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(54) **SEMICONDUCTOR MODULE WITH COOLING MECHANISM AND PRODUCTION METHOD THEREOF**

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(52) **U.S. Cl. 257/713; 438/122; 257/E23.08; 257/E21.499**

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(57) **ABSTRACT**

A semiconductor module is provided which includes a semiconductor unit which is made by a resin mold. The resin mold has formed therein a coolant path through which a coolant flows to cool a semiconductor chip embedded in the resin mold. The resin mold also includes heat spreaders, and electric terminals embedded therein. Each of the heat spreaders has a fin heat sink exposed to the flow of the coolant. The fin heat sink is welded to a surface of each of the heat spreaders through an insulator, thus minimizing an electrical leakage from the heat spreader to the coolant.

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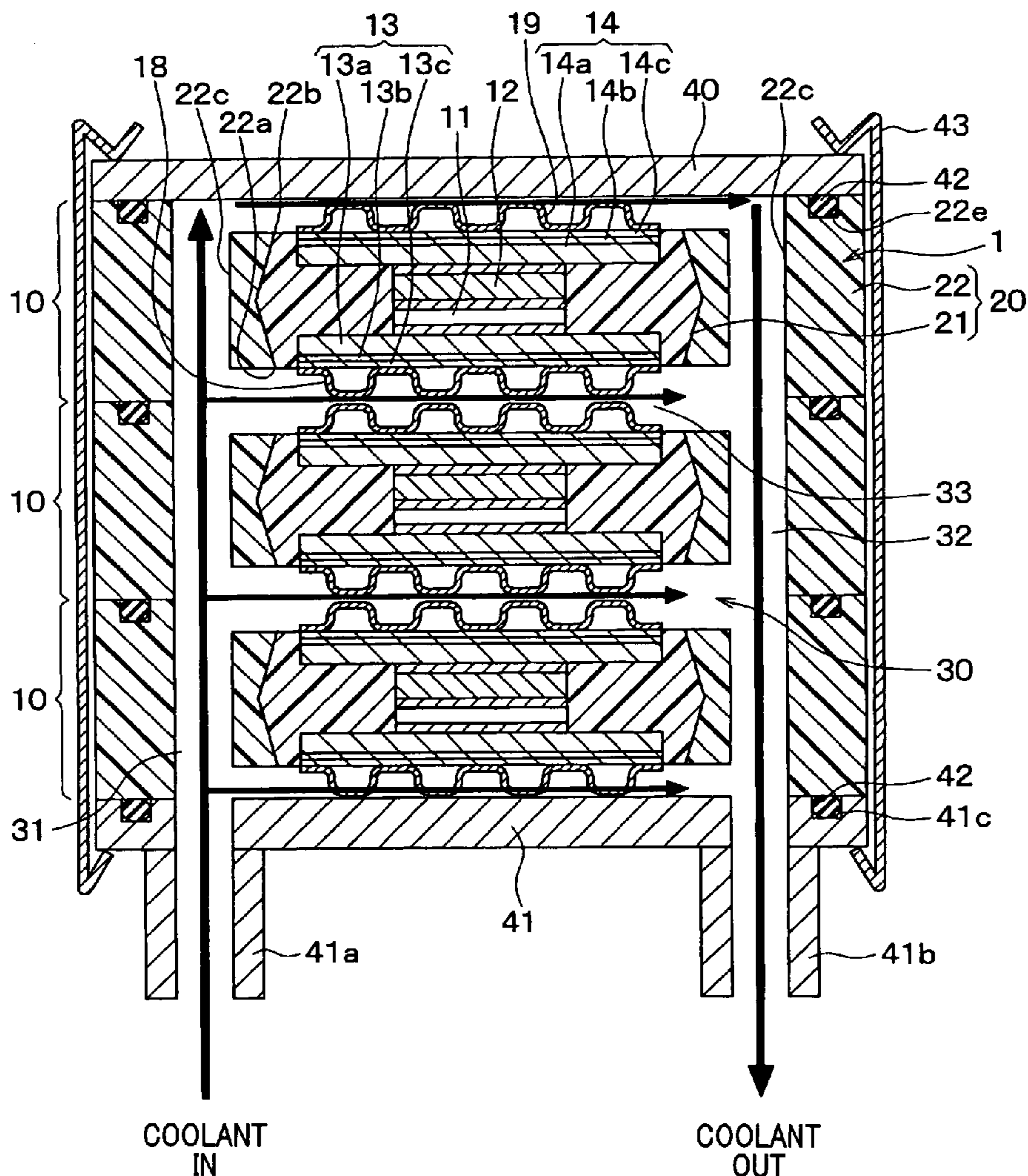


FIG. 1

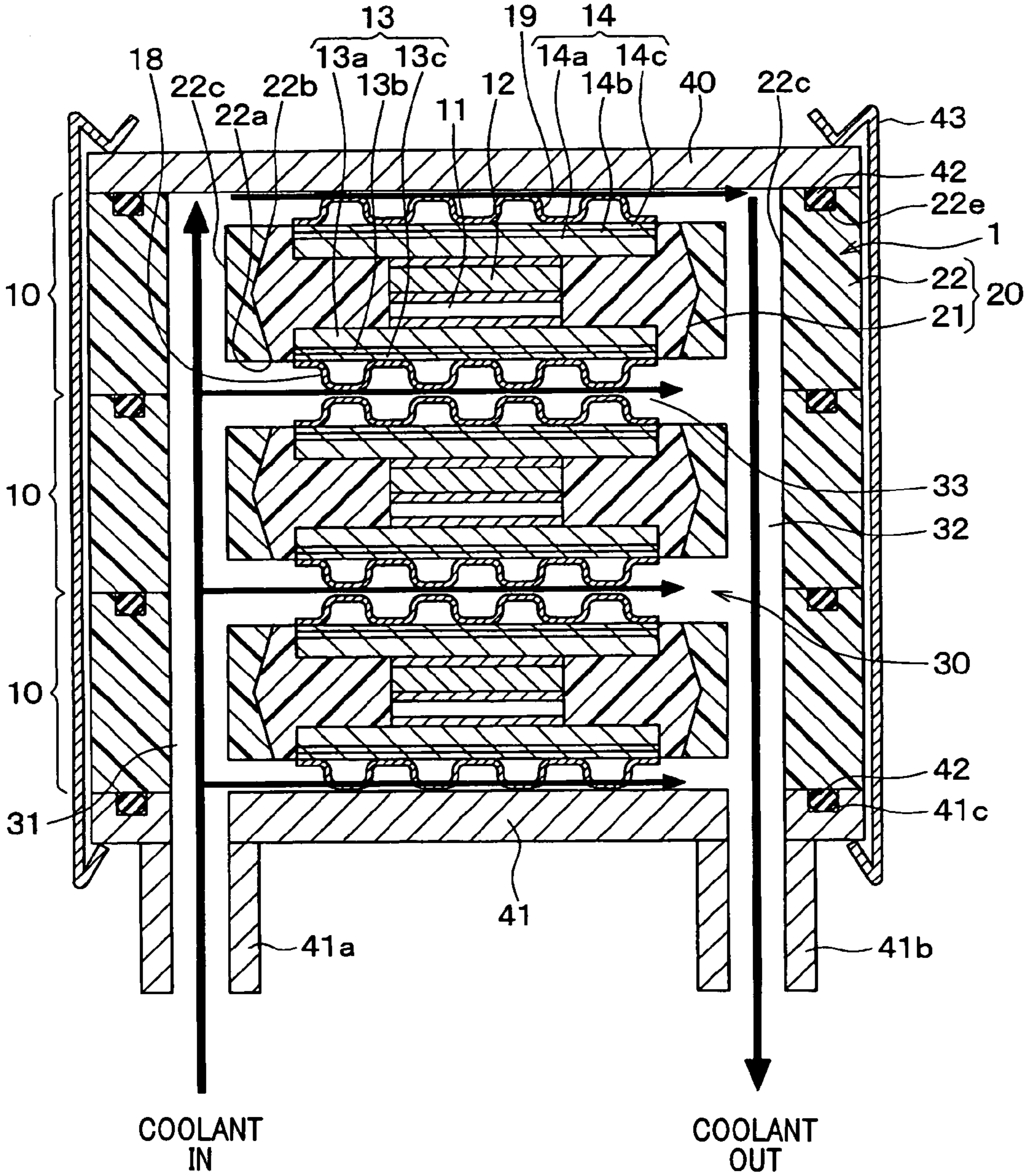


FIG.2(a)

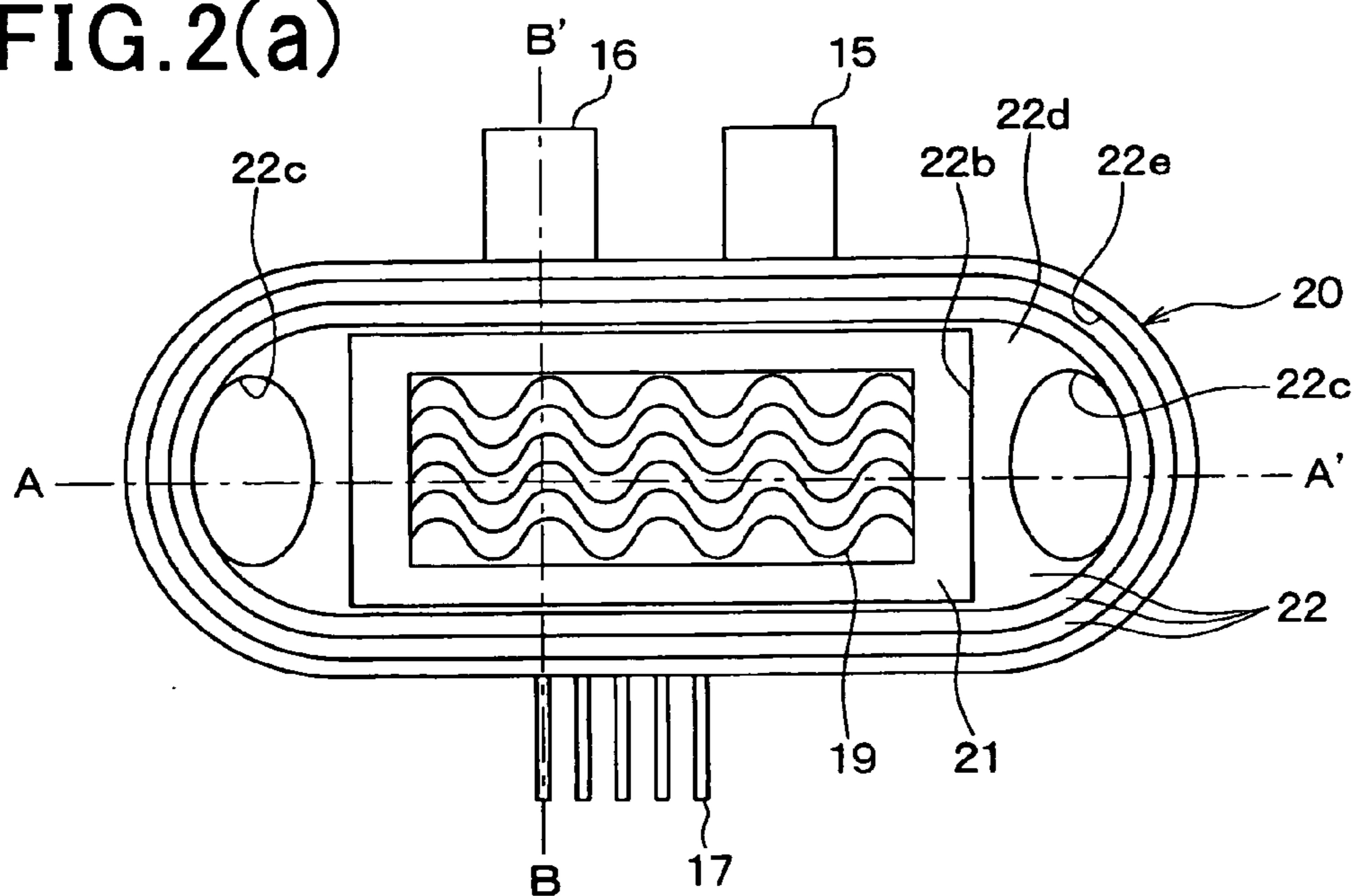


FIG.2(b)

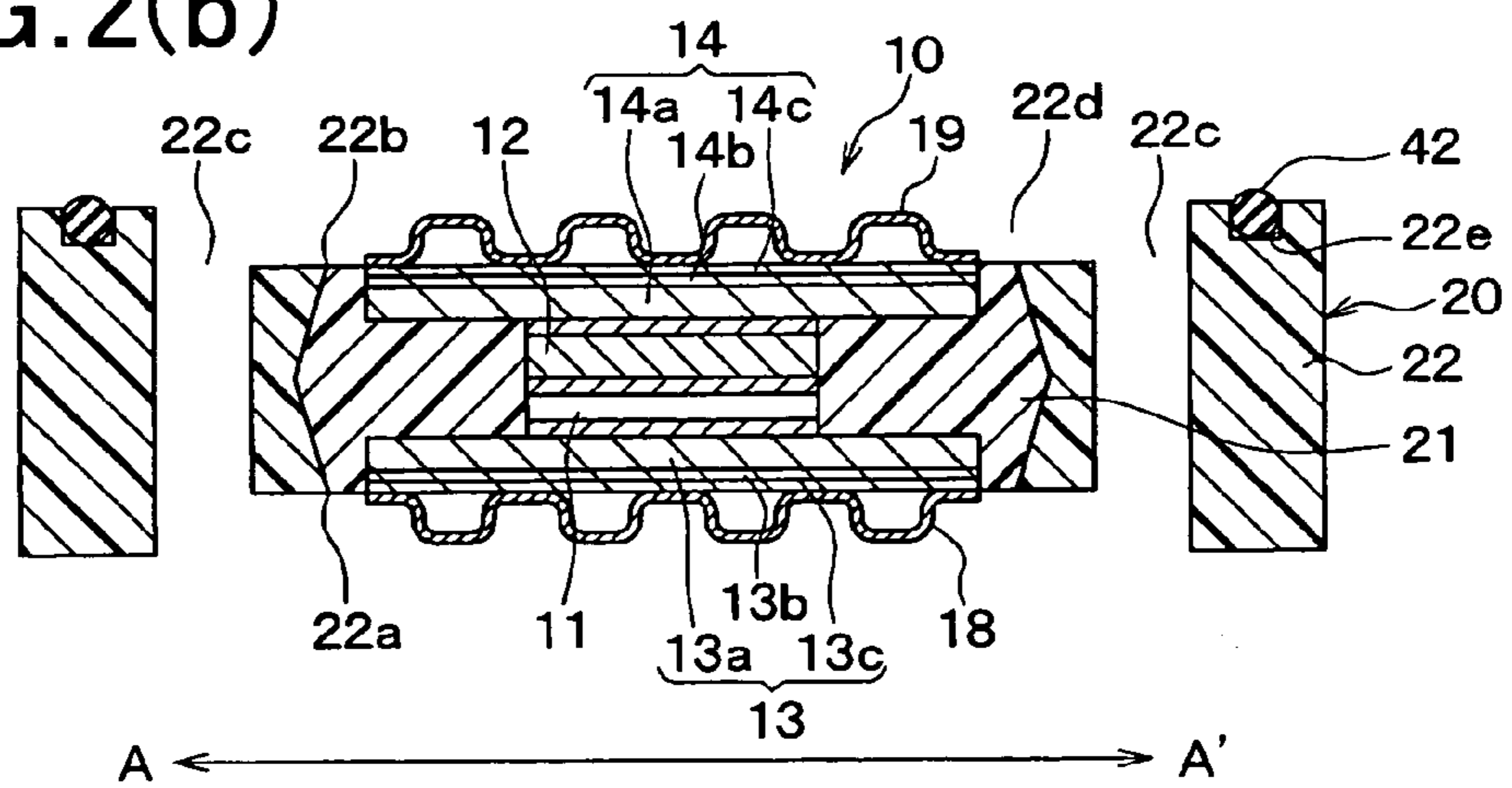


FIG.2(c)

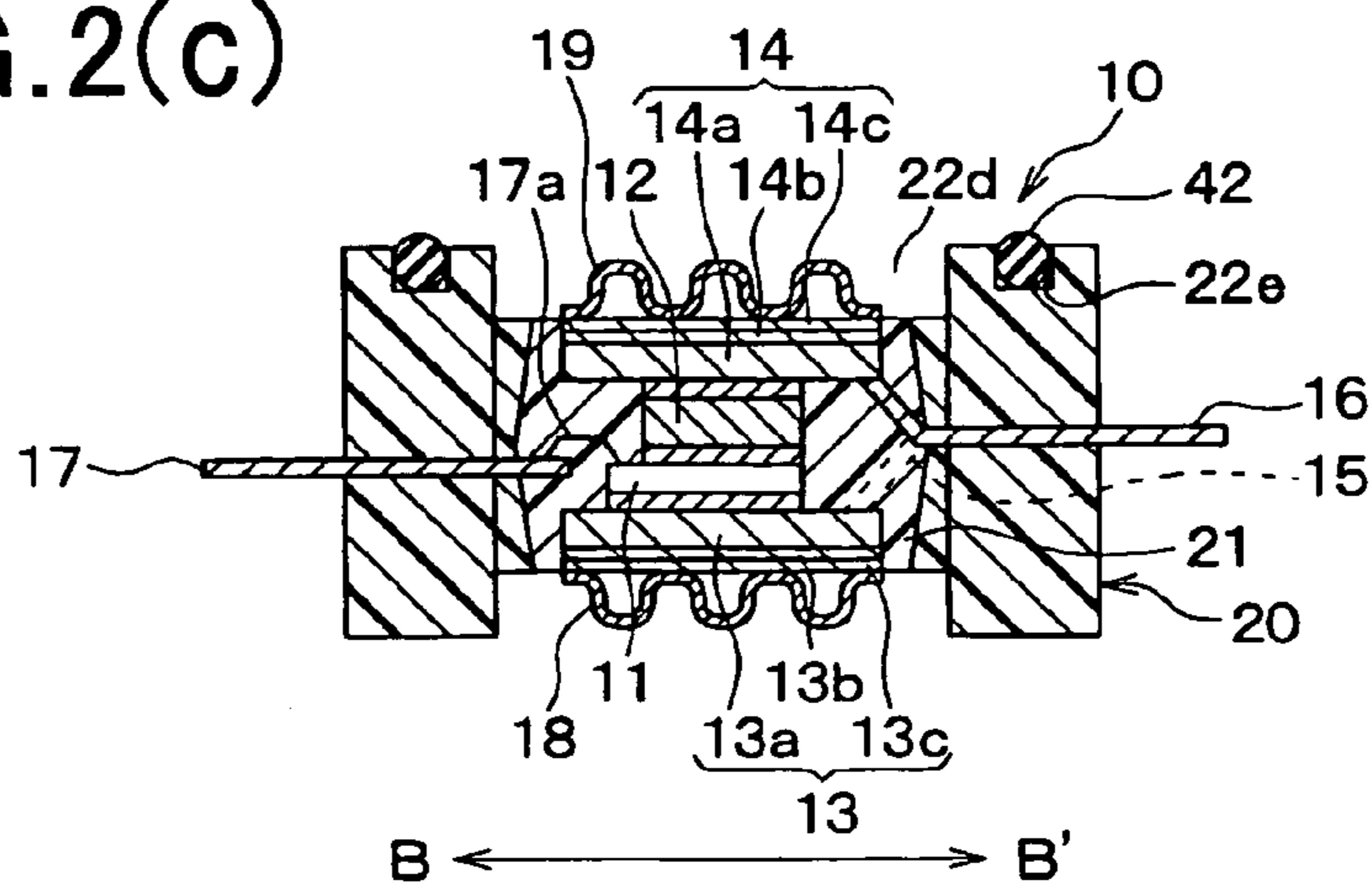


FIG. 3(a)

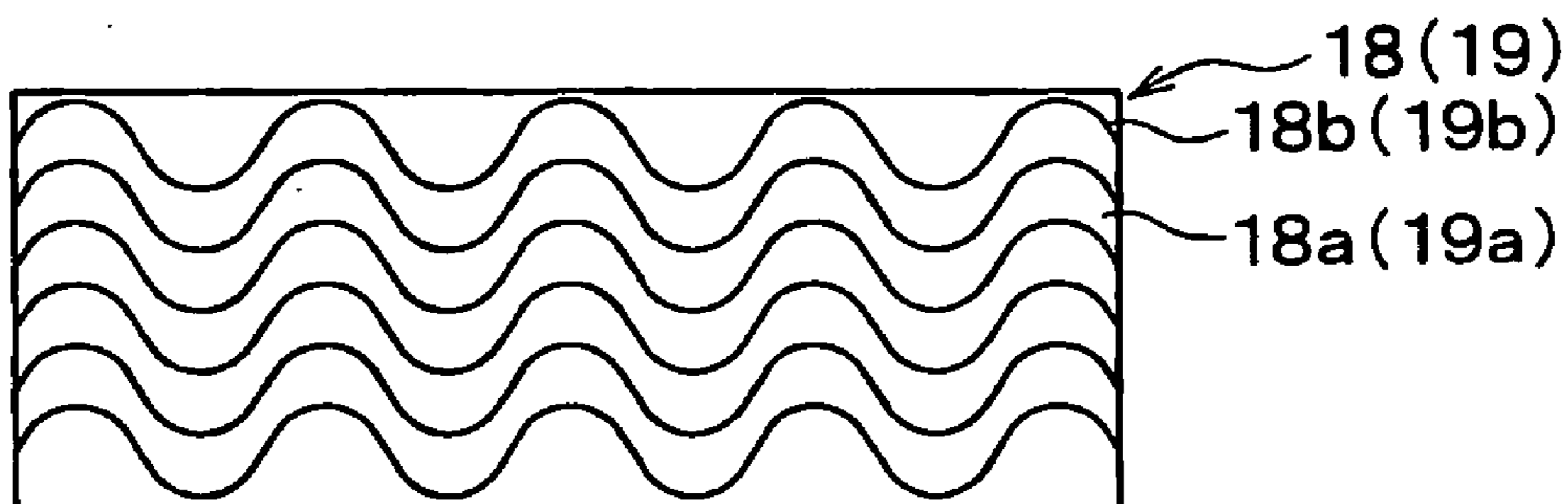


FIG. 3(b)

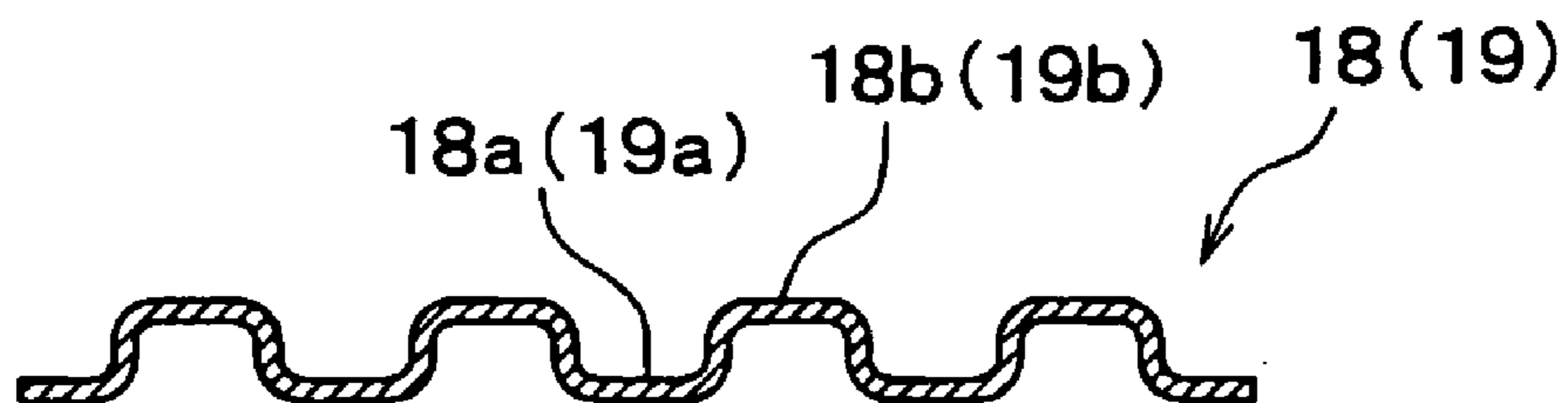


FIG. 4(a)

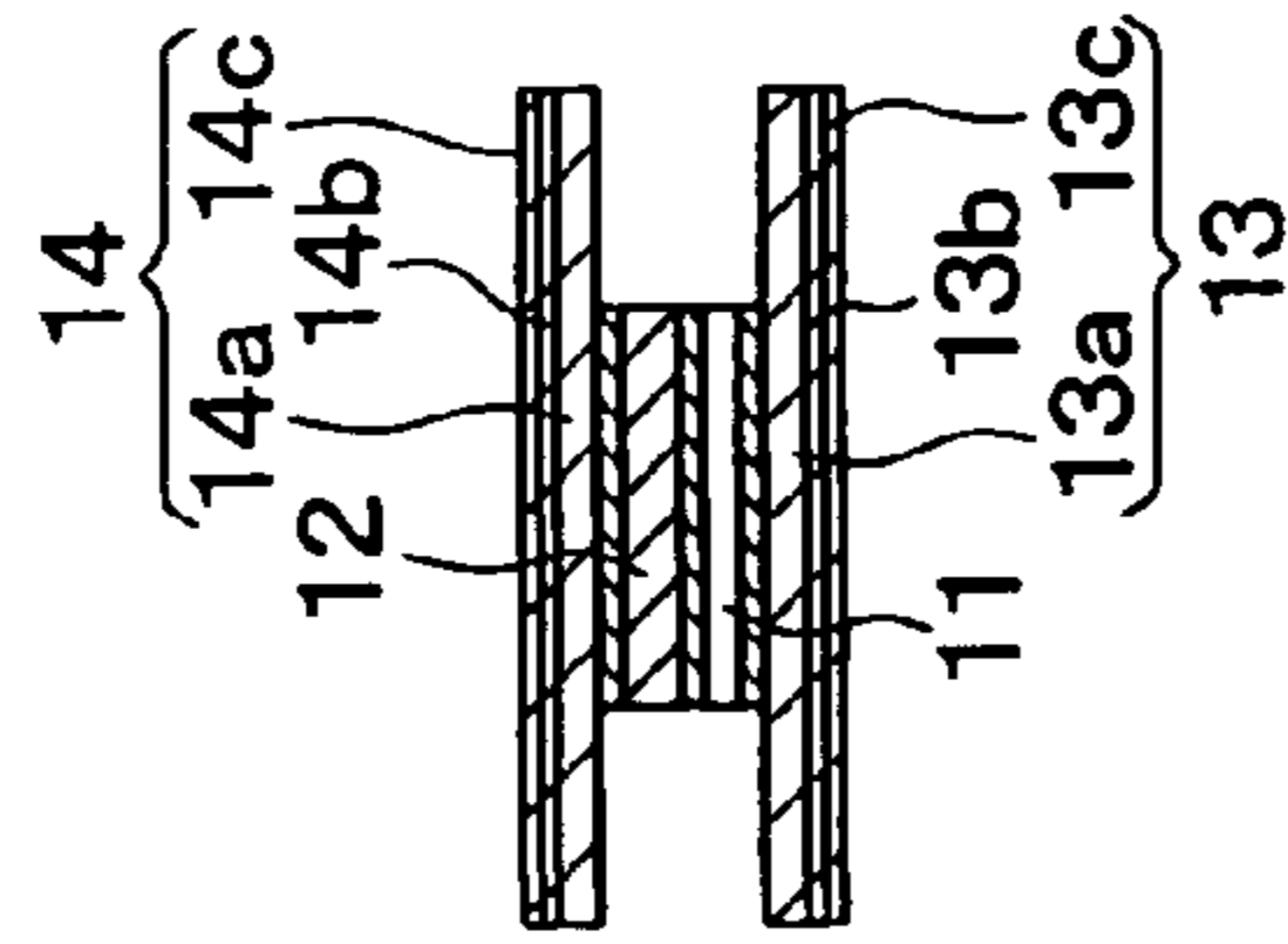


FIG. 4(b)

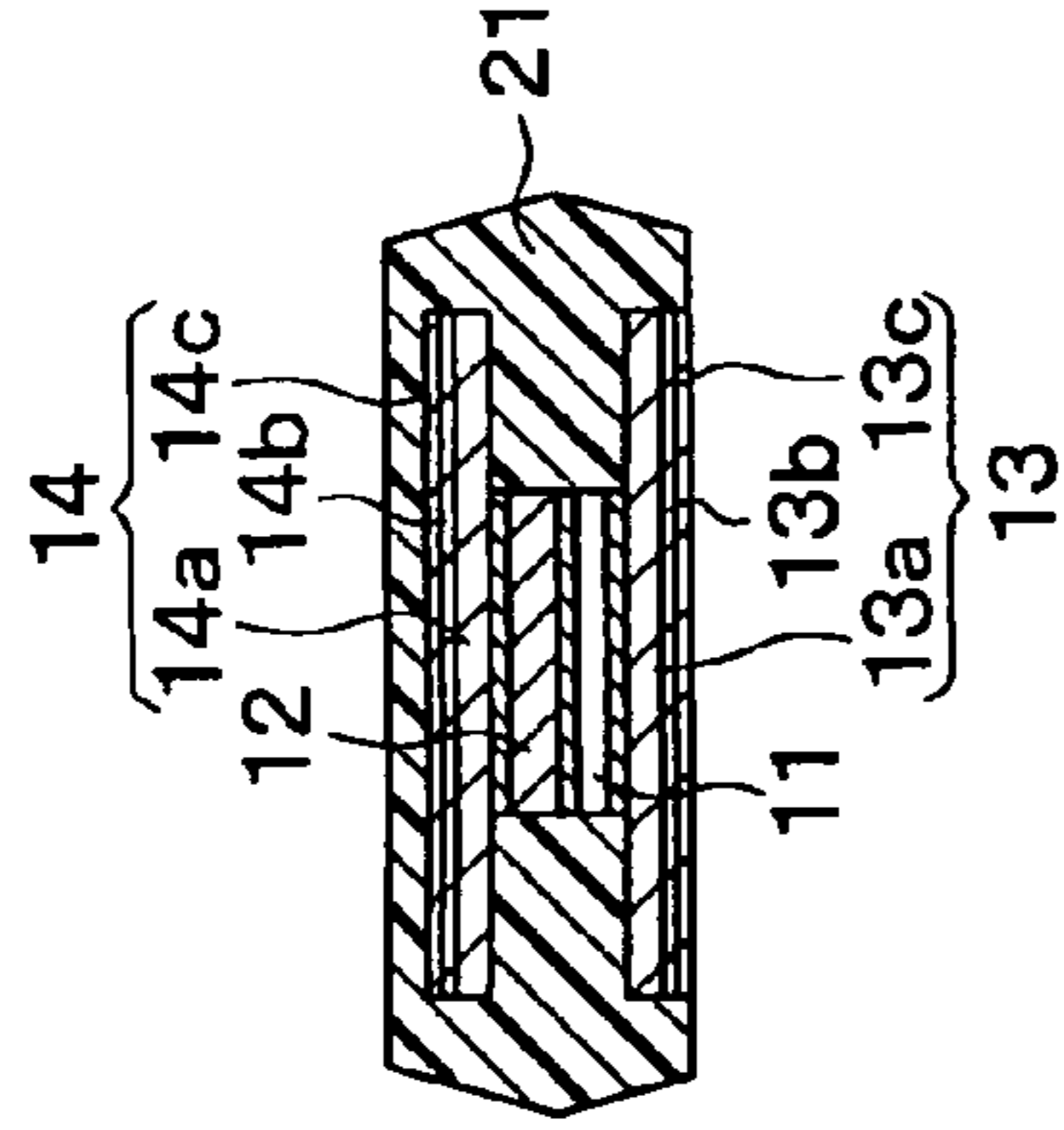


FIG. 4(c)

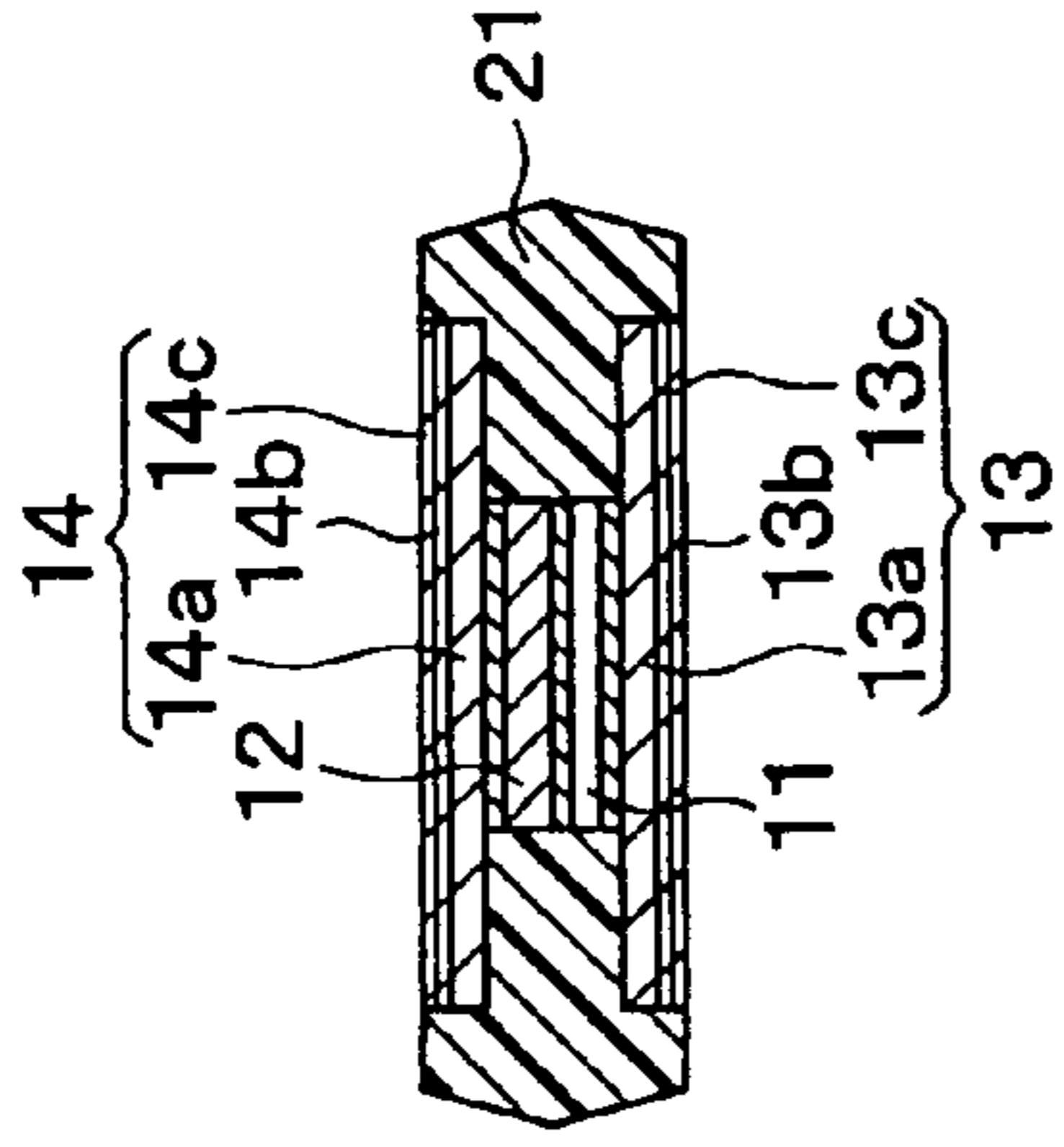


FIG. 4(d)

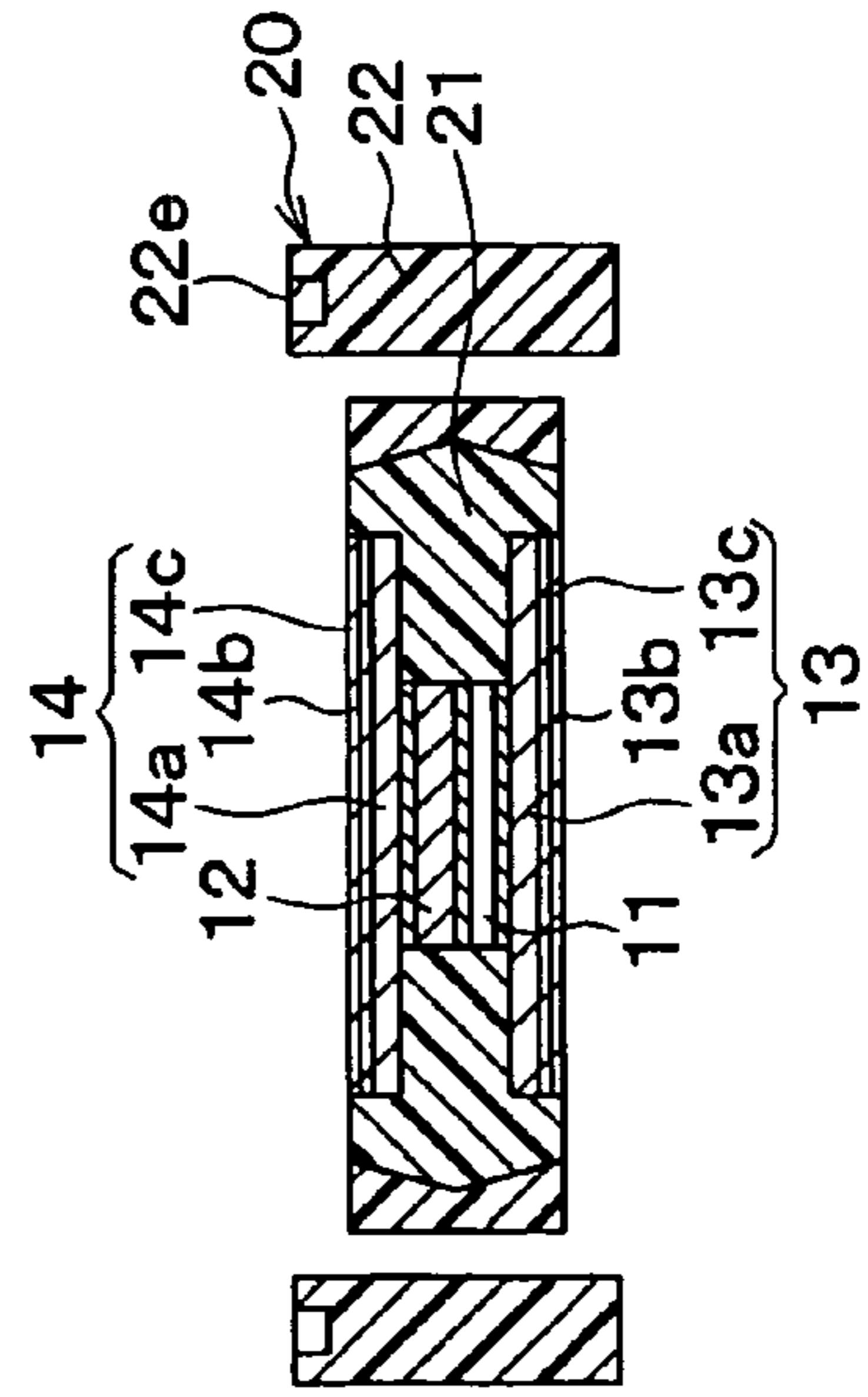


FIG. 4(e)

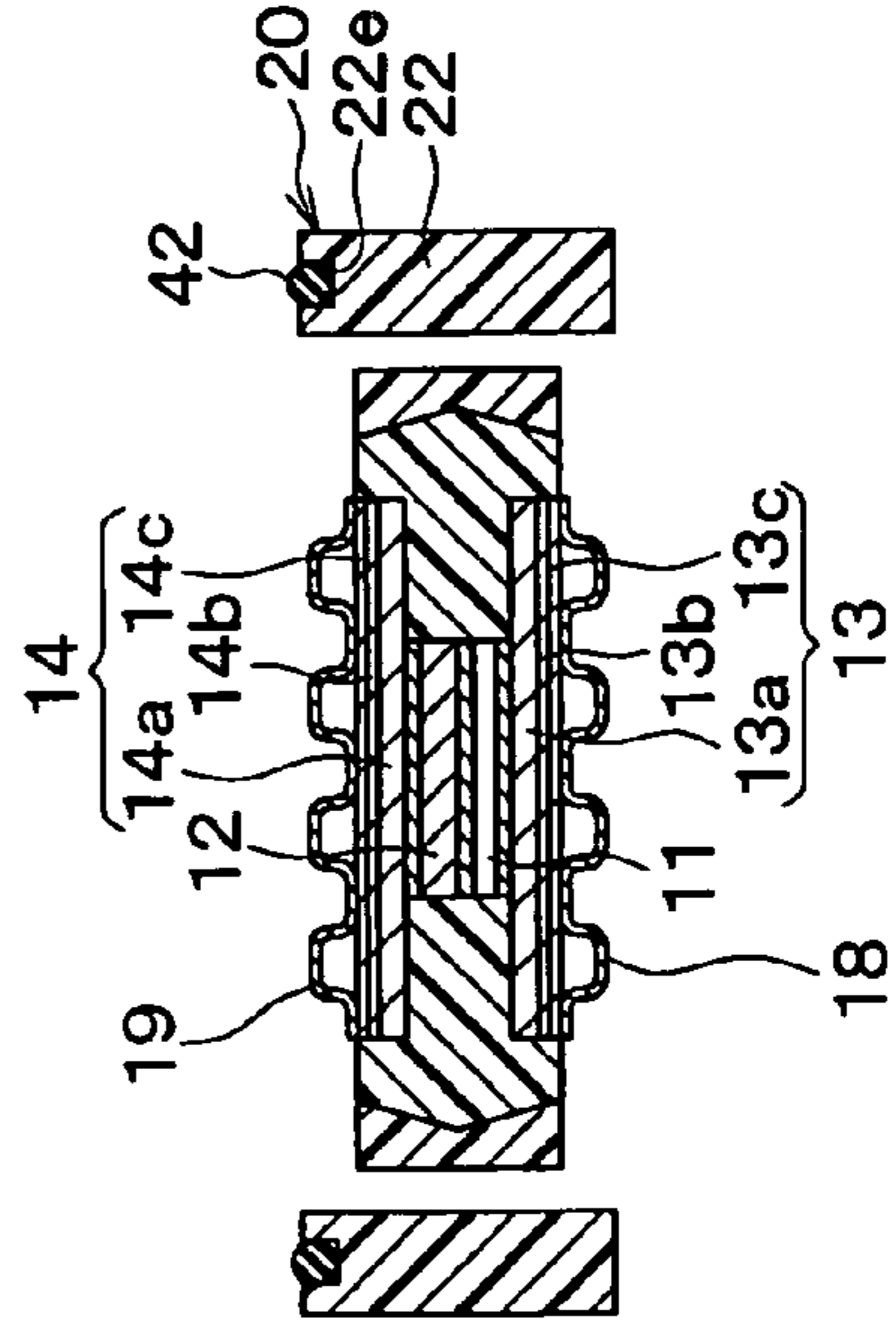


FIG. 5(a)

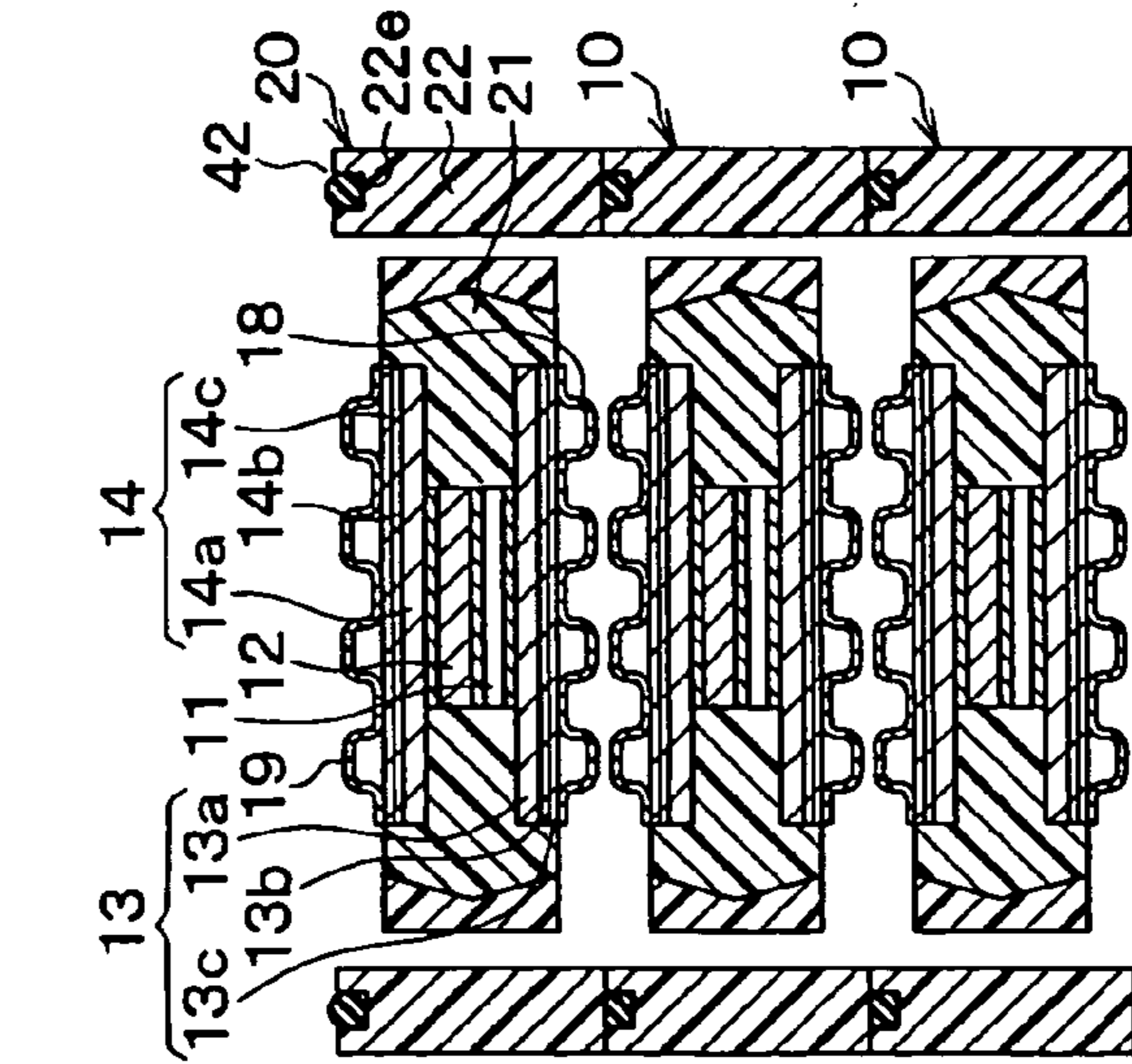


FIG. 5(b)

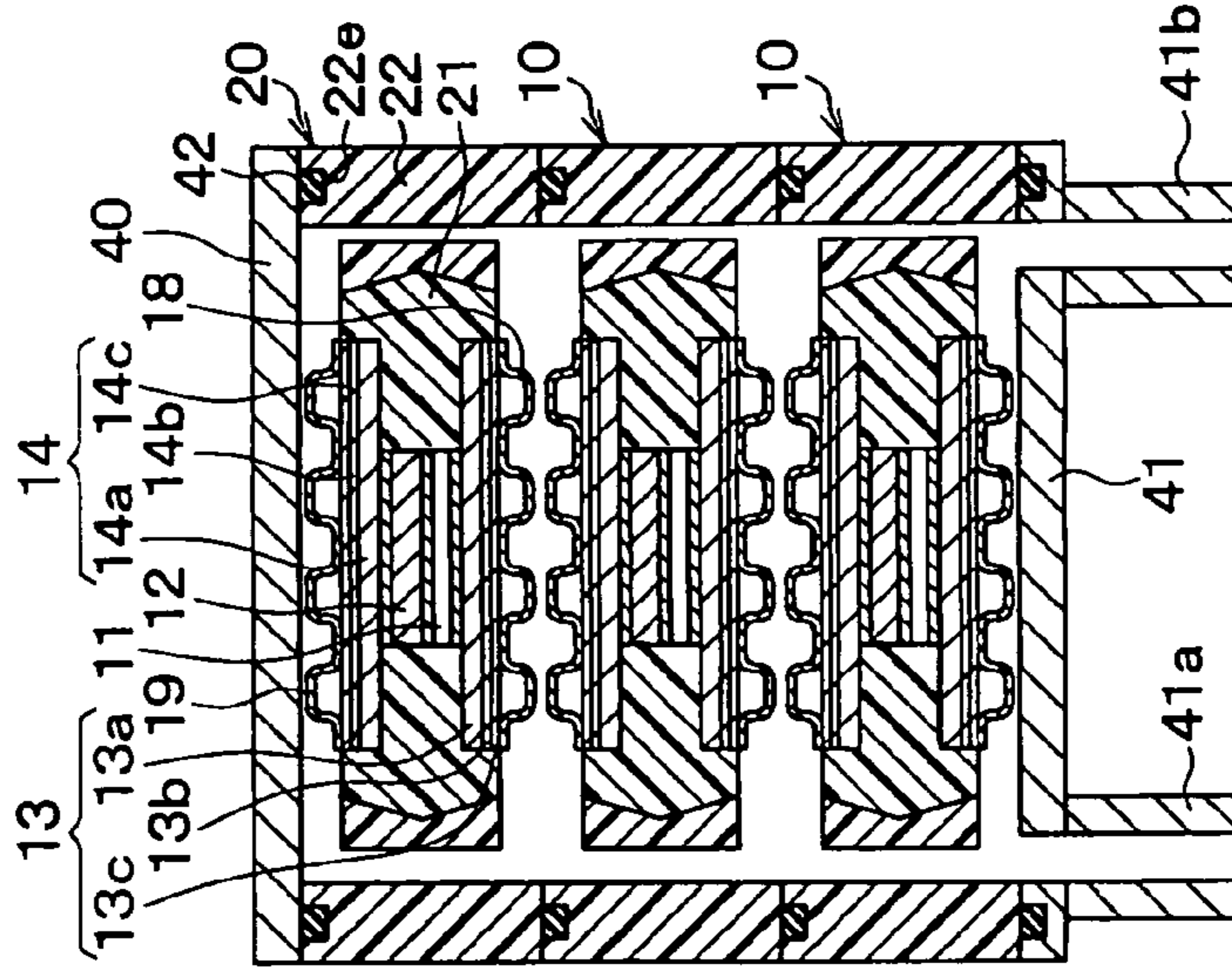


FIG. 5(c)

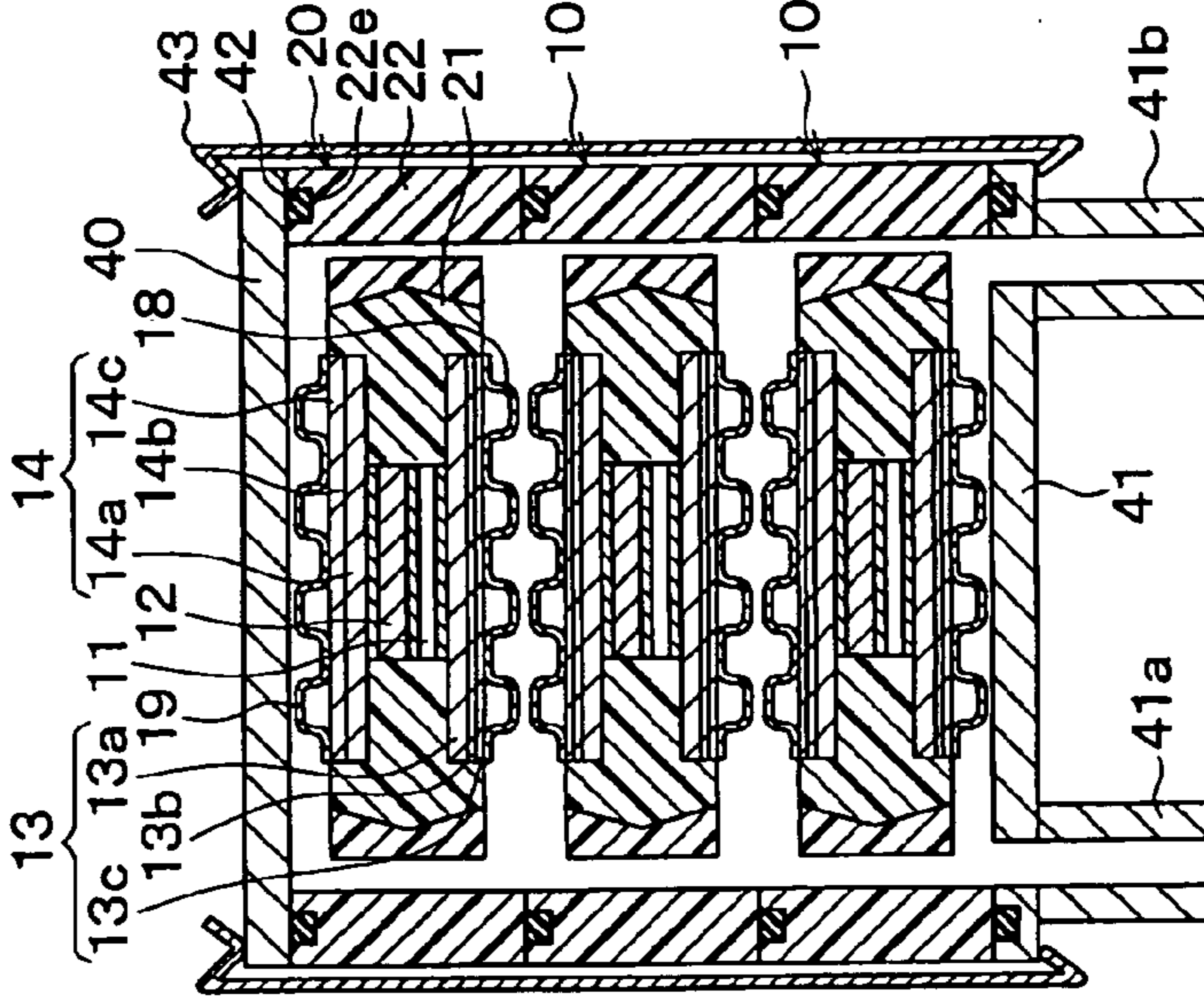


FIG. 6(a)

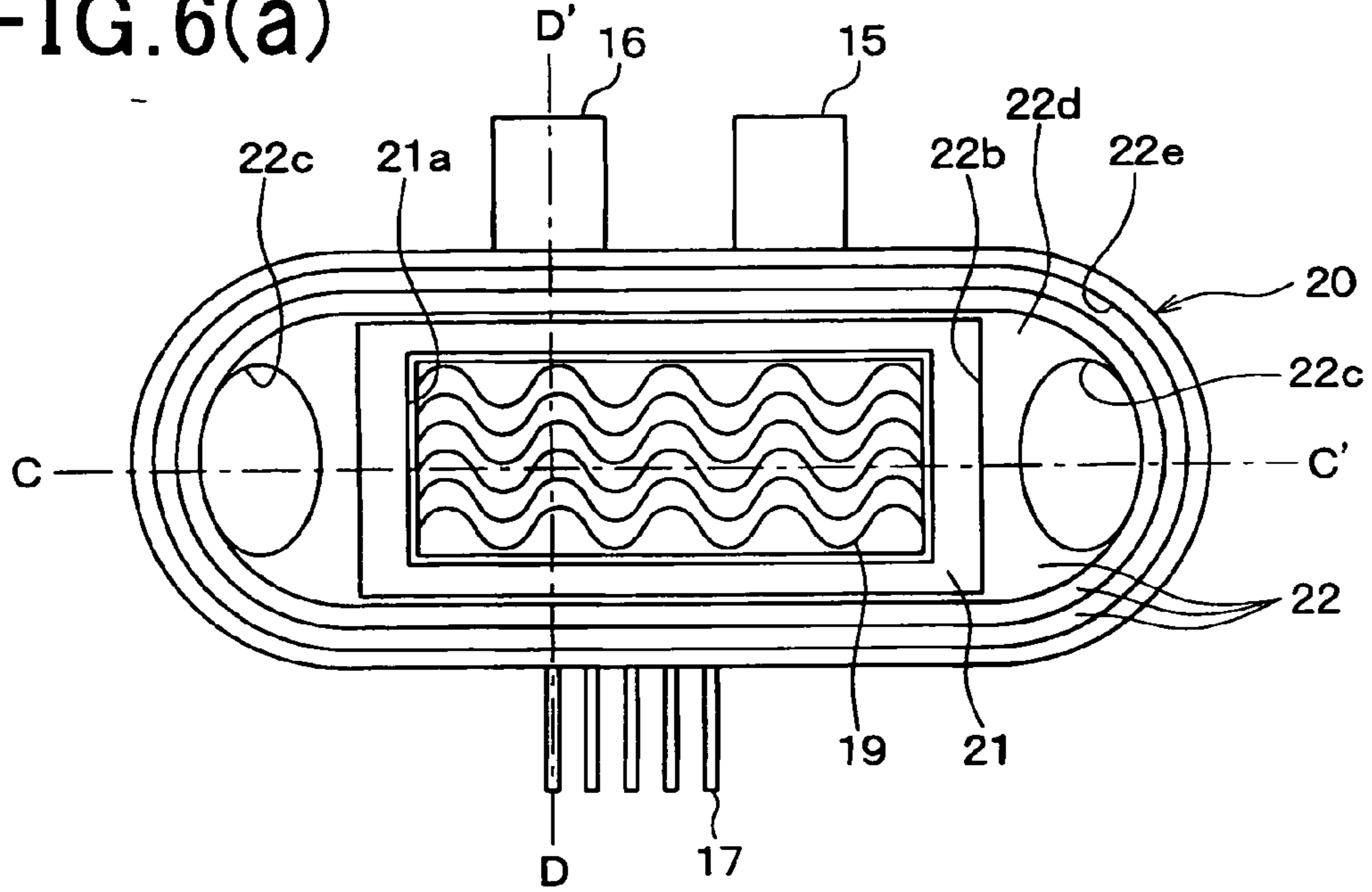


FIG. 6(b)

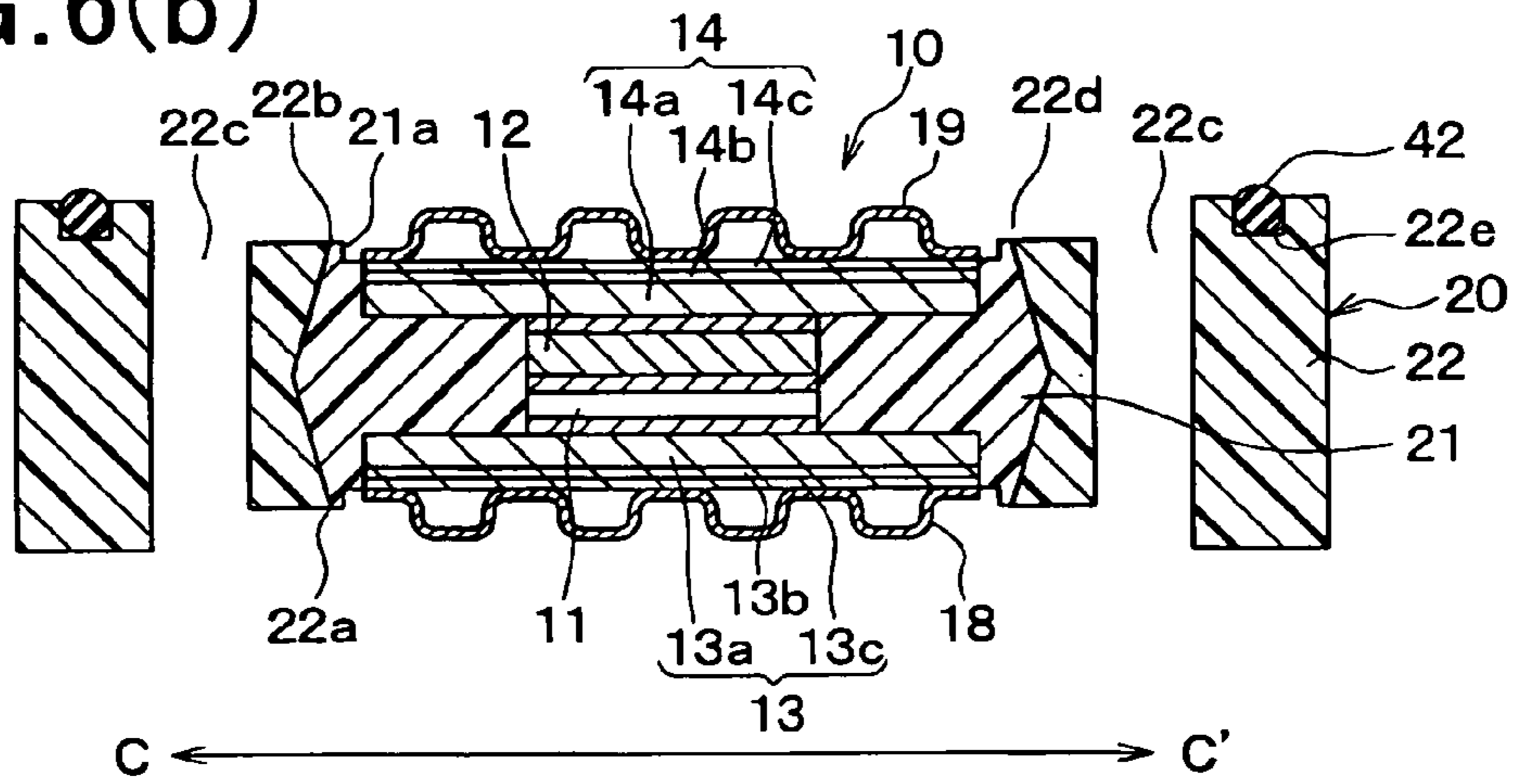


FIG. 6(c)

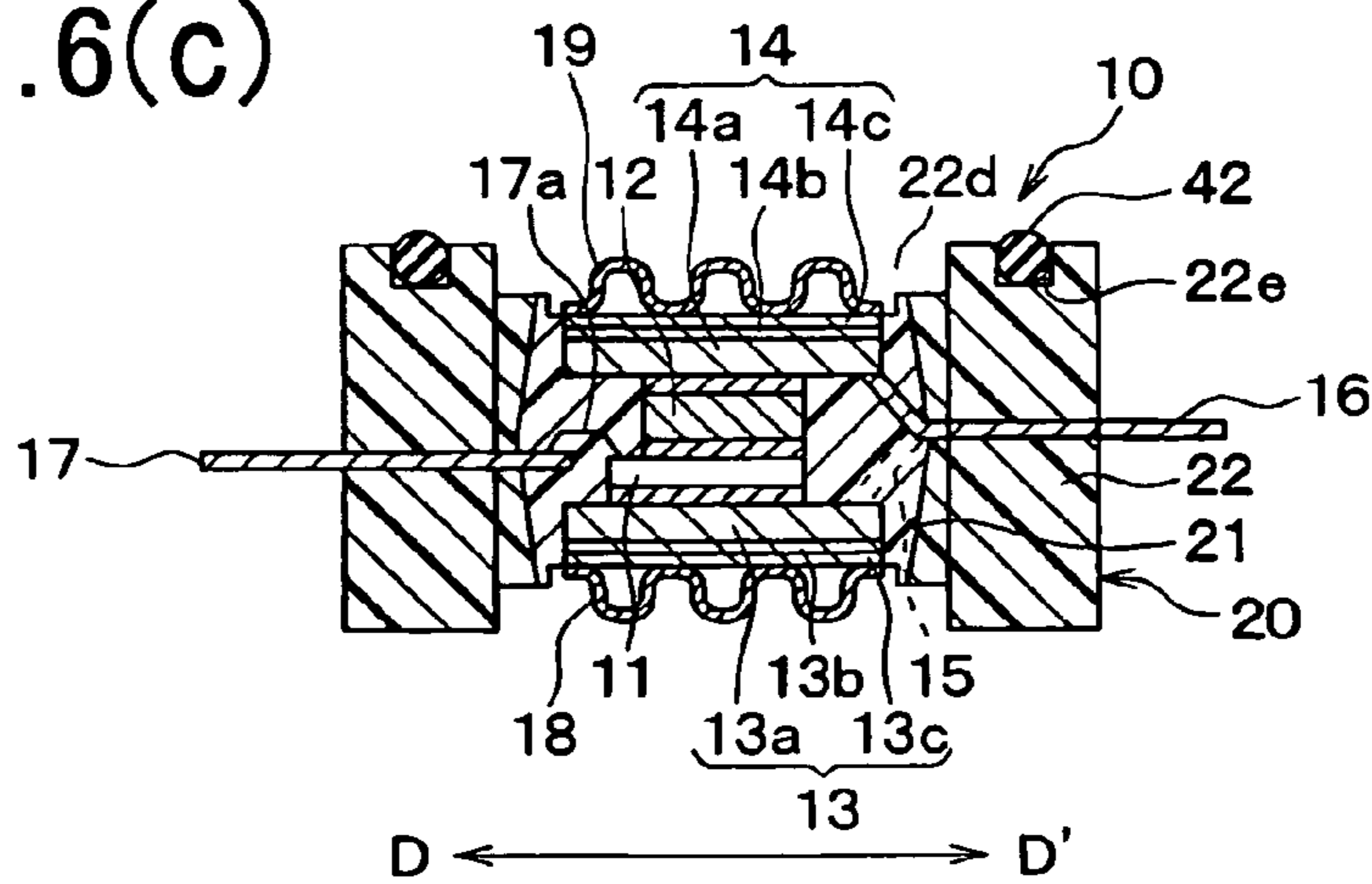


FIG. 7

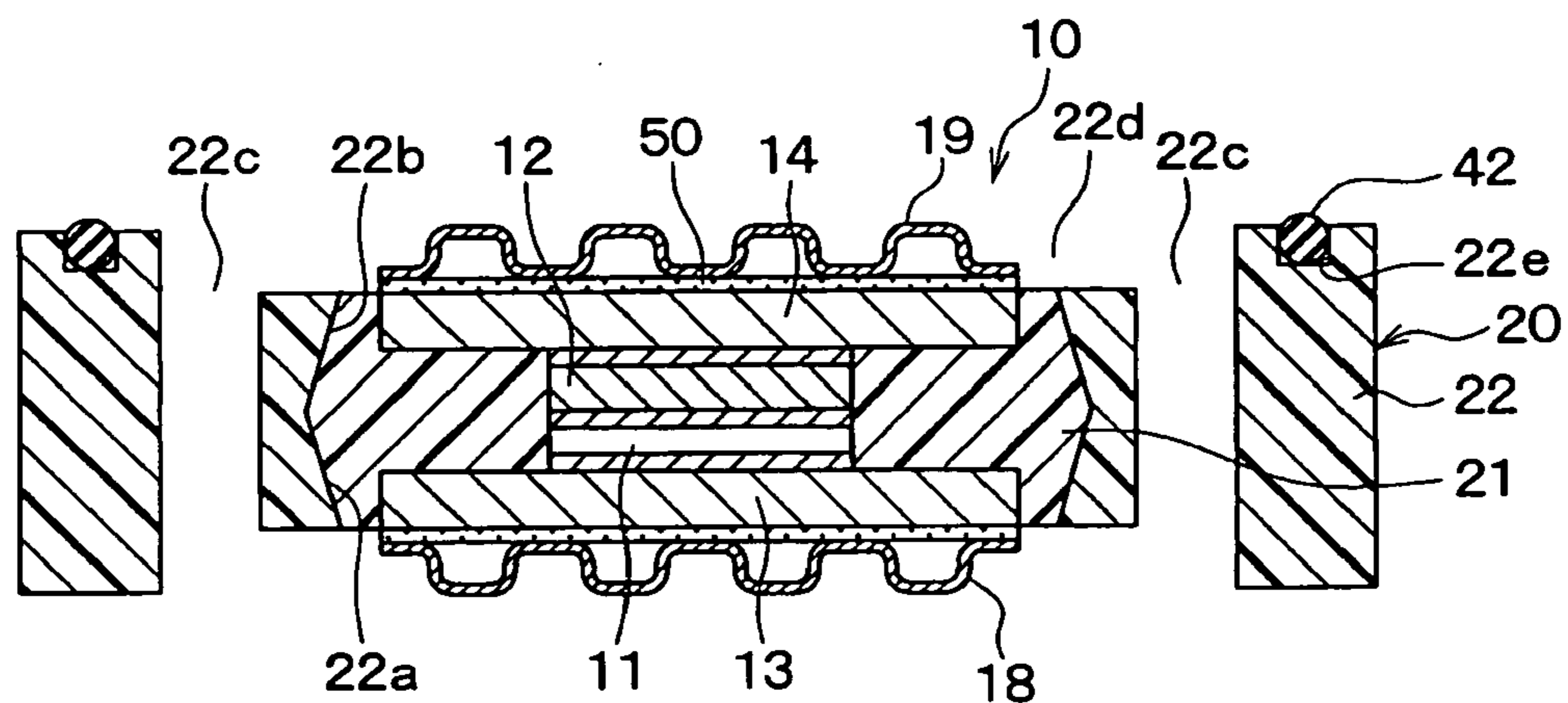


FIG. 8(a)

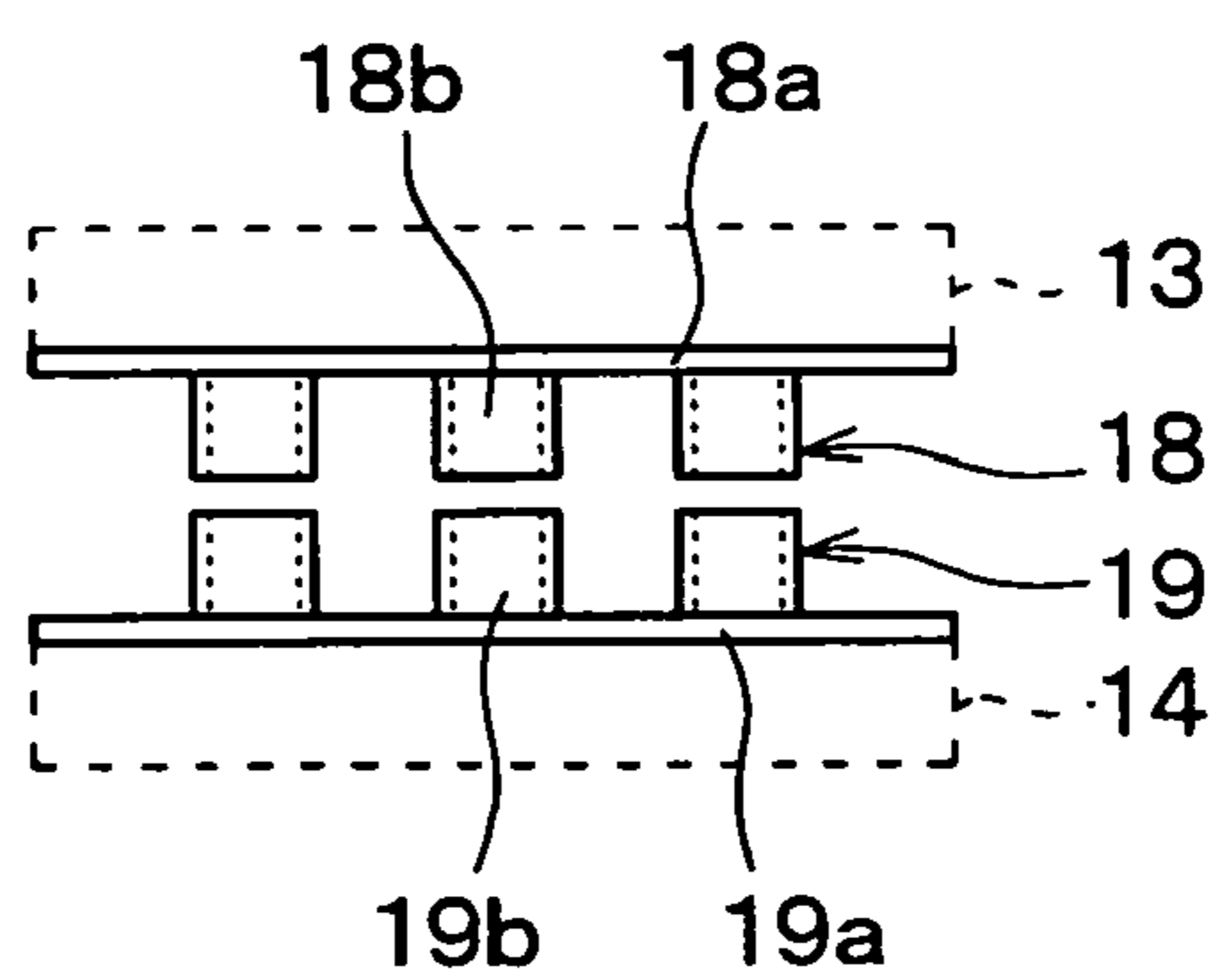


FIG. 8(b)

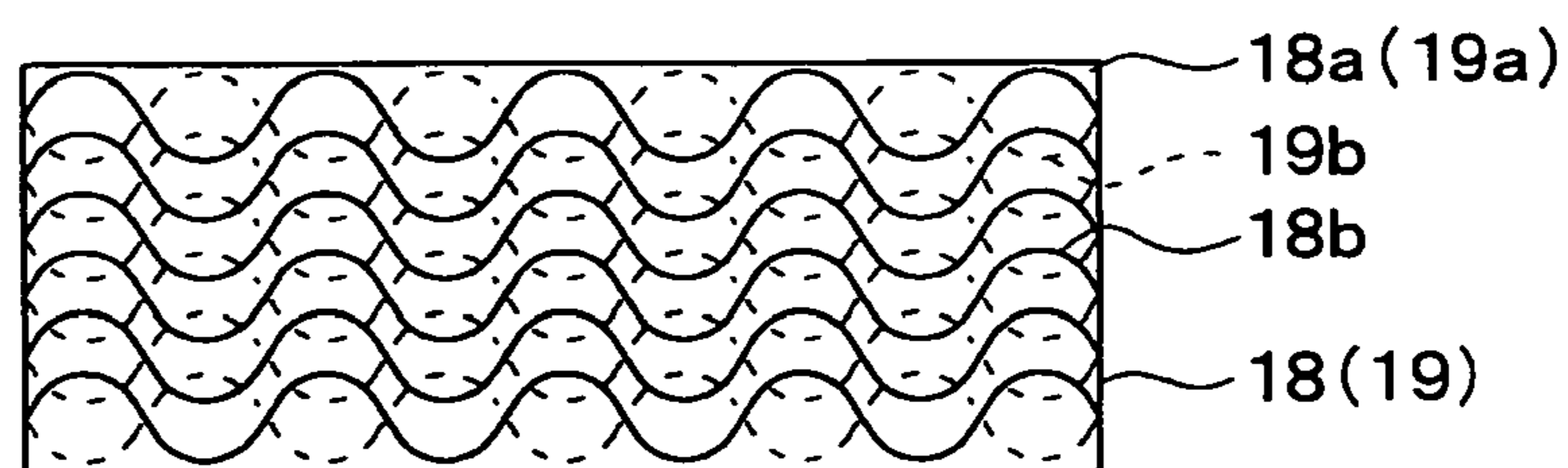


FIG.9(a)

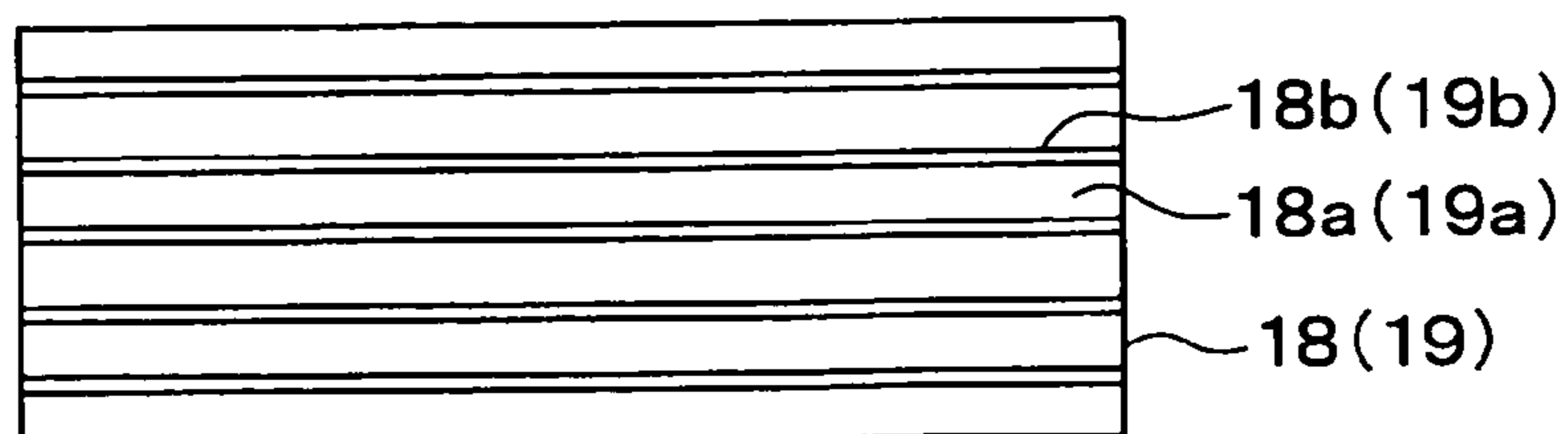


FIG.9(b)

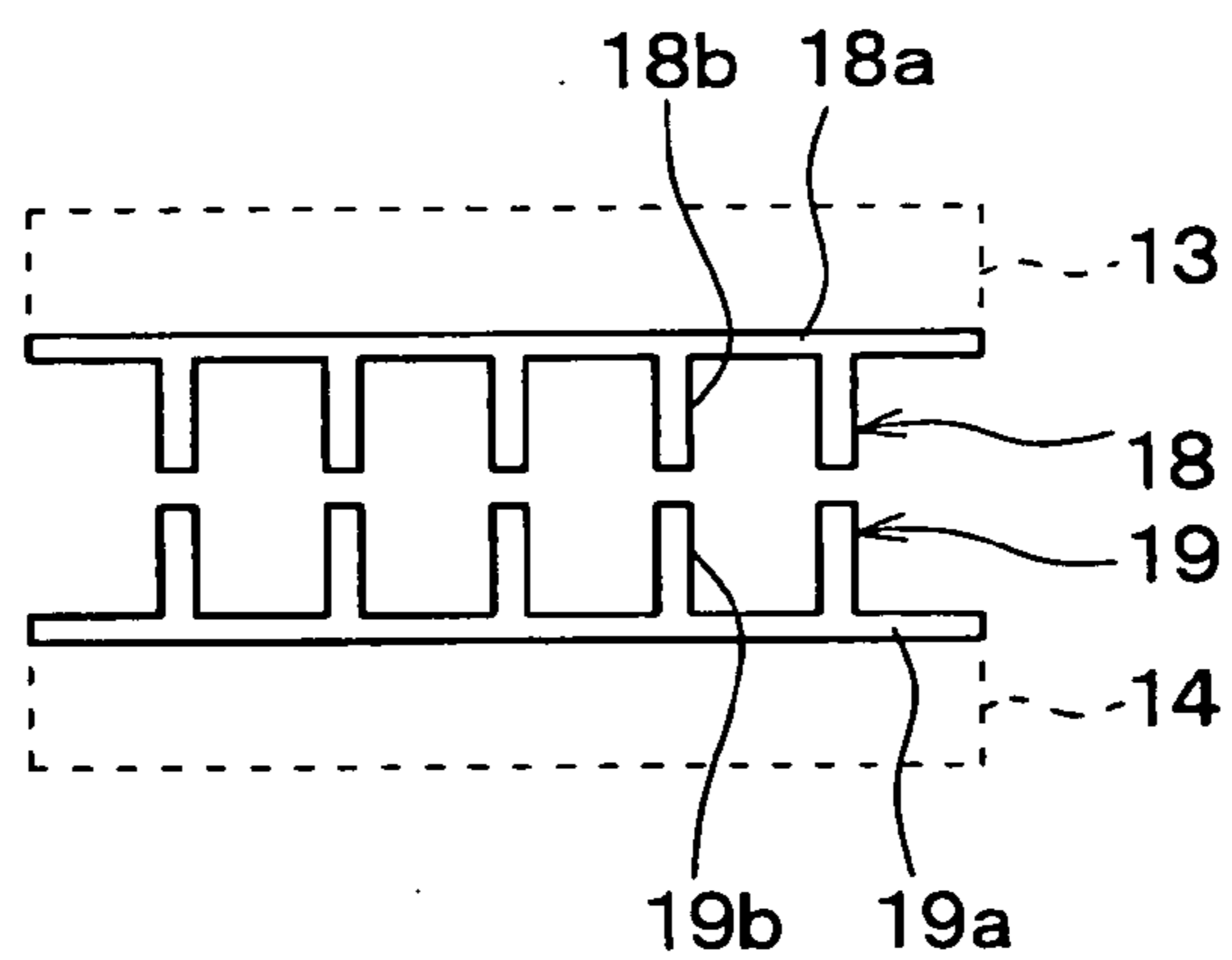


FIG.10

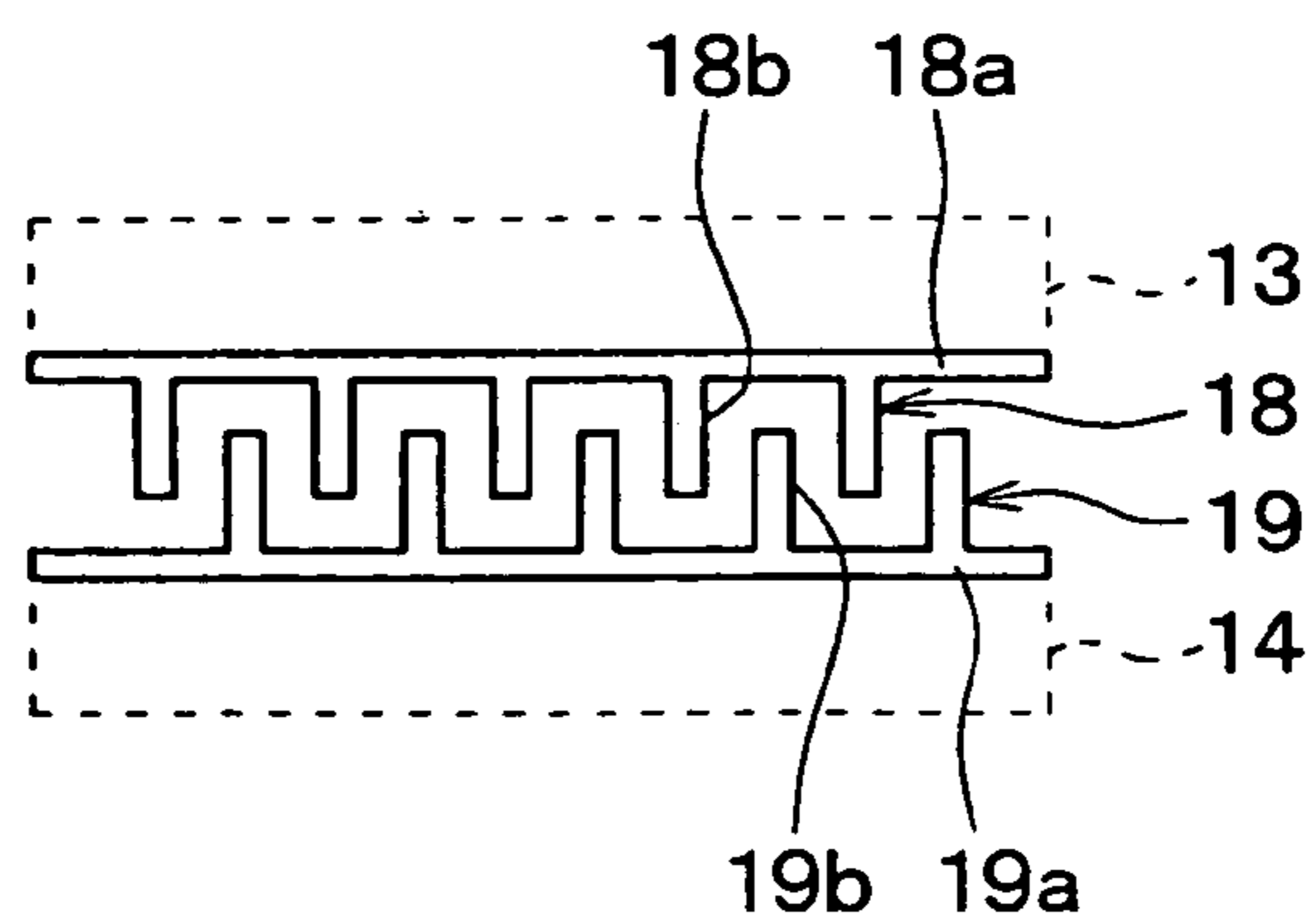


FIG. 11(a)

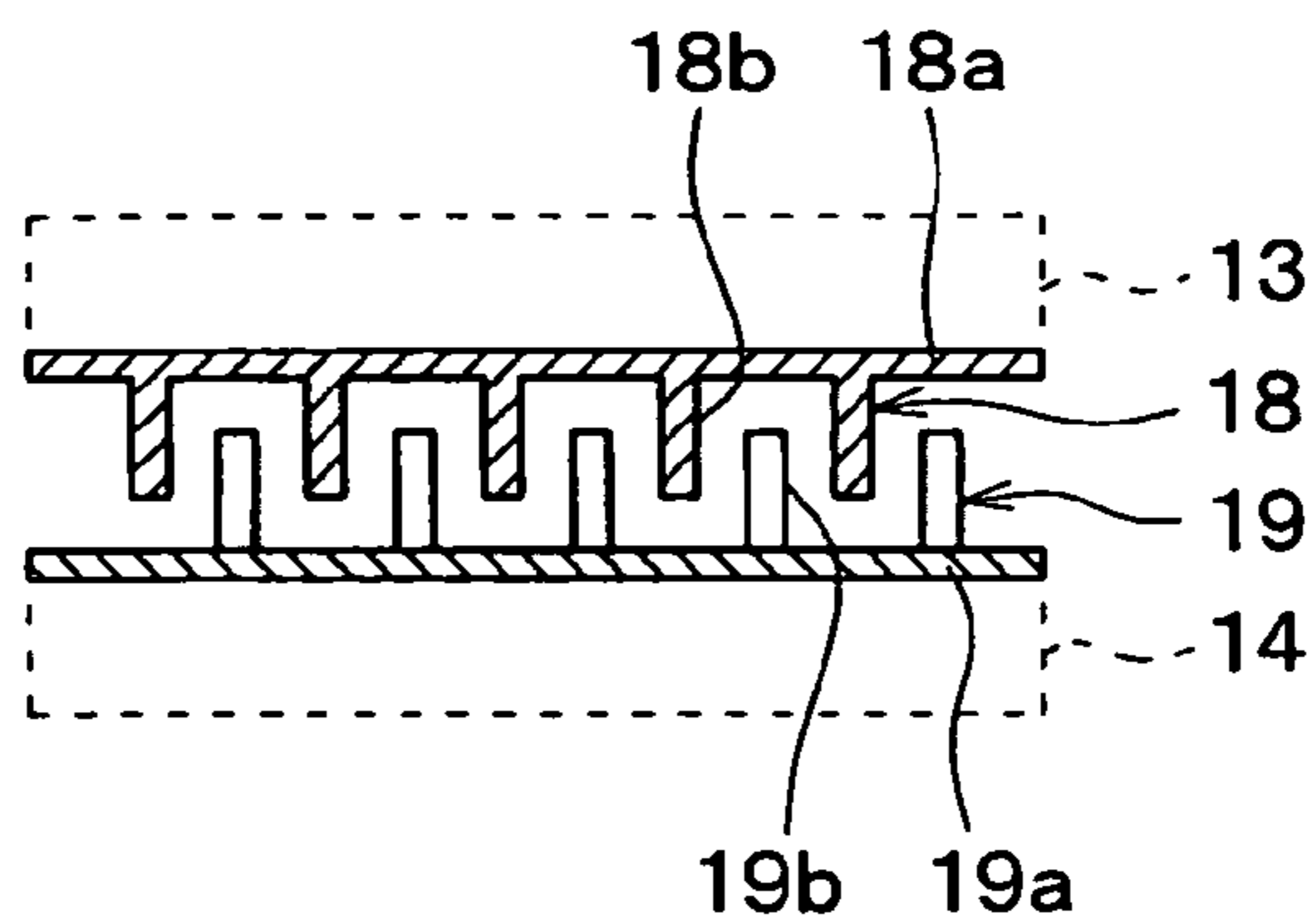


FIG. 11(b)

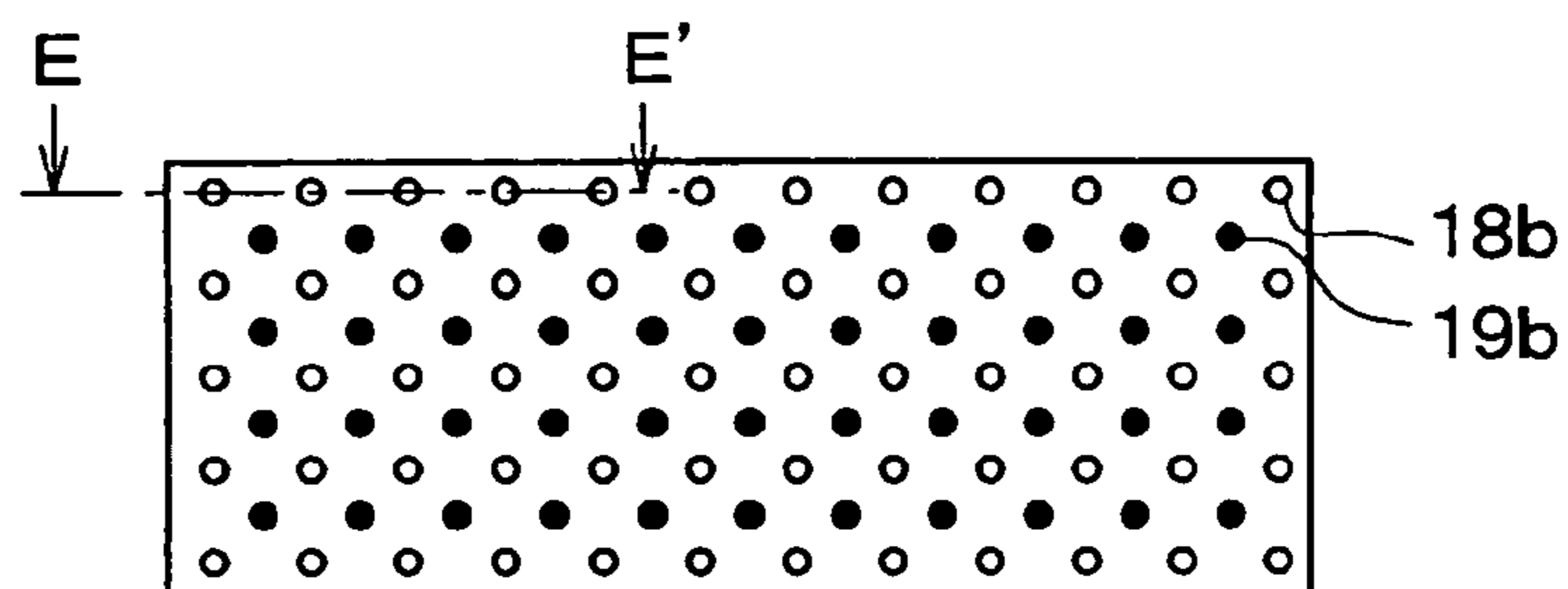


FIG. 12(a)

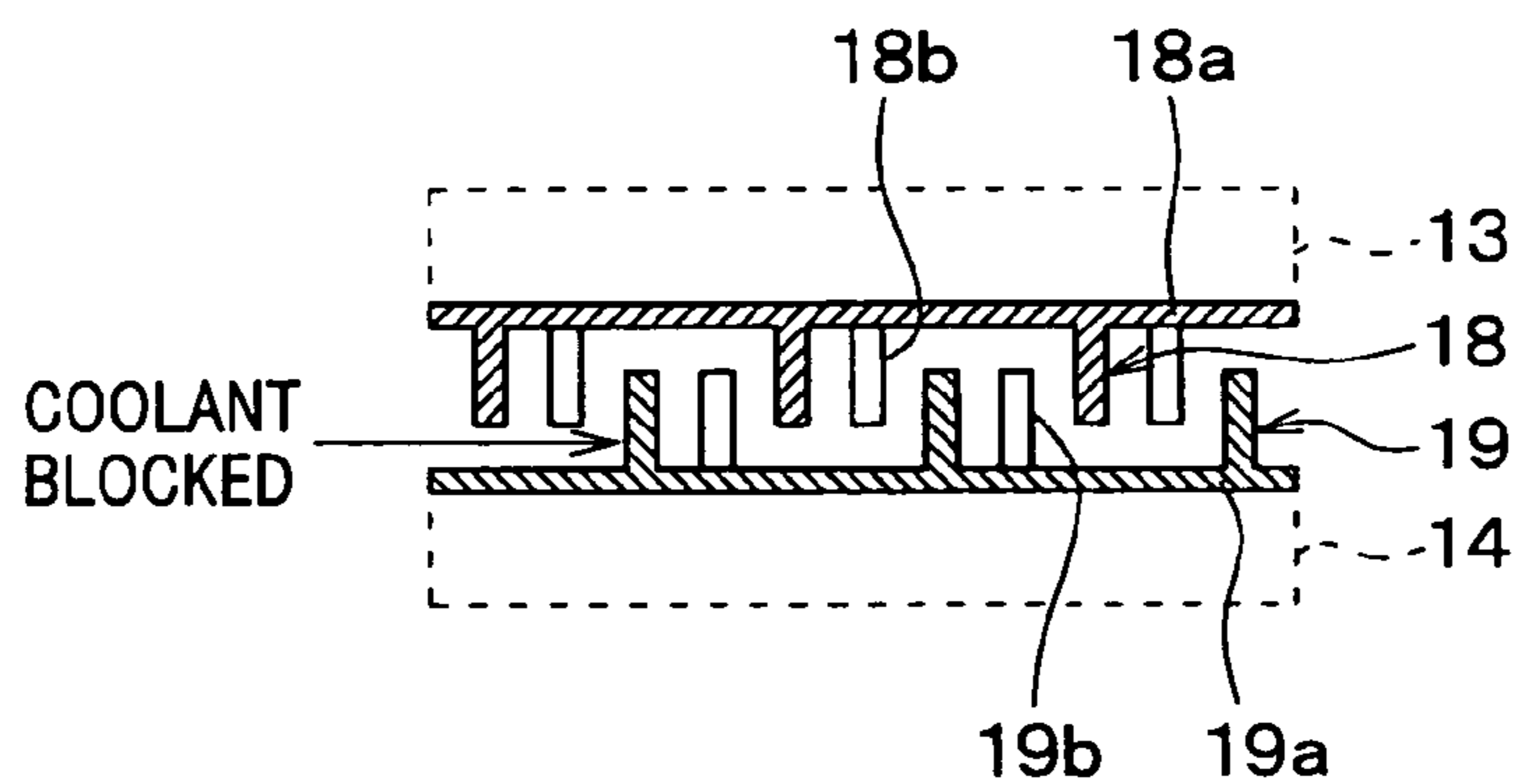


FIG. 12(b)

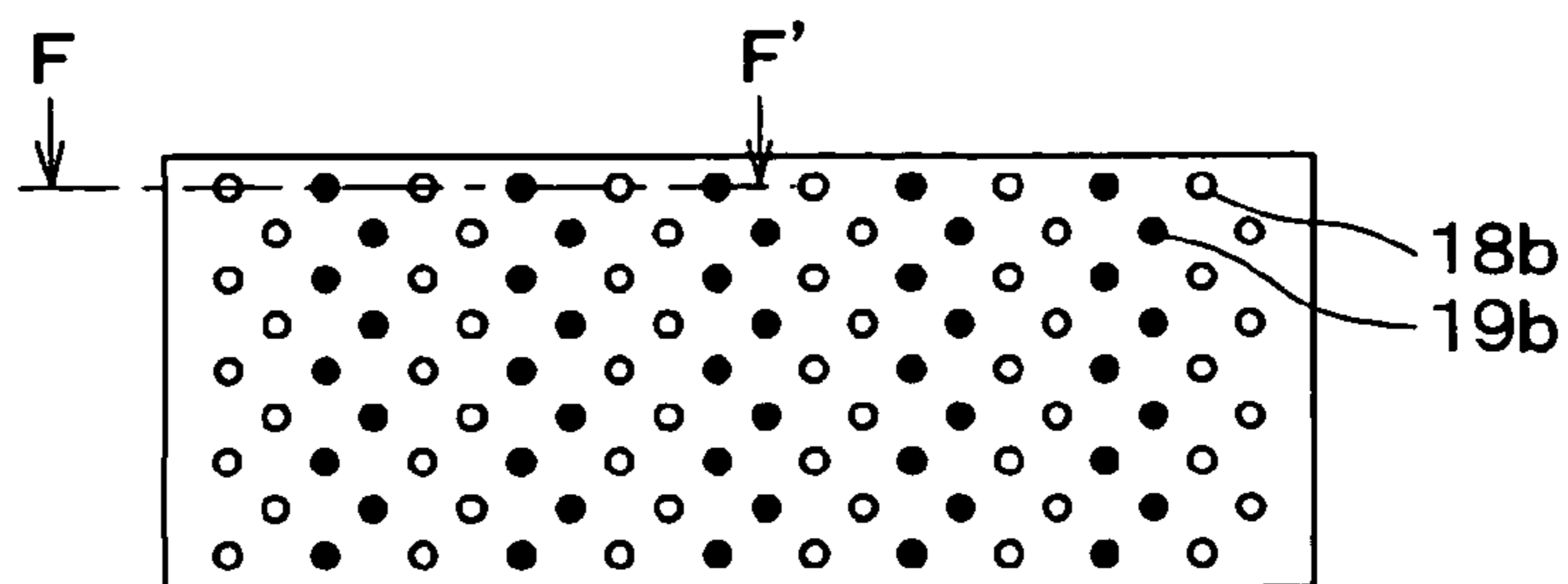
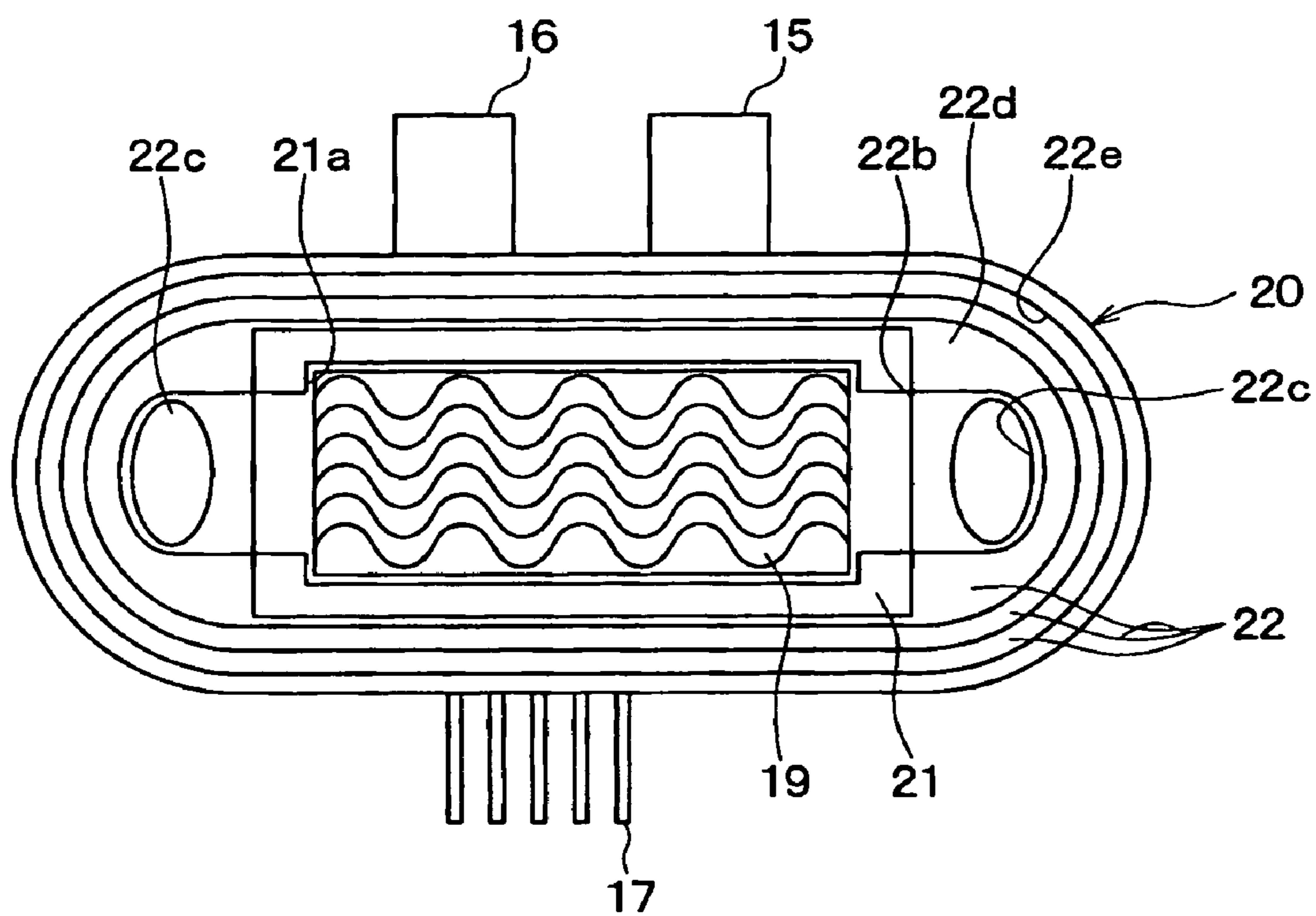


FIG. 13



**SEMICONDUCTOR MODULE WITH
COOLING MECHANISM AND PRODUCTION
METHOD THEREOF**

CROSS REFERENCE TO RELATED DOCUMENT

[0001] The present application claims the benefit of priority of Japanese Patent Application No. 2010-143057 filed on Jun. 23, 2010, the disclosure of which is incorporated herein by reference.

BACKGROUND OF THE INVENTION

[0002] 1. Technical Field

[0003] The present invention relates generally to a semiconductor module which includes a resin molded package equipped with a power semiconductor chip and a heat spreader working to spread heat from the power semiconductor chip and which may be of a 1-in-1 structure into which a single power semiconductor chip(s) such as an IGBT or a power MOSFET for use as either of an upper arm (i.e., a high side device) or a lower arm (i.e., a low side device) of an inverter is resin-molded, or a 2-in-1 structure into which two power semiconductor chips for use as the upper and lower arms, respectively, are resin-molded. The present invention also relates to a production method of such a semiconductor module.

[0004] 2. Background Art

[0005] One of typical semiconductor modules is equipped with a resin molded package in which a semiconductor chip (s) with a semiconductor power device and heat spreaders serving to dissipate heat, as generated by the semiconductor power device, are disposed. Some of such a type of semiconductor modules are also equipped with a fin heat sink formed integrally with each of the heat spreaders in order to enhance dissipation of the heat generated by the semiconductor power device. The heat spreader is so installed as to expose the fin heat sink to a cooling fluid such as water fed from a cooling mechanism installed in the semiconductor module to transfer the heat to the cooling fluid.

[0006] Japanese Patent First Publication No. 2006-165534 discloses heat spreaders which are so disposed as to face each other. Coolant flows between the heat spreaders to cool semiconductor power devices. In order to enhance such cooling efficiency, the heat spreaders have irregularities formed facing surfaces thereof which work as fin heat sinks. All the heat spreaders and the cooling fins are made of metal, which may result in electrical leakage between the facing surfaces of the heat spreaders.

[0007] In order to achieve a high degree of the cooling efficiency of the heat spreaders and the electrical insulation between the spreaders at the same time, it is effective to form insulating films on the fin heat sinks. A difficulty is, however, encountered in forming the insulating films on the uneven surface of the fin heat sinks. Such formation may be achieved in the vapor phase epitaxial method such as sputtering, CVD, or spray coating. It is, however, difficult for such a method to achieve a constant thickness of coating of insulator between fins of the fin heat sink, which may lead to the leakage of electricity from the heat spreader.

[0008] To integrate the heat spreader and the fin heat sink, it is usually made by shaving, casting, or extrusion. These methods difficulty in fabricating the pitched fine fins of the fin

heat sink and ensuring a desired size of the area of the fin heat sink from which the heat is dissipated.

SUMMARY

[0009] It is therefore an object to provide an improved structure of a semiconductor module which includes a heat spreader equipped with a fin heat sink and which is designed to minimize an electrical leakage from the heat spreader, and a production method thereof.

[0010] According to one aspect of an embodiment, there is provided a semiconductor module which may be employed with an inverter for an electric motor. The semiconductor module comprises: (a) a resin molded package; (b) first and second insulating films; (c) first and second fin heat sinks; (d) a first cover; (e) a second cover; and (f) a fastener. The resin molded package includes a resin mold. The resin mold has embedded therein a power semiconductor chip which has a first and a second surface opposite each other and on which a semiconductor power device is fabricated, a first heat spreader, a second heat spreader, and electric terminals coupled electrically with the semiconductor power device. The first heat spreader has a first surface and a second flat surface opposed to the first surface and is disposed at the first surface thereof in connection with the first surface of the power semiconductor chip. The second heat spreader has a first surface and a second flat surface opposed to the first surface and is disposed at the first surface thereof in connection with the second surface of the power semiconductor chip. A portion of each of the electric terminals is exposed outside the resin mold. The resin mold also has formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the power semiconductor chip. The first and second insulating films are disposed over the second flat surfaces of the first and second heat spreaders, respectively. The first and second fin heat sinks are joined to the first and second insulating films, respectively. The first cover is disposed on a first surface of the resin molded package. The second cover is disposed on a second surface of the resin molded package. The fastener fastens the first and second covers to hold the resin molded package.

[0011] Specifically, the first and second fin heat sinks are formed separately from of the first and second heat spreaders, respectively, thus facilitating ease of machining the first and second fin heat sinks to have a complex shape. The first and second fin heat sinks are welded to the first and second heat spreaders through the first and second insulating films, thus facilitating ease of forming the first and second insulating films to have a constant thickness on the flat second surfaces of the first and second heat spreaders. The first and second insulating films serve to eliminate the electrical leakage from the first and second heat spreaders.

[0012] In the preferred mode of the embodiment, the resin mold has formed therein positioning recesses which are shaped to conform with contour of the first and second fin heat sinks and serve to position the first and second fin heat sinks. This facilitates placement of the first and second fin heat sinks onto the resin mold when the first and second fin heat sinks are to be welded to the first and second heat spreaders, respectively.

[0013] The first heat spreader may be equipped with a first metal plate disposed on the power semiconductor chip, the first insulating film is disposed on a surface of the first metal plate that is the second surface of the first heat spreader, and a first metal film disposed on the first insulating film and

electrically kept away from the first metal plate. Similarly, the second heat spreader may be equipped with a second metal plate disposed on the power semiconductor chip, the second insulating film disposed on a surface of the second metal plate that is the second surface of the second heat spreader, and a second metal film disposed on the second insulating film and electrically kept away from the second metal plate. The first and second fin heat sinks are welded to the first and second metal films, respectively.

[0014] The first and second fin heat sinks may be attached to the second flat surfaces of the first and second heat spreaders through first and second adhesive layers, respectively. The first and second adhesive layers are made of an insulating material and form the first and second insulating films, respectively. The first and second heat spreaders are made of the same material as that of the first and second fin heat sinks, thus resulting in a decrease in stress acting on the adhesive layers which will arise from a change in temperature therebetween.

[0015] According to another aspect of an embodiment, there is provided a semiconductor module which comprises: (a) a resin molded package which includes a resin mold; (b) first and second fin heat sinks; (c) a first cover; (d) a second cover; and (e) a fastener. The resin mold has embedded therein a power semiconductor chip which has a first and a second surfaces opposed to each other and on which a semiconductor power device is fabricated, a first heat spreader, a second heat spreader, and electric terminals coupled electrically with the semiconductor power device. The first heat spreader has a first surface and a second flat surface opposed to the first surface and is disposed at the first surface thereof in connection with the first surface of the semiconductor chip. The second heat spreader has a first surface and a second flat surface opposed to the first surface and is disposed at the first surface thereof in connection with the second surface of the semiconductor chip. A portion of each of the electric terminals is exposed outside the resin mold. The resin mold also has formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the semiconductor chip. The first and second fin heat sinks are joined to the second flat surfaces of the first and second heat spreaders through first and second adhesive layers, respectively. The first and second adhesive layers are made of material exhibiting electric conductivity. The first cover is disposed on a first surface of the resin molded package. The second cover is disposed on a second surface of the resin molded package. The fastener fastens the first and second covers to hold the resin molded package.

[0016] According to the third aspect of the embodiment, there is provided a semiconductor module which comprises: (a) a plurality of resin molded packages each of which includes a resin mold; (b) first and second insulating films; (c) first and second fin heat sinks; (d) a first cover; (e) a second cover; and (f) a fastener. The resin molded packages are laid to overlap each other as a package stack. The resin mold has embedded therein a power semiconductor chip which has a first and a second surface opposed to each other and on which a semiconductor power device is fabricated, a first heat spreader, a second heat spreader, and electric terminals coupled electrically with the semiconductor power device. The first heat spreader has a first surface and a second flat surface opposed to the first surface and is disposed at the first surface thereof in connection with the first surface of the power semiconductor chip. Similarly, the second heat

spreader has a first surface and a second flat surface opposed to the first surface and is disposed at the first surface thereof in connection with the second surface of the power semiconductor chip. A portion of each of the electric terminals is exposed outside the resin mold. The resin mold also has formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the power semiconductor chip. The first and second insulating films are disposed over the second flat surfaces of the first and second heat spreaders of each of the resin molded packages, respectively. The first and second fin heat sinks are joined to the first and second insulating films of each of the resin molded packages, respectively, so that adjacent two of the resin molded packages are arranged to have the first and second fin heat sink facing one another. The first cover is disposed on a first surface of the package stack. The second cover is disposed on a second surface of the package stack. The fastener fastens the first and second covers to hold the package stack.

[0017] Specifically, the first and second insulating films serve to avoid an electrical short between the first and second fin heat sinks of adjacent two of the resin molded packages.

[0018] In the preferred mode of the embodiment, each of the first and second fin heat sinks may be equipped with corrugated fins. The fins of the first fin heat sink of one of adjacent two of the resin molded packages are arrayed 180° out of phase with the fins of the second fin heat sink of the other of adjacent two of the resin molded packages. This creates lots of turbulent or eddy flows of the coolant within the coolant path, thus enhancing the cooling ability of the heat spreaders.

[0019] Each of the first and second fin heat sinks may alternatively be equipped with an array of straight strips which define fins. The fins of the first fin heat sink of one of adjacent two of the resin molded packages are aligned with the fins of the second fin heat sink of the other of adjacent two of the resin molded packages through a gap in a direction in which the resin molded packages are laid to overlap each other as the package stack.

[0020] Each of the first and second fin heat sinks may alternatively be equipped with an array of straight strips which define fins. Tops of the fins of the first fin heat sink of one of adjacent two of the resin molded packages overlap tops of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in a direction perpendicular to a direction in which the resin molded packages are laid to overlap each other as the package stack.

[0021] Each of the first and second fin heat sinks may alternatively be equipped with a plurality of pins which define fins. Tops of the fins of the first fin heat sink of one of adjacent two of the resin molded packages overlap tops of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in a first direction perpendicular to a second direction in which the resin molded packages are laid to overlap each other as the package stack. The fins of the first fin heat sink of one of adjacent two of the resin molded packages are staggered to the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in the first direction.

[0022] Each of the first and second fin heat sinks may alternatively be equipped with a plurality of pairs of arrays of pins which define fins. Tops of the fins of the first fin heat sink of one of adjacent two of the resin molded packages overlap tops of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in a first direction

perpendicular to a second direction in which the resin molded packages are laid to overlap each other as the package stack. The pairs of the arrays of the fins of the first fin heat sink of one of adjacent two of the resin molded packages are staggered to the pairs of the arrays of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in the first direction. This arrangement of the fins provides lots of obstructions to the flow of the coolant, thus creating lots of turbulent or eddy flows of the coolant within the coolant path, thus enhancing the cooling ability of the heat spreaders.

[0023] According to fourth aspect of the embodiment, there is provided a method of producing a semiconductor module which includes a resin molded package and a coolant path. The production method comprises: (a) a first step of preparing a semiconductor sub-assembly of a semiconductor chip, a first heat spreader, a second heat spreader, and electric terminals, the semiconductor chip having a first and a second surface opposed to each other and being equipped with a semiconductor power device connecting with the electric terminals; (b) a second step of placing the semiconductor sub-assembly in a given molding tool and making a resin mold in which the semiconductor sub-assembly is disposed as the resin molded package, the first heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the first surface of the power semiconductor chip, the second heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the second surface of the power semiconductor chip, a portion of each of the electric terminals being exposed outside the resin mold, the resin mold also having formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the power semiconductor chip; and (c) a third step of holding the resin molded package through covers to complete the semiconductor module.

[0024] The first heat spreader has a first metal plate disposed on the power semiconductor chip, the first insulating film disposed on a surface of the first metal plate that is the second surface of the first heat spreader, and a first metal film disposed on the first insulating film and electrically kept away from the first metal plate. Similarly, the second heat spreader has a second metal plate disposed on the power semiconductor chip, the second insulating film disposed on a surface of the second metal plate that is the second surface of the second heat spreader, and a second metal film disposed on the second insulating film and electrically kept away from the second metal plate. The first and second fin heat sinks are joined to the first and second metal films, respectively, through ultrasonic welding.

[0025] Specifically, the first and second fin heat sinks are formed separately from the first and second heat spreaders, respectively, thus facilitating ease of machining the first and second fin heat sinks to have a complex shape. The first and second fin heat sinks are joined to the first and second heat spreaders through the first and second insulating films, thus facilitating ease of forming the first and second insulating films to have a constant thickness on the flat second surfaces of the first and second heat spreaders. The first and second insulating films serve to eliminate the electrical leakage from the first and second heat spreaders.

[0026] In the preferred mode of the embodiment, the second step forms the resin mold so as to cover the semiconduc-

tor sub-assembly fully and then removes a portion of the resin mold so as to expose one of the first and second metal films.

BRIEF DESCRIPTION OF THE DRAWINGS

[0027] The present invention will be understood more fully from the detailed description given hereinbelow and from the accompanying drawings of the preferred embodiments of the invention, which, however, should not be taken to limit the invention to the specific embodiments but are for the purpose of explanation and understanding only.

[0028] In the drawings:

[0029] FIG. 1 is a vertical sectional view which shows a semiconductor module according to the first embodiment;

[0030] FIG. 2(a) is a plane view which shows one of resin molded packages built in the semiconductor module of FIG. 1;

[0031] FIG. 2(b) is a cross sectional view, as taken along the line A-A' of FIG. 2(a);

[0032] FIG. 2(c) is a cross sectional view, as taken along the line B-B' of FIG. 2(a);

[0033] FIG. 3(a) is a front view which schematically illustrates a structure of a fin heat sink of the resin molded package of FIGS. 2(a) to 2(c);

[0034] FIG. 3(b) is a cross sectional view of FIG. 3(a);

[0035] FIGS. 4(a), 4(b), 4(c), 4(d), and 4(e) are cross sectional views which demonstrate a sequence of steps of producing the resin molded package, as illustrated in FIGS. 2(a) to 2(c);

[0036] FIGS. 5(a), 5(b), and 5(c) are cross sectional views which demonstrate a sequence of steps of assembling the semiconductor module, as illustrated in FIG. 1;

[0037] FIG. 6(a) is a plane view which shows one of resin molded packages built in a semiconductor module of the second embodiment;

[0038] FIG. 6(b) is a cross sectional view, as taken along the line C-C' of FIG. 6(a);

[0039] FIG. 6(c) is a cross sectional view, as taken along the line D-D' of FIG. 6(a);

[0040] FIG. 7 is a cross sectional view of a resin molded package of the third embodiment;

[0041] FIG. 8(a) is a side view which illustrates fins of fin heat sinks of a resin molded package of the fourth embodiment;

[0042] FIG. 8(b) is a schematic illustration of layouts of the fins in FIG. 8(a);

[0043] FIG. 9(a) is a plane view of fin heat sinks of adjacent two of resin molded packages according to the fifth embodiment;

[0044] FIG. 9(b) is a side view of FIG. 9(a);

[0045] FIG. 10 is a side view which illustrates fin heat sinks of adjacent two of resin molded packages according to the sixth embodiment;

[0046] FIG. 11(a) is a cross sectional view, as taken along the line E-E' in FIG. 11(b), which illustrates fin heat sinks of adjacent two of resin molded packages according to the seventh embodiment;

[0047] FIG. 11(b) is a plane view which illustrates a layout of the fin heat sinks of FIG. 11(a);

[0048] FIG. 12(a) is a cross sectional view, as taken along the line F-F' in FIG. 12(b), which illustrates fin heat sinks of adjacent two of resin molded packages according to the eighth embodiment;

[0049] FIG. 12(b) is a plane view which illustrates a layout of the fin heat sinks of FIG. 12(a); and

[0050] FIG. 13 is a plane view which shows a modification of the resin molded package, as illustrated in FIGS. 6(a) to 6(c).

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0051] Referring to the drawings, wherein like reference numbers refer to like parts in several views, there is shown a semiconductor module 1 with a cooling mechanism according to the first embodiment. The semiconductor module 1 is used with, for example, an inverter to drive a three-phase electric motor for automotive vehicles.

[0052] FIG. 1 is a vertical cross sectional front view which illustrates the semiconductor module 1. The semiconductor module 1 includes a stack of resin molded packages 10. Each of the resin molded packages 10 is equipped with a power semiconductor chip 11. The resin molded packages 10 are substantially identical in structure with each other, and the following discussion will be referred to only one of the resin molded packages 10 for the simplicity of disclosure.

[0053] FIGS. 2(a) to 2(c) illustrate the structure of the resin molded package 10. FIG. 2(a) is a front view of the resin molded package 10. FIG. 2(b) is a cross sectional view, as taken along the line A-A' of FIG. 2(a). FIG. 2(c) is a cross sectional view, as taken along the line B-B' of FIG. 2(c).

[0054] The resin molded package 10 also includes a metal block 12, heat spreaders 13 and 14, a positive electric terminal 15, a negative electric terminal 16, and signal terminals 17. The power semiconductor chip 11, the metal block 12, the heat spreaders 13 and 14, the positive electric terminal 15, the negative electric terminal 16, and the signal terminals 17 are molded by resin into a single resin mold assembly 20 as the resin molded package 10. The resin mold assembly 20 will also be referred to as a resin mold below. The resin molded package 10 is also equipped with fin heat sinks 18 and 19 to enhance dissipation of heat from the heat spreaders 13 and 14. The resin molded package 10 is of a 1-in-1 structure equipped with the single power semiconductor chip 11, but may alternatively be designed to have two or more power semiconductor chips 11. For example, the semiconductor unit 10 may be made as a 2-in-1 structure with two semiconductor chips 11 working as an upper and a lower arm of an inverter or as a 3-in-1 structure with three semiconductor chips 11 working as an upper arm or a low arm for three phases of an inverter.

[0055] The semiconductor chip 11 has mounted thereon the semiconductor power device such as an IGBT or a power MOSFET.

[0056] In the case where the power semiconductor chip 11 is equipped with an IGBT, it includes an accompanying free-wheeling diode (FWD) either connected anti-parallel to the IGBT or built into the IGBT itself. While in the case of a power MOSFET, it has a built-in anti-parallel diode, thus does not usually need an additional FWD. In this embodiment, the power semiconductor chip 11 is equipped with a semiconductor power device such as an IGBT which is of a vertical type in which electric current flows in a thickness-wise direction thereof. The power semiconductor device of the power semiconductor chip 11 is fabricated from a semiconductor substrate, and the top surface usually receives greater number of processes to become the negative side of a semiconductor chip, that is, the emitter for an IGBT and the source for a power MOSFET, which occupies the greatest area of the device. The top surface also has control and sensing terminals formed as pads. The entire area of the bottom surface of the

device 11 becomes the positive side of the switch, that is, the collector for an IGBT and the drain for a power MOSFET.

[0057] The semiconductor unit 10, as illustrated in FIGS. 2(a) to 2(c), is of a single chip structure, but may alternatively be engineered to have two chips: an active power device such as IGBT and an FWD. The power semiconductor chip 11 may have a horizontal type power semiconductor chip in which the current flows in a lateral direction of a substrate thereof.

[0058] The metal block 12 is made of a metal material such as copper or aluminum which has a high thermal conductivity. The metal block 12 is glued or soldered mechanically and electrically to the pad which is formed on the first surface of the power semiconductor chip 11 and connected to the emitter of the IGBT. The metal block 12 is disposed on the first surface of the power semiconductor chip 11 to secure an interval between the first surface of the power semiconductor chip 11 and the heat spreader 14.

[0059] Each of the heat spreaders 13 and 14 conducts heat generated in the power semiconductor chip 11 to be diffused widely. The heat spreader 13 is also joined mechanically and electrically to the pad on the second surface of the power semiconductor chip 11 and additionally serves as an electric lead coupled with the collector of the IGBT. The heat spreader 14 is secured mechanically and electrically to the metal block 12 and additionally serves as an electric lead coupled with the emitter of the IGBT. The surface of each of the heat spreaders 13 and 14 which is farther away from the power semiconductor chip 11 is not covered with the material of the resin mold assembly 20 and has affixed thereto a corresponding one of the fin heat sinks 18 and 19 exposed to a coolant such as water flowing therethrough.

[0060] The heat spreaders 13 and 14 also have installed thereon insulators, respectively, in order to keep the heat spreaders 13 and 14 of adjacent two of the resin molded packages 10 from short-circuiting therebetween through the coolant and are engineered to enable the fin heat sinks 18 and 19 to be attached thereto. Specifically, the heat spreader 13 includes a metal plate 13a, an insulating film 13b, and a metal film 13c. Similarly, the heat spreader 14 includes a metal plate 14a, an insulating film 14b, and a metal film 14c.

[0061] The metal plates 13a and 14a each function as a heat sink and a portion of an electric current flow path. Each of the metal plates 13a and 14a is made of metal such as copper that is high in thermal and electric conductivity and formed by an approximately square metal plate of a given thickness. The insulating films 13b and 14b are affixed to the surfaces of the metal plates 13a and 14a which are farther away from the power semiconductor chip 11. The insulating films 13b and 14b are made of an insulating material such as alumina and formed by means of a vapor phase epitaxial method such as sputtering, CVD, or spray coating. The surfaces of the metal plates 13a and 14a on which the insulating films 13b and 14b are to be formed are even without any irregularities, so that the thickness of the insulating films 13b and 14b is substantially constant. The metal films 13c and 14c are made of the same metal material as that of the fin heat sinks 18 and 19 or a metal material that is excellent at adhesion to the material of the fin heat sinks 18 and 19. The metal films 13c and 14c are made of, for example, aluminum. For the reasons, as described later, the thickness of the metal films 13c and 14c is determined in light of an inclination of the heat spreaders 13 and 14, in other words, an error in height thereof when the components thereof are stacked in layers.

[0062] The insulating films **13b** and **14b** are located closer to the coolant than the metal plates **13a** and **14a** which electrically connect to the power semiconductor chip **11**, thereby ensuring electric insulation of the heat spreaders **13** and **14** from the coolant and avoiding a short-circuit therebetween.

[0063] The positive electric terminal **15** is formed integrally with the heat spreader **13** or soldered or welded thereto, so that it is connected electrically to the second surface of the power semiconductor chip **11** which is the positive side of the semiconductor switch. The end of the positive electric terminal **15** is exposed from the resin mold assembly **20** for electric connection with an external circuit.

[0064] The negative electric terminal **16** is formed integrally with the heat spreader **14** or soldered or welded thereto, so that it is connected electrically to the pad which is formed on the first surface of the power semiconductor chip **11**, which is the negative side of the semiconductor switch. One end of the negative electric terminal **16** which is farther away from the heat spreader **14**, is exposed from the resin mold assembly **20** for electric connection with an external circuit.

[0065] The signal terminals **17** through which several different kinds of electric signals flow, such as a gate to turn the semiconductor switch on and off, a current monitor, a temperature monitor, and a signal ground. The signal terminals **17** are electrically joined at ends thereof to the pads formed on the first surface of the power semiconductor chip **11** with bonding wires **17a** and also exposed at other ends thereof outside the resin mold assembly **20** for electrical connections with an external device. The spacing between the first surface of the power semiconductor chip **11** and the heat spreader **18** is, as described above, created by the metal block **12**, thus ensuring the electrical connections of the power semiconductor chip **11** to the signal terminals **17** without physical and electrical interferences of the bonding wires **17a** with the heat spreader **14**.

[0066] The fin heat sinks **18** and **19** are joined to the outside surfaces of the heat spreaders **13** and **14**, that is, the surfaces of the metal films **13c** and **14c** by means of the ultrasonic welding. The fin heat sinks **18** and **19** may be of any of known structures and, in this embodiment, is of a waved fin type. FIG. **3(a)** is a front view of the fin heat sink **18**. FIG. **3(b)** is a cross sectional view of FIG. **3(a)**. The fin heat sink **18** is made of a single plate which is pressed into a corrugated shape in cross section. Six waved lines in FIG. **3(a)** represent six fins **18b** which extend in a direction along the line in FIGS. **2(a)** and **2(b)** and are corrugated in a vertical direction, as viewed in FIG. **3(a)**, i.e., a direction along the line B-B' in FIGS. **2(a)** and **2(c)**. Every adjacent two of the six fins **18b** (i.e., the six waved lines in FIG. **3(a)**) define a waved flow path which extends in the lateral direction of the drawing and through which the coolant flows. The six fins **18b** have ridges of the same height. FIGS. **3(a)** and **3(b)** are different in number of the corrugations from each other for the brevity of illustration. The same is true for FIGS. **2(a)**, **2(b)**, and **2(c)**. The fin heat sinks **18** and **19** are identical in structure and operation with each other, and the following explanation will refer only to the fin heat sink **18** for the brevity of disclosure.

[0067] Specifically, the fin heat sink **18** includes flat surface areas **18a** (i.e., troughs of the corrugations or protrusions, as viewed from the direction along the lines A-A' in FIGS. **2(a)** and **2(b)**) and the fins **18b**. The flat surface areas **18a** form the waved flow paths, as described above. The fins **18b** increase the entire surface area of the fin heat sink **18** from which the heat is dissipated. The fin heat sink **18** is made of the same

metal material as that of the metal films **13c** and **14c** of the heat spreaders **13** and **14** or a metal material that is excellent at adhesion to the material of the metal films **13c** and **14c**. The fin heat sink **18** is made of, for example, aluminum.

[0068] The formation of the resin mold assembly **20** is made in the following steps. A sub-assembly of components, i.e., the power semiconductor chip **11**, the metal block **12**, the heat spreaders **13** and **14**, the positive electrode lead **15**, the negative electrode lead **16**, and the control terminals **17** which are to be disposed in the resin molded package **10** and have been connected electrically or mechanically is first prepared. The sub-assembly is then put in a molding tool. Resin is injected into the molding tool. The resin mold assembly **20** is made up of two molds: a body **21** made of thermosetting resin and a shell **22** made of thermoplastic resin. The body **21** made of the thermosetting resin has the above components embedded therein. The shell **22** of thermoplastic resin functions as a frame to surround or wall the periphery of the body **21** of thermosetting resin.

[0069] The body **21** is made of thermosetting resin, for example, epoxy, phenol, silicon, or urethane and wraps or insulates the components of the resin molded package **10**. The body **21** of thermosetting resin is so shaped as to have the ends of the positive electric terminal **15**, the negative electric terminal **16**, and the signal terminals **17** extend outside it and the major surfaces of the heat spreaders **13** and **14** exposed outside it. Among the parts of the resin mold assembly **20**, only the body **21** made of thermosetting resin encapsulates the components of the resin molded package **10** in a watertight form. The body **21** made of thermosetting resin is of a rectangular shape and has two long side surfaces from one of which the positive electric terminal **15** and the negative electric terminal **16** extend and from the other of which the control terminals **16** extend. The body **21** made of thermosetting resin in which the components of the resin molded package **10** are disposed is usually referred to as a power card which is suitable for being reused.

[0070] The shell **22** is made of thermoplastic resin, for example, polyphenylene sulfide (PPS), polybutylene terephthalate, or nylon, polyethylene, or polypropylene resin and covers the periphery of the body **21** made of thermosetting resin so as to expose the ends of the positive electric terminal **15**, the negative electric terminal **16**, and the signal terminals **17** and the surfaces of the heat spreaders **13** and **14**. The shell **22** made of thermoplastic resin is formed as a frame of the resin mold assembly **20** and has formed therein rectangular windows **22a** and **22b**, as illustrated in FIG. **2(b)**, from which the surfaces of the heat spreaders **13** and **14** are exposed to the outside of the resin molded package **10**.

[0071] The shell **22** made of thermoplastic resin, as illustrated in FIG. **1**, defines a portion of a coolant path **30** working as a cooling mechanism through which cooling medium or refrigerant flows to cool the semiconductor module **1**. Specifically, the shell **22** made of thermoplastic resin is made of an enclosed oval plate with long side surfaces extending in parallel to the long side surfaces of the body **21** made of thermosetting resin. The shell **22** made of thermoplastic resin has oval holes **22c** and recesses **22d** formed therein. The holes **22c** are located in portions of the shell **22** made of thermoplastic resin which lie, as clearly illustrated in FIG. **2(a)**, outside the opposed ends of the body **21** made of thermosetting resin and define the portion of the coolant path **30**. The recesses **22d** are formed in the opposed major surfaces of the shell **22** made of thermoplastic resin. The recesses **22d** also

define, as can be seen from FIG. 1, a portion of the coolant path 30. Specifically, when the resin molded packages 10 are as illustrated in FIG. 1, stacked on top of another, the holes 22c and the recesses 22d of the blocks 22 made of thermoplastic resin complete the coolant path 30.

[0072] The shell 22 made of thermoplastic resin has formed in the peripheral edge thereof a seal mount groove 22e which extends around the recess 22d and in which an O-ring 42, as illustrated in FIGS. 1, 2(b), and 2(c), is inserted. When the resin molded packages 10 are, as illustrated in FIG. 1, stacked on top of another, the O-rings 42 for each of the resin molded packages 10 will be pressed against the adjacent resin molded package 10 to create a watertight seal therebetween which avoids the leakage of coolant flowing through the coolant path 30 to the outside of the resin mold assemblies 20.

[0073] The semiconductor module 1 also includes, as illustrated in FIG. 1, an upper cover 40, a lower cover 41, and clampers 43.

[0074] The upper cover 40 and the lower cover 41 are, as can be seen from FIG. 1, disposed on opposed ends of a stack of the resin molded package 10. The cover 40 is made of a plate shaped to conform to the contour of the resin mold assembly 20 of each of the resin molded packages 10. When the cover 40 is placed on the end of the stack of the resin molded packages 10, an air gap is created between the second surface of the cover 40 and the recess 22d of an uppermost one of the resin molded packages 10. The lower cover 41 is made of a plate contoured to conform with the contour of the resin mold assembly 20 of each of the resin molded package 10 and equipped with two pipes 41a and 41b. The pipes 41a and 41b extend substantially perpendicular to the lower cover 41 and communicate with the holes 22c of the resin molded packages 10 which are aligned to define the coolant path 30. The pipe 41a serves as a coolant inlet, while the pipe 41b serves as a coolant outlet. The lower cover 41 also has formed therein a seal mount groove 41c in which the O-ring 42 is fit.

[0075] The O-rings 42 are fit in the seal mount holes 22e of the resin molded packages 10 and the seal mount holes 41c of the lower cover 41 to develop hermetical seals between every adjacent two of the resin molded packages 10 and between the resin molded packages 10 and the upper and lower covers 40 and 41.

[0076] The clampers 43 function as fastener to firmly join the upper and lower covers 40 and 41 and a stack of the resin molded packages 10 in which the O-rings 42 are disposed in the grooves 22e and 41c to complete the semiconductor module 1. Specifically, each of the clampers 43, as can be seen in FIG. 1, clamps the upper and lower covers 40 and 41 to hold the assembly of the upper and lower cover 40 and 41 and the stack of the resin molded packages 10 tightly, thereby completing the coolant path 30 within the semiconductor module 1. Such an assembly will also be referred to as a module assembly below. The clampers 43 are detachable for disassembling the upper and lower covers 40 and 41 and the resin molded packages 10. Each of the clampers 43 has hooks formed at ends thereof. The interval between the hooks is smaller than the thickness of the module assembly of the upper and lower covers 40 and 41 and the stack of the resin molded packages 10, so that the hooks of each of the clampers 43 may clamp the upper and lower covers 40 and 41 elastically. Each of the clampers 43 may alternatively be designed to hold the module assembly using screws instead of the hooks.

[0077] The use of the O-rings 42 in the semiconductor module 1 constructed, as described above, creates the hermetic seals among the resin molded packages 10, the upper cover 40, and the lower cover 41, thus avoiding the leakage of the coolant from the coolant path 30 and ensuring a required degree of cooling the power semiconductor chips 11 of the resin molded packages 10. The heat spreaders 13 and 14 are equipped with the fin heat sinks 18 and 19 which are disposed in direct contact with the coolant flowing in the branch paths 33, thereby resulting in an increase in area of the heat spreaders 13 and 14 from which the heat is to be radiated or transferred to the coolant.

[0078] Specifically, the pipe 41a and one of the two holes 22c of the respective resin molded packages 10, as illustrated in FIG. 1, define an inlet flow path 31, while the pipe 41b and the other hole 22c of the respectively resin molded packages 10 define an outlet flow path 32. The recess 22c formed in the surface of each of the resin molded packages 10 define a branch path 33. The coolant (e.g., water) enters the pipe 41a, flows through the inlet flow path 31, diverges into the branch paths 33, and then discharges from the outlet flow path 32 through the pipe 41b. The coolant flows in direct contact with the heat spreaders 13 and 14 (i.e., the fin heat sinks 18 and 19) within the branch paths 33 and cools them, so that the heat, as generated by the power semiconductor chips 11, will be absorbed by the coolant.

[0079] The production method of the semiconductor module 1 will be described below with reference to FIGS. 4(a) to 5(c).

Step in FIG. 4(a)

[0080] The heat spreader 13 with a lead frame in which the positive electric terminal 15, the negative electric terminal 16, and the signal terminals 17 are disposed in place is prepared. The power semiconductor chip 11 on which the semiconductor power device such as an IGBT and/or an FWD is fabricated is soldered to the surface of the heat spreader 13. Afterwards, the pads formed on the surface of the power semiconductor chip 11 which connect with, for example, the gate of the IGBT are joined to the signal terminals 17 through the bonding wires 17a. Solder is put on the surfaces of the metal block 12 and the negative electric terminal 16. The heat spreader 14 with a lead frame is placed on the solder and joined to the metal block 12 and the negative electric terminal 16.

Step in FIG. 4(b)

[0081] The components of the resin molded package 10 which are connected together in the above manner are put in, for example, a transfer mold of a transfer molding machine. Thermosetting resin such as epoxy resin is injected into the transfer mold to form the body 21 made of thermosetting resin, thereby making the power card, as described above. The power card may have the outer major surfaces of the heat spreaders 13 and 14 exposed to the outside, however, is shaped in this embodiment to enclose the heat spreader 14 fully. The lead frames may be cut in this step.

[0082] The surface of each of the heat spreaders 13 and 14 may be inclined from a desired horizontal level due to dimension errors and/or assembling errors of the components such as the power semiconductor chip 11, the metal block 12, the heat spreaders 13 and 14, etc., thus resulting in nonparallel orientation between the heat spreaders 13 and 14. Therefore, in the case where either of the outer surfaces of the heat spreaders 13 and 14 is exposed directly from the body 21 made of thermosetting resin, when the heat spreaders 13 and 14 are pressed inwardly by upper and lower mold plates to

form the body **21** made of thermosetting resin, it may result in local exertion of pressure on the heat spreaders **13** and **14**, which causes damage to the power semiconductor chip **11** or the solder layers. In order to avoid this problem at least one of the heat spreaders **13** and **14** (i.e., the heat spreader **14** in this embodiment) is covered with, that is, embedded in the body **21** made of thermosetting resin.

Step in FIG. 4(c)

[0083] A portion of the body **21** made of thermosetting resin with which the outer surface of the heat spreader **14** is covered is removed by cutting or grinding it using a flatter machine to expose the outer surface of the heat spreader **14** outside the body **21** made of thermosetting resin. Simultaneously or subsequently, the outer surfaces of the heat spreaders **13** and **14** are also machined or removed until they are in parallel to each other, in other words, lie flush with the given horizontal level, thereby compensating for the inclination of the heat spreader **13** or **14** due to the dimensional or assembling errors of the components thereof. The surface of an outermost one of the components of each of the heat spreaders **13** and **14** (i.e., the metal film **13c** or **14c**) is necessarily machined. The thickness of the metal films **13c** and **14c** is, therefore, so determined as to cover the entire surfaces of the insulating films **13b** and **14b** even after the outer surfaces of the heat spreaders **13** and **14** are machined and oriented substantially parallel to each other.

[0084] Specifically, the firm welding of the fin heat sinks **18** and **19** to the bodies of the heat spreaders **13** and **14** requires the need for the metal films **13c** and **14c** to be left over the entire surfaces of the insulating films **13b** and **14b**, respectively. The thickness of the metal films **13c** and **14c** is, therefore, selected to be greater than a maximum error of height of the surfaces of the heat spreaders **13** and **14** arising from a maximum accumulated dimensional or assembling error of the components thereof.

[0085] Each of the heat spreaders **13** and **14** is of a three-layer structure made up of one of the metal plates **13a** and **14a**, one of the insulating films **13b** and **14b**, and one of the metal films **13c** and **14c**, however, FIGS. 4(d), 4(e), and 5(a) to 5(c) simplistically show the heat spreaders **13** and **14** for the brevity of illustration.

Step in FIG. 4(d)

[0086] The power card formed by the body **21** made of thermosetting resin into which the above components are resin-molded is put in another mold. Thermoplastic resin such as polyphenylene sulfide is injected into the mold to form the shell **22** made of thermoplastic resin.

[0087] Step in FIG. 4(e)

[0088] The fin heat sinks **18** and **19** are attached by the ultrasonic welding to the surfaces of the heat spreaders **13** and **14** which are exposed outside the body **21** made of thermoplastic resin.

[0089] Specifically, the sub-assembly, as produced by the steps of FIGS. 4(a) to 4(d), is secured at a bottom surface thereof (i.e., the outer surface of the heat spreader **13**) to a stage (i.e., a table) of an ultrasonic welding machine. Next, the fin heat sink **19** is placed on the upper surface (i.e., the outer surface of the heat spreader **14**) of the sub-assembly. A welding tool which is shaped to conform with the contour of the fin heat sink **19** is positioned to the fin heat sink **19**. The ultrasonic welding machine then applies pressure to the welding tool to press the fin heat sink **19** against the heat spreader **14** and welds the fin heat sink **19** to the metal film **14c** in the known ultrasonic welding manner.

[0090] Subsequently, the sub-assembly is removed from the ultrasonic welding machine, turned upside down, and placed at the upper surface thereof (i.e., the fin heat sink **19**) on the table of the ultrasonic welding machine. Specifically, the fin heat sink **19** is secured firmly to the table of the ultrasonic welding machine. Next, the fin heat sink **18** is put on the heat spreader **13** and then welded to the metal film **13c**, thereby completing the resin molded package **10**.

Step in FIG. 5(a)

[0091] A plurality of the resin molded packages **10** each of which has been produced in the steps of FIGS. 4(a) to 4(e) are prepared. For example, the three resin molded packages **10** are prepared. The O-rings **42** are fitted in the grooves **22e** of the shells **22** of the resin molded packages **10** and placed to overlap each other to make a packages stack.

Step in FIG. 5(b)

[0092] The upper and lower covers **40** and **41** are prepared. The O-ring **42** is fitted in the seal mount groove **41c** of the lower cover **41**. The upper cover **40** is placed on one of opposed ends of the package stack, while the lower cover **41** is placed on the other end of the package stack. Such an assembly will also be referred to as a module assembly below.

Step in FIG. 5(c)

[0093] The package stack and the upper and lower cover **40** and **41** which are assembled in the above steps are retained tightly by the clamps **43** to complete the semiconductor module **1**, as illustrated in FIG. 1.

[0094] As apparent from the above discussion, the semiconductor module **1** of this embodiment is made up of a stack of the resin molded package **10**. Note that semiconductor module **1** may alternatively be designed to have only one semiconductor unit **1**. The semiconductor unit **1** is equipped with the heat spreaders **13** and **14**. The heat spreader **13** includes two discrete parts: the body of the heat spreader **13** and the fin heat sink **18**. The body of the heat spreader **13** is made by an assembly of the metal plate **13a**, the insulating film **13b**, and the metal film **13c**. The fin heat sink **18** is joined or welded to the surface of the body of the heat spreader **13**. The insulating film **13b** serves to avoid the leakage of electricity from inside to outside the heat spreader **13**. The fin heat sink **18** is formed separately from the body of the heat spreader **13**, thus facilitating ease of machining the fin heat sink **18** to have a complex shape. The same is true for the heat spreader **14** and the fin heat sink **19**.

[0095] In the case where, for example, the fin heat sink **18** and the heat spreader **13** are formed by a one-piece member, a molding tool which is shaped to have holes into which the fins of the fin heat sink **18** are to be inserted needs to be used in order to keep resin from entering between the fins of the fin heat sink **18** during the molding of the body **21** made of thermosetting resin. The use of such a molding tool results in a difficulty in positioning the fins of the fin heat sink **18** relative to the holes of the molding tool and leads to a concern about undesirable deformation, breakage, or contamination of the fins of the fin heat sink **18**. Additionally, a variation in height of the fins of the fin heat sink **18** may result in undesirable inclination of the sub-assembly, for example, when the shell **22** made of thermoplastic resin is molded.

[0096] The structure of the heat spreaders **13** and **14** of this embodiment permits the resin molded package **10** to be formed in a simplified manner and eliminates the above problems.

[0097] The semiconductor module **1** according to the second embodiment will be described below which is different in

structure of the resin molded package **10** to ensure high-precision positioning of the heat spreaders **13** and **14** from that of the first embodiment. Other arrangements are identical, and explanation thereof in detail will be omitted here.

[0098] FIGS. **6(a)** to **6(c)** illustrate the structure of the resin molded package **10** of the second embodiment. FIG. **6(a)** is a front view of the resin molded package **10**. FIG. **6(b)** is a cross sectional view, as taken along the line C-C' of FIG. **6(a)**, FIG. **6(c)** is a cross sectional view, as taken along the line D-D' of FIG. **6(a)**.

[0099] Specifically, the body **21** made of thermosetting resin has, as can be seen from FIG. **6(a)**, a rectangular positioning recess or shoulder **21a** formed in each of the opposed major surfaces thereof. Each of the positioning shoulders **21a** extends just around the circumference of a corresponding one of the heat spreaders **13** and **14**. In other words, an inner edge of each of the positioning shoulders **21a** is shaped to conform with the contour of the circumferential edge of one of the heat spreaders **13** and **14**. The positioning shoulders **21a** are slightly greater in size than the heat spreaders **13** and **14**. When, for example, the fin heat sink **19** is placed on the body of the heat spreader **14** to be welded thereto, the positioning shoulders **21a** works to position or guide the placement of the fin heat sink **19** onto the metal film **14c**. The same is true for the heat sink **18**.

[0100] Instead of the positioning shoulders **21a**, the opposed surfaces of the body **21** made of thermosetting resin may alternatively extend stepwise to, in other words, may be oriented not to lie flush with the opposed surfaces of the shell **22** made of thermoplastic resin to define rectangular shoulders. The outer edges of the windows **22a** and **22b**, therefore, work, like the positioning shoulders **21a**.

[0101] The semiconductor module **1** according to the third embodiment will be described below which is different in welding of the fin heat sinks **18** and **19** to the bodies of the heat spreaders **13** and **14** from that of the first embodiment. Other arrangements are identical, and explanation thereof in detail will be omitted here. The following discussion will refer only to the heat spreader **14** for the brevity of disclosure.

[0102] FIG. **7** is a transverse sectional view, as taken along the same line as in FIG. **2(b)**, which illustrates the internal structure of the resin molded package **10** of the third embodiment.

[0103] Specifically, the body of the heat spreader **14** of this embodiment is, as clearly illustrated in the drawing, made only of a metal plate, like the metal plate **14a**. The fin heat sink **19** is glued directly to the outer surface of the body of the heat spreader **14** through an adhesive layer **50**. The adhesive layer **50** may be provided with electric conductivity as well as thermal conductivity, either in the form of adhesive paste or adhesive sheet material. The attaching of the fin heat sink **19** to the heat spreader **14** is achieved by applying the adhesive layer **50** over the outer surface of the body of the heat spreader **14** of the sub-assembly, as produced in steps of FIGS. **4(a)** to **4(d)**, and attaching the fin heat sink **19** to the adhesive layer **50**. The attaching of the fin heat sink **18** to the heat spreader **13** is the same as that of the fin heat sink **19** to the heat spreader **14**, and explanation thereof in detail will be omitted here.

[0104] The body of the heat spreader **14** of this embodiment is, as described above, made only of a metal plate, like the metal plate **14a**, however, may include the insulating film **14b**.

[0105] When the material of, for example, the fin heat sink **19** is different from that of body of the heat spreader **14**, a

change in temperature thereof will cause thermal stress to be exerted on the adhesive layer **50**. In order to minimize such thermal stress, the fin heat sink **19** and the body of the heat spreader **14** are preferably made of the same material. The use of the adhesive layer **50** eliminates the need for the ultrasonic-welding of the fin heat sink **19** to the heat spreader **14**, thus eliminating the need for the metal film **14**. The electric insulation of the fin heat sink **19** from the body of the heat spreader **14** may be achieved by making the adhesive layer **50** of an insulating material. The adhesive layer **50**, thus, works as the insulating film **14b**, thus eliminating the need for attaching the insulating film **14b** to the metal plate. The same applies to the fin heat sink **18** and the heat spreader **13**.

[0106] The semiconductor module **1** according to the fourth embodiment will be described below which is different in layout of fins **18b** and **19b** of the fin heat sinks **18** and **19** from that of the first embodiment. Other arrangements are identical, and explanation thereof in detail will be omitted here.

[0107] FIGS. **8(a)** and **8(b)** illustrate the fin heat sinks **18** and **19** of adjacent two of the resin molded packages **10** of the semiconductor module **1**. FIG. **8(a)** is a side view of the fins **18b** and **19b** disposed within the branch path **33** between adjacent two of the resin molded packages **10**, as viewed from the right side of FIG. **1**. FIG. **8(b)** is a schematic illustration of layouts of the fins **18b** and **19b** of the fin heat sinks **18** and **19**, as viewed from the top of FIG. **1**. FIGS. **8(a)** and **8(b)** are, like FIGS. **2(a)** to **2(c)**, different in number of the corrugations from each other for the brevity of illustration.

[0108] The fin heat sink **18** is, like in the first embodiment, made up of a plurality of fins **18b** which extend parallel to the flow of the coolant within the branch path **33** (i.e., a direction perpendicular to a direction in which the resin molded packages **10** are stacked). Similarly, the fin heat sink **19** is made up of a plurality of fins **19b** which extend parallel to the flow of the coolant within the branch path **33**. FIG. **8(b)** shows each of the heat spreaders **13** and **14** as having the six fins **18b** or **19b**, however, FIG. **8(a)** shows each of the heat spreaders **13** and **14** as having the three fins **18b** or **19b** for the brevity of illustration. The fins **18b** of the fin heat sink **18** of each of the resin molded packages **10** are, as clearly illustrated in FIGS. **8(a)**, aligned with the fins **19b** of the fin heat sink **19** of an adjacent one of the resin molded package **10** in the thickness-wise direction of the resin molded package **10**. The fins **18b** are, as can be seen from FIG. **8(b)**, arrayed 180° out of phase with the fins **19b**. In other words, the corrugations of the fins **18b** are located 180° out of phase with those of the fins **19b** in the direction of the flow of the coolant in the branch path **33**. The tips (i.e., ridges) of the fins **18b** are located at a given interval away from the tips (i.e., ridges) of the fins **19b**.

[0109] The above described 180° out-of-phase layouts of the fins **18b** and **19b** of the fin heat sinks **18** and **19** create lots of turbulent or eddy flows of the coolant within each of the branch paths **33** of the semiconductor module **1**, thus enhancing the cooling performance of the heat spreaders **13** and **14**. Note that the fins **18b** may be positioned out of phase with the fins **19b** by an angle other than 180°.

[0110] The semiconductor module **1** according to the fifth embodiment will be described below which is different in structure of the fin heat sinks **18** and **19** from that of the first embodiment. Other arrangements are identical, and explanation thereof in detail will be omitted here.

[0111] FIGS. **9(a)** and **9(b)** illustrate the fin heat sinks **18** and **19** of adjacent two of the resin molded packages **10** of the

semiconductor module **1**. FIG. **9(a)** is a plane view of the fin heat sink **18**. FIG. **9(b)** is a side view of the fins **18b** and **19b** extending within the branch path **33** between adjacent two of the resin molded packages **10**, as viewed from the right side of FIG. **1**.

[0112] Each of the fin heat sinks **18** and **19** made of a flat plate and an array of straight strips extending perpendicular to the flat plate to define the fins **18b**. The fins **18b** also extend parallel to each other (i.e., parallel to the flow of the coolant in the branch path **33**) to define the flat surface areas **18a** therebetween and outside outermost two of the fins **18b**. Each of the fins **18b** of the fin heat sink **18** of one of the resin molded packages **10**, as can be seen from FIG. **9(b)**, faces one of the fins **19b** of the fin heat sink **19** of an adjacent one of the resin molded packages **10** in alignment with one another in the thickness-wise direction of the resin molded packages **10**. Top ends of the fins **18b** are located at a given interval (i.e., an air gap) away from those of the fins **19b**.

[0113] FIG. **10** illustrates the fin heat sinks **18** and **19** according to the sixth embodiment which is a modification of the fifth embodiment. FIG. **10** is a side view of the fins **18b** and **19b** extending within the branch path **33** between adjacent two of the resin molded packages **10**, as viewed from the right side of FIG. **1**.

[0114] Each of the fins **18b** and **19b** has a height greater than that in the fifth embodiment of FIGS. **9(a)** and **9(b)**. Specifically, the fins **18b** are, as can be seen from the drawing, arrayed out of alignment with the fins **19b** in the thickness-wise direction of the resin molded package **10** (i.e., a direction in which the resin molded packages **10** are laid to overlap each other as the package stack). In other words, the fins **18b** are staggered relative to the fins **19b** so that the fins **18b** partially overlap the fins **19b** in a direction perpendicular to the direction of the flow of the coolant in the branch path **33** (i.e., a direction perpendicular to the length of the fins **18b** and **19b**). This layout of the fins **18b** and **19b** serves to create highly turbulent eddy flows of the coolant within each of the branch paths **33** of the semiconductor module **1**, thus enhancing the cooling performance of the heat spreaders **13** and **14**.

[0115] The semiconductor module **1** according to the seventh embodiment will be described below which is different in structure of the fin heat sinks **18** and **19** from that of the first embodiment. Other arrangements are identical, and explanation thereof in detail will be omitted here.

[0116] FIGS. **11(a)** and **11(b)** illustrate the fin heat sinks **18** and **19** of adjacent two of the resin molded packages **10** of the semiconductor module **1**, FIG. **11(a)** is a cross sectional view, as taken along the line E-E' in FIG. **11(b)**. FIG. **11(b)** is a plane view which illustrates a layout of the fin heat sinks **18** and **19**. White circles indicate the fins **18b** of the fin heat sink **18**, while black circles indicate the fins **19b** of the fin heat sink **19**.

[0117] Each of the fin heat sinks **18** and **19** is of a pin type. Specifically, each of the fin heat sinks **18** and **19** is made up of a flat plate and a matrix of pins protruding perpendicular to the flat plate to define the fins **18b**. An area of the flat plate other than the fins **18b** or **19b** is the flat surface area **18a** or **19a**.

[0118] The fins **18b** are, as illustrated in FIG. **11(b)**, arranged in, for example, five arrays (columns) extending parallel to the flow of the coolant in the branch path, while the fins **19b** are arrayed in, for example, four arrays. Additionally, the fins **18b** are also arranged in, for example, twelve arrays (rows) extending perpendicular to the flow of the coolant in the branch path, while the fins **19b** are arrayed in for example,

eleven arrays (rows). These arrangements define a matrix layout of the fins **18b** and **19b** in which each of the fins **19b** is located at the middle of every surrounding four of the fins **18b**. In other words, the fins **18b** are staggered relative to the fins **19b** in vertical and lateral directions, as viewed in FIG. **11(b)**.

[0119] The height of the fins **18b** and **19b** is so selected that the fins **18b** and **19b** partially overlap one another in the direction of the flow of the coolant, as viewed in FIG. **11(a)**. The fins **18b** and **19b** do not physically interfere with one another, in other words, tops of the fins **18b** are located at a given interval (i.e., an air gap) away from those of the fins **19b**. These layouts of the fins **18b** and **19b** serve to create highly turbulent eddy flows of the coolant within each of the branch paths **33** of the semiconductor module **1**, thus enhancing the cooling performance of the heat spreaders **13** and **14**.

[0120] The semiconductor module **1** according to the eighth embodiment will be described below which is different in layout of the fin heat sinks **18** and **19** from that of the seventh embodiment. Other arrangements are identical, and explanation thereof in detail will be omitted here.

[0121] FIGS. **12(a)** and **12(b)** illustrate the fin heat sinks **18** and **19** of adjacent two of the resin molded packages **10** of the semiconductor module **1**, FIG. **12(a)** is a cross sectional view, as taken along the line F-F' in FIG. **12(b)**. FIG. **12(b)** is a plane view which illustrates a layout of the fin heat sinks **18** and **19**. White circles indicate the fins **18b** of the fin heat sink **18**, while black circles indicate the fins **19b** of the fin heat sink **19**.

[0122] Each of the fin heat sinks **18** and **19** is, like in the seventh embodiment, of a pin type.

[0123] The fins **18b** are, as illustrated in FIG. **12(b)**, arranged in six pairs of arrays extending perpendicular to the flow of the coolant in the branch path, while the fins **19b** are arrayed in, for example, five pairs of arrays extending parallel to the arrays of the fins **18b**. The six pairs of arrays of the fins **18b** and the five pairs of arrays of the fins **19b** are, as can be seen in FIG. **12(b)**, interleaved alternately in the direction of the flow of the coolant. In other words, the fins **18b** and **19b** lie alternately along each of lines extending parallel to the flow of the coolant.

[0124] In the layouts of the fins **18b** and **19b** of FIGS. **11(a)** and **11(b)**, each of the pin arrays extending parallel to the flow of the coolant is made up of only either of the fins **18b** or the fins **19b**. The tops of the fins **18b** of one of the resin molded package **10** are, as described above, located away from the flat plate (i.e., the flat surface area **19a**) of the fin heat sink **19** of an adjacent one of the resin molded package **10** through the gap. The gap, thus, defines a flow path along which the coolant will flow within the branch path **33**. The same is true for the arrays of the fins **19b**.

[0125] In the layouts of the fins **18b** and **19b** of this embodiment, each of the pin arrays extending parallel to the flow of the coolant is made up of the fins **18b** and **19b** lying alternately. In other words, each of flows of the coolant along the pin arrays will be as indicated by an arrow in FIG. **12(a)**, disrupted or blocked by either of the fins **18b** or **19b**. This ensures the formation of the turbulent or eddy flows of the coolant within each of the branch paths **33** of the semiconductor module **1**, thus further enhancing the cooling performance of the fin heat sinks **13** and **14**.

[0126] While the present invention has been disclosed in terms of the preferred embodiments in order to facilitate better understanding thereof, it should be appreciated that the invention can be embodied in various ways without departing

from the principle of the invention. Therefore, the invention should be understood to include all possible embodiments and modifications to the shown embodiments which can be embodied without departing from the principle of the invention as set forth in the appended claims.

[0127] For example, the body **21** and the shell **22** may be both made of either of thermosetting resin or thermoplastic resin. It is, however, advisable that the body **21** in which the power semiconductor chip **11**, etc., is embedded be made of thermosetting resin in terms of the thermal endurance. Alternatively, in order to permit the shell **22** to be softened at relatively low temperatures and removed for reuse of the resin molded package **10**, the shell **22** is preferably made of thermoplastic resin.

[0128] The semiconductor module **1** has been described as being used in the inverter for driving the three-phase electric motor, but may alternatively be used with other types of electrical devices.

[0129] FIG. **13** shows a modification of the structure of the resin molded package **10** of the second embodiment, as illustrated in FIGS. **6(a)** to **6(c)**.

[0130] The body **21** of the second embodiment has the positioning shoulder **21a** formed in each of the opposed major surfaces thereof. The whole of the upright wall of each of the positioning shoulders **21a** faces one of the fin heat sinks **18** and **19**. The positioning shoulders **21a** may be designed to have another configuration. In the modification of the resin molded package **10** of FIG. **13**, each of the positioning shoulders **21a** is shaped to have opposed side walls which at least partially extend around the holes **22c** defining the coolant path **30**. The other side walls of the positioning shoulder **21a** extend parallel to the length of the fin heat sink **18** or **19**. This configuration of each of the positioning shoulders **21a** also serves to guide the placement of a corresponding one of the fin heat sinks **18** and **19** on the body of the heat spreader **13** or **14**.

[0131] The coolant flowing through the coolant path **30** may be water or another type of cooling medium. Each of the fin heat sinks **18** and **19** may alternatively be of another typical corrugated type or flared type.

[0132] The semiconductor module **1** may be made to include the only one resin molded package **10** which is retained tightly between the upper and lower covers **40** and **41** through the clampers **43**.

What is claimed is:

1. A semiconductor module comprising:

a resin molded package which includes a resin mold, the resin mold having embedded therein a power semiconductor chip which has a first and a second surface opposed to each other and on which a semiconductor power device is fabricated, a first heat spreader, a second heat spreader, and electric terminals coupled electrically with the semiconductor power device, the first heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the first surface of the power semiconductor chip, the second heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the second surface of the power semiconductor chip, a portion of each of the electric terminals being exposed outside the resin mold, the resin mold also having formed therein a coolant path that

is a portion of a coolant path through which a coolant flows to cool the semiconductor chip;

first and second insulating films disposed over the second flat surfaces of the first and second heat spreaders, respectively;

first and second fin heat sinks joined to the first and second insulating films, respectively;

a first cover disposed on a first surface of the resin molded package;

a second cover disposed on a second surface of the resin molded package; and

a fastener which fastens the first and second covers to hold the resin molded package.

2. A semiconductor module as set forth in claim **1**, wherein the resin mold has formed therein positioning recesses which are shaped to conform with contour of the first and second fin heat sinks and serve to position the first and second fin heat sinks.

3. A semiconductor module as set forth in claim **1**, wherein the first heat spreader has a first metal plate disposed on the semiconductor chip, the first insulating film disposed on a surface of the first metal plate that is the second surface of the first heat spreader, and a first metal film disposed on the first insulating film away from the first metal plate, wherein the second heat spreader has a second metal plate disposed on the semiconductor chip, the second insulating film disposed on a surface of the second metal plate that is the second surface of the second heat spreader, and a second metal film disposed on the second insulating film and electrically kept away from the second metal plate, and wherein the first and second fin heat sinks are welded to the first and second metal films, respectively.

4. A semiconductor module as set forth in claim **1**, wherein the first and second fin heat sinks are attached to the second flat surfaces of the first and second heat spreaders through first and second adhesive layers, respectively, wherein the first and second adhesive layers are made of an insulating material and form the first and second insulating films, respectively, and wherein the first and second heat spreaders are made of the same material as that of the first and second fin heat sinks.

5. A semiconductor module comprising:

a resin molded package which includes a resin mold, the resin mold having embedded therein a power semiconductor chip which has a first and a second surfaces opposed to each other and on which a semiconductor power device is fabricated, a first heat spreader, a second heat spreader, and electric terminals coupled electrically with the semiconductor power device, the first heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the first surface of the semiconductor chip, the second heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the second surface of the power semiconductor chip, a portion of each of the electric terminals being exposed outside the resin mold, the resin mold also having formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the semiconductor chip;

first and second fin heat sinks joined to the second flat surfaces of the first and second heat spreaders through first and second adhesive layers, respectively, the first

and second adhesive layers being made of material exhibiting electric conductivity;
 a first cover disposed on a first surface of the resin molded package;
 a second cover disposed on a second surface of the resin molded package; and
 a fastener which fastens the first and second covers to hold the resin molded package.

6. A semiconductor module comprising:

a plurality of resin molded packages each of which includes a resin mold, the resin molded packages being laid to overlap each other as a package stack, the resin mold having embedded therein a power semiconductor chip which has a first and a second surface opposed to each other and on which a semiconductor power device is fabricated, a first heat spreader, a second heat spreader, and electric terminals coupled electrically with the semiconductor power device, the first heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the first surface of the semiconductor chip, the second heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the second surface of the power semiconductor chip, a portion of each of the electric terminals being exposed outside the resin mold, the resin mold also having formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the power semiconductor chip;
 first and second insulating films disposed over the second flat surfaces of the first and second heat spreaders of each of the resin molded packages, respectively;
 first and second fin heat sinks joined to the first and second insulating films of each of the resin molded packages, respectively, so that adjacent two of the resin molded packages are arranged to have the first and second fin heat sink facing one another;
 a first cover disposed on a first surface of the package stack;
 a second cover disposed on a second surface of the package stack; and
 a fastener which fastens the first and second covers to hold the package stack.

7. A semiconductor module as set forth in claim 6, wherein each of the first and second fin heat sinks is equipped with corrugated fins, and wherein the fins of the first fin heat sink of one of adjacent two of the resin molded packages are arrayed 180° out of phase with the fins of the second fin heat sink of the other of adjacent two of the resin molded packages.

8. A semiconductor module as set forth in claim 6, wherein each of the first and second fin heat sinks is equipped with an array of straight strips which define fins, and wherein the fins of the first fin heat sink of one of adjacent two of the resin molded packages are aligned with the fins of the second fin heat sink of the other of adjacent two of the resin molded packages through a gap in a direction in which the resin molded packages are laid to overlap each other as the package stack.

9. A semiconductor module as set forth in claim 6, wherein each of the first and second fin heat sinks is equipped with an array of straight strips which define fins, and wherein tops of the fins of the first fin heat sink of one of adjacent two of the resin molded packages overlap tops of the fins of the second fin heat sink of the other of adjacent two of the resin molded

packages in a direction perpendicular to a direction in which the resin molded packages are laid to overlap each other as the package stack.

10. A semiconductor module as set forth in claim 6, wherein each of the first and second fin heat sinks is equipped with a plurality of pins which define fins, wherein tops of the fins of the first fin heat sink of one of adjacent two of the resin molded packages overlap tops of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in a first direction perpendicular to a second direction in which the resin molded packages are laid to overlap each other as the package stack, and wherein the fins of the first fin heat sink of one of adjacent two of the resin molded packages are staggered to the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in the first direction.

11. A semiconductor module as set forth in claim 6, wherein each of the first and second fin heat sinks is equipped with a plurality of pairs of arrays of pins which define fins, wherein tops of the fins of the first fin heat sink of one of adjacent two of the resin molded packages overlap tops of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in a first direction perpendicular to a second direction in which the resin molded packages are laid to overlap each other as the package stack, and wherein the pairs of the arrays of the fins of the first fin heat sink of one of adjacent two of the resin molded packages are staggered to the pairs of the arrays of the fins of the second fin heat sink of the other of adjacent two of the resin molded packages in the first direction.

12. A method of producing a semiconductor module which includes a resin molded package and a coolant path comprising:

a first step of preparing a semiconductor sub-assembly of a power semiconductor chip, a first heat spreader, a second heat spreader, and electric terminals, the semiconductor chip having a first and a second surface opposed to each other and being equipped with a semiconductor power device connecting with the electric terminals;
 a second step of placing the semiconductor sub-assembly in a given molding tool and making a resin mold in which the semiconductor sub-assembly is disposed as the resin molded package, the first heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the first surface of the power semiconductor chip, the second heat spreader having a first surface and a second flat surface opposed to the first surface and being disposed at the first surface thereof in connection with the second surface of the power semiconductor chip, a portion of each of the electric terminals being exposed outside the resin mold, the resin mold also having formed therein a coolant path that is a portion of a coolant path through which a coolant flows to cool the power semiconductor chip; and
 a third step of holding the resin molded package through covers to complete the semiconductor module,
 wherein the first heat spreader has a first metal plate disposed on the power semiconductor chip, the first insulating film disposed on a surface of the first metal plate that is the second surface of the first heat spreader, and a first metal film disposed on the first insulating film and electrically kept away from the first metal plate, wherein the second heat spreader has a second metal plate disposed on the power semiconductor chip, the second insulating film disposed on a surface of the second metal

plate that is the second surface of the second heat spreader, and a second metal film disposed on the second insulating film and electrically kept away from the second metal plate, and wherein the first and second fin heat sinks are joined to the first and second metal films, respectively, through ultrasonic welding.

13. A method as set forth in claim **12**, wherein the second step forms the resin mold so as to cover the semiconductor sub-assembly fully and then removes a portion of the resin mold so as to expose one of the first and second metal films.

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