solvent combinations we have used in an attempt to determine the sensitivity to electron beams.

We have also expanded our studies to include chromium(III) systems. However, for the chromium centers we have chosen the more volatile trifluoro (tfa^-) and hexafluoro (hfa^-) derivatives of 2,4-pentatedione. Since the fluorinated derivatives are deactivated relative to the electrophilic attack used in these polymerizations, the Cr(acac)$_2$(tfa) mixed ligand complex has been used initially to obtain polymeric products with sulfur halides.

We have also nitrated the $Cr(acac)_2$-(tfa) complex and reduced the nitro groups to amines to provide links with organic oligomers. Unfortunately, the first nitro together with the trifluoro group deactivates the system such that no dinitro product can be obtained.

SUMMARY

Four cobalt polymers have been synthesized, three of which are very sensitive to gamma irradiation with resulting G_s values which exceed any known organic polymers. Furthermore, the cobalt is not released during the scission reactions. Films which adhere well enough for commercial use have not yet been obtained for the cobalt systems.

Acknowledgement.--The authors acknowledge the support of the Office of Naval Research for this reseach.

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