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### SEMICONDUCTOR PACKAGE INCLUDING REDISTRIBUTION SUBSTRATE

#### Abstract

A semiconductor package includes a lower semiconductor chip disposed on a lower redistribution substrate, lower solder patterns disposed between the lower redistribution substrate and the lower semiconductor chip, conductive structures disposed on the lower redistribution substrate, a lower molding layer disposed on the lower redistribution substrate and covering a top surface of the lower semiconductor chip, an upper redistribution substrate disposed on the lower molding layer and electrically connected to the conductive structures, an upper semiconductor chip disposed on the upper redistribution substrate, upper solder patterns disposed between the upper redistribution substrate and the upper semiconductor chip, and an upper molding layer disposed on the upper redistribution substrate and covering a sidewall of the upper semiconductor chip. The number of the conductive structures is greater than that of chip pads of the upper semiconductor chip.

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## Background/Summary

CROSS-REFERENCE TO RELATED APPLICATION [0001] This application is a Continuation of U.S. patent application Ser. No. 17/648,424, filed on Jan. 20, 2022, which claims priority under 35 U.S.C. § 119 to Korean Patent Application No. 10-2021-0030289, filed on Mar. 8, 2021 in the Korean Intellectual Property Office, the disclosures of which are incorporated by reference herein in their entireties.

### TECHNICAL FIELD

[0002] The present inventive concepts relate to a semiconductor package, and more particularly, to a semiconductor package including a redistribution substrate.

### DISCUSSION OF THE RELATED ART

[0003] Semiconductor packages are used to protect and provide electrical connections for integrated circuit chips for use in electronic products. A semiconductor package may be used to mount a semiconductor chip on a printed circuit board. Bonding wires or bumps may then be used to electrically connect the semiconductor chip to the printed circuit board.

### SUMMARY

[0004] A semiconductor package includes a lower redistribution substrate; a first lower semiconductor chip mounted on a top surface of the lower redistribution substrate; a plurality of first lower solder patterns disposed between the lower redistribution substrate and the first lower semiconductor chip; a plurality of conductive structures disposed on the top surface of the lower redistribution substrate and laterally spaced apart from the first lower semiconductor chip; a lower molding layer disposed on the top surface of the lower redistribution substrate, the lower molding layer covering sidewalls of the conductive structures and a top surface of the first lower semiconductor chip; an upper redistribution substrate disposed on the lower molding layer and the conductive structures, the upper redistribution substrate being electrically connected to the conductive structures; a first upper semiconductor chip mounted on a top surface of the upper redistribution substrate; a plurality of first upper solder patterns disposed between the upper redistribution substrate and the first upper semiconductor chip; and an upper molding layer covering a sidewall of the first upper semiconductor chip and exposing a top surface of the first upper semiconductor chip. The lower molding layer extends between the lower redistribution substrate and the first lower semiconductor chip and covers sidewalls of the first lower solder patterns. The upper molding layer extends between the upper redistribution substrate and the first upper semiconductor chip and covers sidewalls of the first upper solder patterns. Resistivity of the conductive structures is less than resistivity of the first lower solder patterns. The number of the

conductive structures is the same as or greater than the number of a plurality of first upper chip pads of the first upper semiconductor chip. The lower redistribution substrate includes: a redistribution pattern disposed in a lower dielectric layer, the redistribution pattern including a via portion and a wire portion; and a seed pattern disposed on a bottom surface of the redistribution pattern. A width at a top surface of the via portion is greater than a width at a bottom surface of the via portion. The upper redistribution substrate includes: a redistribution layer disposed in an upper dielectric layer, the redistribution layer including a via pattern and a wire pattern; and an upper seed pattern disposed on a bottom surface of the redistribution layer. A width at a top surface of the via pattern is greater than a width at a bottom surface of the via pattern.

[0005] A semiconductor package includes a lower redistribution substrate; a first lower semiconductor chip mounted on a top surface of the lower redistribution substrate; a plurality of first lower solder patterns disposed between the lower redistribution substrate and the first lower semiconductor chip; a second lower semiconductor chip mounted on the top surface of the lower redistribution substrate; a plurality of second lower solder patterns disposed between the lower redistribution substrate and the second lower semiconductor chip; a conductive structure disposed on the top surface of the lower redistribution substrate; a lower molding layer disposed on the top surface of the lower redistribution substrate, the lower molding layer covering a top surface of the first lower semiconductor chip and a top surface of the second lower semiconductor chip; an upper redistribution substrate disposed on the lower molding layer and the conductive structure, the upper redistribution substrate being electrically connected to the conductive structure; a first upper semiconductor chip mounted on the upper redistribution substrate; a plurality of first upper solder patterns disposed between the upper redistribution substrate and the first upper semiconductor chip; a second upper semiconductor chip mounted on the upper redistribution substrate and laterally spaced apart from the first upper semiconductor chip; a plurality of second upper solder patterns disposed between the upper redistribution substrate and the second upper semiconductor chip; and an upper molding layer disposed on a top surface of the upper redistribution substrate, the upper molding layer covering a sidewall of the first upper semiconductor chip and a sidewall of the second upper semiconductor chip. The lower molding layer extends onto a bottom surface of the first lower semiconductor chip and a bottom surface of the second lower semiconductor chip and encapsulates the first lower solder patterns and the second lower solder patterns. The upper molding layer extends onto a bottom surface of the first upper semiconductor chip and a bottom surface of the second upper semiconductor chip and encapsulates the first upper solder patterns and the second upper solder patterns. In a plan view, the conductive structure is disposed between the first lower semiconductor chip and the second lower semiconductor chip. The lower redistribution substrate includes: a lower dielectric layer; a redistribution pattern disposed in the lower dielectric layer, the redistribution pattern including a via portion and a wire portion; and a seed pattern disposed on a bottom surface of the redistribution pattern. The upper redistribution substrate includes: an upper dielectric layer; a redistribution layer disposed in the upper dielectric layer, the redistribution layer including a via pattern and a wire pattern; and an upper seed pattern disposed on a bottom surface of the redistribution layer.

[0006] A semiconductor package includes: a lower redistribution substrate; a lower semiconductor chip mounted on a top surface of the lower redistribution substrate; a plurality of lower solder patterns disposed between the lower redistribution substrate and the lower semiconductor chip; a plurality of conductive structures disposed on the top surface of the lower redistribution substrate; a lower molding layer disposed on the top surface of the lower redistribution substrate, the lower molding layer covering a top surface of the lower semiconductor chip; an upper redistribution substrate disposed on the lower molding layer and the conductive structures, the upper redistribution substrate being electrically connected to the conductive structures; an upper semiconductor chip mounted on a top surface of the upper redistribution substrate; a plurality of upper solder patterns disposed between the upper redistribution substrate and the upper

semiconductor chip; and an upper molding layer disposed on the top surface of the upper redistribution substrate, the upper molding layer covering a sidewall of the upper semiconductor chip. The lower molding layer extends between the lower redistribution substrate and the lower semiconductor chip and encapsulates the lower solder patterns. The upper molding layer extends between the upper redistribution substrate and the upper semiconductor chip and encapsulates the upper solder patterns. The number of the conductive structures is the same as or greater than the number of a plurality of upper chip pads of the upper semiconductor chip. The lower redistribution substrate includes: a redistribution pattern disposed in a lower dielectric layer, the redistribution pattern including a via portion and a wire portion; and a seed pattern disposed on a bottom surface of the redistribution pattern. The upper redistribution substrate includes: a redistribution layer disposed in an upper dielectric layer, the redistribution layer including a via pattern and a wire pattern; and a seed layer disposed on a bottom surface of the redistribution layer.

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## Description

### BRIEF DESCRIPTION OF THE DRAWINGS

[0007] A more complete appreciation of the present disclosure and many of the attendant aspects thereof will be readily obtained as the same becomes better understood by reference to the following detailed description when considered in connection with the accompanying drawings, wherein:

[0008] FIG. 1A is a plan view showing a semiconductor package according to some example embodiments;

[0009] FIG. 1B is a cross-sectional view taken along line A-B of FIG. 1A;

[0010] FIG. 1C is an enlarged view showing section C of FIG. 1B;

[0011] FIG. 1D is an enlarged view showing section D of FIG. 1B;

[0012] FIG. 2A is a cross-sectional view showing a semiconductor package according to some example embodiments;

[0013] FIG. 2B is a cross-sectional view showing a semiconductor package according to some example embodiments;

[0014] FIG. 3A is a plan view showing a semiconductor package according to some example embodiments;

[0015] FIG. 3B is a cross-sectional view taken along line A'-B' of FIG. 3A;

[0016] FIG. 4A is a cross-sectional view showing a semiconductor package according to some example embodiments;

[0017] FIG. 4B is a cross-sectional view showing a semiconductor package according to some example embodiments;

[0018] FIGS. 5A to 5I are cross-sectional views showing a method of fabricating a semiconductor package according to some example embodiments;

[0019] FIG. 6 is a cross-sectional view showing a method of fabricating a semiconductor package according to some example embodiments; and

[0020] FIGS. 7A to 7D are cross-sectional views showing a method of fabricating a semiconductor package according to some example embodiments.

### DETAILED DESCRIPTION OF EMBODIMENTS

[0021] In this description and the drawings, like reference numerals may refer like components. The following will now describe semiconductor packages and their fabricating methods according to the present inventive concepts.

[0022] FIG. 1A is a plan view showing a semiconductor package according to some example embodiments. FIG. 1B is a cross-sectional view taken along line A-B of FIG. 1A. FIG. 1C is an enlarged view showing section C of FIG. 1B. FIG. 1D is an enlarged view showing section D of

FIG. 1B.

[0023] Referring to FIGS. 1A to 1D, a semiconductor package **1** may include a lower package and an upper package. The lower package may include a lower redistribution substrate **100**, a first lower semiconductor chip **201**, first lower solder patterns **251**, conductive structures **300**, and a lower molding layer **400**. The upper package may include an upper redistribution substrate **600**, a first upper semiconductor chip **701**, first upper solder patterns **751**, and an upper molding layer **800**.

[0024] The lower redistribution substrate **100** may include a lower dielectric layer **110**, under-bump patterns **150**, redistribution patterns **120**, seed patterns **130**, and redistribution pads **140**. The lower dielectric layer **110** may include an organic material, such as a photosensitive polymer or photo-imageable polymer. The photosensitive polymer may include, for example, photosensitive polyimide, polybenzoxazole, phenolic polymers, and/or benzocyclobutene polymers. The lower dielectric layer **110** may be provided in plural. For example, the plurality of lower dielectric layers **110** may include the same material. No distinct interface might be provided between neighboring lower dielectric layers **110**. For example, as shown in FIG. 1C, the lower dielectric layer **110** may include a first lower dielectric layer **111**, a second lower dielectric layer **112**, and a third lower dielectric layer **113**. The second lower dielectric layer **112** may be disposed between the first lower dielectric layer **111** and the third lower dielectric layer **113**. The first lower dielectric layer **111** may be a lowermost one of the lower dielectric layers **110**. The third lower dielectric layer **113** may be an uppermost one of the lower dielectric layers **110**. The number of the stacked lower dielectric layers **110** may be variously changed.

[0025] The under-bump patterns **150** may be provided in the lowermost one of the lower dielectric layers **110**. The under-bump patterns **150** may have bottom surfaces that are not covered with the lower dielectric layers **110**. The under-bump patterns **150** may serve as pads for solder terminals **500**. The under-bump patterns **150** may be laterally spaced apart and electrically insulated from each other. The phrase “two components are laterally spaced apart from each other” may mean “the two components are horizontally spaced apart from each other.” The term “horizontally” may indicate “parallel to a bottom surface of the first lower dielectric layer **111**.” The first lower dielectric layer **111** may cover top surfaces and sidewalls of the under-bump patterns **150**. The under-bump patterns **150** may include a metallic material such as copper. The under-bump patterns **150** may alternatively be disposed on the bottom surface of the first lower dielectric layer **111**.

[0026] As shown in FIG. 1C, the redistribution patterns **120** may include first redistribution patterns **121** and second redistribution patterns **122**. The first redistribution patterns **121** may be disposed on, and correspond with, the under-bump patterns **150**. The first redistribution patterns **121** may be laterally spaced apart and electrically separated from each other. The first redistribution patterns **121** may be disposed on a top surface and inside of the first lower dielectric layer **111**. Each of the first redistribution patterns **121** may include a first via portion **121V** and a first wire portion **121W**. The first via portion **121V** may be disposed in the first lower dielectric layer **111** and on the top surface of a corresponding under-bump pattern **150**. The first via portion **121V** may have a width **W1** at its top surface greater than a width **W2** at its bottom surface. The top and bottom surfaces of the first via portion **121V** may be opposite to each other. The top surface of the first via portion **121V** may be an imaginary surface that may be disposed at the same level as that of a bottom surface of the first wire portion **121W**. The first wire portion **121W** may be provided on the first via portion **121V**, and the first wire portion **121W** and the first via portion **121V** may be connected to each other with no boundary therebetween. The first wire portion **121W** may have a width that is greater than the width **W1** at the top surface of the first via portion **121V**. The first wire portion **121W** may extend onto the top surface of the first lower dielectric layer **111** and may have a major axis that extends in a first direction. The first direction may be parallel to the bottom surface of the first lower dielectric layer **111**. The first redistribution patterns **121** may include metal such as copper. In this description, the element “via” may be a constituent for vertical

connection, and the element “wire” may be a constituent for horizontal connection. The term “vertical” may mean “perpendicular to the bottom surface of the first lower dielectric layer **111**.” In this description, the language “level” may denote “vertical level”, and “level difference” may be measured in a direction perpendicular to the bottom surface of the first lower dielectric layer **111**. The phrase “certain components are the same in terms of level and width” may include an allowable tolerance possibly occurring during fabrication process.

[0027] The first lower dielectric layer **111** may be provided thereon with the second lower dielectric layer **112** that covers the top surface and a sidewall of the first wire portion **121W**.

[0028] The seed patterns **130** may include first seed patterns **131** and second seed patterns **132**. The first seed patterns **131** may be disposed on, and may correspond to, bottom surfaces of the first redistribution patterns **121**. For example, each of the first seed patterns **131** may be interposed between a corresponding under-bump pattern **150** and a corresponding first via portion **121V**, and may cover a sidewall of the first via portion **121V** and the bottom surface of the first wire portion **121W**. Each of the first seed patterns **131** might not extend onto the sidewall of a corresponding first wire portion **121W**. The first seed patterns **131** may include a material different from that of the under-bump patterns **150** and that of the first redistribution patterns **121**. For example, the first seed patterns **131** may include a conductive seed material. The conductive seed material may include copper, and/or titanium, and/or any alloy thereof. The first seed patterns **131** may serve as barrier layers to prevent diffusion of materials included in the first redistribution patterns **121**.

[0029] The second redistribution patterns **122** may be disposed on, may correspond to, and may be electrically connected to the first redistribution patterns **121**. Each of the second redistribution patterns **122** may include a second wire portion **122W** and a second via portion **122V**. The second via portion **122V** may be provided in the second lower dielectric layer **112** and may be coupled to a corresponding first redistribution pattern **121**. The second via portion **122V** may have a width at its top surface that is greater than a width at its bottom surface. The top and bottom surfaces of the second via portion **122V** may be opposite to each other. The top surface of the second via portion **122V** may be an imaginary surface disposed at the same level as that of a bottom surface of the second wire portion **122W**. The second wire portion **122W** may be provided on the second via portion **122V**, and the second wire portion **122W** and the second via portion **122V** may be connected to each other with no boundary therebetween. The second wire portion **122W** may have a width that is greater than the width at the top surface of the second via portion **122V**. The second wire portion **122W** may extend onto a top surface of the second lower dielectric layer **112**. The second redistribution patterns **122** may include metal such as copper.

[0030] The second seed patterns **132** may be disposed on, and may correspond to, bottom surfaces of the second redistribution patterns **122**. The second seed patterns **132** may be interposed between, and may correspond to, the first redistribution patterns **121** and the second redistribution patterns **122**. For example, each of the second seed patterns **132** may cover the bottom surface and a sidewall of a corresponding second via portion **122V** and may also cover the bottom surface of a corresponding second wire portion **122W**. Each of the second seed patterns **132** might not extend onto a sidewall of the corresponding second wire portion **122W**. The second seed patterns **132** may include, for example, a conductive seed material. The second seed patterns **132** may serve as barrier layers to prevent diffusion of materials included in the second redistribution patterns **122**.

[0031] The number of the stacked redistribution patterns **120** may be variously changed. For example, the redistribution patterns **120** may further include third redistribution patterns. In this case, the third redistribution patterns may be interposed between, and may correspond to, the first redistribution patterns **121** and the second redistribution patterns **122**.

[0032] The third lower dielectric layer **113** may be provided on the top surface of the second lower dielectric layer **112** and may cover the second redistribution patterns **122**.

[0033] The redistribution pads **140** may be provided on and coupled to corresponding second redistribution patterns **122**. The redistribution pads **140** may be laterally spaced apart from each

other. As the redistribution patterns **120** are provided, at least one redistribution pad **140** might not be vertically aligned with the under-bump pattern **150** electrically connected thereto. Therefore, it may be possible to freely design an arrangement of the under-bump patterns **150** and/or the redistribution pads **140**.

[0034] The redistribution pads **140** may be provided in the third lower dielectric layer **113** and may extend onto a top surface of the third lower dielectric layer **113**. Each of the redistribution pads **140** may have a lower portion that is disposed in the third lower dielectric layer **113**. Each of the redistribution pads **140** may have an upper portion that is disposed on the top surface of the third lower dielectric layer **113**. Each of the redistribution pads **140** may be configured such that the upper portion may have a width that is greater than that of the lower portion, and that the upper portion may be connected to the lower portion. The redistribution pads **140** may include metal such as copper. The lower redistribution substrate **100** may further include seed pads **143**. The seed pads **143** may be provided on, and may correspond to, bottom surfaces of the redistribution pads **140**. The seed pads **143** may be provided between, and may correspond to, the second redistribution patterns **122** and the redistribution pads **140**, and may extend between the third lower dielectric layer **113** and the redistribution pads **140**. The seed pads **143** may include a different material from that of the redistribution pads **140**. The seed pads **143** may include, for example, a conductive seed material. The lower redistribution substrate **100** may further include bonding pads that are provided on, and may correspond to, top surfaces of the redistribution pads **140**. The bonding pads may include a different material from that of the redistribution pads **140**. For example, the bonding pads may include nickel and/or gold, and/or any alloy thereof. The bonding pads may serve as protection layers and/or adhesion layers.

[0035] The lower redistribution substrate **100** may have a first thickness **T1**. A thickness of a certain component may be measured in a direction substantially perpendicular to a bottom surface of the certain component. A thickness of a certain component may correspond to an interval between top and bottom surfaces of the certain component. For example, the first thickness **T1** may correspond to an interval between a bottom surface of the lowermost lower dielectric layer **110** (or the first lower dielectric layer **111**) and the top surfaces of the redistribution pads **140**. The first thickness **T1** may range from about 10  $\mu\text{m}$  to about 50  $\mu\text{m}$ . As the first thickness **T1** is equal to or less than about 50  $\mu\text{m}$ , the semiconductor package **1** may be small in size.

[0036] As shown in FIG. **1B**, the first lower semiconductor chip **201** may be mounted on a top surface of the lower redistribution substrate **100**. In a plan view, the first lower semiconductor chip **201** may be disposed on a central region of the lower redistribution substrate **100**. The first lower semiconductor chip **201** may be a logic chip, a buffer chip, and/or a memory chip. The first lower semiconductor chip **201** may have top and bottom surfaces that are opposite to each other. The bottom surface of the first lower semiconductor chip **201** may be directed toward the lower redistribution substrate **100** and may be an active surface. The top surface of the first lower semiconductor chip **201** may be an inactive surface. For example, as shown in FIG. **1C**, the first lower semiconductor chip **201** may include a lower semiconductor substrate **210**, a lower wiring layer, lower integrated circuits **215**, and first lower chip pads **231**. The lower integrated circuits **215** may be disposed on a bottom surface of the lower semiconductor substrate **210**. The lower integrated circuits **215** may include logic circuits, memory circuits, or any combination thereof. The lower wiring layer may be disposed on the bottom surface of the lower semiconductor substrate **210**. The lower wiring layer may include a lower dielectric pattern **220** and lower wiring structures **225**. The lower wiring structures **225** may be disposed in the lower dielectric pattern **220**. The first lower chip pads **231** may be disposed on a bottom surface of the lower wiring layer. The first lower chip pads **231** may be coupled through the lower wiring structures **225** to the lower integrated circuits **215**. The phrase “a certain component is electrically connected to a semiconductor chip” may mean “the certain component is electrically connected through chip pads of the semiconductor chip to integrated circuits of the semiconductor chip.”

[0037] As shown in FIG. 1B, the first lower solder patterns **251** may be interposed between the lower redistribution substrate **100** and the first lower semiconductor chip **201**. The first lower solder patterns **251** may be provided between, may correspond to, and may be coupled to the redistribution pads **140** and the first lower chip pads **231**. Therefore, the first lower semiconductor chip **201** may be coupled through the first lower solder patterns **251** to the lower redistribution substrate **100**. The phrase “coupled to the lower redistribution substrate **100**” may indicate “coupled to at least one of the redistribution patterns **120**.” The number of the first lower solder patterns **251** may be the same as the number of the first lower chip pads **231**, but the present inventive concepts are not necessarily limited thereto. Each of the first lower solder patterns **251** may have a solder ball shape and may include a solder material. In this description, the solder material may include tin, bismuth, lead, silver, or any alloy thereof.

[0038] The first lower solder patterns **251**, the redistribution pads **140**, and the redistribution patterns **120** may have high thermal conductivity. For example, the thermal conductivity of the first lower solder patterns **251**, of the redistribution pads **140**, and of the redistribution patterns **120** may be greater than that of the lower molding layer **400**. Accordingly, when the semiconductor package **1** operates, heat generated from the first lower semiconductor chip **201** may be promptly discharged to the outside through the first lower solder patterns **251**, the redistribution pads **140**, and the redistribution patterns **120**. As the first thickness **T1** is equal to or less than about 50  $\mu\text{m}$ , the first lower semiconductor chip **201** may achieve greater thermal radiation.

[0039] The conductive structures **300** may be provided on the top surface of the lower redistribution substrate **100**. In a plan view, the conductive structures **300** may be disposed on an edge region of the lower redistribution substrate **100**. In a plan view, the edge region may surround the central region of the lower redistribution substrate **100**. The conductive structures **300** may be laterally spaced apart from the first lower semiconductor chip **201**. The conductive structures **300** may be laterally spaced apart from each other. The conductive structures **300** may be disposed on and coupled to corresponding redistribution pads **140**. The conductive structures **300** may be electrically connected to the redistribution patterns **120**.

[0040] The conductive structures **300** may have top surfaces at a higher level than that of a top surface of the first lower semiconductor chip **201**. The conductive structures **300** may have heights greater than those of the first lower solder patterns **251**. The conductive structures **300** may include a different material from that of the first lower solder patterns **251**. For example, the conductive structures **300** may include copper and/or tungsten, and alloys thereof.

[0041] It may be required that the conductive structures **300** have heights the same as or similar to an interval between the lower redistribution substrate **100** and the upper redistribution substrate **600**. When the lower redistribution substrate **100** and the upper redistribution substrate **600** are connected to each other through solder balls, the interval between the lower redistribution substrate **100** and the upper redistribution substrate **600** may induce an increase in pitch and width of the solder balls. According to some example embodiments, the conductive structures **300** may be metal pillars. The conductive structures **300** may have the same width **W**. For example, the conductive structures **300** may have widths at their top surfaces substantially the same as widths at their bottom surfaces. The conductive structures **300** may have a fine pitch **P1**. For example, the pitch **P1** of the conductive structures **300** may range from about 70  $\mu\text{m}$  to about 350  $\mu\text{m}$ . The conductive structures **300** may each have a small width **W**. For example, the width **W** of the conductive structure **300** may range from about 50  $\mu\text{m}$  to about 250  $\mu\text{m}$ . As the conductive structures **300** have the pitch **P1** equal to or less than about 350  $\mu\text{m}$  and the width **W** equal to or less than about 250  $\mu\text{m}$ , the conductive structures **300** may be densely disposed. The semiconductor package **1** may decrease in planar area and size.

[0042] The lower molding layer **400** may be formed on the lower redistribution substrate **100** and may cover the first lower semiconductor chip **201**. For example, the lower molding layer **400** may cover the top surface and a sidewall of the first lower semiconductor chip **201**. The lower molding



layer **400** may have a top surface **400a** at a higher level than that of the top surface of the first lower semiconductor chip **201**. The lower molding layer **400** may extend into a gap between the lower redistribution substrate **100** and the first lower semiconductor chip **201**, and may cover a bottom surface of the first lower semiconductor chip **201** and sidewalls of the first lower solder patterns **251**. The lower molding layer **400** may encapsulate and protect the first lower solder patterns **251**. Therefore, it might not be necessary to separately form an under-fill layer and accordingly it may be possible to fabricate the semiconductor package **1** more simply.

[0043] The lower molding layer **400** may cover sidewalls of the conductive structures **300**, but may expose the top surfaces of the conductive structures **300**. The top surface **400a** of the lower molding layer **400** may be located at substantially the same level as that of the top surface of the conductive structures **300**. The lower molding layer **400** may include a dielectric polymer, such as an epoxy-based molding compound.

[0044] The upper redistribution substrate **600** may be disposed on the lower molding layer **400** and the conductive structures **300**. The upper redistribution substrate **600** may be spaced apart from the top surface of the first lower semiconductor chip **201**. A conductive component, such as solder or bump, might not be provided between the first lower semiconductor chip **201** and the upper redistribution substrate **600**. The lower molding layer **400** may fill a gap between the upper redistribution substrate **600** and the top surface of the first lower semiconductor chip **201**.

[0045] The upper redistribution substrate **600** may include an upper dielectric layer **610**, upper redistribution layers **620**, upper seed patterns **630**, and upper redistribution pads **640**. The upper dielectric layer **610** may include a plurality of upper dielectric layers, and the plurality of upper dielectric layers **610** may be stacked on the lower molding layer **400**. The upper dielectric layers **610** may include an organic material, such as a photosensitive polymer or photo-imageable polymer. For example, the upper dielectric layers **610** may include the same material. No distinct interface might be provided between neighboring upper dielectric layers **610**. For example, as shown in FIG. **1D**, the upper dielectric layers **610** may include a first upper dielectric layer **611**, a second upper dielectric layer **612**, and a third upper dielectric layer **613**. The first upper dielectric layer **611** may be a lowermost one of the upper dielectric layers **610**. The first upper dielectric layer **611** may be in direct physical contact with the top surface **400a** of the lower molding layer **400**. The third upper dielectric layer **613** may be an uppermost one of the upper dielectric layers **610**. The second upper dielectric layer **612** may be disposed between the first upper dielectric layer **611** and the third upper dielectric layer **613**. The number of the stacked upper dielectric layers **610** may be variously changed.

[0046] The upper redistribution layers **620** may include first upper redistribution layers **621** and second upper redistribution layers **622**. The first upper redistribution layers **621** may be provided on corresponding conductive structures **300**. The first upper redistribution layers **621** may be laterally spaced apart and electrically separated from each other. Referring to FIG. **1D**, each of the first upper redistribution layers **621** may include a first via pattern **621V** and a first wire pattern **621W**. The first via pattern **621V** may be disposed on the top surface of a corresponding conductive structure **300**. The first via pattern **621V** may be provided in the first upper dielectric layer **611**. The first via pattern **621V** may have a width **W3** at its top surface greater than a width **W4** at its bottom surface. The top and bottom surfaces of the first via pattern **621V** may be opposite to each other. The top surface of the first via pattern **621V** may be an imaginary surface located at substantially the same level as that of a bottom surface of the first wire pattern **621W**. The first wire pattern **621W** may be provided on the first via pattern **621V**, and the first wire pattern **621W** and the first via pattern **621V** may be connected to each other with no boundary therebetween. The first wire pattern **621W** may have a width that is greater than the width **W3** at the top surface of the first via pattern **621V**. The first wire pattern **621W** may extend onto a top surface of the first upper dielectric layer **611**. The first upper redistribution layers **621** may include metal such as copper. On the first upper dielectric layer **611**, the second upper dielectric layer **612** may cover a top surface and a

sidewall of the first wire pattern **621W**.

[0047] The upper seed patterns **630** may include first upper seed patterns **631** and second upper seed patterns **632**. The first upper seed patterns **631** may be disposed on and may correspond to bottom surfaces of the first upper redistribution layers **621**. For example, each of the first upper seed patterns **631** may be interposed between a corresponding conductive structure **300** and a corresponding first via pattern **621V**, and may extend onto a sidewall of the first via pattern **621V** and the bottom surface of the first wire pattern **621W**. Each of the first upper seed patterns **631** might not cover the sidewall of a corresponding first wire pattern **621W**. The first upper seed patterns **631** may include a different material from that of the conductive structures **300** and that of the first upper redistribution layers **621**. For example, the first upper seed patterns **631** may include a conductive seed material. The first upper seed patterns **631** may serve as barrier layers to prevent diffusion of materials included in the first upper redistribution layers **621**.

[0048] The second upper redistribution layers **622** may be disposed on, may correspond to, and may be electrically connected to the first upper redistribution layers **621**. Each of the second upper redistribution layers **622** may include a second wire pattern **622W** and a second via pattern **622V**. The second via pattern **622V** may be provided on the second upper dielectric layer **612** and may be coupled to the first upper redistribution layer **621**. The second via pattern **622V** may have a width at its top surface that is greater than a width at its bottom surface. The top and bottom surfaces of the second via pattern **622V** may be opposite to each other. The top surface of the second via pattern **622V** may be an imaginary surface located at substantially the same level as that of a bottom surface of the second wire pattern **622W**. The second wire pattern **622W** may be provided on the second via pattern **622V**, and the second wire pattern **622W** and the second via pattern **622V** may be connected to each other with no boundary therebetween. The second wire pattern **622W** may have a width that is greater than the width at the top surface of the second via pattern **622V**. The second wire pattern **622W** may extend onto a top surface of the second upper dielectric layer **612**. The second upper redistribution layers **622** may include metal such as copper.

[0049] The second upper seed patterns **632** may be disposed on and may correspond to bottom surfaces of the second upper redistribution layers **622**. The second upper seed patterns **632** may be interposed between, and may correspond to, the first upper redistribution layers **621** and the second upper redistribution layers **622**. Each of the second upper seed patterns **632** may cover the bottom surface and a sidewall of a corresponding second via pattern **622V** and may also cover the bottom surface of the second wire pattern **622W**. The second upper seed patterns **632** may include a different material from that of the second upper redistribution layers **622**. The second upper seed patterns **632** may include, for example, a conductive seed material. The second upper seed patterns **632** may serve as barrier layers to prevent diffusion of materials included in the second upper redistribution layers **622**.

[0050] The second upper dielectric layer **612** may be provided on its top surface with the third upper dielectric layer **613** that covers the second upper dielectric layers **622**.

[0051] The upper redistribution pads **640** may be disposed on, may correspond to, and may be coupled to the second upper redistribution layers **622**. The upper redistribution pads **640** may be laterally spaced apart from each other. As the upper redistribution layers **620** are provided, at least one upper redistribution pad **640** might not be vertically aligned with the conductive structure **300** electrically connected thereto. Therefore, it may be possible to freely design an arrangement of the upper redistribution pads **640**.

[0052] Each of the upper redistribution pads **640** may have a lower portion that is provided in the third upper dielectric layer **613**. Each of the upper redistribution pads **640** may have an upper portion that is disposed on a top surface of the third upper dielectric layer **613**. Each of the upper redistribution pads **640** may be configured such that the upper portion may have a width that is greater than that of the lower portion, and that the upper portion may be connected to the lower portion. The upper redistribution pads **640** may include metal such as copper.

[0053] The upper redistribution substrate **600** may further include upper seed pads **643**. The upper seed pads **643** may be interposed between, and may correspond to, the second upper redistribution layers **622** and the upper redistribution pads **640**, and may extend between the third upper dielectric layer **613** and the upper redistribution pads **640**. The upper seed pads **643** may include a different material from that of the upper redistribution pads **640**. The upper seed pads **643** may include, for example, a conductive seed material. The upper redistribution substrate **600** may further include upper bonding pads. The upper bonding pads may be provided on, and may correspond to, top surfaces of the upper redistribution pads **640**. The upper bonding pads may include a different material from that of the upper redistribution pads **640**. For example, the upper bonding pads may include nickel and/or gold, or an alloy thereof.

[0054] The upper redistribution substrate **600** may have a second thickness **T2**. For example, the second thickness **T2** may correspond to an interval between a bottom surface of the lowermost upper dielectric layer **610** and the top surfaces of the upper redistribution pads **640**. The second thickness **T2** may range from about 10  $\mu\text{m}$  to about 50  $\mu\text{m}$ . As the second thickness **T2** is equal to or less than about 50  $\mu\text{m}$ , the semiconductor package **1** may become small in size.

[0055] There may be various changes in the number of the upper redistribution layers **620** provided between, and may correspond to, the conductive structures **300** and the upper redistribution pads **640**.

[0056] As shown in FIG. **1B**, the first upper semiconductor chip **701** may be mounted on a top surface of the upper redistribution substrate **600**. The first upper semiconductor chip **701** may be a logic chip, a buffer chip, and/or a memory chip. For example, the first upper semiconductor chip **701** may be of a different type from the first lower semiconductor chip **201**. The first upper semiconductor chip **701** may be one of logic and memory chips, and the first lower semiconductor chip **201** may be the other of logic and memory chips. Alternatively, the first upper semiconductor chip **701** may be of the same type as the first lower semiconductor chip **201**.

[0057] The first upper semiconductor chip **701** may have top and bottom surfaces that are opposite to each other. The bottom surface of the first upper semiconductor chip **701** may be directed toward the upper redistribution substrate **600** and may be an active surface. The top surface of the first upper semiconductor chip **701** may be an inactive surface. For example, as shown in FIG. **1D**, the first upper semiconductor chip **701** may include an upper semiconductor substrate **710**, an upper wiring layer, upper integrated circuits **715**, and first upper chip pads **731**. The upper integrated circuits **715** may be provided on a bottom surface of the upper semiconductor substrate **710**. The upper integrated circuits **715** may include transistors. The upper wiring layer may be disposed on the bottom surface of the upper semiconductor substrate **710**. The upper wiring layer may include an upper dielectric pattern **720** and upper wiring structures **725**. The upper wiring structures **725** may be provided in the upper dielectric pattern **720**. The first upper chip pads **731** may be disposed on a bottom surface of the upper wiring layer. The first upper chip pads **731** may be coupled through the upper wiring structures **725** to the upper integrated circuits **715**.

[0058] The first upper solder patterns **751** may be interposed between the upper redistribution substrate **600** and the first upper semiconductor chip **701**. The first upper solder patterns **751** may be provided between, may correspond to, and may be coupled to the upper redistribution pads **640** and the first upper chip pads **731**. Therefore, the first upper semiconductor chip **701** may be coupled through the first upper solder patterns **751** to the upper redistribution substrate **600**. The phrase “coupled to the upper redistribution substrate **600**” may indicate “coupled to at least one of the upper redistribution layers **620**.” Each of the first upper solder patterns **751** may have a solder ball shape and may include a solder material. The number of the first upper solder patterns **751** may be the same as the number of the first upper chip pads **731**, but the present inventive concepts are not necessarily limited thereto.

[0059] As shown in FIG. **1B**, the upper molding layer **800** may be formed on the upper redistribution substrate **600** and may cover a sidewall of the first upper semiconductor chip **701**.

The upper molding layer **800** may expose a top surface of the first upper semiconductor chip **701**. The upper molding layer **800** may have a top surface **800a** at substantially the same level as that of the top surface of the first upper semiconductor chip **701**. The upper molding layer **800** may have a relatively low thermal conductivity. As the upper molding layer **800** exposes the top surface of the first upper semiconductor chip **701**, heat generated from the first upper semiconductor chip **701** may be promptly discharged to the outside. Therefore, the first upper semiconductor chip **701** may achieve greater thermal radiation. The upper molding layer **800** may extend between the first upper semiconductor chip **701** and the upper redistribution substrate **600**, and may cover a bottom surface of the first upper semiconductor chip **701** and sidewalls of the first upper solder patterns **751**. The upper molding layer **800** may encapsulate and protect the first upper solder patterns **751**. Thus, it might not be necessary to form an under-fill layer between the first upper semiconductor chip **701** and the upper redistribution substrate **600**, and accordingly it may be possible to more simply fabricate the semiconductor package **1**.

[0060] The upper molding layer **800** may have outer sidewalls that are vertically aligned with those of the upper redistribution substrate **600**, those of the lower molding layer **400**, and those of the lower redistribution substrate **100**.

[0061] The solder terminals **500** may be provided on the bottom surface of the lower redistribution substrate **100**. The solder terminals **500** may be disposed on and may correspond to bottom surfaces of the under-bump patterns **150** and may be coupled to corresponding members of the under-bump patterns **150**. The solder terminals **500** may be electrically connected through the under-bump patterns **150** to the redistribution patterns **120**. The solder terminals **500** may be laterally spaced apart and electrically separated from each other. The solder terminals **500** may include a solder material.

[0062] The solder terminals **500** may include first solder terminals **501** and second solder terminals **502**. The first solder terminals **501** may be disposed on the bottom surface at the central region of the lower redistribution substrate **100**. The first solder terminals **501** may vertically overlap the first lower semiconductor chip **201**. The first solder terminals **501** may be electrically connected through the redistribution patterns **120** to the first lower semiconductor chip **201**. Therefore, lengths of electrical paths may be reduced between the first solder terminals **501** and the first lower semiconductor chip **201**. As the first thickness **T1** is relatively small, the lengths of electrical paths may further be reduced between the first solder terminals **501** and the first lower semiconductor chip **201**. The first lower semiconductor chip **201** may achieve an increase in operating speed.

[0063] The second solder terminals **502** may be disposed on the bottom surface at the edge region of the lower redistribution substrate **100**. In a plan view, the second solder terminals **502** may be spaced apart from the first lower semiconductor chip **201**. The second solder terminals **502** may be electrically connected through the lower redistribution substrate **100** to the conductive structures **300**. For example, the second solder terminals **502** may be electrically connected to the first upper semiconductor chip **701** through the conductive structures **300** and the upper redistribution substrate **600**. At least one of the second solder terminals **502** may vertically overlap the conductive structure **300** electrically connected thereto. Alternatively, in a plan view, one of the second solder terminals **502** may be adjacent to the conductive structure **300** electrically connected thereto. Therefore, lengths of electrical paths may be reduced between the second solder terminals **502** and the first upper semiconductor chip **701**. The first upper semiconductor chip **701** may achieve an increase in operating speed. As the first and second thicknesses **T1** and **T2** are relatively small, the first upper semiconductor chip **701** may achieve a further increase in operating speed.

[0064] The conductive structures **300** may serve as electrical paths for the first upper semiconductor chip **701**. The conductive structures **300** may have relatively small resistivity. For example, the resistivity of the conductive structures **300** may be less than that of a solder material. The resistivity of the conductive structures **300** may be less than that of the first lower solder patterns **251** and also less than that of the first upper solder patterns **751**. Therefore, even though

the conductive structures **300** have large height, the conductive structures **300** may accomplish rapid signal transfer therethrough. Accordingly, the first upper semiconductor chip **701** may achieve better electrical properties.

[0065] The first upper semiconductor chip **701** may have high performance properties and a relatively large number of input/output terminals. The input/output terminals of the first upper semiconductor chip **701** may be the first upper chip pads **731**. According to some example embodiments, a large number of the conductive structures **300** per unit area may be disposed due to their relatively small pitch **P1** and width **W**. For example, the number of the conductive structures **300** may be the same as or greater than that of the first upper chip pads **731**. Therefore, even though the number of the first upper chip pads **731** is large, a good electrical connection may be provided between the first upper semiconductor chip **701** and an external apparatus.

[0066] The semiconductor package **1** may be a package-on-package, but the present inventive concepts are not necessarily limited thereto.

[0067] FIG. **2A** is a cross-sectional view taken along line A-B of FIG. **1A**, showing a semiconductor package according to some example embodiments. To the extent that a description of various elements has been omitted, it may be assumed that those elements are at least similar to corresponding elements that have been described elsewhere within the present disclosure.

[0068] Referring to FIG. **2A**, a semiconductor package **1A** may include a lower redistribution substrate **100**, solder terminals **500**, a first lower semiconductor chip **201**, first lower solder patterns **251**, a lower molding layer **400**, conductive structures **300**, an upper redistribution substrate **600**, a first upper semiconductor chip **701**, first upper solder patterns **751**, and an upper molding layer **800**.

[0069] The upper molding layer **800** may cover a top surface of the first upper semiconductor chip **701**. The upper molding layer **800** may have a top surface **800a** at a higher level than that of the top surface of the first upper semiconductor chip **701**.

[0070] FIG. **2B** is a cross-sectional view taken along line A-B of FIG. **1A**, showing a semiconductor package according to some example embodiments.

[0071] Referring to FIG. **2B**, a semiconductor package **1B** may include a lower redistribution substrate **100**, solder terminals **500**, a first lower semiconductor chip **201**, first lower solder patterns **251**, a lower molding layer **400**, conductive structures **300**, an upper redistribution substrate **600**, a first upper semiconductor chip **701**, first upper solder patterns **751**, and an upper molding layer **800**, and may further include a thermal radiation structure **900**. The upper molding layer **800** may expose a top surface of the first upper semiconductor chip **701**.

[0072] The thermal radiation structure **900** may be disposed on the first upper semiconductor chip **701** and the upper molding layer **800**. The thermal radiation structure **900** may include one or both of a heat transfer layer **910** and a thermal radiation plate **930**. The thermal radiation plate **930** may include a heat slug or a heat sink. The thermal radiation plate **930** may have thermal conductivity greater than that of the upper molding layer **800**. The thermal radiation plate **930** may include, for example, metal. The heat transfer layer **910** may be interposed between the first upper semiconductor chip **701** and the thermal radiation plate **930**. The heat transfer layer **910** may be in direct physical contact with the top surface of the first upper semiconductor chip **701**. The heat transfer layer **910** may extend between the upper molding layer **800** and the thermal radiation plate **930**. The heat transfer layer **910** may include a thermal interface material (TIM). As the thermal radiation structure **900** is provided, the first upper semiconductor chip **701** may achieve greater thermal radiation.

[0073] FIG. **3A** is a plan view showing a semiconductor package according to some example embodiments. FIG. **3B** is a cross-sectional view taken along line A'-B' of FIG. **3A**. To the extent that a description of various elements has been omitted, it may be assumed that those elements are at least similar to corresponding elements that have been described elsewhere within the present disclosure.

[0074] Referring to FIGS. 3A and 3B, a semiconductor package 2 may include a lower redistribution substrate 100, solder terminals 500, a first lower semiconductor chip 201, a second lower semiconductor chip 202, first lower solder patterns 251, second lower solder patterns 252, a lower molding layer 400, conductive structures 300, an upper redistribution substrate 600, a first upper semiconductor chip 701, a second upper semiconductor chip 702, first upper solder patterns 751, second upper solder patterns 752, and an upper molding layer 800. The lower redistribution substrate 100 may have a first outer lateral surface 101 and a second outer lateral surface 102 that are opposite to each other. In a plan view, the first lower semiconductor chip 201 may be disposed adjacent to the first outer lateral surface 101 of the lower redistribution substrate 100. For example, an interval between the first lower semiconductor chip 201 and the first outer lateral surface 101 of the lower redistribution substrate 100 may be less than that between the first lower semiconductor chip 201 and the second outer lateral surface 102 of the lower redistribution substrate 100.

[0075] The second lower semiconductor chip 202 may be provided on a top surface of the lower redistribution substrate 100. The second lower semiconductor chip 202 may be laterally spaced apart from the first lower semiconductor chip 201. In a plan view, the second lower semiconductor chip 202 may be disposed between the first lower semiconductor chip 201 and the second outer lateral surface of the lower redistribution substrate 100. The second lower semiconductor chip 202 may have top and bottom surfaces that are opposite to each other. The bottom surface of the second lower semiconductor chip 202 may be an active surface, and the top surface of the second lower semiconductor chip 202 may be an inactive surface. For example, the second lower semiconductor chip 202 may include second lower chip pads 232 disposed on the bottom surface thereof. The second lower semiconductor chip 202 may further include a semiconductor substrate, integrated circuits, and a wiring layer. The semiconductor substrate, the integrated circuits, and the wiring layer of the second lower semiconductor chip 202 may respectively be the same as or similar to the lower semiconductor substrate 210, the lower integrated circuits 215, and the lower wiring layer of the first lower semiconductor chip 201 depicted in FIG. 1C.

[0076] The second lower solder patterns 252 may be interposed between the lower redistribution substrate 100 and the second lower semiconductor chip 202. The second lower solder patterns 252 may be interposed between, may correspond to, and may be coupled to the redistribution pads 140 and the second lower chip pads 232. Therefore, the second lower semiconductor chip 202 may be coupled through the second lower solder patterns 252 to the lower redistribution substrate 100. The number of the second lower solder patterns 252 may be the same as the number of the second lower chip pads 232, but the present inventive concepts are not necessarily limited thereto. Each of the second lower solder patterns 252 may have a solder ball shape and may include a solder material. The second lower solder patterns 252 may have a relatively high thermal conductivity. For example, the thermal conductivity of the second lower solder patterns 252 may be greater than that of the lower molding layer 400. When the semiconductor package 2 operates, heat generated from the second lower semiconductor chip 202 may be promptly discharged to the outside through the second lower solder patterns 252, the redistribution pads 140, and the redistribution patterns 120. As the first thickness T1 is relatively small, the second lower semiconductor chip 202 may achieve greater thermal radiation.

[0077] The lower molding layer 400 may be disposed substantially the same as that discussed in the example of FIG. 1B. In addition, the lower molding layer 400 may cover the top surface and a sidewall of the second lower semiconductor chip 202. The lower molding layer 400 may have a top surface 400a at a higher level than that of the top surface of the second lower semiconductor chip 202. The lower molding layer 400 may be provided in a gap between the lower redistribution substrate 100 and the second lower semiconductor chip 202, and may cover the bottom surface of the second lower semiconductor chip 202 and sidewalls of the second lower solder patterns 252. Therefore, it might not be necessary to separately form an under-fill layer between the lower redistribution substrate 100 and the second lower semiconductor chip 202, and accordingly it may

be possible to fabricate the semiconductor package 2 more simply.

[0078] The second upper semiconductor chip 702 may be disposed on a top surface of the upper redistribution substrate 600 and may be laterally spaced apart from the first upper semiconductor chip 701. The second upper semiconductor chip 702 may have a bottom surface as an active surface, and may also have a top surface as an inactive surface. For example, the second upper semiconductor chip 702 may include second upper chip pads 732 provided on the bottom surface thereof. The second upper semiconductor chip 702 may further include a semiconductor substrate, integrated circuits, and a wiring layer. The semiconductor substrate, the integrated circuits, and the wiring layer of the second upper semiconductor chip 702 may respectively be the same as or similar to the upper semiconductor substrate 710, the upper integrated circuits 715, and the upper wiring layer of the first upper semiconductor chip 701 depicted in FIG. 1D.

[0079] The second upper solder patterns 752 may be interposed between the upper redistribution substrate 600 and the second upper semiconductor chip 702. The second upper solder patterns 752 may be interposed between, may correspond to, and may be coupled to the upper redistribution pads 640 and the second upper chip pads 732. Therefore, the second upper semiconductor chip 702 may be coupled through the second upper solder patterns 752 to the upper redistribution substrate 600. Each of the second upper solder patterns 752 may have a solder ball shape and may include a solder material. The number of the second upper solder patterns 752 may be the same as the number of the second upper chip pads 732, but the present inventive concepts are not necessarily limited thereto.

[0080] For example, the first lower semiconductor chip 201 may be of the same type as the second lower semiconductor chip 202, the first upper semiconductor chip 701, and the second upper semiconductor chip 702. The first lower semiconductor chip 201, the second lower semiconductor chip 202, the first upper semiconductor chip 701, and the second upper semiconductor chip 702 may be memory chips, such as GDDR SDRAM. In this case, the first lower semiconductor chip 201 may have the same size and storage capacity as those of the second lower semiconductor chip 202, the first upper semiconductor chip 701, and the second upper semiconductor chip 702. The number of the first lower chip pads 231 may be the same as that of the second lower chip pads 232, that of the first upper chip pads 731, that of the first upper chip pads 731, and that of the second upper chip pads 732. Alternatively, the first lower semiconductor chip 201 may be of a different type from at least one selected from the second lower semiconductor chip 202, the first upper semiconductor chip 701, and the second upper semiconductor chip 702. In this case, the first lower semiconductor chip 201 may have a different size from that of at least one of the lower semiconductor chip 202, the first upper semiconductor chip 701, or the second upper semiconductor chip 702. The number of the first lower chip pads 231 may be different from that of the second lower chip pads 232, that of the first upper chip pads 731, or that of the second upper chip pads 732.

[0081] The upper redistribution substrate 600 may be provided on its top surface with the upper molding layer 800 that covers a sidewall of the first upper semiconductor chip 701 and a sidewall of the second upper semiconductor chip 702. The upper molding layer 800 might not cover any of top surfaces of the first and second upper semiconductor chips 701 and 702. The upper molding layer 800 may have a top surface 800a at substantially the same level as that of the top surface of the first upper semiconductor chip 701 and that of the top surface of the second upper semiconductor chip 702. Therefore, the first and second upper semiconductor chips 701 and 702 may achieve greater thermal radiation. The upper molding layer 800 may extend into a gap between the upper redistribution substrate 600 and the second upper semiconductor chip 702, and may cover the bottom surface of the second upper semiconductor chip 702 and sidewalls of the second upper solder patterns 752. Therefore, it might not be necessary to separately form an under-fill layer between the upper redistribution substrate 600 and the second upper semiconductor chip 702, and accordingly it may be possible to fabricate the semiconductor package 2 more simply.

[0082] The conductive structures **300** may be provided between and electrically connected to the lower redistribution substrate **100** and the upper redistribution substrate **600**. The conductive structures **300** may be laterally spaced apart from the first lower semiconductor chip **201** and the second lower semiconductor chip **202**. The conductive structures **300** may have top surfaces at a higher level than that of the top surface of the second lower semiconductor chip **202**.

[0083] The number of the conductive structures **300** may be the same as or greater than a sum of the number of the first upper chip pads **731** and the number of the second upper chip pads **732**. The number of the conductive structures **300** may be the same as or greater than a sum of the number of the first upper solder patterns **751** and the number of the second upper solder patterns **752**. For example, the number of the conductive structures **300** may be the same as or greater than a sum of the number of the first lower chip pads **231** and the number of the second lower chip pads **232**. The number of the conductive structures **300** may be the same as or greater than a sum of the number of the first lower solder patterns **251** and the number of the second lower solder patterns **252**. A large number of the conductive structures **300** per unit area may be disposed, and the semiconductor package **2** may decrease in size.

[0084] In a plan view, the lower redistribution substrate **100** may have a first region, a second region, and a third region. The first region of the lower redistribution substrate **100** may be provided between the first lower semiconductor chip **201** and the first outer lateral surface **101** of the lower redistribution substrate **100**. The second region of the lower redistribution substrate **100** may be provided between the second lower semiconductor chip **202** and the second outer lateral surface **102** of the lower redistribution substrate **100**. The third region of the lower redistribution substrate **100** may be provided between the first lower semiconductor chip **201** and the second lower semiconductor chip **202**. In a plan view, the conductive structures **300** may be provided on the first, second, and third regions of the lower redistribution substrate **100**.

[0085] The solder terminals **500** may include first solder terminals **501** and second solder terminals **502**. One of the first solder terminals **501** may vertically overlap and have electrical connection with the first lower semiconductor chip **201**. Another of the first solder terminals **501** may vertically overlap and have electrical connection with the second lower semiconductor chip **202**. Therefore, lengths of electrical connections may be reduced between the first solder terminals **501** and the first and second lower semiconductor chips **201** and **202**. The first and second lower semiconductor chips **201** and **202** may achieve an increase in operating speed.

[0086] In a plan view, the second solder terminals **502** may be spaced apart from the first lower semiconductor chip **201** and the second lower semiconductor chip **202**. In a plan view, the second solder terminals **502** may be provided on the first, second, or third region of the lower redistribution substrate **100**. The second solder terminals **502** may be electrically connected through the redistribution patterns **120** and the conductive structures **300** to the first upper semiconductor chip **701** or the second upper semiconductor chip **702**. The lower redistribution substrate **100** may have, on a bottom surface at the first region, the second solder terminals **502** electrically connected to the conductive structures **300** on a top surface at the first region of the lower redistribution substrate **100**. The lower redistribution substrate **100** may have, on a bottom surface at the second region, the second solder terminals **502** electrically connected to the conductive structures **300** on a top surface at the second region of the lower redistribution substrate **100**. The lower redistribution substrate **100** may have, on a bottom surface at the third region, the second solder terminals **502** electrically connected to the conductive structures **300** on a top surface at the third region of the lower redistribution substrate **100**. Therefore, lengths of electrical connections may be reduced between the first upper semiconductor chip **701** and the first solder terminals **501** and between the second upper semiconductor chip **702** and the second solder terminals **502**. The first and second upper semiconductor chips **701** and **702** may achieve a further increase in operating speed.

[0087] The conductive structures **300** may have resistivity that is less than that of the first lower



solder patterns **251**, that of the second lower solder patterns **252**, that of the first upper solder patterns **751**, and that of the second upper solder patterns **752**. Therefore, the first and second upper semiconductor chips **701** and **702** may achieve an increase in operating speed.

[0088] FIG. **4A** is a cross-sectional view taken along line A'-B' of FIG. **1A**, showing a semiconductor package according to some example embodiments. To the extent that a description of various elements has been omitted, it may be assumed that those elements are at least similar to corresponding elements that have been described elsewhere within the present disclosure.

[0089] Referring to FIG. **4A**, a semiconductor package **2A** may include a lower redistribution substrate **100**, solder terminals **500**, a first lower semiconductor chip **201**, a second lower semiconductor chip **202**, first lower solder patterns **251**, second lower solder patterns **252**, a lower molding layer **400**, conductive structures **300**, an upper redistribution substrate **600**, a first upper semiconductor chip **701**, a second upper semiconductor chip **702**, first upper solder patterns **751**, second upper solder patterns **752**, and an upper molding layer **800**.

[0090] The upper molding layer **800** may cover a top surface of the first upper semiconductor chip **701** and a top surface of the second upper semiconductor chip **702**. The upper molding layer **800** may have a top surface **800a** at a higher level than that of the top surface of the first upper semiconductor chip **701** and that of the top surface of the second upper semiconductor chip **702**.

[0091] FIG. **4B** is a cross-sectional view taken along line A'-B' of FIG. **1A**, showing a semiconductor package according to some example embodiments.

[0092] Referring to FIG. **4B**, a semiconductor package **2B** may include a lower redistribution substrate **100**, solder terminals **500**, a first lower semiconductor chip **201**, a second lower semiconductor chip **202**, first lower solder patterns **251**, second lower solder patterns **252**, a lower molding layer **400**, conductive structures **300**, an upper redistribution substrate **600**, a first upper semiconductor chip **701**, a second upper semiconductor chip **702**, first upper solder patterns **751**, second upper solder patterns **752**, an upper molding layer **800**, and a thermal radiation structure **900**. The upper molding layer **800** may expose a top surface of the first upper semiconductor chip **701** and a top surface of the second upper semiconductor chip **702**.

[0093] The thermal radiation structure **900** may be disposed on the top surface of the first upper semiconductor chip **701**, the top surface of the second upper semiconductor chip **702**, and a top surface **800a** of the upper molding layer **800**. The thermal radiation structure **900** may include one or both of a heat transfer layer **910** and a thermal radiation plate **930**. The heat transfer layer **910** may be interposed between the first upper semiconductor chip **701** and the thermal radiation plate **930**, between the second upper semiconductor chip **702** and the thermal radiation plate **930**, and between the upper molding layer **800** and the thermal radiation plate **930**. The heat transfer layer **910** may be in direct physical contact with the top surface of the first upper semiconductor chip **701** and the top surface of the second upper semiconductor chip **702**.

[0094] FIGS. **5A** to **5I** are cross-sectional views taken along line A-B of FIG. **1A**, showing a method of fabricating a semiconductor package according to some example embodiments.

[0095] Referring to FIG. **5A**, under-bump patterns **150**, a first lower dielectric layer **111**, first seed patterns **131**, and first redistribution patterns **121** may be formed on a carrier substrate **990**. A carrier adhesive layer **980** may further be formed between the carrier substrate **990** and the first lower dielectric layer **111** and between the carrier substrate **990** and the under-bump patterns **150**. The carrier adhesive layer **980** may attach the first lower dielectric layer **111** and the under-bump patterns **150** to the carrier substrate **990**. The carrier adhesive layer **980** may be a release layer.

[0096] According to some example embodiments, the under-bump patterns **150** may be formed on the carrier adhesive layer **980**. The first lower dielectric layer **111** may be formed on the carrier adhesive layer **980** and may cover sidewalls and top surfaces of the under-bump patterns **150**. First openings **119** may be formed in the first lower dielectric layer **111** and may expose the under-bump patterns **150**.

[0097] The formation of the first seed patterns **131** and the first redistribution patterns **121** may

include forming a first seed layer in the first openings **119** and on a top surface of the first lower dielectric layer **111**, forming on the first seed layer a resist pattern having guide openings, performing an electroplating process in which the first seed layer is used as an electrode, removing the resist pattern and exposing a portion of the first seed layer, and etching the exposed portion of the first seed layer.

[0098] The guide openings may be correspondingly connected to the first openings **119**. The electroplating process may form the first redistribution patterns **121** in the first openings **119** and the guide openings. Each of the first redistribution patterns **121** may include a first via portion **121V** and a first wire portion **121W**. The first via portion **121V** may be formed in a corresponding first opening **119**, and the first wire portion **121W** may be formed in a lower portion of a corresponding guide opening. The etching of the first seed layer may form the first seed patterns **131** below, and in correspondence with, first redistribution patterns **121**.

[0099] Referring to FIG. 5B, a second lower dielectric layer **112** may be formed on the first lower dielectric layer **111** and may cover the first redistribution patterns **121**. Second openings **118** may be formed in the second lower dielectric layer **112** to expose the first redistribution patterns **121**. Second redistribution patterns **122** may be formed in the second openings **118** and may be coupled to the first redistribution patterns **121**. Each of the second redistribution patterns **122** may include a second via portion **122V** and a second wire portion **122W**. The second via portion **122V** may be provided in a corresponding second opening **118**. The second wire portion **122W** may be formed on the second via portion **122V** to extend onto a top surface of the second lower dielectric layer **112**.

[0100] Second seed patterns **132** may be formed below, and may correspond to, the second redistribution patterns **122**. The formation of the second seed patterns **132** and the second redistribution patterns **122** may be formed by performing a method substantially the same as that used for forming the first seed patterns **131** and the first redistribution patterns **121** of FIG. 5A. For example, an electroplating process may be performed in which the second seed patterns **132** are used as electrodes to form the second redistribution patterns **122**.

[0101] A third lower dielectric layer **113** may be formed on the second lower dielectric layer **112** and may cover the second redistribution patterns **122**. Third openings **117** may be formed in the third lower dielectric layer **113** and may expose the second redistribution patterns **122**. Redistribution pads **140** may be formed in, and correspond to, the third openings **117** and may be coupled to the second redistribution patterns **122**. Seed pads **143** may be formed below, and may correspond to, the redistribution pads **140**. According to some example embodiments, an electroplating process may be performed in which the seed pads **143** are used as electrodes to form the redistribution pads **140**. Therefore, a lower redistribution substrate **100** may be fabricated. The lower redistribution substrate **100** may include the first, second, and third lower dielectric layers **111**, **112**, and **113**, the first seed patterns **131**, the first redistribution patterns **121**, the second seed patterns **132**, the second redistribution patterns **122**, the seed pads **143**, and the redistribution pads **140**.

[0102] Referring to FIG. 5C, a first lower semiconductor chip **201** may be mounted on a top surface of the lower redistribution substrate **100**. The mounting of the first lower semiconductor chip **201** may include forming first lower solder patterns **251** between first lower chip pads **231** and corresponding redistribution pads **140**.

[0103] Conductive structures **300** may be formed on the top surface at an edge region of the lower redistribution substrate **100** and may be coupled to corresponding redistribution pads **140**. The formation of the conductive structures **300** may include providing metal pillars on corresponding redistribution pads **140**. In this case, the conductive structures **300** may have top surfaces **300a** at a higher level than that of a top surface of the first lower semiconductor chip **201**. The formation of the conductive structures **300** may be performed before or after the mounting of the first lower semiconductor chip **201**.

[0104] Referring to FIG. 5D, a preliminary lower molding layer **401** may be formed on the top

surface of the lower redistribution substrate **100** and may cover the first lower semiconductor chip **201** and the conductive structures **300**. For example, the preliminary lower molding layer **401** may have a top surface **401a** at a higher level than that of the top surface of the first lower semiconductor chip **201** and top surfaces **300a** of the conductive structures **300**. The preliminary lower molding layer **401** may extend onto a bottom surface of the first lower semiconductor chip **201** and may encapsulate the first lower solder patterns **251**.

[0105] Referring to FIG. 5E, the preliminary lower molding layer **401** may undergo a grinding process to form a lower molding layer **400**. For example, the grinding process may include a chemical mechanical polishing (CMP) process. The grinding process may continue until the top surfaces **300a** of the conductive structures **300** are exposed.

[0106] When the grinding process is further performed on the first lower semiconductor chip **201**, grinding residues may be generated from the first lower semiconductor chip **201**. The residues may migrate onto and contaminate the top surfaces **300a** of the conductive structures **300**. According to some example embodiments, the grinding process may stop before the top surface of the first lower semiconductor chip **201** is exposed. Therefore, the conductive structures **300** may be prevented from contamination.

[0107] As a result of the grinding process, a top surface **400a** of the lower molding layer **400** may be located at a higher level than that of the top surface of the first lower semiconductor chip **201** and may cover the top surface of the first lower semiconductor chip **201**. The top surface **400a** of the lower molding layer **400** may be coplanar with the top surfaces **300a** of the conductive structures **300**.

[0108] Referring to FIG. 5F, a first upper dielectric layer **611** may be formed on the top surface **400a** of the lower molding layer **400**. First upper openings **619** may be formed in the first upper dielectric layer **611** to expose the corresponding top surfaces **300a** of the conductive structures **300**. First upper redistribution layers **621** may be formed in the first upper openings **619** and on a top surface of the first upper dielectric layer **611**. Each of the first upper redistribution layers **621** may include a first via pattern **621V** and a first wire pattern **621W**. The first via pattern **621V** may be formed in a corresponding first upper opening **619**. The first wire pattern **621W** may be formed on the first via pattern **621V** and may extend onto the top surface of the first upper dielectric layer **611**. First upper seed patterns **631** may be formed on bottom surfaces of the first upper redistribution layers **621**. The formation of the first upper redistribution layers **621** and the first upper seed patterns **631** may be the same as or similar to that used for forming the first redistribution patterns **121** and the first seed patterns **131** of FIG. 5A.

[0109] Referring to FIG. 5G, a second upper dielectric layer **612** may be formed on the first upper dielectric layer **611** and may cover the first upper redistribution layers **621**. Second upper openings **618** may be formed in the second upper dielectric layer **612** to expose the first upper redistribution layers **621**. Second upper redistribution layers **622** may be formed in, and correspond to, the second upper openings **618** and may be coupled to the first upper redistribution layers **621**. Each of the second upper redistribution layers **622** may include a second via pattern **622V** and a second wire pattern **622W**. The second via pattern **622V** may be formed in a corresponding second upper opening **618**. The second wire pattern **622W** may be formed on the second via pattern **622V** and may extend onto a top surface of the second upper dielectric layer **612**. Second upper seed patterns **632** may be formed below, and may correspond to, the second upper redistribution layers **622**. According to some example embodiments, an electroplating process may be performed in which the second upper seed patterns **632** are used as electrodes to form the second upper redistribution layers **622**.

[0110] A third upper dielectric layer **613** may be formed on the second upper dielectric layer **612** and may cover the second redistribution layers **622**. Third upper openings **617** may be formed in the third upper dielectric layer **613** and may expose the second upper redistribution layers **622**. Upper redistribution pads **640** may be formed in, and may correspond to, the third upper openings

**617** and may be coupled to the second upper redistribution layers **622**. Upper seed pads **643** may be formed below, and may correspond to, the upper redistribution pads **640**. The upper redistribution pads **640** may be formed by an electroplating process in which the upper seed pads **643** are used as electrodes. Accordingly, an upper redistribution substrate **600** may be fabricated. The upper redistribution substrate **600** may include the first, second, and third upper dielectric layers **611**, **612**, and **613**, the first upper seed patterns **631**, the first upper redistribution layers **621**, the second upper seed patterns **632**, the second upper redistribution layers **622**, upper seed pads **643**, and the upper redistribution pads **640**.

[0111] Referring to FIG. 5H, a first upper semiconductor chip **701** may be mounted on a top surface of the upper redistribution substrate **600**. The mounting of the first upper semiconductor chip **701** may include forming first upper solder patterns **751** between first upper chip pads **731** and corresponding upper redistribution pads **640**.

[0112] A preliminary upper molding layer **801** may be formed on the top surface of the upper redistribution substrate **600** and may cover the first upper semiconductor chip **701**. For example, the preliminary upper molding layer **801** may have a top surface **801a** at a higher level than that of a top surface of the first upper semiconductor chip **701** and may cover the top surface of the first upper semiconductor chip **701**. The preliminary upper molding layer **801** may extend onto a bottom surface of the first upper semiconductor chip **701** and may encapsulate the first upper solder patterns **751**.

[0113] Referring to FIG. 5I, the preliminary upper molding layer **801** may undergo a grinding process to form an upper molding layer **800**. For example, the grinding process may include a chemical mechanical polishing (CMP) process. The grinding process may continue until the first upper semiconductor chip **701** is exposed. As a result of the grinding process, the upper molding layer **800** may have a top surface **800a** that is coplanar with the top surface of the first upper semiconductor chip **701**.

[0114] Referring back to FIG. 1B, the carrier substrate **990** and the carrier adhesive layer **980** may be removed and a bottom surface of the lower redistribution substrate **100** may be exposed. For example, bottom surfaces of the under-bump patterns **150** may be exposed. Solder terminals **500** may be formed on, and may correspond to, the bottom surfaces of the under-bump patterns **150**. Accordingly, a semiconductor package **1** may be fabricated eventually.

[0115] Differently from the description of FIG. 5I, the grinding process of the preliminary upper molding layer **801** may stop before the first upper semiconductor chip **701** is exposed. In this case, a semiconductor package **1A** discussed in FIG. 2A may be fabricated.

[0116] FIG. 6 is a cross-sectional view showing a method of fabricating a semiconductor package according to some example embodiments.

[0117] Referring to FIG. 6, a lower redistribution substrate **100** may be formed. The lower redistribution substrate **100** may include under-bump patterns **150**, lower dielectric layers **110**, redistribution patterns **120**, seed patterns **130**, and redistribution pads **140**. The formation of the lower redistribution substrate **100** may be substantially the same as that discussed in FIGS. 5A and 5B. In contrast, the lower redistribution substrate **100** may be formed in a panel or wafer level.

[0118] A plurality of first lower semiconductor chips **201** may be provided on the lower redistribution substrate **100**. The plurality of first lower semiconductor chips **201** may be laterally spaced apart from each other. First lower solder patterns **251** may be formed between the lower redistribution substrate **100** and the first lower semiconductor chips **201**. Conductive structures **300** may be formed on the lower redistribution substrate **100**. A lower molding layer **400** may be formed on the lower redistribution substrate **100** and may cover the first lower semiconductor chips **201** and sidewalls of the conductive structures **300**. The lower molding layer **400** may expose top surfaces of the conductive structures **300**.

[0119] An upper redistribution substrate **600** may be formed on the lower molding layer **400**. The upper redistribution substrate **600** may include upper dielectric layers **610**, upper redistribution

layers **620**, upper seed patterns **630**, and upper redistribution pads **640**. The formation of the upper redistribution substrate **600** may be substantially the same as that discussed in FIGS. 5F and 5G. In contrast, the upper redistribution substrate **600** may be formed in a panel or wafer level.

[0120] A plurality of first upper semiconductor chips **701** may be provided on the upper redistribution substrate **600**. The plurality of first upper semiconductor chips **701** may be laterally spaced apart from each other. First upper solder patterns **751** may be correspondingly formed between the upper redistribution substrate **600** and the first upper semiconductor chips **701**. An upper molding layer **800** may be formed on the upper redistribution substrate **600** and may cover sidewalls of the first upper semiconductor chips **701**.

[0121] Solder terminals **500** may be formed on a bottom surface of the lower redistribution substrate **100** and may be coupled to the under-bump patterns **150**.

[0122] The lower redistribution substrate **100**, the lower molding layer **400**, the upper redistribution substrate **600**, and the upper molding layer **800** may be diced along dot-and-dash lines, which may result in fabricating a plurality of semiconductor packages **1** that are separated from each other. The semiconductor packages **1** may be formed in a panel or wafer level. Each of the semiconductor packages **1** may be the same as that discussed in the example of FIGS. 1A to 1D. For brevity of explanation, the following description refers to a single semiconductor package, except for the example of FIG. 6, but it is to be understood that the method of fabricating a semiconductor package is not necessarily limited to chip-level fabrication.

[0123] FIGS. 7A to 7D are cross-sectional views taken along line A'-B' of FIG. 3A, showing a method of fabricating a semiconductor package according to some example embodiments of the present inventive concepts.

[0124] Referring to FIG. 7A, a lower redistribution substrate **100** may be formed on a carrier substrate **990**. The formation of the lower redistribution substrate **100** may include forming under-bump patterns **150**, lower dielectric layers **110**, redistribution patterns **120**, seed patterns **130**, and redistribution pads **140**. The formation of the lower redistribution substrate **100** may be substantially the same as that discussed in FIGS. 5A and 5B. A carrier adhesive layer **980** may further be interposed between the carrier substrate **990** and the lower redistribution substrate **100**.

[0125] A first lower semiconductor chip **201** and a second lower semiconductor chip **202** may be mounted on the lower redistribution substrate **100**. The first and second lower semiconductor chips **201** and **202** may be laterally spaced apart from each other. First lower solder patterns **251** may be formed between the lower redistribution substrate **100** and the first lower semiconductor chip **201**. Second lower solder patterns **252** may be formed between the lower redistribution substrate **100** and the second lower semiconductor chip **202**. Conductive structures **300** may be formed on the lower redistribution substrate **100** and may be coupled to corresponding redistribution pads **140**.

[0126] A preliminary lower molding layer **401** may be formed on the lower redistribution substrate **100** and may cover sidewalls and top surfaces of the first and second lower semiconductor chips **201** and **202**. The preliminary lower molding layer **401** may have a top surface **401a** at a higher level than that of the top surface of the first lower semiconductor chip **201**, that of the top surface of the second lower semiconductor chip **202**, and that of top surfaces **300a** of the conductive structures **300**. The preliminary lower molding layer **401** may encapsulate the first lower solder patterns **251**. The preliminary lower molding layer **401** may extend onto a bottom surface of the second lower semiconductor chip **202** and may encapsulate the second lower solder patterns **252**.

[0127] Referring to FIG. 7B, the preliminary lower molding layer **401** may undergo a grinding process to form a lower molding layer **400**. The grinding process may stop after the conductive structures **300** are exposed. The lower molding layer **400** may have a top surface **400a** that is coplanar with the top surfaces **300a** of the conductive structures **300**.

[0128] The grinding process may stop before exposure of the first and second lower semiconductor chips **201** and **202**. Therefore, the conductive structures **300** may be prevented from being contaminated by grinding residues generated from the first lower semiconductor chip **201** and/or

grinding reissues generated from the second lower semiconductor chip **202**. After the termination of the grinding process, the top surface **400a** of the lower molding layer **400** may be located at a higher level than that of the top surface of the first lower semiconductor chip **201** and that of the top surface of the second lower semiconductor chip **202**, and the lower molding layer **400** may cover the top surfaces of the first and second lower semiconductor chips **201** and **202**.

[0129] Referring to FIG. 7C, an upper redistribution substrate **600** may be formed on the top surface **400a** of the lower molding layer **400**. The formation of the upper redistribution substrate **600** may include forming upper dielectric layers **610**, upper redistribution layers **620**, upper seed patterns **630**, and upper redistribution pads **640**. The formation of the upper redistribution substrate **600** may be substantially the same as that discussed in FIGS. 5F and 5G.

[0130] A first upper semiconductor chip **701** and a second upper semiconductor chip **702** may be mounted on a top surface of the upper redistribution substrate **600**. The first and second upper semiconductor chips **701** and **702** may be laterally spaced apart from each other. The mounting of the first upper semiconductor chip **701** may include forming first upper solder patterns **751**. The mounting of the second upper semiconductor chip **702** may include forming second upper solder patterns **752** between second upper chip pads **732** and corresponding upper redistribution pads **640**.

[0131] A preliminary upper molding layer **801** may be formed on the top surface of the upper redistribution substrate **600** and may cover the first upper semiconductor chip **701** and the second upper semiconductor chip **702**. For example, the preliminary upper molding layer **801** may have a top surface **801a** at a higher level than that of a top surface of the first upper semiconductor chip **701** and that of a top surface of the second upper semiconductor chip **702**. The preliminary upper molding layer **801** may encapsulate the first upper solder patterns **751**. The preliminary upper molding layer **801** may extend onto a bottom surface of the second upper semiconductor chip **702** and may encapsulate the second upper solder patterns **752**.

[0132] Referring to FIG. 7D, the preliminary upper molding layer **801** may undergo a grinding process to form an upper molding layer **800**. The upper molding layer **800** may have a top surface **800a** that is coplanar with the top surface of the first upper semiconductor chip **701** and the top surface of the second upper semiconductor chip **702**.

[0133] Referring back to FIG. 3B, the carrier substrate **990** and the carrier adhesive layer **980** may be removed and may expose a bottom surface of the lower redistribution substrate **100**. For example, bottom surfaces of the under-bump patterns **150** may be exposed. Solder terminals **500** may be formed on, and may correspond to, the bottom surfaces of the under-bump patterns **150**. Accordingly, a semiconductor package **2** may be fabricated.

[0134] Differently from the description of FIG. 7D, the grinding process of the preliminary upper molding layer **801** may stop before the first and second upper semiconductor chips **701** and **702** are exposed. In this case, a semiconductor package **2A** discussed in FIG. 4A may be fabricated.

[0135] According to the present inventive concepts, a lower semiconductor chip may be electrically connected to first solder terminals through a redistribution substrate. An upper semiconductor chip may be electrically connected to second solder terminals through an upper redistribution substrate and conductive structures. The redistribution substrate and the upper redistribution substrate may have small thicknesses, and thus the lower and upper semiconductor chips may have reduced electrical paths and a semiconductor package may decrease in size. The conductive structures may have lower resistivity to allow the upper semiconductor chip to have an increased operating speed. The lower and upper semiconductor chips may achieve an increase in thermal radiation.

[0136] This detailed description of the present inventive concepts should not necessarily be construed as limited to the embodiments set forth herein, and it is intended that the present inventive concepts cover the various combinations, the modifications and variations of this invention without departing from the spirit and scope of the present disclosure. Various elements of different example embodiments of the present inventive concepts may be combined with each other.

## Claims

1. A method of manufacturing a semiconductor package, comprising: forming a lower redistribution substrate comprising a lower dielectric layer and a lower redistribution pad on the lower dielectric layer; forming a conductive structure on the lower redistribution layer; mounting a lower semiconductor chip on the lower redistribution layer; forming a lower molding layer covering the lower semiconductor chip and a top surface of the lower redistribution layer; forming an upper redistribution substrate on the lower molding layer, wherein the upper redistribution substrate comprises an upper dielectric layer and an upper redistribution pad on the upper dielectric layer; mounting an upper semiconductor chip on the upper redistribution layer; and forming an upper molding layer covering a top surface of the upper redistribution substrate and a side wall of the upper semiconductor chip, wherein the upper molding layer exposes a top surface of the upper semiconductor chip, wherein mounting the lower semiconductor chip on the lower redistribution layer comprises forming a lower solder pattern between the lower semiconductor chip and the lower redistribution pad, wherein mounting the upper semiconductor chip on the upper redistribution layer comprises forming an upper solder pattern between the upper semiconductor chip and the upper redistribution pad, wherein the lower molding layer contacts with the lower solder pattern, wherein the upper molding layer contacts with the upper solder pattern, wherein the lower redistribution pattern comprises a lower via pattern and a lower wire pattern, wherein a width of a top surface of the lower via pattern is greater than a width of a bottom surface of the lower via pattern, wherein the upper redistribution pattern comprises an upper via pattern and an upper wire pattern, and wherein a width of a top surface of the upper via pattern is greater than a width of a bottom surface of the upper via pattern.
2. The method of manufacturing a semiconductor package of claim 1, wherein forming lower redistribution substrate comprises: forming the lower dielectric layer; forming a lower opening by patterning the lower dielectric layer; forming a lower seed layer on the lower opening; and forming the lower redistribution pad on the lower seed layer.
3. The method of manufacturing a semiconductor package of claim 1, wherein forming the lower molding layer comprises: forming a preliminary lower molding layer covering the lower redistribution substrate, the conductive structure and the lower semiconductor chip; and performing a gridding process to the preliminary lower molding layer until a top surface of the conductive structure is exposed, wherein the top surface of the conductive structure located at higher level than a top surface of the lower semiconductor chip.
4. The method of manufacturing a semiconductor package of claim 1, wherein the lower molding layer and the upper molding layer include a photo-imageable polymer.
5. The method of manufacturing a semiconductor package of claim 1, wherein forming the upper molding layer comprises: forming a preliminary upper molding layer covering the upper redistribution substrate and the upper semiconductor chip, and performing a gridding process to the preliminary lower molding layer until a top surface of the upper semiconductor chip is exposed.
6. The method of manufacturing a semiconductor package of claim 1, wherein a resistivity of the conductive structure is less than a resistivity of the lower solder pattern.
7. The method of manufacturing a semiconductor package of claim 1, wherein forming the upper redistribution substrate comprises: forming a first upper dielectric layer on the lower molding layer; exposing a top surface of the conductive structure by patterning the first upper dielectric layer; forming a first upper seed layer on the exposed top surface of the conductive structure; and forming a first upper via pattern and a first upper wire pattern on the first upper seed layer.
8. The method of manufacturing a semiconductor package of claim 1, wherein forming the lower redistribution substrate comprises: forming a first lower dielectric layer on a carrier substrate; forming a first lower opening by patterning the first lower dielectric layer; forming a first seed

layer on the first lower opening; and forming a first lower via pattern and a first lower wire pattern on the first lower seed layer, wherein the carrier substrate comprises a carrier adhesive layer formed between the carrier substrate and the first lower dielectric layer, and wherein the carrier adhesive layer attaches the carrier substrate and the first lower dielectric layer.

**9.** The method of manufacturing a semiconductor package of claim 8, further comprising: after forming the upper molding layer, removing the carrier substrate and the carrier adhesive layer.

**10.** A method of manufacturing a semiconductor package, comprising: forming a lower redistribution substrate comprising a lower dielectric layer and a lower redistribution pad on the lower dielectric layer; forming a plurality of a conductive structures on the lower redistribution layer; mounting a first lower semiconductor chip and a second lower semiconductor on the lower redistribution layer; forming a lower molding layer covering the lower semiconductor chip and a top surface of the lower redistribution layer; forming an upper redistribution substrate on the lower molding layer, wherein the upper redistribution substrate comprises an upper dielectric layer and an upper redistribution pad on the upper dielectric layer; mounting a first upper semiconductor chip and a second upper semiconductor on the upper redistribution layer; and forming an upper molding layer covering a top surface of the upper redistribution substrate and a side wall of the upper semiconductor chip, wherein the upper molding layer exposes a top surface of the upper semiconductor chip, wherein at least one of the plurality of the conductive structures is formed between the first lower semiconductor and the second lower semiconductor, wherein mounting the first lower semiconductor chip on the lower redistribution layer comprises forming a first lower solder pattern between the first lower semiconductor chip and the lower redistribution pad, wherein mounting the second lower semiconductor chip on the lower redistribution layer comprises forming a second lower solder pattern between the second lower semiconductor chip and the lower redistribution pad, wherein mounting the first upper semiconductor chip on the upper redistribution layer comprises forming a first upper solder pattern between the first upper semiconductor chip and the upper redistribution pad, wherein mounting the second upper semiconductor chip on the upper redistribution layer comprises forming a second upper solder pattern between the second upper semiconductor chip and the upper redistribution pad, wherein the lower molding layer contacts with the first and second lower solder pattern, wherein the upper molding layer contacts with the first and second upper solder pattern, wherein the lower redistribution pattern comprises a lower via pattern and a lower wire pattern, wherein a width of a top surface of the lower via pattern is greater than a width of a bottom surface of the lower via pattern, wherein the upper redistribution pattern comprises an upper via pattern and an upper wire pattern, and wherein a width of a top surface of the upper via pattern is greater than a width of a bottom surface of the upper via pattern.

**11.** The method of manufacturing a semiconductor package of claim 10, wherein the forming the lower redistribution substrate comprises: forming a first lower dielectric layer on a carrier substrate; forming a first lower opening by patterning the first lower dielectric layer; forming a first seed layer on the first lower opening; and forming a first lower via pattern and a first lower wire pattern on the first lower seed layer, wherein the carrier substrate comprises a carrier adhesive layer formed between the carrier substrate and the first lower dielectric layer, and wherein the carrier adhesive layer attaches the carrier substrate and the first lower dielectric layer.

**12.** The method of manufacturing a semiconductor package of claim 11, wherein forming the first lower via pattern and the first lower wire pattern comprises performing an electroplating process in which the first lower seed layer is used as an electrode.

**13.** The method of manufacturing a semiconductor package of claim 11, further comprising: after forming the upper molding layer, removing the carrier substrate and the carrier adhesive layer.

**14.** The method of manufacturing a semiconductor package of claim 13, further comprising: after removing the carrier substrate and the carrier adhesive layer, forming a solder terminal on a bottom surface of the lower redistribution substrate.

**15.** The method of manufacturing a semiconductor package of claim 10, wherein the lower molding



layer includes a photo-imageable polymer and the upper molding layer includes a photo-imageable polymer.

**16.** The method of manufacturing a semiconductor package of claim 10, wherein forming the upper molding layer comprises: forming a preliminary upper molding layer covering the upper redistribution substrate and the upper semiconductor chip; and performing a grinding process to the preliminary lower molding layer until a top surface of the upper semiconductor chip is exposed.

**17.** A method of manufacturing a semiconductor package, comprising: forming a lower redistribution substrate on a carrier adhesive layer of a carrier substrate, wherein the lower redistribution substrate comprises a lower dielectric layer and a lower redistribution pad on the lower dielectric layer; forming a conductive structure on the lower redistribution layer; mounting a lower semiconductor chip on the lower redistribution layer; forming a lower molding layer covering the lower semiconductor chip and a top surface of the lower redistribution layer; forming an upper redistribution substrate on the lower molding layer, wherein the upper redistribution substrate comprises an upper dielectric layer and an upper redistribution pad on the upper dielectric layer; mounting an upper semiconductor chip on the upper redistribution layers; and forming an upper molding layer covering a top surface of the upper redistribution substrate and a side wall of the upper semiconductor chip, wherein the upper molding layer exposes a top surface of the upper semiconductor chip, wherein the mounting the lower semiconductor chip on the lower redistribution layer comprises forming a lower solder pattern between the lower semiconductor chip and the lower redistribution pad, wherein the mounting the upper semiconductor chip on the upper redistribution layer comprises forming an upper solder pattern between the upper semiconductor chip and the upper redistribution pad, wherein the lower molding layer includes a photo-imageable polymer, wherein the upper molding layer includes a photo-imageable polymer, wherein the lower redistribution pattern comprises a lower via pattern and a lower wire pattern, wherein a width of a top surface of the lower via pattern is greater than a width of a bottom surface of the lower via pattern, wherein the upper redistribution pattern comprises an upper via pattern and an upper wire pattern, and wherein a width of a top surface of the upper via pattern is greater than a width of a bottom surface of the upper via pattern.

**18.** The method of manufacturing a semiconductor package of claim 17, wherein the lower molding layer contacts with the lower solder pattern, and the upper molding layer contacts with the upper solder pattern,

**19.** The method of manufacturing a semiconductor package of claim 17, wherein forming the lower molding layer comprises: forming a preliminary lower molding layer covering the lower redistribution substrate, the conductive structure and the lower semiconductor chip, and performing a grinding process to the preliminary lower molding layer until a top surface of the conductive structure is exposed, wherein the top surface of the conductive structure is located at higher level than a top surface of the lower semiconductor chip.

**20.** The method of manufacturing a semiconductor package of claim 17, wherein forming the upper molding layer comprises: forming a preliminary upper molding layer covering the upper redistribution substrate and the upper semiconductor chip, and performing a grinding process to the preliminary lower molding layer until a top surface of the upper semiconductor chip is exposed.

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