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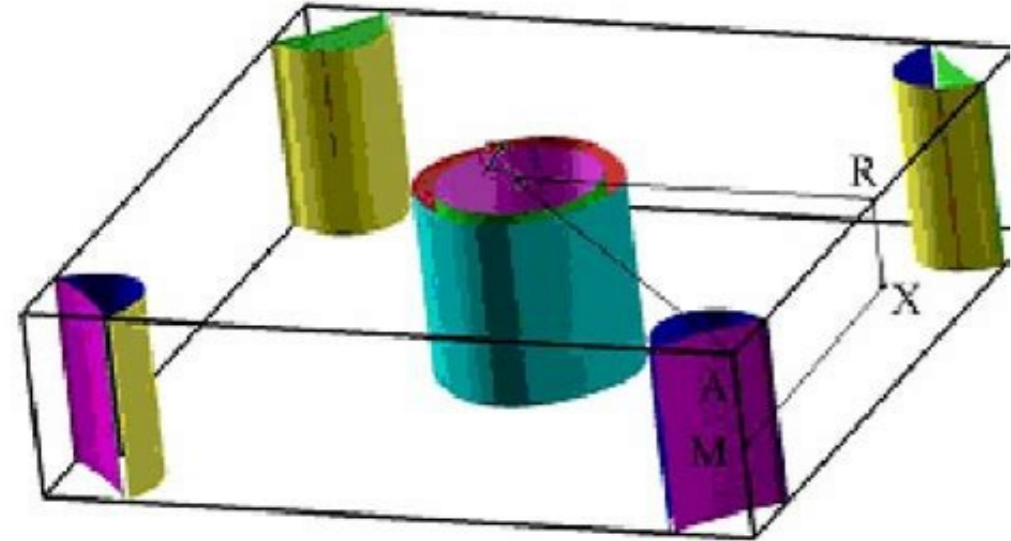
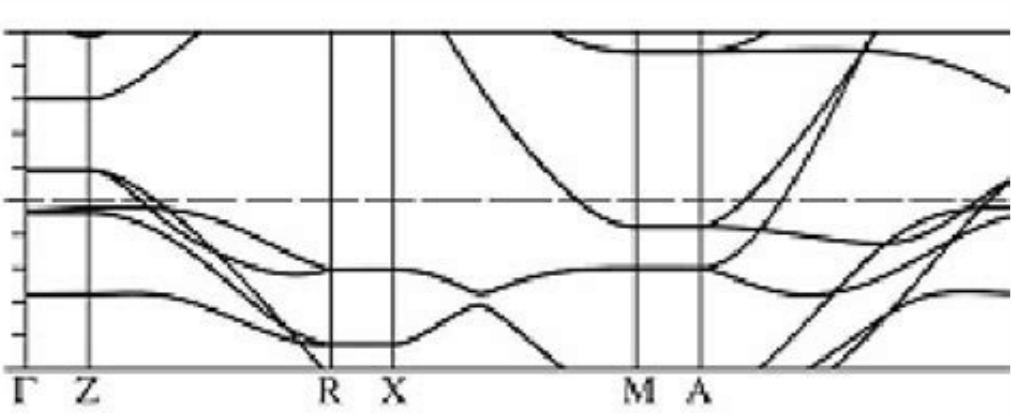
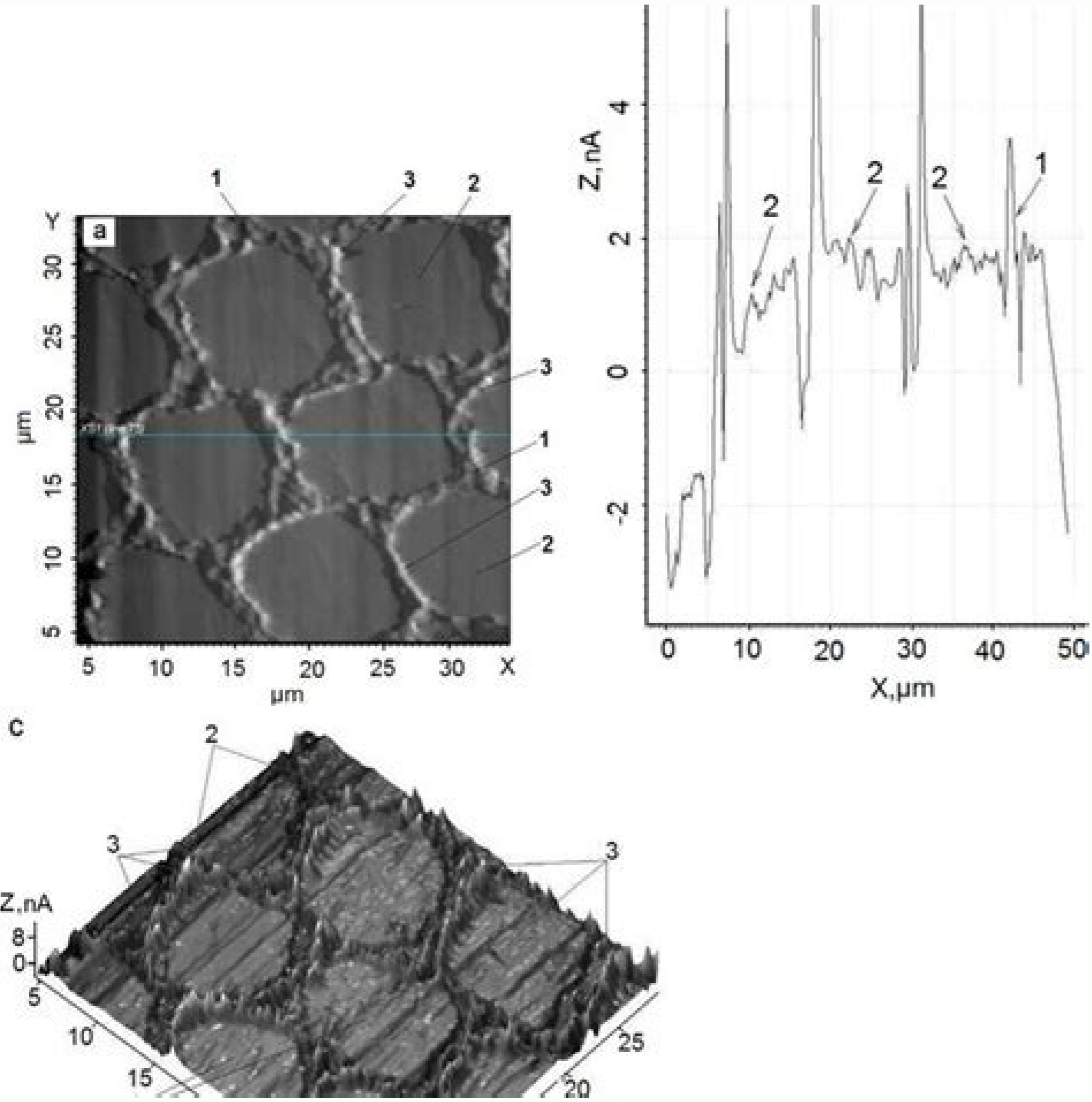
cost over silicon, or (b) where GaAs devices possess a unique material property or processing advantage providing gains in performance, reliability, and cost as in the Schottky-barrier avalanche oscillator, or (c) where one just cannot make the desired device with silicon, as in the case of transferred electron oscillators and amplifiers.

In addition to the above competitive consideration, it would appear that the most pressing material problem in designing and fabricating GaAs microwave devices is not one of feasibility of performance of a given device, but rather one of reliability and high yield. Thus, crystal growth techniques for producing the substrate material, the active epitaxial layer, and ohmic contacts have not been refined to ensure adequate control over such important material parameters as crystal defect density, impurity concentration, and electrical junction profiles and characteristics. Moreover, there is a problem of insufficient data on correlation between device performance and materials properties.

5.5.4 Recommendations

The most pressing materials problems where current research is needed are in the areas of compositional uniformity and control of impurity doping. These are directly concerned with refinements in crystal growth techniques and material purity and perfection. Associated with these problems is a need for better understanding of band structure and, in particular, impurity and trapping levels. This information can lead to improved characterization and uniformity of materials resulting in higher breakdown voltages. Control of impurity concentration will improve yield and reduce costs, and provide improved device efficiency, lower noise figures, and broader bandwidth capability. As already indicated, underlying all of these immediate goals is a need for a definitive correlation of device performance with the properties of both the GaAs substrate and epitaxial layer. This correlation is complicated by the difficulty of comparing devices made by different methods currently used by fabricators of these devices.

Long-range research is needed in the exploration of new materials as well as in further advancing GaAs materials and process technology. A very interesting new microwave material is the InAs_{0.5}P_{0.5} alloy system, which has two potential areas of application. The first is TEQ devices with larger peak-to-valley ratios and, hence, higher efficiencies. Alloys with 80-100 percent InP have peak-to-valley ratios exceeding those of GaAs, and, because of their 3-level band structure, could provide a new transferred-electron mode independent of transit time. The second application is in high frequency FET devices. Here



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GaAs mixer diodes are used throughout the microwave and millimeter portions of the spectrum. GaAs Schottky-barrier mixer diodes are comparable in performance to silicon diodes in the 2-10 GHz region, but at millimeter frequencies they are used exclusively because of their superior noise- and conversion-loss characteristics. It would appear that there are no major problems in the fabrication of these mixer diodes. The same can be said for GaAs tunnel diodes.

GaAs variable capacitance (Varactor) diodes have already been used as low noise rf amplifiers or as nonlinear elements in frequency multiplication channels for digital communications systems. A more recent application under consideration for these diodes is for television UHF tuning, particularly because they have a significantly lower insertion loss than their silicon counterpart. GaAs varactor diodes have been fabricated by vapor phase growth techniques which result in the best combination of reverse breakdown voltage (80-100 V) and cut-off frequency (150-250 GHz) at -6 V and a junction capacitance of 0.3 to 0.7 pF. This may be compared to typical values of 40 V and 160 GHz with diodes made from GaAs crystals grown from the melt, subsequently processed to produce rectifying junctions by conventional diffusion techniques. These superior characteristics can be directly attributed to accurate control of the electrical properties of the material in the diode structure, as well as to the preparation of defect-free and abrupt rectifying $n-p$ junctions that minimize the effect of microplasma discharge.

5.5.3 Major Problems

As already indicated, GaAs microwave devices are in direct competition with silicon devices over the entire microwave frequency spectrum. Therefore, one of the major problems is the fast-moving target of silicon processing technology in the areas of epitaxial crystal growth, subtractive processes by selective etching and machining, solid state diffusion, and surface chemistry and material technologies with are so powerful in making sophisticated device structures with superior performance, high yield and eventually lower cost. The double drift IMPATT oscillator, which cannot yet be made with GaAs is a classic example of this. Thus, GaAs materials technology is still far behind; and there is a need to close the gap if one is to capitalize on the superior intrinsic electrical properties of GaAs. Resources should be allocated to those applications (a) where the GaAs devices would provide a very significant improvement in performance over silicon devices, e.g., low noise or improved efficiency suffice to justify any additional device

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