

Documents

Daud, N.D.^a, Hasan, M.N.^a, Saleh, T.^b, Leow, P.L.^a, Mohamed Ali, M.S.^a

Non-traditional machining techniques for silicon wafers

(2022) *International Journal of Advanced Manufacturing Technology*, 121 (1-2), pp. 29-57.

DOI: 10.1007/s00170-022-09365-z

^a School of Electrical Engineering, Faculty of Engineering, Universiti Teknologi Malaysia, Johor, Johor Bahru, 81310, Malaysia

^b Department of Mechatronics Engineering, Kulliyah of Engineering, International Islamic University Malaysia, Jalan Gombak, Kuala Lumpur, 53100, Malaysia

Abstract

Silicon (Si) micromachining techniques have recently witnessed significant advancement, attributable to the high surge in demand for microelectromechanical and microelectronic devices. Micromachining techniques are widely used to cut or pattern Si, in order to obtain high-quality surface finishes for the fabrication of devices. Micromachining techniques are used for the fabrication of three-dimensional (3D) microstructures for microelectromechanical devices. In this work, the capabilities and competencies of non-traditional Si micromachining techniques, including ultrasonic, ion beam milling, laser machining, and electrical discharge machining, are discussed and compared accordingly. The working principles, advantages, limitations, and Si microstructures that have been fabricated before are discussed in detail. Additionally, this work covers the performance reported by multiple researchers on these micromachining methods, spanning the temporal range of 1990 to 2020. The key outcomes of this study are explored and summarized. © 2022, The Author(s), under exclusive licence to Springer-Verlag London Ltd., part of Springer Nature.

Author Keywords

Electrical discharge; Ion beam; Laser; Machining performances; Micromachining; Silicon; Ultrasonic

Index Keywords

Composite micromechanics, Electric discharge machining, Ion beams, Microelectronics, Micromachining, Microstructure, Silicon wafers; Electrical discharges, High quality surface, Machining performance, Machining techniques, Micro-electro-mechanical, Micro-electronic devices, Micromachining techniques, Non-traditional machining, Silicon micromachining, Surface finishes; Electric discharges

References

- Sahu, A.K., Malhotra, J., Jha, S.
Laser-based hybrid micromachining processes: A review
(2022) *Opt Laser Technol*, 146.
- de Rooij
Current applications of silicon based microsystems
(1995) *Micro Machine and Human Science, 1995 MHS'95, Proceedings of the Sixth International Symposium On: IEEE*, pp. 7-10.
N ()
- El-Hofy, H.-G.
(2005) *Advanced Machining Processes: Nontraditional and Hybrid Machining Processes*, McGraw Hill Professional
- Daud, N.D., Hasan, M.N., Ali, M.S.M.
Microelectrical discharge machining of silicon wafers
(2021) *Micro Electro-Fabrication*, pp. 219-244.
Elsevier

- Gentili, E., Tabaglio, L., Aggogeri, F.
(2005) *Review on micromachining techniques*, Springer
- Hasan, M.N., Ali, M.S.M.
Electrical discharge machining for the formation of bulk-shape memory alloy actuators
(2021) *Micro Electro-Fabrication*, pp. 195-217.
Elsevier
- Thoe, T.B., Aspinwall, D.K., Wise, M.L.H.
Review on ultrasonic machining
(1998) *Int J Mach Tools Manuf*, 38 (4), pp. 239-255.
- Mirad, M.M., Das, B.
A critical review of the state of the art literature in the monitoring of ultrasonic machining process and tool failure prediction
(2021) *Eng Fail Anal*, 130.
- Jain, V., Sharma, A.K., Kumar, P.
Recent developments and research issues in microultrasonic machining
(2011) *ISRN Mech Eng*,
- Kremer, D., Saleh, S., Ghabrial, S., Moisan, A.
The state of the art of ultrasonic machining
(1981) *CIRP Ann Manuf Technol*, 30 (1), pp. 107-110.
- Sun, X.-Q., Masuzawa, T., Fujino, M.
Micro ultrasonic machining and self-aligned multilayer machining/assembly technologies for 3D micromachines. Micro Electro Mechanical Systems, 1996, MEMS'96, Proceedings An Investigation of Micro Structures, Sensors, Actuators, Machines and Systems IEEE
(1996) *The Ninth Annual International Workshop On: IEEE*, pp. 312-317.
- Sun, X.-Q., Masuzawa, T., Fujino, M.
Micro ultrasonic machining and its applications in MEMS
(1996) *Sens Actuators A*, 57 (2), pp. 159-164.
- Moreland, M.
Versatile performance of ultrasonic machining
(1988) *Am Ceram Soc Bull*, 67 (6), pp. 1045-1047.
- Koval'chenko, M., Paustovskii, A., Perevyazko, V.
Influence of properties of abrasive materials on the effectiveness of ultrasonic machining of ceramics
(1986) *Soviet Powder Metall Metal Ceram*, 25 (7), pp. 560-562.
- Moore, D.
(1985) *Ultrasonic impact grinding. Nontraditional Mach*, pp. 137-139.
- Gilmore, R.
Ultrasonic machining and orbital abrasion techniques
(1990) *Soc Manuf Eng Trans Best Pap 1989*, p. 20.

- Neppiras, E., Foskett, R.
Ultrasonic machining-II. Operating conditions and performance of ultrasonic drills
(1957) *Philips Tech Rev*, 18 (12), pp. 368-379.
- Yu, Z., Hu, X., Rajurkar, K.P.
Influence of Debris Accumulation on Material Removal and Surface Roughness in Micro Ultrasonic Machining of Silicon
(2006) *CIRP Ann Manuf Technol*, 55 (1), pp. 201-204.
- Cong, W., Feng, Q., Pei, Z., Deines, T.W., Treadwell, C.
Edge chipping in rotary ultrasonic machining of silicon
(2012) *Int J Manuf Res*, 7 (3), pp. 311-329.
- Guzzo, P.L., Raslan, A., de Mello, J.D.B.
Relationship between quartz crystal orientation and the surface quality obtained by ultrasonic machining. Frequency and Time Forum, 1999 and the IEEE International Frequency Control Symposium, 1999
(1999) *Proceedings of The, 1999*, pp. 792-795.
Joint Meeting of the European, IEEE
- Yan, B.H., Wang, A.C., Huang, C.Y., Huang, F.Y.
Study of precision micro-holes in borosilicate glass using micro EDM combined with micro ultrasonic vibration machining
(2002) *Int J Mach Tools Manuf*, 42 (10), pp. 1105-1112.
- Kumar, J., Khamba, J., Mohapatra, S.
An investigation into the machining characteristics of titanium using ultrasonic machining
(2008) *Int J Mach Mach Mater*, 3 (1-2), pp. 143-161.
- Ghahramani, B., Wang, Z.Y.
Precision ultrasonic machining process: a case study of stress analysis of ceramic (Al₂O₃)
(2001) *Int J Mach Tools Manuf*, 41 (8), pp. 1189-1208.
- Khoo, C., Hamzah, E., Sudin, I.
A review on the rotary ultrasonic machining of advanced ceramics
(2008) *Jurnal Mekanikal*, 25, pp. 9-23.
- Farago, F.T.
(1976) *Abrasive Methods Engineering*,
Industrial Press
- Balamuth, L.
Ultrasonic vibrations assist cutting tools
(1964) *Metalwork Prod*, 108 (24), pp. 75-77.
- Wang, J., Zhang, J., Feng, P., Guo, P.
Damage formation and suppression in rotary ultrasonic machining of hard and brittle materials: a critical review
(2018) *Ceram Int*, 44 (2), pp. 1227-1239.
- Egashira, K., Masuzawa, T.
Microultrasonic Machining by the Application of Workpiece Vibration
(1999) *CIRP Ann Manuf Technol*, 48 (1), pp. 131-134.

- Komaraiah, M., Narasimha Reddy, P.
A study on the influence of workpiece properties in ultrasonic machining
(1993) *Int J Mach Tools Manuf*, 33 (3), pp. 495-505.
- Endo, T., Tsujimoto, T., Mitsui, K.
Study of vibration-assisted micro-EDM—The effect of vibration on machining time and stability of discharge
(2008) *Precis Eng*, 32 (4), pp. 269-277.
- Egashira, K., Masuzawa, T., Fujino, M., Sun, X.-Q.
Application of USM to micromachining by on-the-machine tool fabrication
(1997) *Int J Electr Mach*, 2, pp. 31-36.
- Yu, Z., Rajurkar, K., Tandon, A.
Study of 3D micro-ultrasonic machining
(2004) *J Manuf Sci Eng*, 126 (4), pp. 727-732.
- Tsui, C.-Y., Wu, C.-C., Lu, M.-C., Huang, C.-F.
Drilling of microholes on silicon wafer with ultrasonic workpiece holder
(2008) *ASME 2008 International Design Engineering Technical Conferences and Computers and Information in Engineering Conference: American Society of Mechanical Engineers*, pp. 811-817.
- Zarepour, H., Yeo, S.
Single abrasive particle impingements as a benchmark to determine material removal modes in micro ultrasonic machining
(2012) *Wear*, 288, pp. 1-8.
- Sreehari, D., Sharma, A.K.
On form accuracy and surface roughness in micro-ultrasonic machining of silicon microchannels
(2018) *Precis Eng*, 53, pp. 300-309.
- Kumar, S., Dvivedi, A.
On machining of hard and brittle materials using rotary tool micro-ultrasonic drilling process
(2019) *Mater Manuf Processes*, 34 (7), pp. 736-748.
- Castaing, R., Laborie, P.
Examen direct des métaux par transmission au microscope électronique
(1953) *Comptes Rendus Hebdomadaires des Seances de L academie des Sciences*, 237 (21), pp. 1330-1332.
- Paulus, M., Reverchon, F.
Dispositif de bombardement ionique pour préparations micrographiques
(1961) *J Phys Appl*, 22 (S6), pp. 103-107.
- Heaney, P.J., Vicenzi, E.P., Giannuzzi, L.A., Livi, K.J.
Focused ion beam milling: A method of site-specific sample extraction for microanalysis of Earth and planetary materials
(2001) *Am Miner*, 86 (8-9), pp. 1094-1099.

- Barber, D.
Development of ion-beam milling as a major tool for EM
(1999) *Microsc Anal*, pp. 5-10.
- McGeough, J.A.
Advanced methods of machining
(1988) *Springer Science & Business Media*,
- Amirmajidi, O.M., Ashyer-Soltani, R., Clode, M.P., Mannan, S.H., Wang, Y., Cabruja, E.
Cross-section preparation for solder joints and MEMS device using argon ion beam milling
(2009) *IEEE Trans Electron Packag Manuf*, 32 (4), pp. 265-271.
- Preiß, E.I., Merle, B., Xiao, Y., Gannott, F., Liebig, J.P., Wheeler, J.M.
Applicability of focused ion beam (FIB) milling with gallium, neon, and xenon to the fracture toughness characterization of gold thin films
(2021) *J Mater Res*, 36 (12), pp. 2505-2514.
- Pastewka, L., Salzer, R., Graff, A., Altmann, F., Moseler, M.
Surface amorphization, sputter rate, and intrinsic stresses of silicon during low energy Ga⁺ focused-ion beam milling
(2009) *Nucl Instrum Methods Phys Res Sect B*, 267 (18), pp. 3072-3075.
- Tseng, A.A.
Recent developments in micromilling using focused ion beam technology
(2004) *J Micromech Microeng*, 14 (4), p. R15.
- Hung, N., Fu, Y., Ali, M.Y.
Focused ion beam machining of silicon
(2002) *J Mater Process Technol*, 127 (2), pp. 256-260.
- Giannuzzi, L., Prenitzer, B., Drown-MacDonald, J., Shofner, T., Brown, S., Irwin, R.
Electron microscopy sample preparation for the biological and physical sciences using focused ion beams
(1998) *AT PROCESS*, 4, pp. 162-167.
- **Focused ion beam technology and application in failure analysis**
(2010) *Electronic Packaging Technology & High Density Packaging (ICEPT-HDP)*, pp. 957-960.
- Tseng, A.A.
Recent developments in nanofabrication using focused ion beams
(2005) *Small*, 1 (10), pp. 924-939.
- Takahashi, H., Sato, A., Takakura, M., Mori, N., Boerder, J., Knoll, W.
A new method of surface preparation for high spatial resolution EPMA/SEM with an argon ion beam
(2006) *Microchim Acta*, 155 (1-2), pp. 295-300.
- Bhavsar, S.N., Aravindan, S., Rao, P.V.
Machinability study of high speed steel for focused ion beam (FIB) milling process—An experimental investigation at micron/nano scale
(2014) *Precis Eng*, 38 (1), pp. 168-173.

- Tang, L., Zhang, Y., Bosman, M., Woo, J.
Study of ion beam damage on FIB prepared TEM samples
(2010) *Physical and Failure Analysis of Integrated Circuits (IPFA)*, pp. 1-4.
- Ali, M.Y., Loo, Y.W.
Geometrical integrity of micromold cavity sputtered by FIB using multilayer slicing approach
(2007) *Microsyst Technol*, 13 (1), pp. 103-107.
- Youn, S.-W., Okuyama, C., Takahashi, M., Maeda, R.
A study on fabrication of silicon mold for polymer hot-embossing using focused ion beam milling
(2008) *J Mater Process Technol*, 201 (1), pp. 548-553.
- Chew, N.G., Cullis, A.G.
The preparation of transmission electron microscope specimens from compound semiconductors by ion milling
(1987) *Ultramicroscopy*, 23 (2), pp. 175-198.
- Giannuzzi, L.A., Drown, J.L., Brown, S.R., Irwin, R.B., Stevie, F.A.
Applications of the FIB lift-out technique for TEM specimen preparation
(1998) *Microsc Res Tech*, 41 (4), pp. 285-290.
- Hopman, W.C., Ay, F., Hu, W., Gadgil, V.J., Kuipers, L., Pollnau, M.
Focused ion beam scan routine, dwell time and dose optimizations for submicrometre period planar photonic crystal components and stamps in silicon
(2007) *Nanotechnology*, 18 (19).
- Sabouri, A., Anthony, C., Bowen, J., Vishnyakov, V., Prewett, P.
The effects of dwell time on focused ion beam machining of silicon
(2014) *Microelectron Eng*, 121, pp. 24-26.
- Salvati, E., Brandt, L., Papadaki, C., Zhang, H., Mousavi, S., Wermeille, D.
Nanoscale structural damage due to focused ion beam milling of silicon with Ga ions
(2018) *Mater Lett*, 213, pp. 346-349.
- Goswami, A., Singh, K., Aravindan, S., Rao, P.V.
Optimizing FIB milling process parameters for silicon and its use in nanoreplication
(2017) *Mater Manuf Processes*, 32 (10), pp. 1052-1058.
- Garg, V., Mote, R.G., Fu, J.
Facile fabrication of functional 3D micro-nano architectures with focused ion beam implantation and selective chemical etching
(2020) *Appl Surf Sci*, pp. -.
146644
- Simon, P., Ihlemann, J.
Machining of submicron structures on metals and semiconductors by ultrashort UV-laser pulses
(1996) *Appl Phys A*, 63 (5), pp. 505-508.
- Bakhtiyari, A.N., Wang, Z., Wang, L., Zheng, H.
A review on applications of artificial intelligence in modeling and optimization of laser beam machining

(2021) *Opt Laser Technol*, 135.

- Majumdar, J.D., Manna, I.
Laser processing of materials
(2003) *Sadhana*, 28 (3-4), pp. 495-562.
- Chryssolouris, G.
(1991) *Laser Machining Theory and Practice*,
Springer-Verlag
- Dubey, A.K., Yadava, V.
Laser beam machining—A review
(2008) *Int J Mach Tools Manuf*, 48 (6), pp. 609-628.
- Muthuramalingam, T., Akash, R., Krishnan, S., Phan, N.H., Pi, V.N., Elsheikh, A.H.
Surface quality measures analysis and optimization on machining titanium alloy using CO2 based laser beam drilling process
(2021) *J Manuf Processes*, 62, pp. 1-6.
- Gautam, G.D., Pandey, A.K.
Pulsed Nd: YAG laser beam drilling: A review
(2018) *Opt Laser Technol*, 100, pp. 183-215.
- Meijer, J.
Laser beam machining (LBM), state of the art and new opportunities
(2004) *J Mater Process Technol*, 149 (1), pp. 2-17.
- Tabata, N., Yagi, S., Hishii, M.
Present and future of lasers for fine cutting of metal plate
(1996) *J Mater Process Technol*, 62 (4), pp. 309-314.
- Faisal, N., Zindani, D., Kumar, K., Bhowmik, S.
Laser micromachining of engineering materials—a review
(2019) *Micro Nano Mach Eng Mater*, pp. 121-136.
- Goswami, D., Chakraborty, S.
A study on the optimization performance of fireworks and cuckoo search algorithms in laser machining processes
(2015) *J Inst Eng (India) Ser C*, 96 (3), pp. 215-229.
- Hamad, A.H.
Effects of different laser pulse regimes (nanosecond, picosecond and femtosecond) on the ablation of materials for production of nanoparticles in liquid solution
(2016) *High Energy Short Pulse Lasers*, pp. 305-325.
- Liu, H.-H., Hu, Y., Cui, H.-P.
Femtosecond laser in refractive and cataract surgeries
(2015) *Int J Ophthalmol*, 8 (2), p. 419.
- Venkatakrisnan, K., Sudani, N., Tan, B.
A high-repetition-rate femtosecond laser for thin silicon wafer dicing
(2008) *J Micromech Microeng*, 18 (7).

- Kasaai, M.R., Kacham, V., Theberge, F., Chin, S.L.
The interaction of femtosecond and nanosecond laser pulses with the surface of glass
(2003) *J Non-Cryst Solids*, 319 (1), pp. 129-135.
- Amer, M., El-Ashry, M., Dosser, L., Hix, K., Maguire, J., Irwin, B.
Femtosecond versus nanosecond laser machining: comparison of induced stresses and structural changes in silicon wafers
(2005) *Appl Surf Sci*, 242 (1), pp. 162-167.
- Dahotre, N.B., Harimkar, S.
Laser fabrication and machining of materials
(2008) *Springer Science & Business Media*,
- Sugioka, K., Cheng, Y.
Femtosecond laser three-dimensional micro-and nanofabrication
(2014) *Appl Phys Rev*, 1 (4).
- Voisey, K., Cheng, C., Clyne, T.
Quantification of melt ejection phenomena during laser drilling
(2000) *MRS Online Proc Libr Arch*, 617.
- Tahmouch, G., Meyrueis, P., Grandjean, P.
Cutting by a high power laser at a long distance without an assist gas for dismantling
(1997) *Opt Laser Technol*, 29 (6), pp. 307-315.
- Chen, T.-C., Darling, R.B.
Parametric studies on pulsed near ultraviolet frequency tripled Nd: YAG laser micromachining of sapphire and silicon
(2005) *J Mater Process Technol*, 169 (2), pp. 214-218.
- Ghany, K.A., Newishy, M.
Cutting of 1.2 mm thick austenitic stainless steel sheet using pulsed and CW Nd: YAG laser
(2005) *J Mater Process Technol*, 168 (3), pp. 438-447.
- Chen, S.-L.
The effects of high-pressure assistant-gas flow on high-power CO2 laser cutting
(1999) *J Mater Process Technol*, 88 (1-3), pp. 57-66.
- Krüger, J., Kautek, W.
(1995) *Femtosecond-Pulse Laser Processing of Metallic and Semiconducting Thin Films. Photonics West'95: International Society for Optics and Photonics*, pp. 436-447.
- Chichkov, B.N., Momma, C., Nolte, S., Von Alvensleben, F., Tünnermann, A.
Femtosecond, picosecond and nanosecond laser ablation of solids
(1996) *Appl Phys A*, 63 (2), pp. 109-115.
- Müllenborn, M., Dirac, H., Petersen, J.W., Bouwstra, S.
Fast three-dimensional laser micromachining of silicon for microsystems
(1996) *Sens Actuators A*, 52 (1), pp. 121-125.

- Geng, N., Fu, X., Li, H., Ni, X., Hu, X.T.
Effect of Laser Parameters in the Micromachining of Silicon by Femtosecond Pulse Laser
(2007) *Key Eng Mater*, 339, pp. 136-140.
- Dauer, S., Ehlert, A., Büttgenbach, S.
Rapid prototyping of micromechanical devices using a Q-switched Nd: YAG laser with optional frequency doubling
(1999) *Sens Actuators A*, 76 (1), pp. 381-385.
- Amer, M.S., Dosser, L., LeClair, S., Maguire, J.F.
Induced stresses and structural changes in silicon wafers as a result of laser micro-machining
(2002) *Appl Surf Sci*, 187 (3-4), pp. 291-296.
- Pan, C.T., Hwang, Y.M., Hsieh, C.W.
Dynamic characterization of silicon-based microstructure of high aspect ratio by dual-prism UV laser system
(2005) *Sens Actuators A*, 122 (1), pp. 45-54.
- Tang, Y., Fuh, J., Loh, H., Wong, Y., Lim, Y.
Laser dicing of silicon wafer
(2008) *Surf Rev Lett*, 15 (1-2), pp. 153-159.
- Kagerer, M., Irlinger, F., Lueth, T.C.
Laser source independent basic parameters in micro-cutting
(2011) *Advanced Intelligent Mechatronics (AIM), 2011 IEEE/ASME International Conference On: IEEE*, pp. 391-396.
- Chung, C., Wu, M., Wu, J., Sung, Y., Huang, G.
Silicon micromachining by CO₂ laser
(2006) *Nano/Micro Engineered and Molecular Systems, 2006 NEMS'06 1st IEEE International Conference On: IEEE*, pp. 1445-1448.
- Weinhold, S., Gruner, A., Ebert, R., Schille, J., Exner, H.
Study of fast laser induced cutting of silicon materials
(2014) *SPIE LASE: International Society for Optics and Photonics*,
- Wang, F., Zhao, L., Tu, Y.P., Liu, Y., Chen, J.-X.
Image feature analysis of plasma spot produced from femtosecond laser ablation for silicon wafer
(2017) *J Micro/Nanolithogr MEMS MOEMS*, 16 (2).
- Goodarzi, R., Hajiesmaeilbaigi, F.
Circular ripple formation on the silicon wafer surface after interaction with linearly polarized femtosecond laser pulses in air and water environments
(2018) *Opt Quantum Electron*, 50 (7), p. 299.
- Chen, T.-H., Fardel, R., Arnold, C.B.
Ultrafast z-scanning for high-efficiency laser micro-machining
(2018) *Light Sci Appl*, 7 (4).
- Singh, N.K., Singh, Y., Sharma, A., Singla, A., Negi, P.
An environmental-friendly electrical discharge machining using different sustainable techniques: a review

(2021) *Adv Mater Process Technol*, 7 (4), pp. 537-566.

- Ramulu, M., Taya, M.
EDM machinability of SiCw/Alcomposites
(1989) *J Mater Sci*, 24 (3), pp. 1103-1108.
- König, W., Dauw, D.F., Levy, G., Panten, U.
EDM-Future Steps towards the Machining of Ceramics
(1988) *CIRP Ann Manuf Technol*, 37 (2), pp. 623-631.
- Grigoriev, S.N., Hamdy, K., Volosova, M.A., Okunkova, A.A., Fedorov, S.V.
Electrical discharge machining of oxide and nitride ceramics: A review
(2021) *Mater Des*, 209.
- Reynaerts, D., Meeusen, W., Song, X., Van Brussel, H., Reyntjens, S., De Bruyker, D.
Integrating electro-discharge machining and photolithography: work in progress
(2000) *J Micromech Microeng*, 10 (2), p. 189.
- Weng, F.T., Hsu, C.S., Lin, W.F.
Fabrication of micro components to Silicon wafer using EDM process
(2006) *Mater Sci Forum Trans Tech Publ*, p. 217.
- Abu Qudeiri, J.E., Saleh, A., Ziout, A., Mourad, A.-H.I., Abidi, M.H., Elkaseer, A.
Advanced electric discharge machining of stainless steels: Assessment of the state of the art, gaps and future prospect
(2019) *Materials*, 12 (6), p. 907.
- Czelusniak, T., Higa, C., Torres, R., Laurindo, C., Paiva, J.M., Jr., Lohrengel, A.
Materials used for sinking EDM electrodes: a review
(2019) *J Braz Soc Mech Sci Eng*,
- Rajurkar, K., Sundaram, M., Malshe, A.
Review of electrochemical and electrodischarge machining
(2013) *Procedia CIRP*, 6, pp. 13-26.
- Drozda, T., Wick, C., Bakerjian, R., Benedict, J.T., Veilleux, R.F.
Tool and manufacturing engineers handbook: continuous improvement
(1983) *Soc Manuf Eng*,
- Muttamara, A., Fukuzawa, Y., Mohri, N., Tani, T.
Effect of electrode material on electrical discharge machining of alumina
(2009) *J Mater Process Technol*, 209 (5), pp. 2545-2552.
- Song, X., Reynaerts, D., Meeusen, W., van Brussel, H.
Micro-EDM for silicon microstructure fabrication
(1999) *Design, Test, and Microfabrication of MEMS/MOEMS: International Society for Optics and Photonics*, pp. 792-799.
- Davis, J.R., Lampman, S., Zorc, T.
(1989) *Metals Handbook*, 16, p. 944.
Machining. ASM International, Metals Park, Ohio 44073, USA
- Tsai, Y.-Y., Masuzawa, T.
An index to evaluate the wear resistance of the electrode in micro-EDM
(2004) *J Mater Process Technol*, 149 (1), pp. 304-309.

- Reynaerts, D., Van Brussel, H.
Microstructuring of silicon by electro-discharge machining (EDM)—part I: theory
(1997) *Sens Actuators A*, 60 (1), pp. 212-218.
- Luo, Y.
An energy-distribution strategy in fast-cutting wire EDM
(1995) *J Mater Process Technol*, 55 (3), pp. 380-390.
- Suzuki, Y., Kishi, M.
Improvement of Surface Roughness in wire EDM
(1989) *Proceedings of the Ninth International Symposium for Electro-Machining (ISEM-9, Nagoya, Japan)*
- Kalpakjian, S.
(1997) *Manufacturing Process for Engineering Materials*,
Addison-Wesley, Reading, MA
- Luo, Y., Chen, C., Tong, Z.
Investigation of silicon wafering by wire EDM
(1992) *J Mater Sci*, 27 (21), pp. 5805-5810.
- Uno, Y., Okada, A., Okamoto, Y., Hirano, T.
Wire EDM slicing of monocrystalline silicon ingot
(2000) *Proc 2000 ASPE Annu Meet*, pp. 172-175.
- Peng, W., Liao, Y.
Study of electrical discharge machining technology for slicing silicon ingots
(2003) *J Mater Process Technol*, 140 (1), pp. 274-279.
- Okamoto, Y., Uno, Y., Okada, A., Ohshita, S., Hirano, T., Takata, S.
Development of multi-wire EDM slicing method for silicon ingot
(2008) *Proc ASPE Ann Meet 12Th ICPE2008* 530,
- Takino, H., Ichinohe, T., Tanimoto, K., Yamaguchi, S., Nomura, K., Kunieda, M.
Cutting of polished single-crystal silicon by wire electrical discharge machining
(2004) *Precis Eng*, 28 (3), pp. 314-319.
- Takino, H., Ichinohe, T., Tanimoto, K., Yamaguchi, S., Nomura, K., Kunieda, M.
High-quality cutting of polished single-crystal silicon by wire electrical discharge machining
(2005) *Precis Eng*, 29 (4), pp. 423-430.
- Huijun, P., Zhidong, L., Lian, G., Mingbo, Q., Zongjun, T.
Study of small holes on monocrystalline silicon cut by WEDM
(2013) *Mater Sci Semicond Process*, 16 (2), pp. 385-389.
- Joshi, K., Bhandarkar, U.V., Joshi, S.S.
Surface integrity and wafer-thickness variation analysis of ultra-thin silicon wafers sliced using wire-EDM
(2019) *Adv Mater Process Technol*, 5 (3), pp. 512-525.
- Saleh, T., Rasheed, A.N., Muthalif, A.G.
Experimental study on improving μ -WEDM and μ -EDM of doped silicon by temporary metallic coating

- (2015) *Int J Adv Manuf Technol*, 78 (9-12), pp. 1651-1663.
- Masuzawa, T.
State of the Art of Micromachining
(2000) *CIRP Ann Manuf Technol*, 49 (2), pp. 473-488.
 - Masaki, T., Kawata, K., Masuzawa, T.
Micro electro-discharge machining and its applications
(1990) *Micro Electro Mechanical Systems, 1990 Proceedings, An Investigation of Micro Structures, Sensors, Actuators, Machines and Robots IEEE*, 1990, pp. 21-26.
 - Reynaerts, D., Meeusen, W., Van Brussel, H.
Machining of three-dimensional microstructures in silicon by electro-discharge machining
(1998) *Sens Actuators A*, 67 (1), pp. 159-165.
 - Heeren, P., Reynaerts, D., van Brussel, H.
Three-dimensional silicon micromechanical parts manufactured by electro-discharge machining
(1997) *Advanced Robotics, 1997 ICAR'97 Proceedings, 8Th International Conference On: IEEE*, pp. 247-252.
 - Reynaerts, D., Van Brussel, H., Beuret, C., Larsson, O., Bertholds, A.
Microstructuring of silicon by electro-discharge machining (EDM)—part II: applications
(1997) *Sens Actuators A*, 61 (1), pp. 379-386.
 - Murray, J., Fay, M., Kunieda, M., Clare, A.
TEM study on the electrical discharge machined surface of single-crystal silicon
(2013) *J Mater Process Technol*, 213 (5), pp. 801-809.
 - Uno, Y., Okada, A., Okamoto, Y., Yamazaki, K., Risbud, S.H., Yamada, Y.
High efficiency fine boring of monocrystalline silicon ingot by electrical discharge machining
(1999) *Precis Eng*, 23 (2), pp. 126-133.
 - Kunieda, M., Ojima, S.
Improvement of EDM efficiency of silicon single crystal through ohmic contact
(2000) *Precis Eng*, 24 (3), pp. 185-190.
 - Rasheed, A.N., Muthalif, A., Gani, A., Saleh, T.
(2014) *Improving μ -wire electro-discharge machining operation of polished silicon wafer by conductive coating*,
 - Daud, N.D., AbuZaiter, A., Leow, P.L., Ali, M.S.M.
The effects of the silicon wafer resistivity on the performance of microelectrical discharge machining
(2018) *Int J Adv Manuf Technol*, 95 (1-4), pp. 257-266.
 - Daud, N.D., Ghazali, F.A.M., Abd Hamid, F.K., Nafea, M., Saleh, T., Leow, P.L., Ali, M.S.M.
Heat-assisted μ -electrical discharge machining of silicon
(2021) *Int J Adv Manuf Technol*, pp. 1-12.

- Asami, T., Miura, H.
(2012) *Ultrasonics Symposium (IUS), 2012 IEEE International: IEEE 2012*, pp. 2667-2670.
- Atiqah, N., Jaafar, I., Ali, M.Y., Asfana, B.
Application of focused ion beam micromachining: a review
(2012) *Adv Mater Res Trans Tech Publ*, pp. 507-510.
- Meijer, J., Du, K., Gillner, A., Hoffmann, D., Kovalenko, V., Masuzawa, T.
Laser machining by short and ultrashort pulses, state of the art and new opportunities in the age of the photons
(2002) *CIRP Ann Manuf Technol*, 51 (2), pp. 531-550.
- Samant, A.N., Dahotre, N.B.
Laser machining of structural ceramics—A review
(2009) *J Eur Ceram Soc*, 29 (6), pp. 969-993.
- Ho, K.H., Newman, S.T.
State of the art electrical discharge machining (EDM)
(2003) *Int J Mach Tool Manuf*, 43 (13), pp. 1287-1300.
- Chan, M., Fonda, P., Reyes, C., Xie, J., Najjar, H., Lin, L.
Micromachining 3D hemispherical features in silicon via micro-EDM
(2012) . *Micro Electro Mechanical Systems (MEMS), 2012 IEEE 25Th International Conference On: IEEE 2012*, pp. 289-292.
- Fonda, P., Chan, M., Heidari, A., Nakamoto, K., Sano, S., Horsley, D.
The Application of Diamond-based Electrodes for Efficient EDMing of Silicon Wafers for Freeform MEMS Device Fabrication
(2013) *Procedia CIRP*, 6, pp. 280-285.
- Mingbo, Q., Zhidong, L., Zongjun, T., Wei, W., Yinhui, H.
Study of unidirectional conductivity on the electrical discharge machining of semiconductor crystals
(2013) *Precis Eng*, 37 (4), pp. 902-907.
- Patel, D., Vaghmare, V.
A Review of recent work in wire electrical discharge machining (WEDM)
(2013) *IJERA*, 3 (3), pp. 805-816.
- Egashira, K., Mizutani, K.
Micro-drilling of monocrystalline silicon using a cutting tool
(2002) *Precis Eng*, 26 (3), pp. 263-268.
- Shannon, G.
(2017) *Ultrafast Lasers Offer Great Promise as a Unique Manufacturing Tool*,
Accessed 24 Feb 2021
- Mishra, S., Yadava, V.
Laser Beam MicroMachining (LBMM) – A review
(2015) *Opt Lasers Eng*, 73, pp. 89-122.

- Song, X., Reynaerts, D., Meeusen, W., Van Brussel, H.
A study on the elimination of micro-cracks in a sparked silicon surface
(2001) *Sens Actuators A*, 92 (1), pp. 286-291.
- Wang, W., Liu, Z.D., Tian, Z.J., Huang, Y.H., Liu, Z.X.
High efficiency slicing of low resistance silicon ingot by wire electrolytic-spark hybrid machining
(2009) *J Mater Process Technol*, 209 (7), pp. 3149-3155.
- Punturat, J., Tangwarodomnukun, V., Dumkum, C.
Surface characteristics and damage of monocrystalline silicon induced by wire-EDM
(2014) *Appl Surf Sci*, 320, pp. 83-92.
- Punturat, J., Tangwarodomnukun, V., Dumkum, C.
Investigation of process performances and cut surface characteristics in the wire-EDMing of silicon
(2014) *Adv Mater Res*, 845, pp. 950-954.

Correspondence Address

Mohamed Ali M.S.; School of Electrical Engineering, Johor, Malaysia; email: sultan_ali@fke.utm.my

Publisher: Springer Science and Business Media Deutschland GmbH

ISSN: 02683768

CODEN: IJATE

Language of Original Document: English

Abbreviated Source Title: Int J Adv Manuf Technol

2-s2.0-85130720451

Document Type: Review

Publication Stage: Final

Source: Scopus

ELSEVIER

Copyright © 2022 Elsevier B.V. All rights reserved. Scopus® is a registered trademark of Elsevier B.V.

 RELX Group™