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### Semiconductor package and fabricating method thereof

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#### Abstract

A semiconductor device structure, for example a 3D structure, and a method for fabricating a semiconductor device. As non-limiting examples, various aspects of this disclosure provide various semiconductor package structures, and methods for manufacturing thereof, that comprise interposer, interlayer, and/or heat dissipater configurations that provide for low cost, increased manufacturability, and high reliability.

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## Background/Summary

### CROSS-REFERENCE TO RELATED APPLICATIONS/INCORPORATION BY REFERENCE

(1) The present application is a CONTINUATION of U.S. patent application Ser. No. 17/468,981, filed Sep. 8, 2021, and titled “SEMICONDUCTOR PACKAGE AND FABRICATING METHOD THEREOF,” now U.S. Pat. No. 11,961,797; which is a CONTINUATION of U.S. patent application Ser. No. 16/813,368, filed Mar. 9, 2020, and titled “SEMICONDUCTOR PACKAGE AND FABRICATING METHOD THEREOF,” now U.S. Pat. No. 11,121,071; which is a CONTINUATION of U.S. patent application Ser. No. 15/832,027, filed Dec. 5, 2017, and titled “SEMICONDUCTOR PACKAGE AND FABRICATING METHOD THEREOF,” now U.S. Pat. No. 10,586,761; which is a CONTINUATION of U.S. patent application Ser. No. 14/694,269, filed Apr. 23, 2015, and titled “SEMICONDUCTOR PACKAGE AND MANUFACTURING METHOD THEREOF,” now U.S. Pat. No. 9,859,203; which makes reference to, claims priority to, and claims the benefit of Korean Patent Application No. 10-2015-0017324, filed on Feb. 4, 2015 in the Korean Intellectual Property Office and titled “SEMICONDUCTOR PACKAGE AND FABRICATING METHOD THEREOF,” the contents of each of which are hereby incorporated herein by reference, in their entirety.

### FEDERALLY SPONSORED RESEARCH OR DEVELOPMENT

(2) [Not Applicable]

### SEQUENCE LISTING

(3) [Not Applicable]

### MICROFICHE/COPYRIGHT REFERENCE

(4) [Not Applicable]

### BACKGROUND

(5) Present systems, methods and/or architectures for forming semiconductor packages are inadequate, for example resulting in excess cost, decreased reliability, or package sizes that are too large. Further limitations and disadvantages of conventional and traditional approaches will become apparent to one of skill in the art, through comparison of such approaches with the present disclosure as set forth in the remainder of the present application with reference to the drawings.

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## Description

## BRIEF DESCRIPTION OF SEVERAL VIEWS OF THE DRAWINGS

- (1) The accompanying drawings are included to provide a further understanding of the present disclosure, and are incorporated in and constitute a part of this specification. The drawings illustrate examples of the present disclosure and, together with the description, serve to explain various principles of the present disclosure. In the drawings:
- (2) FIG. 1 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (3) FIG. 2 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (4) FIGS. 3A to 3D are cross-sectional views illustrating an example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (5) FIGS. 4A to 4G are cross-sectional views illustrating another example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (6) FIG. 5 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (7) FIG. 6 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (8) FIG. 7 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (9) FIGS. 8A to 8D are cross-sectional views illustrating still another example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (10) FIGS. 9A to 9E are cross-sectional views illustrating an additional example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (11) FIGS. 10A and 10B are cross-sectional views illustrating a further example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (12) FIG. 11 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (13) FIG. 12 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (14) FIG. 13 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (15) FIGS. 14A to 14E are cross-sectional views illustrating a still further example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (16) FIGS. 15A to 15D are cross-sectional views illustrating yet another example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure;
- (17) FIG. 16 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure;
- (18) FIG. 17 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure; and
- (19) FIG. 18 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

## SUMMARY

- (20) Various aspects of this disclosure provide a semiconductor device structure, for example a 3D structure, and a method for fabricating a semiconductor device. As non-limiting examples, various aspects of this disclosure provide various semiconductor package structures, and methods for manufacturing thereof, that comprise interposer, interlayer, and/or heat dissipater configurations that provide for low cost, increased manufacturability, and high reliability.

## DETAILED DESCRIPTION OF VARIOUS ASPECTS OF THE DISCLOSURE

- (21) The following discussion presents various aspects of the present disclosure by providing

various examples thereof. Such examples are non-limiting, and thus the scope of various aspects of the present disclosure should not necessarily be limited by any particular characteristics of the provided examples. In the following discussion, the phrases “for example,” “e.g.,” and “exemplary” are non-limiting and are generally synonymous with “by way of example and not limitation,” “for example and not limitation,” and the like.

(22) As utilized herein, “and/or” means any one or more of the items in the list joined by “and/or”. As an example, “x and/or y” means any element of the three-element set  $\{(x), (y), (x, y)\}$ . In other words, “x and/or y” means “one or both of x and y.” As another example, “x, y, and/or z” means any element of the seven-element set  $\{(x), (y), (z), (x, y), (x, z), (y, z), (x, y, z)\}$ . In other words, “x, y and/or z” means “one or more of x, y, and z.”

(23) The terminology used herein is for the purpose of describing particular examples only and is not intended to be limiting of the disclosure. As used herein, the singular forms are intended to include the plural forms as well, unless the context clearly indicates otherwise. It will be further understood that the terms “comprises,” “includes,” “comprising,” “including,” “has,” “have,” “having,” and the like when used in this specification, specify the presence of stated features, integers, steps, operations, elements, and/or components, but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, and/or groups thereof.

(24) It will be understood that, although the terms first, second, etc. may be used herein to describe various elements, these elements should not be limited by these terms. These terms are only used to distinguish one element from another element. Thus, for example, a first element, a first component or a first section discussed below could be termed a second element, a second component or a second section without departing from the teachings of the present disclosure. Similarly, various spatial terms, such as “upper,” “lower,” “side,” and the like, may be used in distinguishing one element from another element in a relative manner. It should be understood, however, that components may be oriented in different manners, for example a semiconductor device may be turned sideways so that its “top” surface is facing horizontally and its “side” surface is facing vertically, without departing from the teachings of the present disclosure.

(25) Various aspects of the present disclosure provide a semiconductor device or package and a fabricating (or manufacturing) method thereof, which can decrease the cost, increase the reliability, and/or increase the manufacturability of the semiconductor device.

(26) The above and other aspects of the present disclosure will be described in or be apparent from the following description of various example implementations.

(27) According to an aspect of the present disclosure, there is provided a semiconductor package including a semiconductor device including a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, a semiconductor die mounted on a top surface of the circuit board, an encapsulant encapsulating the semiconductor die from an upper portion of the circuit board and having through vias exposing the first circuit pattern to the outside of the encapsulant, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern, an interposer mounted on the semiconductor device and including an insulator, a circuit pattern formed on a bottom surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern, and an interlayer member interposed between the semiconductor device and the interposer, wherein the conductive structures of the interposer are electrically connected to the conductive structures in the through vias, and the interlayer member is formed to cover the conductive bumps and the solder balls.

(28) The interlayer member may, for example, be formed of an epoxy flux, an epoxy resin, an epoxy molding compound (EMC), an anisotropically conductive paste (ACP), etc.

(29) In addition, the interlayer member may include a first interlayer member part covering the

conductive bumps and the solder balls and a second interlayer member part formed along an outer peripheral edge of the first interlayer member part.

(30) The first interlayer member part may, for example, be formed of an epoxy flux and the second interlayer member part may, for example, be formed of an adhesive.

(31) The second interlayer member part may, for example, be formed between the semiconductor die and the interposer and between the encapsulant and the interposer.

(32) According to an aspect of the present disclosure, there is provided a fabricating method of a semiconductor package, including preparing a semiconductor device including a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, a semiconductor die mounted on a top surface of the circuit board, an encapsulant encapsulating the semiconductor die and having through vias exposing the first circuit pattern to the outside of the encapsulant, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern, forming an interlayer member on the semiconductor device, and positioning an interposer on the interlayer member and performing a reflow process on the interlayer member, the interposer including an insulator, a circuit pattern formed on a bottom surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern.

(33) In the performing of the reflow process, the conductive structures in the through vias may be welded to the conductive structures of the interposer.

(34) In addition, in the performing of the reflow process, the interlayer member may be cured between the semiconductor device and the interposer.

(35) The interlayer member may cover lateral surfaces of any or all of the conductive structures.

(36) In the forming of the interlayer member, the interlayer member may be coated to entirely cover a top portion of the semiconductor device.

(37) The interlayer member may, for example, be formed of an epoxy flux, an epoxy resin, an epoxy molding compound (EMC), an anisotropically conductive paste (ACP), etc.

(38) In the forming of the interlayer member, a first interlayer member part may be formed on the through vias and a second interlayer member part may be formed on the semiconductor die and the encapsulant.

(39) The first interlayer member part may, for example, be formed of an epoxy flux and the second interlayer member part may, for example, be formed of an adhesive.

(40) According to still another aspect of the present disclosure, there is provided a fabricating method of a semiconductor package, including preparing a semiconductor device including a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, a semiconductor die mounted on a top surface of the circuit board, an encapsulant encapsulating the semiconductor die from an upper portion of the circuit board and having through vias exposing the first circuit pattern to the outside, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern, forming a first interlayer member part on the semiconductor device by coating, positioning an interposer on the interlayer member and performing a reflow process on the interposer, the interposer including an insulator, a circuit pattern formed on a bottom surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern, and forming a second interlayer member part between the semiconductor device and the interposer by, for example, injection-molding.

(41) In the forming of the first interlayer member part, the first interlayer member part may be coated on the through vias.

(42) In addition, in the performing of the reflow process, the conductive structures in the through vias may be welded to the conductive structures of the interposer and the first interlayer member

part may cover lateral surfaces of any or all of the conductive structures.

(43) In the forming of the second interlayer member part, the second interlayer member part may, for example, be injected into portions between the semiconductor die and the interposer and between the encapsulant and the interposer.

(44) In the forming of the first interlayer member part, the first interlayer member part may, for example, be formed on the solder balls by dipping.

(45) According to yet another aspect of the present disclosure, there is provided a semiconductor package including a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, a semiconductor die mounted on the circuit board, an interposer mounted on the circuit board and the semiconductor die and including an insulator, a circuit pattern formed on a bottom surface of the insulator and a conductive filler formed on the circuit pattern, and an interlayer member interposed between the circuit board and the interposer, wherein the conductive filler is electrically connected to the first circuit pattern and the interlayer member is formed to cover lateral surfaces of the conductive filler.

(46) The interlayer member may, for example, be formed of an epoxy flux, an epoxy resin, an epoxy molding compound (EMC), an anisotropically conductive paste (ACP), etc.

(47) In addition, the interlayer member may, for example, include a first interlayer member part covering the conductive filler, the first circuit pattern of the circuit board electrically connected to the conductive filler and the circuit pattern of the interposer and a second interlayer member part formed along an outer peripheral edge of the first interlayer member part.

(48) The first interlayer member part may, for example, be formed of an epoxy flux and the second interlayer member part is formed of an adhesive.

(49) The second interlayer member part may, for example, be formed between the semiconductor die and the interposer and between the encapsulant and the interposer.

(50) In addition, the second interlayer member part may, for example, be formed between the semiconductor die and the interposer.

(51) According to a still further aspect of the present disclosure, there is provided a fabricating method of a semiconductor package, including attaching a semiconductor die on a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, forming an interlayer member on the circuit board and the semiconductor die, for example by coating, and positioning an interposer on the interlayer member and performing a reflow process on the interlayer member, the interposer including an insulator, a circuit pattern formed on a bottom surface of the insulator and a conductive filler formed on the circuit pattern.

(52) In the performing of the reflow process, the conductive filler may be electrically connected to the first circuit pattern of the circuit board.

(53) In addition, in the performing of the reflow process, the interlayer member may, for example, be cured between the circuit board and the interposer.

(54) The interlayer member may, for example, cover the conductive filler, the first circuit pattern of the circuit board electrically connected to the conductive filler and the circuit pattern of the interposer.

(55) In addition, the interlayer member may, for example, be formed of an epoxy flux, an epoxy resin, an epoxy molding compound (EMC), an anisotropically conductive paste (ACP), etc.

(56) In the forming of the interlayer member, a first interlayer member part may, for example, be formed on the first circuit pattern and a second interlayer member part may, for example, be formed on the semiconductor die.

(57) The first interlayer member part may, for example, be formed of an epoxy flux and the second interlayer member part may, for example, be formed of an adhesive.

(58) According to still further aspect of the present disclosure, there is provided a fabricating

method of a semiconductor package, including attaching a semiconductor die on a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, forming a first interlayer member part on the circuit board, for example by coating, positioning an interposer on the interlayer member and performing a reflow process on the interlayer member, the interposer including an insulator, a circuit pattern formed on a bottom surface of the insulator and a conductive filler formed on the circuit pattern, and forming a second interlayer member part between the circuit board and the interposer, for example by injection-molding.

(59) In the forming of the first interlayer member part, the first interlayer member part may, for example, be coated on the first circuit pattern of the circuit board.

(60) In the performing of the reflow process, the conductive filler may, for example, be electrically connected to the first circuit pattern and the first interlayer member part may, for example, cover the conductive filler, the first circuit pattern of the circuit board electrically connected to the conductive filler and the circuit pattern of the interposer.

(61) In the forming of the second interlayer member part, the second interlayer member part may, for example, be injected into portions between the semiconductor die and the interposer and between the circuit board and the interposer.

(62) According to a still further aspect of the present disclosure, there is provided a semiconductor package including a semiconductor device including a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, a semiconductor die mounted on a top surface of the circuit board and having a metal layer formed thereon, an encapsulant encapsulating the semiconductor die from an upper portion of the circuit board and having through vias exposing the first circuit pattern to the outside, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern, an interposer mounted on the semiconductor device and including an insulator, a circuit pattern formed on a bottom surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern, and a heat radiating member disposed between the semiconductor die and the interposer, where the heat radiating member is electrically (or at least heat-conductively) connected to the metal layer and the interposer (e.g., a conductive pad formed thereon).

(63) The heat radiating member may, for example, be formed of a solder paste (e.g., at least initially, prior to a reflow process if performed).

(64) The semiconductor package may, for example, further include an interlayer member between the semiconductor device and the interposer.

(65) The interlayer member may, for example, be formed between the encapsulant and the interposer.

(66) According to still another aspect of the present disclosure, there is provided a semiconductor package including an interposer including an insulator, a circuit pattern and conductive pads formed on a top surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern, a semiconductor device mounted on the interposer and including a circuit board including an insulating layer, a first circuit pattern formed on a bottom surface of the insulating layer and a second circuit pattern formed on a top surface of the insulating layer, a semiconductor die mounted on a bottom surface of the circuit board and having a metal layer formed on its bottom surface, an encapsulant encapsulating the semiconductor die from a lower portion of the circuit board and having through vias exposing the first circuit pattern to the outside, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern, and a heat radiating member between the interposer and the semiconductor die, wherein the heat radiating member is electrically connected to the metal layer and the conductive pad.



(67) The heat radiating member may, for example, be formed of a solder paste (e.g., at least initially, prior to a reflow process if performed).

(68) According to still another aspect of the present disclosure, there is provided a fabricating method of a semiconductor package, including preparing a semiconductor device including a circuit board including an insulating layer, a first circuit pattern formed on a top surface of the insulating layer and a second circuit pattern formed on a bottom surface of the insulating layer, a semiconductor die mounted on a top surface of the circuit board and having a metal layer formed thereon, an encapsulant encapsulating the semiconductor die from an upper portion of the circuit board and having through vias exposing the first circuit pattern to the outside of the encapsulant, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern, forming a heat radiating member on the semiconductor die, for example by coating, and positioning an interposer on the heat radiating member and performing a reflow process on the interposer, the interposer including an insulator, a circuit pattern and conductive pads formed on a bottom surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern.

(69) In the forming of the heat radiating member, the heat radiating member may, for example, be coated on the metal layer of the semiconductor die.

(70) In the performing of the reflow process, the conductive structures in the through vias may, for example, be welded to the conductive structures attached to the interposer, and the heat radiating member may be electrically connected to the metal layer and the conductive pad.

(71) The heat radiating member may, for example, be formed of a solder paste (e.g., at least initially, prior to a reflow process if performed).

(72) After the performing of the reflow process, the fabricating method may, for example, further include forming an interlayer member between the semiconductor device and the interposer by, for example, injection-molding.

(73) According to still another aspect of the present disclosure, there is provided a fabricating method of a semiconductor package, including preparing an interposer including an insulator, a circuit pattern and a conductive pad formed on a top surface of the insulator and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern, forming a heat radiating member on the interposer, for example by coating, and positioning a semiconductor device and performing a reflow process on the semiconductor device, the semiconductor device including a circuit board including an insulating layer formed on the heat radiating member, a first circuit pattern formed on a bottom surface of the insulating layer and a second circuit pattern formed on a top surface of the insulating layer, a semiconductor die mounted on a bottom surface of the circuit board and having a metal layer formed on its bottom surface, an encapsulant encapsulating the semiconductor die from a bottom portion of the circuit board and having through vias exposing the first circuit pattern to the outside, and conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) formed in the through vias and electrically connected to the first circuit pattern.

(74) In the forming of the heat radiating member, the heat radiating member may, for example, be coated on conductive pads of the interposer.

(75) In the performing of the reflow process, the conductive structures in the through vias may be welded to the conductive structures attached to the interposer, and the heat radiating member may be electrically connected to the metal layer and the conductive pad.

(76) The heat radiating member may, for example, be formed of a solder paste (e.g., at least initially, prior to a reflow process if performed).

(77) As described above, in the semiconductor package according to an example of the present disclosure, since the interlayer member made of an epoxy flux is formed between the semiconductor device and the interposer, bondability between the semiconductor device and the

interposer is increased, thereby improving the reliability and reducing warpage.

(78) In addition, in a semiconductor package according to various aspects of the present disclosure, since the heat radiating member made of a solder paste is formed between the semiconductor device and the interposer, heat generated from the semiconductor device can be efficiently radiated to the outside through the interposer.

(79) Example aspects of the present disclosure will now be presented with reference to accompanying drawings, such that those skilled in the art may readily practice the various aspects.

(80) Referring to FIG. 1, the semiconductor package **100** according to an example of the present disclosure includes a semiconductor device **110**, an interposer **160** and an interlayer member **170**.

Note that the example semiconductor package **100** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(81) The semiconductor device **110** includes a circuit board **120**, a semiconductor die **130**, an encapsulant **140** and conductive structures **150** (e.g., conductive bumps or balls, pillars, wires, etc.). The semiconductor device **110** may, for example, be called a through mold via (TMV) semiconductor device.

(82) The circuit board **120** includes an insulating layer **121** having planar top and bottom surfaces, a first circuit pattern **122** formed on a top surface of the insulating layer **121**, a second circuit pattern **123** formed on a bottom surface of the insulating layer **121**, and a passivation layer **124** formed along outer peripheral edges of the first and second circuit patterns **122** and **123** to a predetermined thickness. The circuit board **120** may, for example, be a printed circuit board (PCB) having opposite surfaces. Here, conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) (not shown) are welded plated or otherwise attached to the second circuit pattern **123** to then be electrically connected to an external circuit.

(83) The semiconductor die **130** is mounted on the circuit board **120**. The semiconductor die **130** may, for example, be generally made of a silicon material and have a plurality of semiconductor devices formed therein. In addition, a plurality of conductive structures **131** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) may be formed under the semiconductor die **130**. The semiconductor die **130** is electrically connected to the circuit board **120** through the conductive structures **131**. The conductive structures **131** may be electrically connected to the first circuit pattern **122** of the circuit board **120**.

(84) The encapsulant **140** encapsulates the semiconductor die **130** from an upper portion of the circuit board **120**. The encapsulant **140** may, for example, expose a top portion of the semiconductor die **130** to the outside of the encapsulant **140**. In addition, through vias **141** may be formed in the encapsulant **140**. The through vias **141** may, for example, be formed over the first circuit pattern **122** of the circuit board **120** and expose the first circuit pattern **122** to the outside of the encapsulant **140**.

(85) The conductive structures **150** (e.g., conductive bumps or balls, pillars, wires, etc.) may be formed on the first circuit pattern **122** exposed to the outside of the encapsulant **140** by the through vias **141**. The conductive structures **150** may, for example, be electrically connected to the semiconductor die **130** through the first circuit pattern **122**. The conductive structures **150** may, for example, include tin/lead, leadless tin, equivalents thereof, etc., but aspects of the present disclosure are not limited thereto.

(86) The interposer **160** is mounted on the semiconductor device **110**. The interposer **160** includes an insulator **161** having planar top and bottom surfaces, a circuit pattern **162** formed on a bottom surface of the insulator **161** and conductive structures **163** (e.g., conductive bumps or balls, pillars, wires, etc.) formed on the circuit pattern **162**. In addition, the interposer **160** may also include a circuit pattern formed on a top surface of the insulator **161** so as to stack semiconductor devices, such as for example memory chips or logic chips, thereon. The solder balls **163** are electrically connected to the conductive bumps **150** of the semiconductor device **110**. For example, when the interposer **160** is mounted on the semiconductor device **110**, the solder balls **163** are welded to the

conductive bumps **150** to electrically connect the interposer **160** and the semiconductor device **110** to each other. The interposer **160** may, for example, be a silicon substrate, a printed circuit board (PCB), etc.

(87) The interlayer member **170** may be formed between the semiconductor device **110** and the interposer **160**. For example, the interlayer member **170** may be interposed between a top surface of the semiconductor die **130** mounted on the circuit board **120** and a bottom surface of the interposer **160**. In addition, the interlayer member **170** may be formed to cover lateral surfaces of the conductive bumps **150** of the semiconductor device **110** and the solder balls **163** of the interposer **160**.

(88) The interlayer member **170** may, for example, be formed of an epoxy flux. The epoxy flux may, for example, be applied to surrounding areas of the conductive bumps **150** and the solder balls **163**, thereby improving adhesion between the conductive bumps **150** and the solder balls **163** and allowing the heat generated from the semiconductor die **130** to be transferred to the interposer **160** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. Accordingly, cooling efficiency of the semiconductor package **100** according to various aspects of the present disclosure may be improved. For example, the interlayer member **170** may tightly couple the semiconductor device **110** to the interposer **160**. In addition, the interlayer member **170** may reduce warpage occurring between the semiconductor device **110** and the interposer **160**.

(89) In addition, the interlayer member **170** may, for example, be formed by injecting an epoxy resin or an epoxy molding compound (EMC) into a region between the semiconductor device **110** and the interposer **160**. Further for example, the interlayer member **170** may also be formed of an anisotropically conductive paste (ACP). The anisotropically conductive paste (ACP) includes a binder and a conductive filler mixed therein and is used to mechanically and electrically connect upper and lower electrodes coupled to each other, for example by thermal compression. In addition, since the binder functions as an insulator, an insulating property is maintained between conductive fillers existing in adjacent circuits.

(90) FIG. **2** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(91) Referring to FIG. **2**, the semiconductor package **200** according to another example of the present disclosure includes a semiconductor device **110**, an interposer **160** and an interlayer member **270**. The semiconductor package **200** shown in FIG. **2** is substantially the same as the semiconductor package **100** shown in FIG. **1**, and the following description will generally focus on differences therebetween. Note that the example semiconductor package **200** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(92) The interlayer member **270** is formed between the semiconductor device **110** and the interposer **160**. The interlayer member **270** may, for example, include a first interlayer member part **271** covering lateral surfaces of the conductive structures **150** and the conductive structures **163** and a second interlayer member part **272** formed at an outer peripheral edge of the first interlayer member part **271**. For example, the second interlayer member part **272** may encapsulate the first interlayer member part **271**. Also for example, the second interlayer member part **272** may be formed outside of a region generally defined by a plurality of first interlayer member parts **271**, inside of a region generally defined by a plurality of first interlayer member parts **271**, and/or between first interlayer member parts **271**. Though shown in FIG. **2** as contacting the first interlayer member part **271**, the second interlayer member part **272** may be separated from the first interlayer member part **271** by a gap (e.g., an air gap or gap filled with another material).

(93) The first interlayer member part **271** is formed in the vicinity of areas where the conductive bumps **150** of the semiconductor device **110** are welded or otherwise attached to the conductive structures **163** attached to the interposer **160**. Here, the first interlayer member part **271** may be formed to fill the through vias **141** of the semiconductor device **110** (e.g., in regions not already occupied by conductive structure). In addition, the first interlayer member part **271** may, for

example, be formed of an epoxy flux and cover the surrounding areas of the conductive structures **150** and the conductive structures **163**. Therefore, the first interlayer member part **271** may improve adhesion between the conductive structures **150** and the conductive structures **163**.

(94) The second interlayer member part **272** may, for example, be formed along the outer peripheral edge of the first interlayer member part **271**. For example, the second interlayer member part **272** may be formed between the semiconductor device **110** and the interposer **160**, where the conductive structures **150** are not welded to the conductive structures **163**. For example, the second interlayer member part **272** is formed between the semiconductor die **130** and the interposer **160** and between the encapsulant **140** and the interposer **160**. The second interlayer member part **272** may, for example, be formed of a general adhesive, such as an epoxy resin or EMC, or of other materials. The second interlayer member part **272** may, for example, transfer the heat generated from the semiconductor die **130** to the interposer **160** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. In addition, the second interlayer member part **272** may improve bondability between the semiconductor device **110** and the interposer **160**.

(95) FIGS. **3A** to **3D** are cross-sectional views illustrating an example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure.

(96) The method of fabricating (or manufacturing) a semiconductor package according to an example of the present disclosure includes preparing a semiconductor device, forming an interlayer member and performing a reflow process. Hereinafter, the method of fabricating a semiconductor package according to an example of the present disclosure will be described in detail with reference to FIGS. **3A** to **3D**. Note that the example method may share any or all characteristics with any one or more other methods discussed herein.

(97) In the preparing of the semiconductor device, as illustrated in FIG. **3A**, the semiconductor device **110** is prepared, the semiconductor device **110** including a circuit board **120** having a first circuit pattern **122** formed on its top surface, a semiconductor die **130** mounted on a top surface of the circuit board **120**, an encapsulant **140** encapsulating the semiconductor die **130** from an upper portion of the circuit board **120**, and conductive structures **150** (e.g., conductive bumps or balls, pillars, wires, etc.) formed on the first circuit pattern **122** and penetrating (e.g., extending partly through, extending completely through, or extending completely through and beyond) the encapsulant **140**. Here, the circuit board **120** may, for example, include an insulating layer **121** having planar top and bottom surfaces, the first circuit pattern **122** formed on the top surface of the insulating layer **121**, a second circuit pattern **123** formed on the bottom surface of the insulating layer **121** and a passivation layer **124** formed along outer peripheral edges of the first and second circuit patterns **122** and **123** to a predetermined thickness.

(98) In the forming of the interlayer member, as illustrated in FIG. **3B**, the interlayer member **170** is formed (e.g., coated, etc.) on the semiconductor device **110**. Here, the interlayer member **170** may be formed to entirely cover the top portion of the semiconductor device **110**. The interlayer member **170** may, for example, be formed of an epoxy flux, an anisotropically conductive paste (ACP), etc. The epoxy flux may, for example, cover surrounding areas of the conductive structures **150** and the conductive structures **163** of the interposer **160**, which will later be described, thereby improving adhesion between the conductive structures **150** and the conductive structures **163** and allowing the heat generated from the semiconductor die **130** to be transferred to the interposer **160** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. In addition, the anisotropically conductive paste (ACP) may include a binder and a conductive filler mixed therein and is used to mechanically and electrically connect upper and lower electrodes combined with each other by thermal compression. In addition, since the binder functions as an insulator, an insulating property is maintained between conductive material existing in adjacent circuits.

(99) In the performing of the reflow process, as illustrated in FIG. **3C**, the interposer **160** is positioned on the interlayer member **170** and a reflow process is performed thereon, the interposer **160** including an insulator **161**, a circuit pattern **162** formed on a bottom surface of the insulator

**161** and conductive structures **163** formed on the circuit pattern **162**. Accordingly, as illustrated in FIG. 3D, the conductive structures **150** of the semiconductor device **110** are welded (or otherwise attached) to the conductive structures **163** of the interposer **160**. In addition, the interlayer member **170** is cured between the semiconductor device **110** and the interposer **160**, thereby improving bondability between the semiconductor device **110** and the interposer **160**.

(100) FIGS. 4A to 4G are cross-sectional views illustrating another example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure.

(101) The method of fabricating (or manufacturing) a semiconductor package according to another example of the present disclosure includes preparing a semiconductor device, forming a first interlayer member part, performing a reflow process and forming a second interlayer member part. Hereinafter, the method of fabricating a semiconductor package according to another example of the present disclosure will be described in detail with reference to FIGS. 4A to 4G. Note that the example method may share any or all characteristics with any one or more other methods discussed herein.

(102) In the preparing of the semiconductor device, as illustrated in FIG. 4A, the semiconductor device **110** is prepared, the semiconductor device **110** including a circuit board **120** having a first circuit pattern **122** formed on its top surface, a semiconductor die **130** mounted on a top surface of the circuit board **120**, an encapsulant **140** encapsulating the semiconductor die **130** from an upper portion of the circuit board **120**, and conductive structures **150** (e.g., conductive bumps or balls, pillars, wires, etc.) formed on the first circuit pattern **122** and penetrating (e.g., extending partially through, extending completely through, extending completely through and past, etc.) the encapsulant **140**.

(103) In the forming of the first interlayer member part, as illustrated in FIG. 4B, the first interlayer member part **271** is formed on the semiconductor device **110**. Here, the first interlayer member part **271** is formed to cover top portions of through vias **141** having conductive structures **150** formed in the semiconductor device **110**. The first interlayer member part **271** may be formed of an epoxy flux.

(104) In the performing of the reflow process, as illustrated in FIG. 4C, an interposer **160** is positioned on the first interlayer member part **271** and a reflow process is performed thereon, the interposer **160** including an insulator **161**, a circuit pattern **162** formed on a bottom surface of the insulator **161** and conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern **162**. Accordingly, as illustrated in FIG. 4D, the conductive structures **150** of (or attached to) the semiconductor device **110** are welded (or otherwise connected) to the conductive structures **163** of (or attached to) the interposer **160**. In addition, the first interlayer member part **271** is cured while covering lateral surfaces of the conductive bumps **150** and the solder balls **163**, thereby improving bondability between the semiconductor device **110** and the interposer **160**.

(105) In the forming of the second interlayer member part, as illustrated in FIG. 4E, a second interlayer member part **272** is injected into a portion between the semiconductor device **110** and the interposer **160**, followed by curing. The second interlayer member part **272** may, for example, be formed of a general adhesive, such as an epoxy resin. Accordingly, the semiconductor package **200** according to the present disclosure can be completed.

(106) In addition, for example, the second interlayer member part **272** may be pre-formed on the semiconductor device **110** in the forming of the first interlayer member part, as illustrated in FIG. 4F. For example, after the first interlayer member part **271** and the second interlayer member part **272** are both formed on the semiconductor device **110**, a reflow process is then performed, and the semiconductor package **200** according to the present disclosure may then be completed, as illustrated in FIG. 4E.

(107) Further, for example, the first interlayer member part **271** may be performed by dipping, as illustrated in FIG. 4G. For example, after the first interlayer member part **271** is pre-formed on the

conductive structures **163** of the interposer **160** by dipping, the interposer **160** is mounted on the semiconductor device **110**, followed by performing a reflow process, thereby allowing the first interlayer member part **271** to cover lateral surfaces of the conductive structures **150** and the conductive structures **163**, as illustrated in FIG. **4D**.

(108) FIG. **5** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(109) Referring to FIG. **5**, the semiconductor package **300** according to still another example of the present disclosure includes a circuit board **310**, a semiconductor die **320**, an interposer **330** and an interlayer member **340**. Note that the example semiconductor package **300** may share any or all characteristics with any one or more other semiconductor packages discussed herein

(110) The circuit board **310** includes an insulating layer **311** having planar top and bottom surfaces, a first circuit pattern **312** formed on a top surface of the insulating layer **311**, a second circuit pattern **313** formed on a bottom surface of the insulating layer **311**, and a passivation layer **314** formed along outer peripheral edges of the first and second circuit patterns **312** and **313** to a predetermined thickness. The circuit board **310** may, for example, be a printed circuit board (PCB) (e.g., a package or device substrate) having opposite surfaces. Here, conductive structures (e.g., conductive bumps or balls, pillars, wires, etc.) (not shown) may be welded (or otherwise attached) to the second circuit pattern **313** to then be electrically connected to an external circuit.

(111) The semiconductor die **320** is mounted on the circuit board **310**. The semiconductor die **320** may, for example, be generally made of a silicon material and has a plurality of semiconductor devices formed therein. In addition, a plurality of conductive structures **321** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) are formed under the semiconductor die **320**. The semiconductor die **320** is electrically connected to the circuit board **310** through the conductive structures **321**. The conductive structures **321** may, for example, be electrically connected to the first circuit pattern **312** of the circuit board **310**. In addition, an underfill **322** may, for example, be formed between the semiconductor die **320** and the circuit board **310**. The underfill **322** is injected into a space between the semiconductor die **320** and the circuit board **310** to then encapsulate the conductive structures **321**.

(112) The interposer **330** is mounted on the circuit board **310** and the semiconductor die **320**. The interposer **330** includes an insulator **331** having planar top and bottom surfaces, a circuit pattern **332** formed on a bottom surface of the insulator **331** and a conductive structure **333** (e.g., conductive filler, pillar, wire, conductive bump or ball, etc.) formed on the circuit pattern **332**. In addition, the interposer **330** may also include a circuit pattern formed on a top surface of the insulator **331** so as to stack semiconductor devices, such as memory chips or logic chips, thereon. The conductive structure **333** is electrically connected to the first circuit pattern **312** of the circuit board **310**. A solder cap **333a** may be formed in the conductive structure **333** to then be easily coupled to the first circuit pattern **312**. The conductive structure **333** may, for example, be formed to have a height equal to or greater than that of the semiconductor die **320**. The conductive structure **333** may, for example, electrically connect the interposer **330** and the semiconductor die **320** to each other through the first circuit pattern **312**. In addition, the conductive structure **333** may comprise a copper filler (e.g., a copper pillar), but aspects of the present disclosure are not limited thereto. In addition, the interposer **330** may comprise a silicon substrate, a laminate substrate, a printed circuit board (PCB), etc.

(113) The interlayer member **340** is formed between the circuit board **310** and the interposer **330**. For example, the interlayer member **340** is formed between the circuit board **310** and the interposer **330** to cover lateral surfaces of the semiconductor die **320** and the conductive structure **333** positioned between the circuit board **310** and the interposer **330**.

(114) The interlayer member **340** may, for example, be formed of an epoxy flux. The epoxy flux may, for example, be applied to surrounding areas of the conductive structure **333**, thereby improving adhesion between the solder cap **333a** and the first circuit pattern **312** and allowing the

heat generated from the semiconductor die **320** to be transferred to the interposer **330** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. Accordingly, cooling efficiency of the semiconductor package **300** according to the present disclosure may be improved. For example, the interlayer member **340** may tightly couple the circuit board **310** to the interposer **330**. In addition, the interlayer member **340** may reduce warpage occurring between the circuit board **310** and the interposer **330**.

(115) In addition, the interlayer member **340** may be formed by injecting an epoxy resin or an epoxy molding compound (EMC) into a space between the circuit board **310** and the interposer **330**. Further, the interlayer member **340** may also be formed of an anisotropically conductive paste (ACP). The anisotropically conductive paste (ACP) includes a binder and a conductive filler mixed therein and is used to mechanically and electrically connect upper and lower electrodes combined with each other, for example by thermal compression. In addition, since the binder functions as an insulator, an insulating property is maintained between conductive materials (e.g., conductive fillers, conductive structures, etc.) existing in adjacent circuits.

(116) FIG. **6** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(117) Referring to FIG. **6**, the semiconductor package **400** according to still another example of the present disclosure includes a circuit board **310**, a semiconductor die **320**, an interposer **330** and an interlayer member **440**. The semiconductor package **400** shown in FIG. **6** is substantially the same as the semiconductor package **300** shown in FIG. **5**, and the following description the following description will generally focus on differences therebetween. Note that the example semiconductor package **400** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(118) The interlayer member **440** is formed between the circuit board **310** and the interposer **330**. For example, the interlayer member **440** includes a first interlayer member part **441** covering lateral surfaces of the conductive structure **333** (e.g., conductive filler, pillar, wire, conductive bump or ball, etc.) and a second interlayer member part **442** formed at least along an outer peripheral edge of the first interlayer member part **441**.

(119) The first interlayer member part **441** is formed to cover the lateral surfaces of the conductive structure **333**. In addition, the first interlayer member part **441** is formed in vicinity of the first circuit pattern **312** of the circuit board **310** electrically connected to the conductive structure **333** and the circuit pattern **332** of the interposer **330**. In addition, the first interlayer member part **441** may be formed of an epoxy flux and may be formed to cover a solder cap **333a** of the conductive structure **333** and the first circuit pattern **312** of the circuit board **310**. Therefore, the first interlayer member part **441** may improve adhesion between the conductive structure **333** and the first circuit pattern **312**.

(120) The second interlayer member part **442** is formed along the outer peripheral edge of the first interlayer member part **441**. For example, the second interlayer member part **442** may be formed between the circuit board **310** and the interposer **330**, where the conductive structure **333** is not formed. For example, the second interlayer member part **442** may be formed between the circuit board **310** and the interposer **330** and/or between the semiconductor die **320** and the interposer **330**. The second interlayer member part **442** may transfer the heat generated from the semiconductor die **320** to the interposer **330** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. In addition, the second interlayer member part **442** may, for example, be formed of a general adhesive, such as an epoxy resin, a molded underfill (MUF), etc.

(121) FIG. **7** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(122) Referring to FIG. **7**, the semiconductor package **500** according to still another example of the present disclosure includes a circuit board **310**, a semiconductor die **320**, an interposer **330** and an interlayer member **540**. The semiconductor package **500** shown in FIG. **7** is substantially the same

as the semiconductor package **400** shown in FIG. **6** and the following description the following description will generally focus on differences therebetween. Note that the example semiconductor package **500** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(123) The interlayer member **540** is formed between the circuit board **310** and the interposer **330**. For example, the interlayer member **540** includes a first interlayer member part **541** covering lateral surfaces of the conductive structure **333** and a second interlayer member part **542** formed between the semiconductor die **320** and the interposer **330**. For example, in the semiconductor package **500** shown in FIG. **7**, the second interlayer member part **542** is formed only between the semiconductor die **320** and the interposer **330**. In an example implementation, there may be voids or gaps between the first interlayer member part **541** and the second interlayer member part **542**, which may then be left void or may be wholly or partially filled with other material.

(124) The second interlayer member part **542**, formed between the semiconductor die **320** and the interposer **330**, may transfer the heat generated from the semiconductor die **320** to the interposer **330** to then transfer (e.g., radiate, conduct, convect, etc.) the heat to the outside. The second interlayer member part **542** may, for example, be formed of a thermally conductive adhesive.

(125) FIGS. **8A** to **8D** are cross-sectional views illustrating still another example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure.

(126) The method of fabricating (or manufacturing) a semiconductor package according to still another example of the present disclosure includes attaching a semiconductor die, forming an interlayer member and performing a reflow process. Hereinafter, the method of fabricating a semiconductor package according to still another example of the present disclosure will be described in detail with reference to FIGS. **8A** to **8D**. Note that the example method may share any or all characteristics with any one or more other methods discussed herein.

(127) In the attaching of the semiconductor die, as illustrated in FIG. **8A**, the semiconductor die **320** is attached on a circuit board **310**. Here, the circuit board **310** includes an insulating layer **311**, a first circuit pattern **312** formed on a top surface of the insulating layer **311**, a second circuit pattern **313** formed on a bottom surface of the insulating layer **311**, and a passivation layer **314** formed along outer peripheral edges of the first and second circuit patterns **312** and **313** to a predetermined thickness. In addition, the semiconductor die **320** may, for example, be generally made of a silicon material and has a plurality of semiconductor devices formed therein. In addition, a plurality of conductive structures **321** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) are formed under the semiconductor die **320** and an underfill **322** is formed between the semiconductor die **320** and the circuit board **310**. In the attaching of the semiconductor die, the conductive structures **321** are electrically connected to the first circuit pattern **312**.

(128) In the forming of the interlayer member, as illustrated in FIG. **8B**, the interlayer member **340** is formed (e.g., coated, etc.) on the circuit board **310** and the semiconductor die **320**.

(129) The interlayer member **340** may, for example, be formed of an epoxy flux, an anisotropically conductive paste (ACP), etc. Here, the epoxy flux may, for example, be applied to surrounding areas of a conductive structure **333** (e.g., conductive filler, pillar, wire, conductive bump or ball, etc.) of an interposer **330**, which will later be described, thereby improving adhesion between the conductive structure **333** and the first circuit pattern **312** and allowing the heat generated from the semiconductor die **320** to be transferred to the interposer **330** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. In addition, the anisotropically conductive paste (ACP) may, for example, include a binder and a conductive filler mixed therein and is used to mechanically and electrically connect upper and lower electrodes combined with each other by thermal compression. In addition, since the binder functions as an insulator, an insulating property is maintained between conductive structures (e.g., fillers, etc.) existing in adjacent circuits.

(130) In the performing of the reflow process, as illustrated in FIG. **8C**, the interposer **330** is positioned on the interlayer member **340** and a reflow process is performed thereon, the interposer



**340** including an insulator **331**, a circuit pattern **332** formed on a bottom surface of the insulator **331** and the conductive structure **333** formed on the circuit pattern **332**. As illustrated in FIG. 8D, a solder cap **333a** of the conductive structure **333** is welded (or otherwise attached) to the first circuit pattern **312** of the circuit board **310**. In addition, the interlayer member **340** is cured between the circuit board **310** and the interposer **330**, thereby improving bondability between each of the circuit board **310**, the semiconductor die **320** and the interposer **330**.

(131) FIGS. 9A to 9E are cross-sectional views illustrating an additional example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure, and FIGS. 10A and 10B are cross-sectional views illustrating a further example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure.

(132) The method of fabricating a semiconductor package according to still another example of the present disclosure includes attaching a semiconductor die, forming a first interlayer member part, performing a reflow process and forming a second interlayer member part. Hereinafter, the fabricating method of a semiconductor package according to still another example of the present disclosure will be described in detail with reference to FIGS. 9A to 9E. Note that the example methods may share any or all characteristics with any one or more other methods discussed herein.

(133) In the attaching of the semiconductor die, as illustrated in FIG. 9A, the semiconductor die **320** is attached on a circuit board **310**. Here, the circuit board **310** includes an insulating layer **311**, a first circuit pattern **312** formed on a top surface of the insulating layer **311**, a second circuit pattern **313** formed on a bottom surface of the insulating layer **311**, and a passivation layer **314** formed along outer peripheral edges of the first and second circuit patterns **312** and **313** to a predetermined thickness. In addition, the semiconductor die **320** may, for example, be generally made of a silicon material and has a plurality of semiconductor devices formed therein. In addition, a plurality of solder structures **321** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) are formed under the semiconductor die **320** and an underfill **322** is formed between the semiconductor die **320** and the circuit board **310**. In the attaching of the semiconductor die, the conductive structures **321** are electrically connected to the first circuit pattern **312**.

(134) In the forming of the first interlayer member part, as illustrated in FIG. 9B, the first interlayer member part **441** is formed on the circuit board **310**. Here, the first interlayer member part **441** is formed (e.g., coated, etc.) to cover a top portion of the first circuit pattern **312** formed on the circuit board **310**. The first interlayer member part **441** may, for example, be formed of an epoxy flux.

(135) In the performing of the reflow process, as illustrated in FIG. 9C, the interposer **330** is positioned on the first interlayer member part **441** and a reflow process is performed thereon, the first interlayer member part **441** including an insulator **331**, a circuit pattern **332** formed on a bottom surface of the insulator **331** and the conductive structure **333** (e.g., conductive filler, pillar, wire, conductive bump or ball, etc.) formed on the circuit pattern **332**. As illustrated in FIG. 9D, a solder cap **333a** of the conductive structure **333** is welded to the first circuit pattern **312**. In addition, the first interlayer member part **441** is cured while covering lateral surfaces of the conductive structure **333**, and the circuit pattern **332** of the interposer **330** is electrically connected to the conductive structure **333** and the first circuit pattern **312** of the circuit board **310**, for example improving bondability between the circuit board **310** and the interposer **330**.

(136) In the forming of the second interlayer member part, as illustrated in FIG. 9E, the second interlayer member part **442** is injected into a space between the circuit board **310** and the interposer **330**, followed by curing. The second interlayer member part **442** may, for example, be formed of a general adhesive, such as an epoxy resin, molded underfill (MUF), etc. Accordingly, the example semiconductor package **400** according to the present example can be produced.

(137) In addition, the second interlayer member part **542** may be pre-formed on the semiconductor die **320** in the forming of the first interlayer member part, as illustrated in FIG. 10A. For example, after the first interlayer member part **541** is formed on the first circuit pattern **312** of the circuit board **310** and the second interlayer member part **542** is formed on the semiconductor die **320**, a

reflow process may then be performed, and the semiconductor package **500** according to the present example may then be produced, as illustrated in FIG. **10B**.

(138) FIG. **11** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(139) Referring to FIG. **11**, the semiconductor package **600** according to still another example of the present invention includes a semiconductor device **610**, an interposer **660** and a heat radiating member **670**. Note that the example semiconductor package **600** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(140) The semiconductor device **610** includes a circuit board **620**, a semiconductor die **630**, an encapsulant **640** and conductive structures **650** (e.g., conductive bumps or balls, pillars, wires, etc.).

(141) The circuit board **620** includes an insulating layer **621** having planar top and bottom surfaces, a first circuit pattern **622** formed on a top surface of the insulating layer **621**, a second circuit pattern **623** formed on a bottom surface of the insulating layer **621**, and a passivation layer **624** formed along outer peripheral edges of the first and second circuit patterns **622** and **623** to a predetermined thickness. The circuit board **620** may be a printed circuit board (PCB) (e.g., a package substrate, etc.) having opposite surfaces. Here, conductive structures (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) (not shown) may be welded (or otherwise attached) to the second circuit pattern **623** to then be electrically connected to an external circuit.

(142) The semiconductor die **630** is mounted on the circuit board **620**. The semiconductor die **630** may, for example, be generally made of a silicon material and has a plurality of semiconductor devices formed therein. In addition, a plurality of conductive structures **631** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) are formed under the semiconductor die **630**. The semiconductor die **630** is electrically connected to the circuit board **620** through the conductive structures **631**. The conductive structures **631** may, for example, be electrically connected to the first circuit pattern **622** of the circuit board **620**. In addition, a metal layer **632** may, for example, be formed on the semiconductor die **630**. The metal layer **632** may be formed by coating a metal on the semiconductor die **630**. For example, the metal layer **632** may be made of a conductive material, such as copper (Cu), gold (Au) or silver (Ag), but aspects of the present disclosure are not limited thereto.

(143) The encapsulant **640** encapsulates the semiconductor die **630** from an upper portion of the circuit board **620**. The encapsulant **640** may, for example, expose the metal layer **632** formed on the semiconductor die **630** to the outside of the encapsulant **640**. In addition, through vias **641** are formed in the encapsulant **640**. The through vias **641** may, for example, be formed over the first circuit pattern **622** of the circuit board **620** and expose the first circuit pattern **622** to the outside of the encapsulant **640**.

(144) The conductive structures **650** (e.g., conductive bumps or balls, pillars, wires, etc.) are formed on the first circuit pattern **622** and exposed to the outside of the encapsulant **640** by the through vias **641**. The conductive structures **650** may, for example, be electrically connected to the semiconductor die **630** through the first circuit pattern **622**. The conductive structures **650** may, for example, include tin/lead, leadless tin, equivalents thereof, etc., but aspects of the present disclosure are not limited thereto.

(145) The interposer **660** is mounted on the semiconductor device **610**. The interposer **660** includes an insulator **661** having planar top and bottom surfaces, a circuit pattern **662** formed on a bottom surface of the insulator **661** and conductive structures **663** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern **662**. In addition, the interposer **660** may also include a circuit pattern formed on a top surface of the insulator **661** so as to stack semiconductor devices, such as memory chips or logic chips, thereon. In addition, the interposer **660** may further include a conductive pad **664** formed on its bottom surface. Here, the conductive pad **664** may, for example, be formed at the center of the interposer **660** and the circuit pattern **662** is formed at an outer peripheral edge of the conductive pad **664**. The circuit pattern **662** and the conductive pad

**664** may, for example, be formed of the same material. In addition, the conductive pad **664** may be formed to correspond to the metal layer **632** of the semiconductor die **630**. Further, the interposer **660** may also include a circuit pattern formed on a top surface of the insulator **661** so as to stack semiconductor devices, such as memory chips or logic chips, thereon.

(146) The conductive structures **663** are electrically connected to the conductive structures **650** of the semiconductor device **610**. For example, when the interposer **660** is mounted on the semiconductor device **610**, the conductive structures **663** are welded (or otherwise attached) to the conductive structures **650** to electrically connect the interposer **660** and the semiconductor device **610** to each other. The interposer **660** may, for example, comprise a silicon substrate, a printed circuit board (PCB), etc.

(147) The heat radiating member **670** is formed between the semiconductor device **610** and the interposer **660**. For example, the heat radiating member **670** may be formed between the semiconductor device **610** and the conductive pad **664** of the interposer **660**. In addition, the heat radiating member **670** may, for example, be formed of a solder paste (e.g., at least initially, prior to reflow if performed) and may be electrically connected (or at least heat-conductively connected) to the metal layer **632** and the conductive pad **664**. The heat radiating member **670** may transfer the heat generated from the semiconductor die **630** to the interposer **660** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. Accordingly, cooling efficiency of the semiconductor package **600** according to the present disclosure may be improved.

(148) FIG. **12** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(149) Referring to FIG. **12**, the semiconductor package **700** according to still another example of the present disclosure includes a semiconductor device **610**, an interposer **660**, a heat radiating member **670** and an interlayer member **780**. For example, the example semiconductor package **700** shown in FIG. **12** further includes the interlayer member **780**, compared to the semiconductor package **600** shown in FIG. **11**. Thus, the following description will focus on the interlayer member **780**, which is a different feature between the semiconductor packages **600** and **700** shown in FIGS. **11** and **12**. Note that the example semiconductor package **700** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(150) The interlayer member **780** is formed between the semiconductor device **610** and the interposer **660**. For example, the interlayer member **780** is formed to fill a space between the semiconductor device **610** and the interposer **660**, where the heat radiating member **670** is not formed and/or where the conductive structures **650** and **663** are not formed. For example, the interlayer member **780** may be formed by injecting an underfill into a space between the semiconductor device **610** and the interposer **660**, followed by curing, thereby more tightly coupling the semiconductor device **610** and the interposer **660** to each other. In addition, the interlayer member **780** may be formed of an epoxy flux, an epoxy resin or other adhesives, but not limited thereto.

(151) In addition, the interlayer member **780** may reduce warpage occurring between the semiconductor device **610** and the interposer **660**. As described above, the interlayer member **780** may improve the reliability of the semiconductor package **700** according to the present disclosure.

(152) FIG. **13** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(153) Referring to FIG. **13**, the semiconductor package **800** according to still another example of the present disclosure includes an interposer **660**, a semiconductor device **610** and a heat radiating member **670**. The semiconductor package **800** shown in FIG. **13** is configured such that the semiconductor package **600** shown in FIG. **11** is reversed. For example, in the semiconductor package **800**, the semiconductor device **610** is formed on the interposer **660** and the heat radiating member **670** is formed between the interposer **660** and the semiconductor device **610**. Note that the example semiconductor package **800** may share any or all characteristics with any one or more

other semiconductor packages discussed herein.

(154) As described above, the semiconductor package **800** according to still another example of the present disclosure is slightly different from the semiconductor package **600** shown in FIG. **11** in that the semiconductor device **610** and the interposer **660** are just transposed, and a detailed description thereof will not be given.

(155) FIGS. **14A** to **14E** are cross-sectional views illustrating a still further example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure.

(156) The method of fabricating a semiconductor package according to still another example of the present disclosure includes preparing a semiconductor device, forming a heat radiating member, performing a reflow process and forming an interlayer member. Hereinafter, the method of fabricating a semiconductor package according to still another example of the present disclosure will be described in detail with reference to FIGS. **14A** to **14E**. Note that the example method may share any or all characteristics with any one or more other methods discussed herein.

(157) In the preparing of the semiconductor device, as illustrated in FIG. **14A**, the semiconductor device **610** is prepared, the semiconductor device **610** including a circuit board **620** having a first circuit pattern **622** formed on its top surface, a semiconductor die **630** mounted on a top surface of the circuit board **620** and having a metal layer **632** formed thereon, an encapsulant **640** encapsulating the semiconductor die **630** from an upper portion of the circuit board **620**, and conductive bumps **650** formed on the first circuit pattern **622** while penetrating the encapsulant **640**. For example, the semiconductor device **610** (or any semiconductor device discussed herein) may include a plurality of semiconductor devices provided in panel types.

(158) In the forming of the heat radiating member, as illustrated in FIG. **14B**, the heat radiating member **670** is formed (e.g., coated, etc.) on the semiconductor die **630**. For example, the heat radiating member **670** may be formed to cover the metal layer **632** formed on the semiconductor die **630**. In addition, the heat radiating member **670** may be formed of a solder paste and may be electrically connected to the metal layer **632** of the semiconductor die **630** and a conductive pad **664** of an interposer **660**, which will be described later.

(159) In the performing of the reflow process, as illustrated in FIG. **14C**, the interposer **660** is positioned on the heat radiating member **670** and the reflow process is performed thereon, the interposer **660** including an insulator **661**, a circuit pattern **662** formed on a bottom surface of the insulator **661**, the conductive pad **664** and conductive structures **663** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern **662**. Accordingly, as illustrated in FIG. **14D**, the conductive structures **650** (e.g., conductive bumps or balls, pillars, wires, etc.) of the semiconductor device **610** are welded (or otherwise attached) to the conductive structures **663** of the interposer **660**. In addition, the heat radiating member **670** may be cured between the semiconductor device **610** and the interposer **660** may be electrically connected to the metal layer **632** and the conductive pad **664**. Therefore, the heat radiating member **670** may transfer the heat generated from the semiconductor die **630** to the interposer **660** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. According to the above-described fabricating method, the semiconductor package **700** according to the present example can be produced.

(160) Alternatively, the semiconductor package **700** may be fabricated by further forming the interlayer member **780** between the semiconductor device **610** and the interposer **660**, for example after the performing of the reflow process. For example, in forming of the interlayer member, as illustrated in FIG. **14E**, the interlayer member **780** may be injected into a space the semiconductor device **610** and the interposer **660**, followed by curing. The interlayer member **780** may, for example, be formed of an underfill, an epoxy flux, an epoxy resin, other adhesives, etc. The interlayer member **780** may improve bondability between the semiconductor device **610** and the interposer **660**. In an example fabrication scenario, the semiconductor package **700** may be produced by sawing the panel-type semiconductor device **610** after the forming of the interlayer member.

(161) FIGS. 15A to 15D are cross-sectional views illustrating yet another example method of fabricating a semiconductor package, in accordance with various aspects of the present disclosure. (162) The method of fabricating a semiconductor package according to still another example of the present disclosure includes preparing an interposer, forming a heat radiating member and performing a reflow process. Hereinafter, the method of fabricating a semiconductor package according to still another example of the present disclosure will be described in detail with reference to FIGS. 15A to 15D. Note that the example method may share any or all characteristics with any one or more other methods discussed herein.

(163) In the preparing of the interposer, as illustrated in FIG. 15A, the interposer 660 is prepared, the interposer 660 including an insulator 661, a circuit pattern 662 formed on a top surface of the insulator 661, a conductive pad 664 and conductive structures 663 (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) formed on the circuit pattern 662. For example, the interposer 660 may, for example, include a plurality of interposers provided in panel types.

(164) In the forming of the heat radiating member, as illustrated in FIG. 15B, the heat radiating member 670 is formed (e.g., coated, etc.) on the interposer 660. Here, the heat radiating member 670 is formed to cover the conductive pad 664 formed on the interposer 660. In addition, the heat radiating member 670 may, for example, be formed of a solder paste and be electrically connected to the conductive pad 664 of the interposer 660 and a metal layer 632 of a semiconductor die 630, which will later be described.

(165) In the performing of the reflow process, as illustrated in FIG. 15C, a semiconductor device 610 is reversed and positioned such that the conductive structures 650 (e.g., conductive bumps or balls, pillars, wires, etc.) face the conductive structures 663 of the interposer 660, and the reflow process is performed on the semiconductor device 610, the semiconductor device 610 including a circuit board 620 having a first circuit pattern 622 formed on its top surface, a semiconductor die 630 mounted on a top surface of the circuit board 620 and having a metal layer 632 formed thereon, an encapsulant 640 encapsulating the semiconductor die 630 from an upper portion of the circuit board 620, and conductive structures 650 formed on the first circuit pattern 622 and penetrating (e.g., extending partly through, extending completely through, extending completely through and beyond, etc.) the encapsulant 640. Accordingly, as illustrated in FIG. 15D, the conductive structures 650 of the semiconductor device 610 are welded (or otherwise attached) to the conductive structures 663 of the interposer 660. In addition, the heat radiating member 670 is cured between the semiconductor device 610 and the interposer 660 and is electrically connected between the metal layer 632 and the conductive pad 664. Therefore, the heat radiating member 670 may transfer the heat generated from the semiconductor die 630 to the interposer 660 to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. According to the above-described fabricating method, the semiconductor package 800 according to various aspects of the present disclosure can be formed.

(166) Alternatively, after the performing of the reflow process, the method of fabricating a semiconductor package according to still another example of the present disclosure may further include injecting an interlayer member in a space between the semiconductor device 610 and the interposer 660. In addition, the method of fabricating a semiconductor package according to still another example of the present disclosure may further include singulating (e.g., sawing, etc.) the panel type interposer 660, thereby forming a discrete semiconductor package 800.

(167) FIG. 16 is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(168) Referring to FIG. 16, the semiconductor package 900 according to still another example of the present disclosure includes a first semiconductor device 110, a second semiconductor device 960, and an interlayer member 170. For example, the semiconductor package 900 shown in FIG. 16 is different from the semiconductor package 100 shown in FIG. 1 in that the second semiconductor device 960, instead of the interposer 160, is provided. Accordingly, the following description will

generally focus on only differences between the semiconductor packages **100** and **900**. In addition, since the first semiconductor device **110** of the semiconductor package **900** shown in FIG. **16** is the same as the semiconductor device **110** of the semiconductor package **100** shown in FIG. **1**, a detailed description thereof will not be given. Note that the example semiconductor package **900** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(169) The second semiconductor device **960** is mounted on the first semiconductor device **110**. The second semiconductor device **960** includes a circuit board **970**, a semiconductor die **980** and an encapsulant **990**.

(170) The circuit board **970** includes an insulating layer **971** having planar top and bottom surfaces, a first circuit pattern **972** formed on a top surface of the insulating layer **971**, a second circuit pattern **973** formed on a bottom surface of the insulating layer **971**, and a passivation layer **974** formed along outer peripheral edges of the first and second circuit patterns **972** and **973** to a predetermined thickness. The circuit board **970** may, for example, comprise a double-sided printed circuit board (PCB). Here, conductive structures **975** (e.g., conductive bumps or balls, solder balls, pillars, wires, etc.) are welded (or otherwise attached) to the second circuit pattern **973**. The conductive structures **975** are connected to a respective conductive structure **150** (e.g., a conductive bump or ball, pillar, wire, etc.) of the first semiconductor device **110**, thereby electrically connecting the first semiconductor device **110** to the second semiconductor device **960**.

(171) The semiconductor die **980** is mounted on the circuit board **970**. The semiconductor die **980** may, for example, be generally made of a silicon material and have a plurality of semiconductor devices formed therein. In addition, a plurality of bond pads (not shown) are formed on the semiconductor die **980** and a conductive wire **981** is connected to the bond pads. In addition, the conductive wire **981** is electrically connected to the first circuit pattern **972** of the circuit board **970**. For example, the conductive wire **981** electrically connects the semiconductor die **980** to the circuit board **970**.

(172) The encapsulant **990** encapsulates the semiconductor die **980** and the conductive wire **981** from an upper portion of the circuit board **970**.

(173) The interlayer member **170** is formed between the first semiconductor device **110** and the second semiconductor device **960**. For example, the interlayer member **170** is interposed between a top surface of the semiconductor die **130** of the first semiconductor device **110** and a bottom surface of the circuit board **970** of the second semiconductor device **960**. In addition, the interlayer member **170** may be formed to cover the conductive structure **150** of the first semiconductor device **110** and lateral surfaces of the conductive structures **975** of the second semiconductor device **960**. The interlayer member **170** may, for example, be formed of an epoxy flux or other material. In addition, the interlayer member **170** may be formed by injecting an epoxy resin, an epoxy molding compound (EMC), or other material into a space between the first semiconductor device **110** and the second semiconductor device **960**. Further, the interlayer member **170** may also be formed of an anisotropically conductive paste (ACP).

(174) FIG. **17** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(175) Referring to FIG. **17**, the semiconductor package **1000** according to still another example of the present disclosure includes a semiconductor device **110**, an interposer **160** and an interlayer member **1070**. The semiconductor package **1000** shown in FIG. **17** is different from the semiconductor package **200** shown in FIG. **2** in that the first interlayer member part **271** is not provided. Accordingly, the following description will generally focus on only differences between the semiconductor packages **200** and **1000**. Note that the example semiconductor package **1000** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(176) The interlayer member **1070** is formed between the semiconductor device **110** and the

interposer **160**. For example, the interlayer member **1070** is formed between the semiconductor device **110** without the conductive structures **150** and conductive structures **163**, and the interposer **160**. For example, the interlayer member **1070** is formed between the semiconductor die **130** and the interposer **160** and between an encapsulant **140** and the interposer **160**. In addition, the interlayer member **1070** may, for example, be formed of a general adhesive, such as an epoxy resin, an epoxy molding compound (EMC), etc. The interlayer member **1070** may transfer the heat generated from the semiconductor die **130** to the interposer **160** to then be transferred (e.g., radiated, conducted, convected, etc.) to the outside. In addition, the interlayer member **1070** may improve bondability between the semiconductor device **110** and the interposer **160**.

(177) FIG. **18** is a cross-sectional view illustrating an example semiconductor package in accordance with various aspects of the present disclosure.

(178) Referring to FIG. **18**, the semiconductor package **1100** according to still another example of the present disclosure includes a semiconductor device **110**, an interposer **1160**, and an interlayer member **1170**. The semiconductor package **1100** shown in FIG. **18** is substantially the same as the semiconductor package **100** shown in FIG. **1**. Accordingly, the following description will generally focus on only differences between the semiconductor packages **100** and **1100**. Note that the example semiconductor package **1100** may share any or all characteristics with any one or more other semiconductor packages discussed herein.

(179) The interposer **1160** is mounted on the semiconductor device **110**. The interposer **1160** includes an insulator **161** having planar top and bottom surfaces, and a circuit pattern **162** formed on a bottom surface of the insulator **161**. In addition, the interposer **1160** may also include a circuit pattern formed on a top surface of the insulator **161** so as to stack semiconductor devices, such as memory chips or logic chips, thereon. The circuit pattern **162** formed on the bottom surface of the insulator **161** is electrically connected to the conductive structure **150** of the semiconductor device **110**. For example, when the interposer **1160** is mounted on the semiconductor device **110**, the conductive structure **150** is welded (or otherwise attached) to the circuit pattern **162** to electrically connect the interposer **1160** and the semiconductor device **110** to each other. Therefore, the bottom surface of the interposer **1160** may be brought into direct contact with a top surface of the semiconductor die **131**. The interposer **1160** may, for example, comprise a silicon substrate, a printed circuit board (PCB), etc.

(180) The interlayer member **1170** is formed between the semiconductor device **110** and the interposer **1160**. For example, the interlayer member **1170** may be formed in a through via **141** of the encapsulant **140** to surround the conductive bump **150**. The interlayer member **1170** may, for example, be formed of an epoxy flux or other material. The epoxy flux may, for example, be applied to surrounding areas of the conductive structure **150**, thereby improving adhesion between the conductive structure **150** and the circuit pattern **162**. In addition, the interlayer member **1170** may be formed by injecting an epoxy resin, an epoxy molding compound (EMC), or other material, into a portion between the semiconductor device **110** and the interposer **1160**. Further, the interlayer member **1170** may also be formed of an anisotropically conductive paste (ACP).

(181) In summary, various aspects of this disclosure provide a semiconductor device or package structure and a method for fabrication thereof. While the foregoing has been described with reference to certain aspects and examples, it will be understood by those skilled in the art that various changes may be made and equivalents may be substituted without departing from the scope of the disclosure. In addition, many modifications may be made to adapt a particular situation or material to the teachings of the disclosure without departing from its scope. Therefore, it is intended that the disclosure not be limited to the particular example(s) disclosed, but that the disclosure will include all examples falling within the scope of the appended claims.

## Claims

1. A semiconductor package comprising: a substrate comprising a top substrate side, a bottom substrate side, a plurality of lateral substrate sides between the top and bottom substrate sides, and a top substrate circuit pattern exposed at the top substrate side; a semiconductor die mounted on the top substrate side, the semiconductor die comprising a top die side, a bottom die side facing the top substrate side, and a plurality of lateral die sides; an interposer comprising: a top interposer side; a bottom interposer side; a plurality of lateral interposer sides; and a bottom interposer circuit pattern exposed at the bottom interposer side; a vertical interconnect structure coupled to the bottom interposer circuit pattern and the top substrate circuit pattern; an insulating member encapsulating the vertical interconnect structure; and an encapsulant of a first composition comprising a top encapsulant side facing and contacting the bottom interposer side, a bottom encapsulant side facing and contacting the top substrate side, and a plurality of lateral encapsulant sides, wherein: the encapsulant extends continuously between the top substrate side and the bottom interposer side, and the encapsulant surrounds the semiconductor die and is laterally between the insulating member and the semiconductor die.
2. The semiconductor package of claim 1, wherein the vertical interconnect structure comprises: an upper portion comprising a first material; and a lower portion comprising a second material, wherein the first material is different from the second material.
3. The semiconductor package of claim 2, wherein: the first material is copper; and the second material is solder.
4. The semiconductor package of claim 1, wherein the encapsulant extends vertically between the bottom interposer side and the top die side.
5. The semiconductor package of claim 1, wherein the lateral interposer sides and the lateral substrate sides are free of the encapsulant.
6. The semiconductor package of claim 1, wherein the insulating member comprises a top insulating member side contacting the bottom interposer side, a bottom insulating member side opposite the top insulating member side, and a plurality of parallel lateral insulating member sides extending between the top insulating member side and the bottom insulating member side.
7. The semiconductor package of claim 1, comprising an adhesive contacting the top die side and the bottom interposer side.
8. The semiconductor package of claim 1, wherein: the vertical interconnect structure comprises a solder part and a solderless part; and no portion of the encapsulant is vertically higher than the interposer.
9. A semiconductor package comprising: a substrate comprising a top substrate side, a bottom substrate side, a plurality of lateral substrate sides between the top and bottom substrate sides, and a top substrate circuit pattern exposed at the top substrate side; a semiconductor die mounted on the top substrate side, the semiconductor die comprising a top die side, a bottom die side facing the top substrate side, and a plurality of lateral die sides; an interposer comprising: a top interposer side; a bottom interposer side; a plurality of lateral interposer sides; and a bottom interposer circuit pattern exposed at the bottom interposer side; a vertical interconnect structure comprising: an upper portion coupled to the bottom interposer circuit pattern and comprising a first material; and a lower portion coupled to the top substrate circuit pattern and comprising a second material different from the first material; an insulating member contacting a lateral side of the vertical interconnect structure; and an encapsulant of a first composition comprising a top encapsulant side facing and contacting the bottom interposer side, a bottom encapsulant side facing and contacting the top substrate side, and a plurality of lateral encapsulant sides, wherein: the encapsulant extends continuously between the top substrate side and the bottom interposer side, and the encapsulant surrounds the semiconductor die and is laterally between the insulating member and the semiconductor die.
10. The semiconductor package of claim 9, wherein: the first material is copper; and the second



material is solder.

11. The semiconductor package of claim 9, wherein the encapsulant extends vertically between the bottom interposer side and the top die side.

12. The semiconductor package of claim 9, wherein the lateral interposer sides and the lateral substrate sides are free of the encapsulant.

13. The semiconductor package of claim 9, wherein the insulating member comprises a top insulating member side contacting the bottom interposer side, a bottom insulating member side opposite the top insulating member side, and a plurality of parallel lateral insulating member sides extending between the top insulating member side and the bottom insulating member side.

14. The semiconductor package of claim 9, comprising an adhesive contacting the top die side and the bottom interposer side.

15. A method of manufacturing a semiconductor package, the method comprising: providing a substrate comprising a top substrate side, a bottom substrate side, a plurality of lateral substrate sides between the top and bottom substrate sides, and a top substrate circuit pattern exposed at the top substrate side; providing a semiconductor die mounted on the top substrate side, the semiconductor die comprising a top die side, a bottom die side facing the top substrate side, and a plurality of lateral die sides; providing an interposer comprising: a top interposer side; a bottom interposer side; a plurality of lateral interposer sides; and a bottom interposer circuit pattern exposed at the bottom interposer side; providing a vertical interconnect structure coupled to the bottom interposer circuit pattern and the top substrate circuit pattern; providing an insulating member encapsulating the vertical interconnect structure; and providing an encapsulant of a first composition comprising a top encapsulant side facing and contacting the bottom interposer side, a bottom encapsulant side facing and contacting the top substrate side, and a plurality of lateral encapsulant sides, wherein: the encapsulant extends continuously between the top substrate side and the bottom interposer side, and the encapsulant surrounds the semiconductor die and is laterally between the insulating member and the semiconductor die.

16. The method of claim 15, wherein the vertical interconnect structure comprises: an upper portion comprising a first material; and a lower portion comprising a second material, wherein the first material is different from the second material.

17. The method of claim 16, wherein: the first material is copper; and the second material is solder.

18. The method of claim 15, wherein the encapsulant extends vertically between the bottom interposer side and the top die side.

19. The method of claim 15, wherein the insulating member comprises a top insulating member side contacting the bottom interposer side, a bottom insulating member side opposite the top insulating member side, and a plurality of parallel lateral insulating member sides extending between the top insulating member side and the bottom insulating member side.

20. The method of claim 15, comprising providing an adhesive contacting the top die side and the bottom interposer side.

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