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Russell et al.

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(54) **SILICON-ON-SAPPHIRE DISPLAY WITH AUDIO TRANSDUCER AND METHOD OF FABRICATING SAME**

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(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 239 days.

This patent is subject to a terminal disclaimer.

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Related U.S. Application Data

(60) Continuation-in-part of application No. 10/614,426, filed on Jul. 7, 2003, now Pat. No. 6,954,235, which is a continuation-in-part of application No. 09/880,660, filed on Aug. 3, 2001, now Pat. No. 6,617,187, which is a division of application No. 09/047,658, filed on Mar. 25, 1998, now Pat. No. 6,312,968, which is a continuation-in-part of application No. 08/301,170, filed on Sep. 1, 1994, now abandoned, which is a continuation-in-part of application No. 08/105,252, filed on Aug. 4, 1993, now abandoned, which is a continuation-in-part of application No. 08/094,541, filed on Jun. 30, 1993, now Pat. No. 5,300,443.

(51) **Int. Cl.**
G02F 1/1333 (2006.01)
(52) **U.S. Cl.** 349/158
(58) **Field of Classification Search** 349/158
See application file for complete search history.

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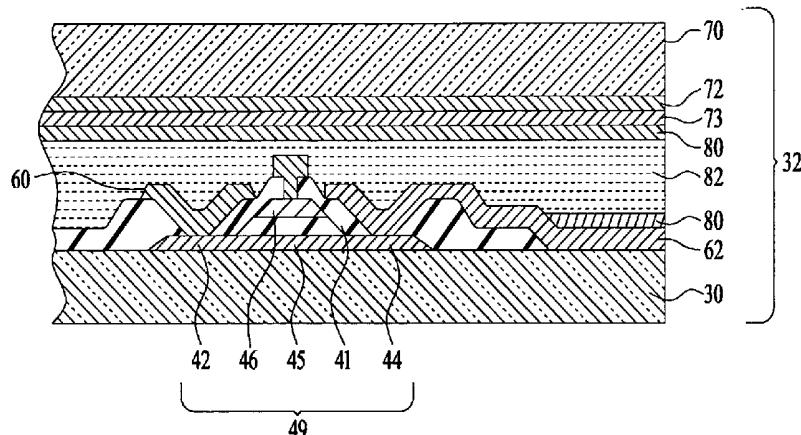
Assistant Examiner—Phu Vu

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(57) **ABSTRACT**

A liquid crystal display includes: a) a sapphire substrate; b) a single crystal silicon structure disposed on the sapphire substrate to create a silicon-on-sapphire structure; c) a plurality of liquid crystal capacitors disposed on the silicon-on-sapphire structure; d) integrated self-aligned circuitry formed from the crystal silicon structure, where the circuitry modulates the liquid crystal capacitors such that a video image is generated; and e) an integrated audio transducer disposed on the silicon-on-sapphire structure for generating an audible signal.

15 Claims, 8 Drawing Sheets



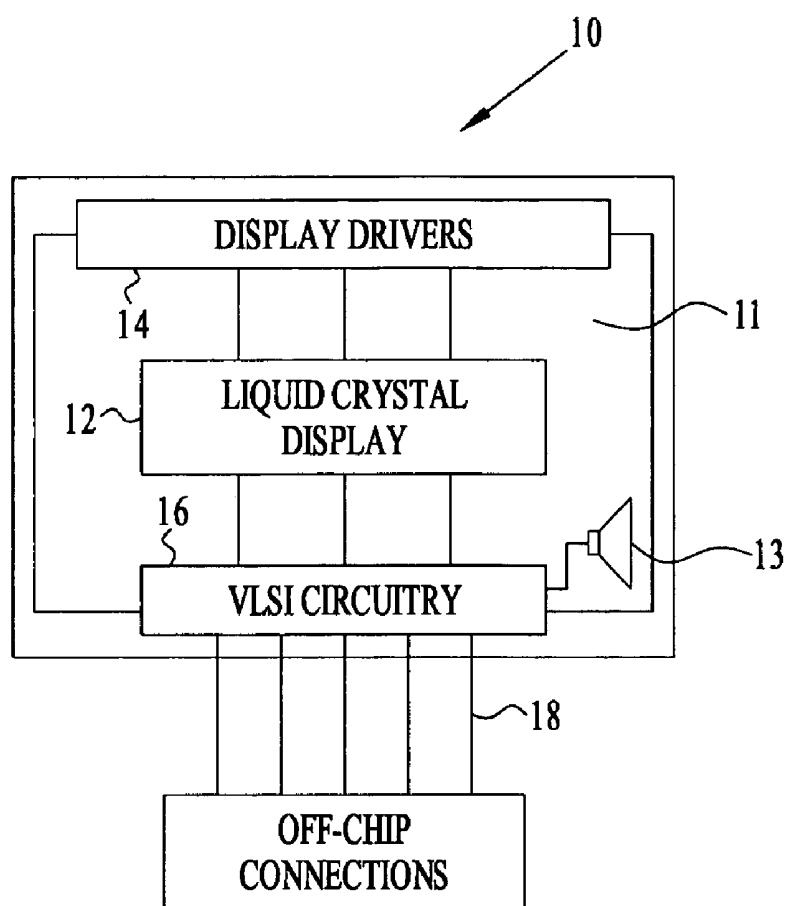


FIG. 1

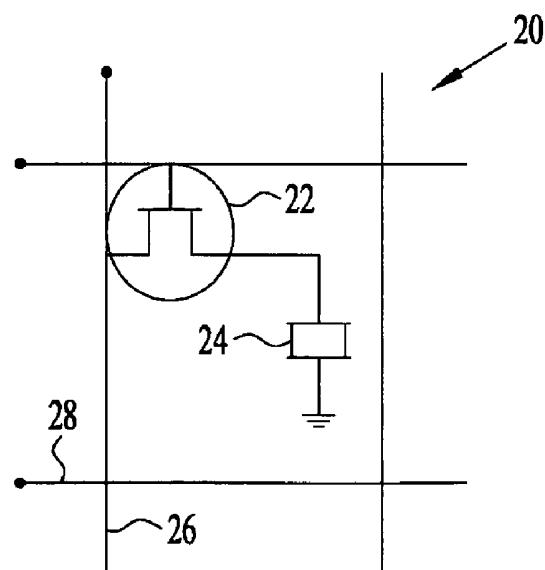


FIG. 2

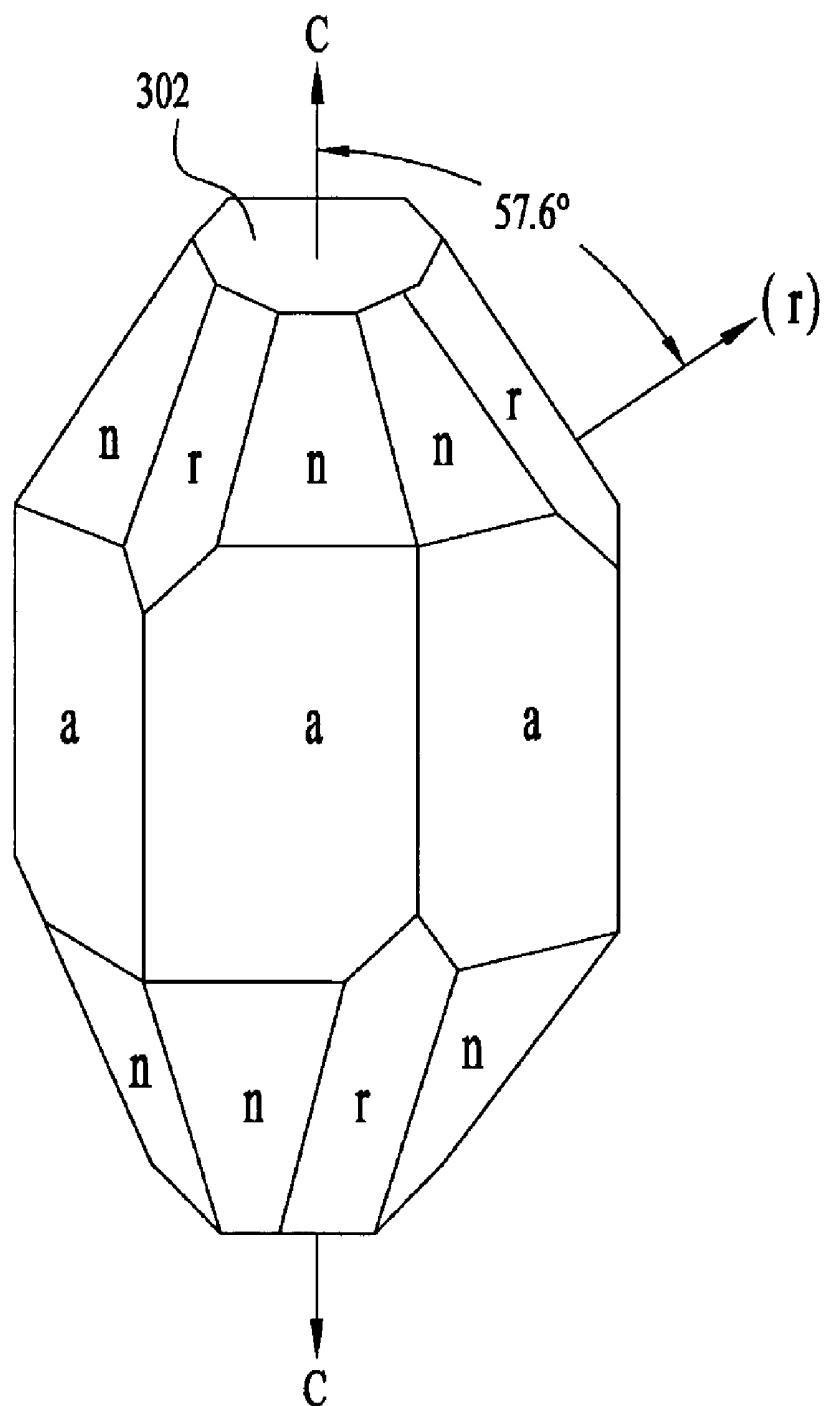


FIG. 3

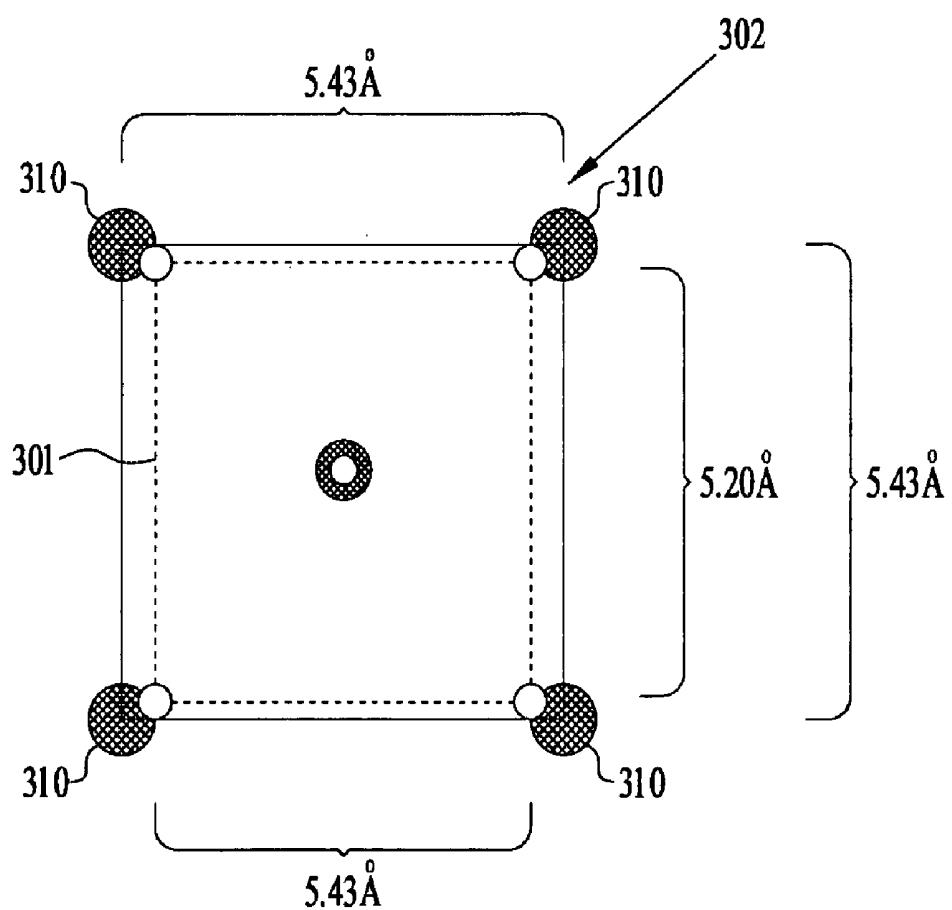


FIG. 4

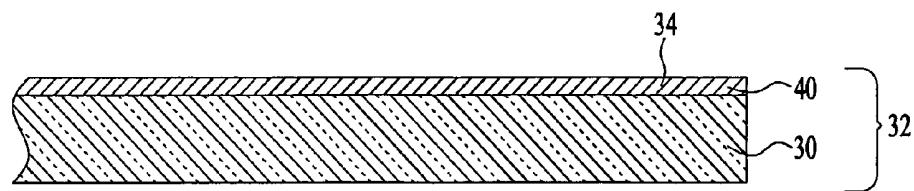


FIG. 5

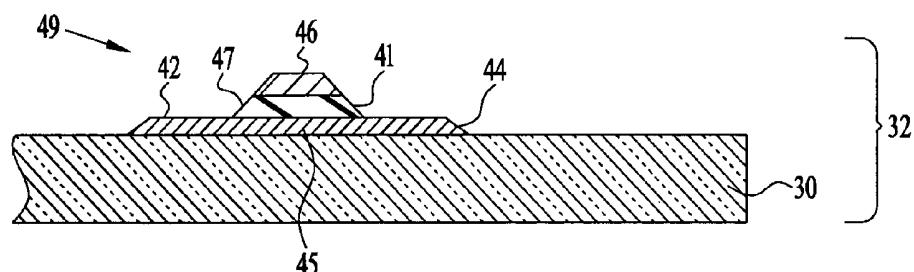


FIG. 6

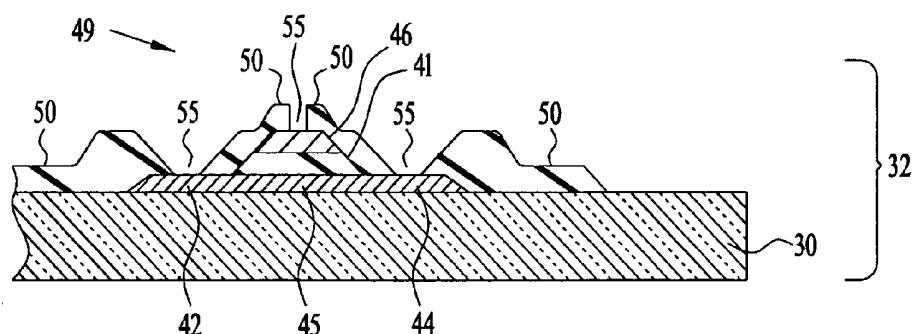


FIG. 7

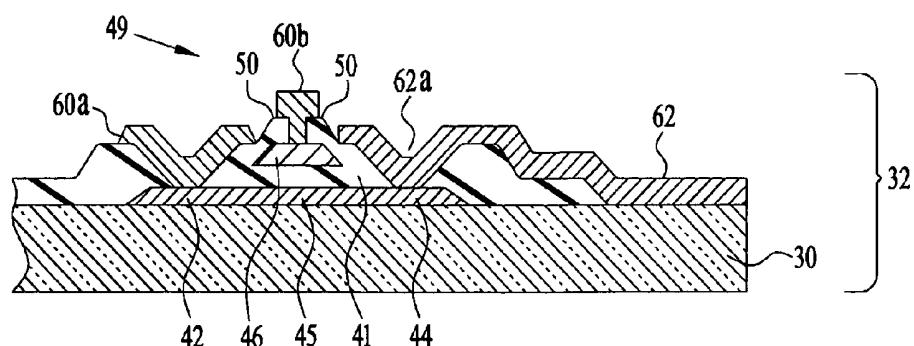


FIG. 8

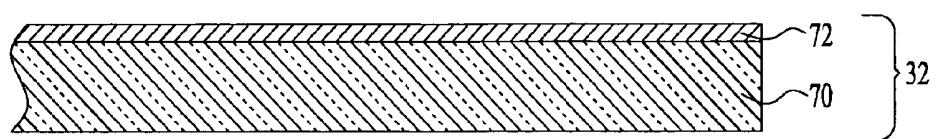


FIG. 9

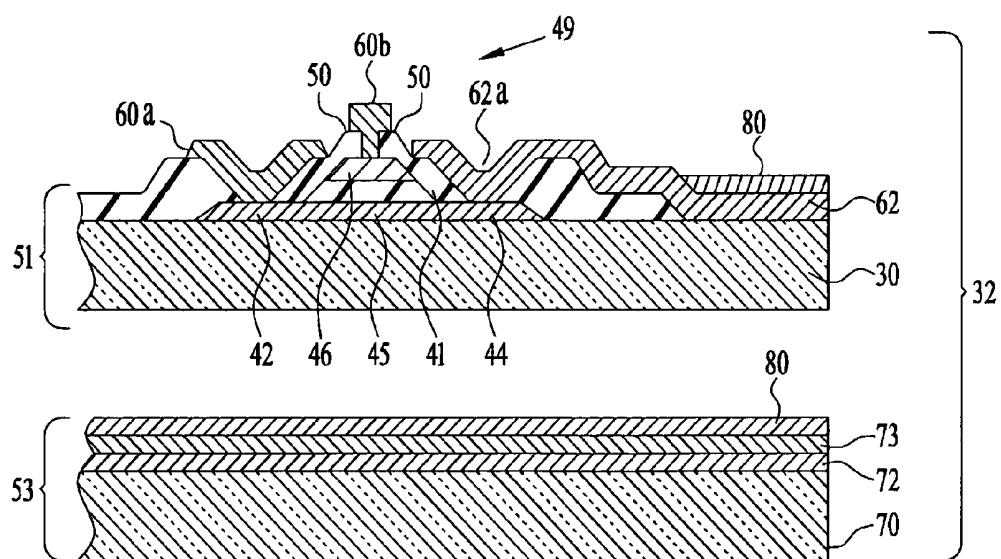


FIG. 10

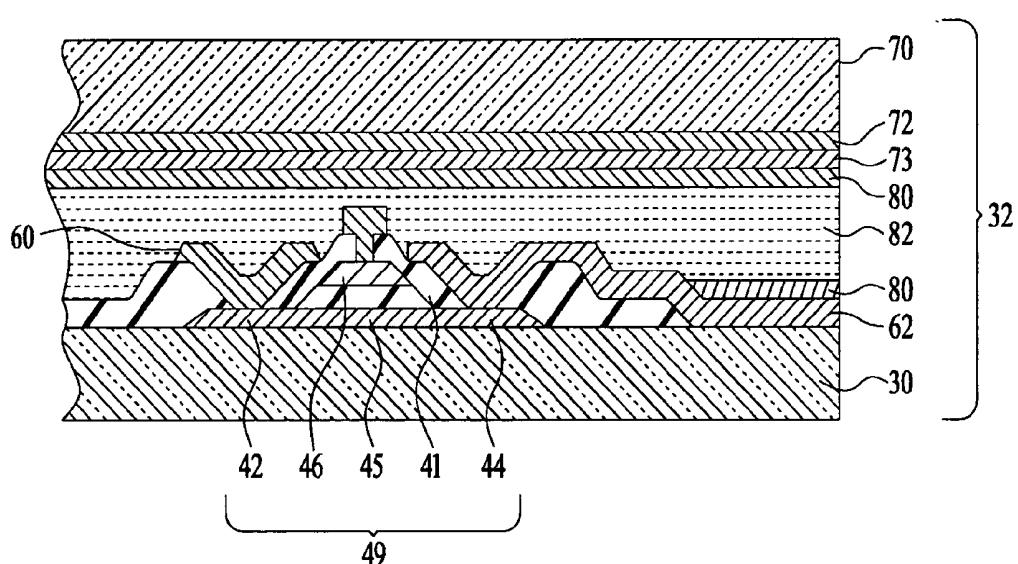


FIG. 11

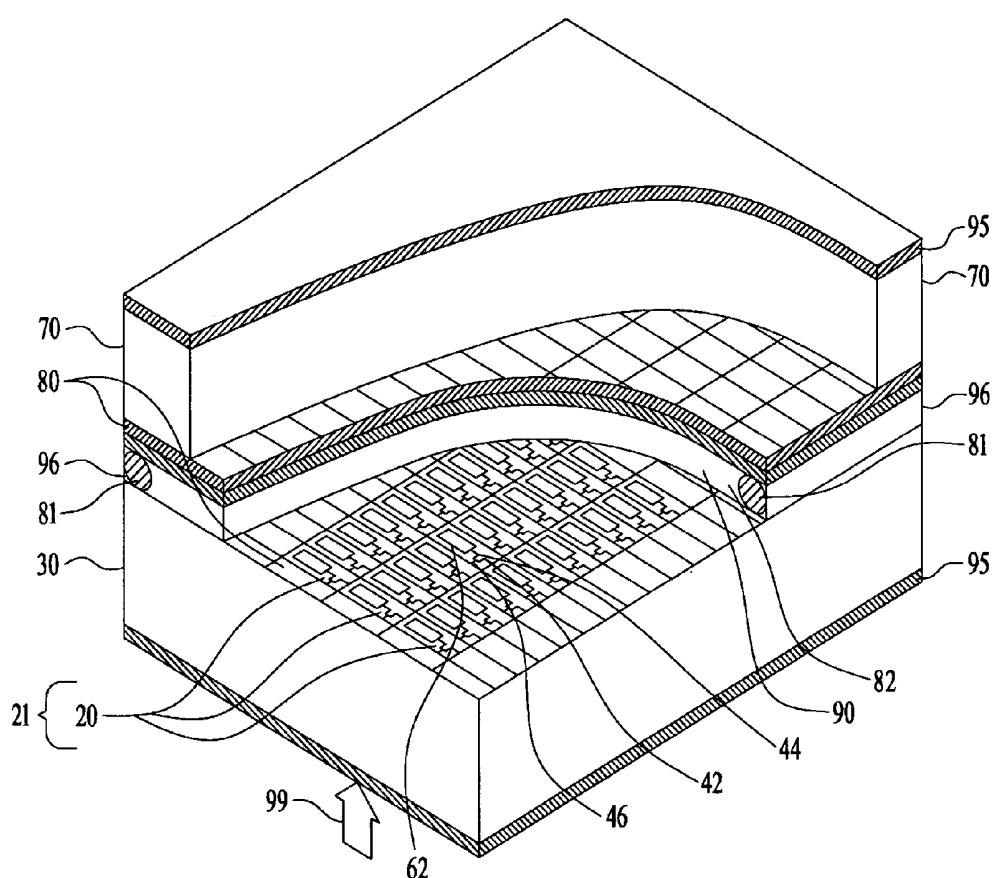


FIG. 12

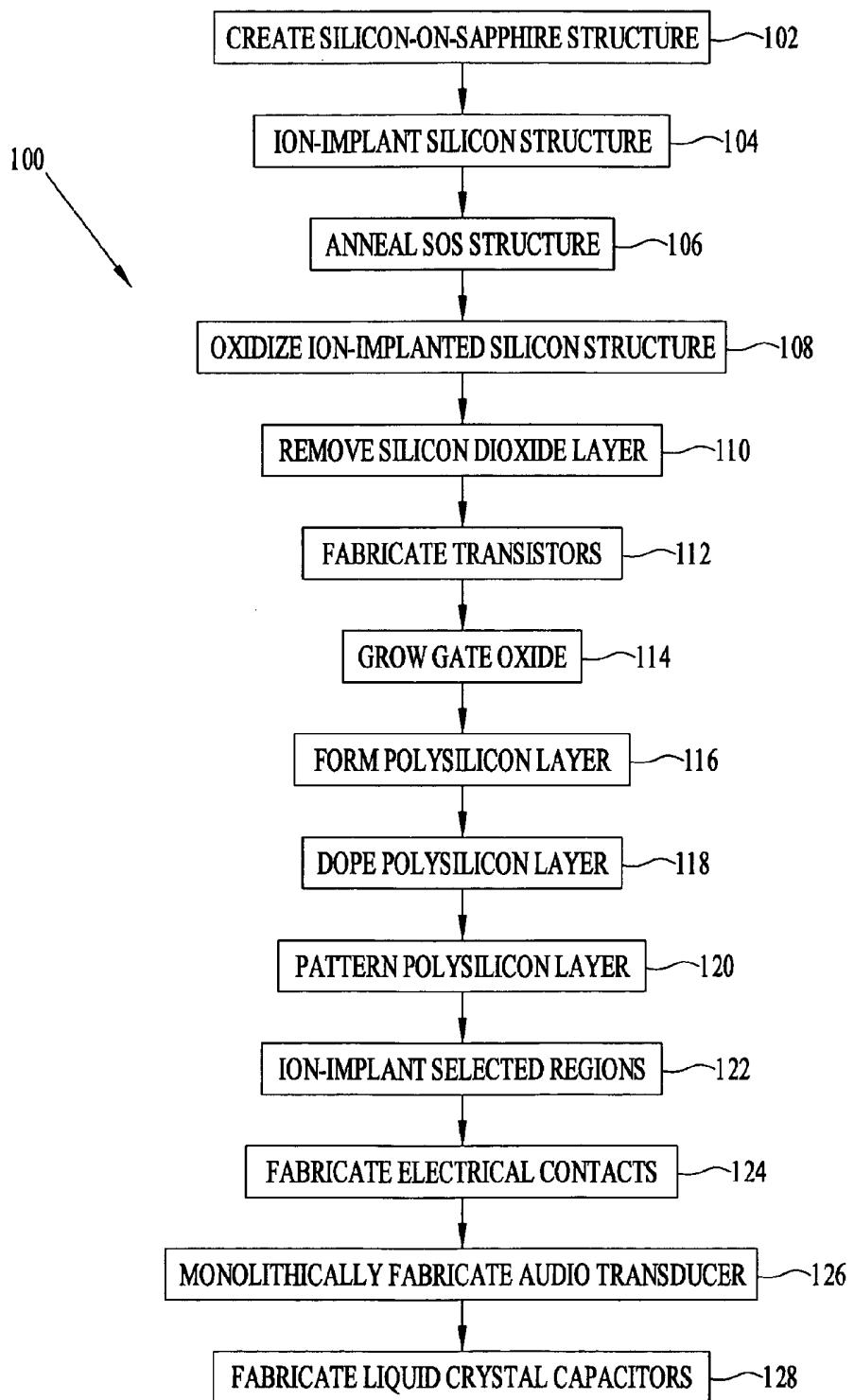


FIG. 13

**SILICON-ON-SAPPHIRE DISPLAY WITH
AUDIO TRANSDUCER AND METHOD OF
FABRICATING SAME**

**CROSS-REFERENCE TO RELATED
APPLICATIONS**

This application is a continuation-in-part of U.S. patent application Ser. No. 10/614,426 (Navy Case No. 84,892) filed Jul. 7, 2003 now U.S. Pat. No. 6,954,235, entitled "Silicon-On-Sapphire Display Apparatus And Method of Fabricating Same," which is a continuation-in-part of U.S. patent application Ser. No. 09/880,660 (Navy Case No. 83,222) filed Aug. 3, 2001 now U.S. Pat. No. 6,6617,187, entitled "Method For Fabricating An Electrically Addressable Silicon-On-Sapphire Light Valve," which is a divisional of U.S. patent application Ser. No. 09/047,658 (Navy Case No. 79,029) filed Mar. 25, 1998 now U.S. Pat. No. 6,312,968, entitled "Method For Fabricating An Electrically Addressable Silicon-On-Sapphire Light Valve," which is a continuation-in-part of U.S. patent application Ser. No. 08/301,170 (Navy Case No. 74,146) filed Sep. 1, 1994 (abandoned), entitled "Method For Fabricating An Electrically Addressable Silicon-On-Sapphire Light Valve," which is a continuation-in-part of U.S. patent application Ser. No. 08/105,252 (Navy Case No. 73,925) filed Aug. 4, 1993 (abandoned), entitled "Ultra-High Resolution Liquid Crystal Display On Silicon-On-Sapphire," which is a continuation-in-part of U.S. patent application Ser. No. 08/094,541 (Navy Case No. 73,899), filed Jun. 30, 1993 now U.S. Pat. No. 5,300,443, entitled "Method For Fabricating Complementary Enhancement And Depletion Mode Field Effect Transistors On A Single Substrate." All six of these related applications are incorporated by reference herein.

**FEDERALLY-SPONSORED RESEARCH AND
DEVELOPMENT**

The SILICON-ON-SAPPHIRE DISPLAY WITH AUDIO TRANSDUCER AND METHOD OF FABRICATING SAME is assigned to the United States Government and is available for licensing for commercial purposes. Licensing and technical inquiries should be directed to the Office of Patent Counsel, Space and Naval Warfare Systems Center, San Diego, Code 20012, San Diego, Calif., 92152; telephone (619)553-3001, facsimile (619) 553-3821. Reference Navy Case No. 96,340.

BACKGROUND OF THE INVENTION

The SILICON-ON-SAPPHIRE DISPLAY WITH AUDIO TRANSDUCER AND METHOD OF FABRICATING SAME generally relates to silicon-on-sapphire liquid crystal displays, and more particularly, relates to silicon-on-sapphire liquid crystal displays with audio transducers.

Liquid crystal displays are used in a wide variety of commercial applications including portable (laptop) computers, wristwatches, camcorders and large screen televisions. Liquid crystal light valves, used as spatial light modulators, may be used in projection systems as well as optical computing applications. Limitations inherent in the existing technology come from the necessity of fabricating the displays on transparent glass or quartz substrates, which are not amenable to high quality electronic materials. Fabrication of displays on bulk silicon, although of high crystal quality, unnecessarily constrains the display to reflective mode schemes due to the opaque substrate and is not

applicable to transmissive applications. The ability to integrate drive circuitry using thin-film transistors (TFTs) with liquid crystal displays has improved reliability and has allowed the use of this technology in lightweight, portable applications. However, the integration of display driving circuitry heretofore has been substantially limited to thin film transistor technology using amorphous (a-Si) or polycrystalline (p-Si) silicon deposited on the glass or quartz substrate. The intrinsic properties such as lattice and thermal mismatch between the silicon layer and the substrate, and the low temperature deposition techniques used in the a-Si and p-Si technologies result in a silicon layer with poor charge carrier mobility and crystallographic defects. These limitations are directly related to inferior electronic device performance and limitations when compared to bulk silicon.

Of particular importance for integrated display systems is the desire for higher density circuitry for ultra-high resolution display and light valve applications and for the monolithic integration of display driver circuitry and related signal processing circuitry on-chip. The characteristic lower (electrical and crystallographic) qualities of a-Si and p-Si materials result in poor fabrication yields when compared to conventional Very Large Scale Integration (VLSI) processing. Overcoming this problem, inherent in the poorer quality amorphous or polycrystalline material, requires the use of redundant circuit elements in each pixel to ensure fully functional displays in a-Si and p-Si. This redundancy requires a concomitant increase in the picture element (pixel) size thereby inhibiting the ability to scale displays and light valves to ultra-high resolution. The additional circuit elements also reduce the aperture ratio, i.e. the fraction of pixel area allowing transmitted light, thereby reducing the brightness of the display or light valve.

Furthermore, the low carrier mobility, low speed, low yield a-Si and p-Si materials are incompatible with VLSI design and fabrication techniques which would otherwise readily allow integration of video drivers, digital logic and other computational circuitry on-chip thereby offering designers greater functionality, higher reliability, and improved performance.

Thus, a need is recognized for a liquid crystal display or light valve system, which monolithically integrates an active matrix display with its associated drive and image processing circuitry.

SUMMARY OF THE INVENTION

In one aspect of the invention, a liquid crystal display includes: a) a sapphire substrate; b) a single crystal silicon structure disposed on the sapphire substrate to create a silicon-on-sapphire structure; c) a plurality of liquid crystal capacitors disposed on the silicon-on-sapphire structure; d) integrated self-aligned circuitry formed from the crystal silicon structure, where the circuitry modulates the liquid crystal capacitors to generate a video signal; and e) an audio transducer disposed on the silicon-on-sapphire structure for generating an audible signal.

In another aspect of the invention, a method of fabricating a monolithically integrated crystal array display and control circuitry on a silicon-on-sapphire structure includes the steps of: (a) affixing a single crystal silicon structure to a sapphire substrate; (b) ion implanting the single crystal silicon structure with a species selected from the group consisting of: silicon ions, tin ions, germanium ions, and carbon ions to create an ion-implanted silicon layer; (c) annealing the silicon-on-sapphire structure; (d) oxidizing the ion-implanted silicon layer to form a silicon dioxide layer from a

portion of the silicon layer so that a thinned, ion-implanted silicon layer remains; (e) removing the silicon dioxide layer to expose the thinned ion-implanted silicon layer; (f) fabricating transistors wherein each of the transistors is formed by patterning the thinned ion-implanted silicon layer to create a patterned silicon layer; (g) growing a gate oxide on the patterned silicon layer; (h) forming a polysilicon layer over the silicon-on-sapphire structure; (i) doping the polysilicon layer; (j) patterning the polysilicon layer and the gate oxide to form a gate region and to expose selected regions of the thinned, ion-implanted silicon layer; (k) ion-implanting the selected regions of the silicon layer to create source and drain regions in the silicon layer that are self-aligned with the gate region; (l) fabricating electrical contacts that are electrically connected to the transistors; (m) monolithically fabricating an audio transducer on the silicon-on-sapphire structure; and (n) fabricating liquid crystal capacitors on the silicon-on-sapphire structure that are electrically connected to the transistors by the electrical contacts.

In yet another aspect of the invention, a liquid crystal display system includes: (a) a liquid crystal display, comprising: (i) a plurality of liquid crystal capacitors disposed on a first structure of silicon-on-sapphire; (ii) integrated self-aligned circuitry disposed on the first structure for modulating the liquid crystal capacitors such that a video image is generated; and (iii) an audio transducer disposed on the first structure for generating an audible signal; and (b) an off-chip circuit disposed on a second structure for generating the electromagnetic radiation.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a block diagram showing a liquid crystal display monolithically integrated with associated circuitry and audio transducer on an improved ultra-thin silicon-on-sapphire (UTSOS) wafer, in accordance with the Silicon-On-Sapphire Display With Audio Transducer and Method of Fabricating Same.

FIG. 2 is a schematic showing a single picture element (pixel), in accordance with the Silicon-On-Sapphire Display With Audio Transducer and Method of Fabricating Same.

FIG. 3 is an illustration showing the crystal structure of sapphire, in accordance with the Silicon-On-Sapphire Display With Audio Transducer and Method of Fabricating Same.

FIG. 4 is a view showing a silicon crystal formed on the r-plane of the sapphire crystal shown in FIG. 3.

FIGS. 5-12 are cross-sectional illustrations showing a liquid crystal display and associated self-aligned circuitry through the integrated fabrication process, in accordance with the Silicon-On-Sapphire Display With Audio Transducer and Method of Fabricating Same.

FIG. 13 is a flow-chart showing an integrated fabrication process, in accordance with the Silicon-On-Sapphire Display With Audio Transducer and Method of Fabricating Same.

DESCRIPTION OF SOME EMBODIMENTS

Following is a glossary of terms used to describe the Silicon-On-Sapphire Display With Audio Transducer and Method of Fabricating Same. The definitions set forth in the glossary are representative of the intended meanings as used herein.

Glossary

The term "audible" means capable of being heard; typically by an average human ear; including frequencies normally in the range of about 15 to about 20,000 hertz.

5 FIG. 1 shows a SOS display 10. Display 10 includes nematic liquid crystal display 12, display drivers 14, very large scale integration (VLSI) circuitry 16, and audio transducer 13 monolithically integrated on an improved ultra-thin silicon-on-sapphire (UTSOS) wafer 11.

10 Liquid crystal display 12 includes an array of one or more pixel elements, which may be individually addressed so that display 12 presents an image for viewing or projection. By way of example, a 1000 pixel \times 1000 pixel display may be incorporated into display 12, but it is recognized that any 15 number of pixel elements may be utilized as may be necessary to suit the needs of a particular application.

15 Display drivers 14 and VLSI circuitry 16 are used to address each of a plurality of individual pixel elements 20 (as shown in FIG. 2) and to generate the appropriate voltages 20 to modulate the liquid crystal capacitors 24 such that a desired video image is presented by liquid crystal display 12. Typically, display drivers 14 include shift registers and clock circuitry. VLSI circuitry 16 may include image processing circuits, and memory and buffer circuits.

20 Referring back to FIG. 1, Display 10 further includes audio transducer 13 formed on the sapphire substrate for generating an audible signal. The audible signal may be generated such that it is synchronized with the video image produced by display 10. Audio transducer 13 is operably 25 coupled to VLSI circuitry 16 by such means as bump-bonding, wire-bonding or other interconnection techniques. By way of example, Audio transducer may be fabricated by monolithically integrating a membrane that can be electrically biased to produce an audible signal, in accordance with 30 MEMS fabrication technologies.

35 For purposes of illustrating the self-aligned manufacture of the SOS display 10 of FIG. 1, fabrication of only the simplest pixel element is described. Each pixel element includes a single nonlinear circuit element (self-aligned 40 transistor) and a single nematic liquid crystal capacitor. As detailed below, a plurality or multitude of such pixels may be configured and interconnected in an array with drive and 45 image processing circuitry using standard photolithographic processes. FIG. 2 shows an electrical schematic for a single liquid crystal display element 20, which includes a nonlinear circuit element 22, such as a MOSFET, and a single nematic liquid crystal capacitor 24. Metal column line 26 and polysilicide row line 28 are appropriately connected to bias the nonlinear circuit element 22 to vary the voltage of the 50 nematic liquid crystal 24 to achieve a desired gray scale. FIGS. 10, 11, and 12 show the steps for fabricating a single liquid crystal display element 20 and non-linear circuit element 22.

55 Referring to FIG. 5, a single crystal silicon layer 40 is affixed to a sapphire (Al_2O_3) substrate 30 to create a silicon-on-sapphire (SOS) wafer 32, where wafer 32 represents the various manufactured stages of the structure being 60 fabricated into liquid crystal display 20. One method for affixing silicon layer 40 to sapphire substrate 30 is by epitaxial deposition of a single crystal layer of silicon onto sapphire substrate 30. Epitaxial deposition of single crystal silicon layer 40 is achieved by thermal decomposition of silane onto sapphire substrate 30 in accordance with well known techniques. As shown in FIG. 3, a sapphire crystal has a rhombohedral structure with hexagonal symmetry along the c -axis. Due to the hexagonal symmetry, the sapphire crystal is often described using hexagonal coordi-

nates rather than the standard crystallographic Miller indices. Thus, the c-axis of sapphire is written as (0001). The crystalline structure of silicon and sapphire are not the same, therefore hetero-epitaxy of silicon on sapphire is not inherently plausible due to substantial crystalline, lattice and thermal expansion coefficient mismatch. However, thin films of single-crystal silicon have been fabricated on certain sapphire crystal planes that have a compatible, although not identical, crystal structure. Compatible crystal structures refer to a single crystal of a first material such as silicon that is capable of being formed on a single crystal of a second material such as sapphire. The r-plane of sapphire crystal and denoted by (1 $\bar{1}$ 02) is one type of crystal structure on which single crystal silicon may be grown. FIG. 4 schematically shows a top view of a (100)-oriented silicon layer 301 formed on a r-plane sapphire crystal 300. The silicon layer 301 has a lattice spacing of 5.43 Å that includes silicon atoms 310. The relative lattice spacing of r-plane sapphire crystal 300, containing aluminum atoms 310 shows a lattice spacing of 4.75 Å along the (11 $\bar{2}$ 0) direction and 5.20 Å along the (T101) direction. Therefore, there is a lattice mismatch of 4.2% along the (T101) direction and a lattice mismatch of 12.5% along the (11 $\bar{2}$ 0) direction. This lattice mismatch and the thermal expansion mismatch between sapphire crystal 300 and silicon crystal 301 lead to crystalline defects (twins and dislocations) in silicon layer 40 that detrimentally effect electronic device performance. The concentration of defects is much higher near the silicon/sapphire interface 34 and decreases in a direction into silicon layer 40, away from the silicon/sapphire interface 34. Thus, it is important to improve the quality of the silicon layer 40 in order to eliminate all or most of the defects in order to obtain a single crystal silicon layer or structure having optimized properties such as a low concentration of twin defects, threading dislocations, high charge carrier mobility, and longer carrier lifetime. An example of a process for improving the quality of the silicon layer 40 is known as solid phase epitaxial regrowth. Alternatively, single crystal silicon layer 40 may be made from a single crystal silicon structure that is bonded to sapphire substrate 30, as described in commonly assigned U.S. Pat. No. 5,441,591, incorporated herein by reference.

Silicon layer 40 then is ion implanted with ^{28}Si atoms (doses on the order of 10^{14} cm^{-2} at 185 keV) into the near interfacial region of the silicon-sapphire interface 34 while the temperature of wafer 32 is maintained at -20 degrees C. Ion implanting other isotopes species of silicon such as ^{29}Si and ^{30}Si may also be employed in the practice of the present invention. Species of substantially different masses such as ions or complexes of tin (Sn), germanium (Ge) or carbon (C) may also be used by appropriately varying the implant parameters.

Still referring to FIG. 5, after being ion-implanted, silicon layer 40, ergo wafer 32, is thermally soaked for about 30 minutes at 550° C., where after the temperature is ramped upwardly over the course of an hour from 550° C. to 900° C. Next, silicon layer 40 is thermally annealed at 900° C. in nitrogen for approximately one hour. A gradual anneal of silicon layer 40 allows the silicon layer 40 to regrow as a single crystal having minimal defects, and avoids subjecting the silicon layer 40 to thermal shock. Then silicon layer 40 is oxidized at 1000° C. in order for a portion of silicon layer 40 to transform into oxide. The oxide is subsequently etched to reduce the thickness of silicon layer 40. The oxidation and etch process of silicon layer 40 may be repeated as required until silicon layer 40 has a thickness generally in the range of about 30 to less than 100 nm. The thinned, single crystal silicon layer 40 offers substantial improvement in absorption

(i.e. increased brightness), resistance to heating, and parasitic photoexcited carriers compared to such properties of thicker silicon structures.

Referring next to FIG. 6, the single nonlinear circuit element 22, such as a MOSFET, is fabricated on the thinned and patterned silicon layer 40 using well known photolithographic techniques to create the self-aligned MOSFET structure 49. MOSFET structure 49 includes gate oxide 41, source region 42, drain region 44, channel region 45, gate electrode 46 and sidewall oxide 47, where source region 42, drain region 44, and channel region 45 are formed from patterned single crystal silicon layer 40. Source region 42 and drain region 44 are formed following the formation of gate electrode 46, and are therefore said to be self-aligned to the gate thereby reducing parasitic capacitance and improving the performance of the device and circuitry formed from such devices.

Referring to FIG. 7, the fabrication of pixel element 20, and particularly that of MOSFET structure 49 on wafer 32, continues by chemical vapor deposition (CVD) and selective etching of passivation oxide layer 50 onto wafer 32. After formation of passivation oxide layer 50, contact holes 55 are patterned in passivation oxide layer 50 to expose selected areas of source region 42, drain region 44 and gate region (via gate electrode 46).

As shown in FIG. 8, depositing and patterning interconnect metallization layer 62 onto wafer 32 to create contacts 60a, 60b, and 62a to source region 42, gate electrode 46, and drain region 44, respectively to provide wafer 32 with the structure. The interconnect metallization layer 62 may be fabricated using a multiple step process. For example, an aluminum alloy (99% Al:1% Si) may be deposited and patterned for all contacts including source contact 60a, gate contact 60b, and interconnections with silicon MOSFETs and related devices and circuits. A transparent conductive material such as indium tin oxide (ITO) may be subsequently deposited and patterned as a transparent drain contact 62a that also extends as a transparent nematic liquid crystal capacitor contact or electrode 62 for a nematic liquid crystal capacitor to be described, (the interconnect metallization also forms the output electrode from the MOSFET to pixel electrode 62). The transparent nematic liquid crystal capacitor electrode 62 may be employed when the display system 10 is used in a transmissive mode. However, for a reflective mode display or light-valve system, the nematic liquid crystal capacitor electrode may be an opaque metal (such as Al or 99% Al:1% Si) as this forms a back reflector for the system.

At this stage of the process, the monolithically integrated self-aligned circuitry, display drivers 14 and VLSI circuitry 16, including the non-linear circuit element 22 within the each pixel 20 are completely fabricated and may, if desired, be covered with additional passivation, shielding or polarization layers useful in certain applications. For example, such passivation may be desired in order to protect devices for subsequent processing of the wafer to provide a region on the sapphire substrate 30 for formation of the audio transducer 13. The process for forming the audio transducer 13 includes patterning the desired areas on the wafer for transducer 13 and forming electrical contacts to the transducer. These steps may be carried out within the process of forming the VLSI circuitry and incorporated in the lithographic mask design. Electrical interconnects to the audio transducer 13 may be done simultaneously with the electrical interconnections of the VLSI circuitry using techniques described above. If desired, audio transducer may be in the form of a membrane, and formed by selective etching of an underlying layer as practiced in the art of microelectromechanical devices to release the patterned transducer. For example, as shown in FIG. 9, a transparent substrate 70, e.g.

sapphire, quartz, fused silica or glass, may be covered with a transparent metallized counter electrode 72, and appropriately patterned. Counter electrode 72 is normally common for the entire array of pixels 20 of crystal display 12.

Referring to FIG. 10, wafer structure 32 now includes wafer subassemblies 51 and 53. Pixel 20 may be fabricated to provide a colored display by attachment of a suitably colored optical filter layer 73 to counter electrode 72. Next, alignment layer 80 then may be formed on filter layer 73 to pin one end of liquid crystal 82 to surface of alignment layer 80 to allow uniform rotation of the liquid crystal 82 when subjected to a voltage bias, therefore uniformly affecting the retardation of the polarized light that is transmitted through the liquid crystal capacitor 24. Formation of alignment layer 80 may be achieved by depositing a thin polyimide layer 80 on, inter alia, optical filter layer 73 and pixel electrode 62, which is subsequently mechanically rubbed to obtain a preferred orientation for the liquid crystal media.

A method for spacing each pixel electrode 62 from counter electrode 72 employs fiber glass spacer rods or beads 81 (FIG. 12) to form a cavity between structures 51, and 53 shown in FIG. 10. Spacer rods 81 normally lie at the periphery of wafer 32. Referring to FIGS. 11 and 12, final assembly of liquid crystal display 10 requires appropriately aligning and positioning substrate 30 with respect to substrate 70 so as to form a cavity 82 which is filled with a desired liquid crystal material 90 such as a nematic liquid crystal material or a ferroelectric crystal material. Cavity 82 is then hermetically sealed or plugged with flat closures 96.

Referring still to FIG. 12, affixing appropriately oriented polarizers 95 to transparent substrate 70 completes the fabrication of the liquid crystal display 10, which includes pixel elements 20 arranged in an array.

The circuit architecture described above is suitable for driving bistable ferroelectric liquid crystal (FLC) materials or nematic liquid crystals that have the requirement for stringent, low leakage in SOS circuits. In all embodiments, self-aligned circuitry is employed to reduce parasitic capacitances, thereby improving the performance and ease of fabrication of the display apparatus. The liquid crystal display may be formed on silicon-on-insulator, of which silicon-on-sapphire is an example.

We claim:

1. A liquid crystal display, comprising:
a sapphire substrate having a first crystal lattice structure;
a single crystal silicon structure disposed on said sapphire substrate to create a silicon-on-sapphire structure,
wherein said crystal silicon structure has a thickness no greater than about 100 nanometers, and
wherein said crystal silicon structure has a second crystal lattice structure oriented by said first crystal lattice structure;
a plurality of liquid crystal capacitors disposed on said silicon-on-sapphire structure; integrated self-aligned circuitry formed from said crystal silicon structure for modulating said liquid crystal capacitors such that said plurality of liquid crystal capacitors generate a video image; and
an audio transducer integrated on said silicon-on-sapphire structure for generating an audible signal.
2. The liquid crystal display of claim 1 wherein said audible signal is substantially synchronized with said video image.
3. The liquid crystal display of claim 1 wherein said sapphire substrate has an r-plane orientation and said single crystal silicon structure has a (100)-orientation.
4. The liquid crystal display of claim 1 wherein each of said liquid crystal capacitors is coupled to a transistor disposed on said silicon-on-sapphire structure.

5. The liquid crystal display of claim 1 wherein said liquid crystal capacitor provides a reflective pixel element.

6. The liquid crystal display of claim 1 wherein said liquid crystal capacitor provides a pixel element that is transmissible to light.

7. The liquid crystal display of claim 1 wherein said liquid crystal capacitors include nematic liquid crystal capacitors.

8. The liquid crystal display of claim 1 wherein said liquid crystal capacitors include ferroelectric liquid crystal capacitors.

9. A method of fabricating a monolithically integrated crystal array display and control circuitry on a silicon-on-sapphire structure, comprising the steps of:

- affixing a single crystal silicon structure to a sapphire substrate having a first crystal lattice structure to create a silicon-on-sapphire structure, wherein said crystal silicon structure has a thickness no greater than about 100 nanometers and a second crystal lattice structure oriented by said first crystal lattice structure;
- ion implanting said single crystal silicon structure with a species selected from the group consisting of: silicon ions, tin ions, germanium ions, and carbon ions to create an ion-implanted silicon layer;
- annealing said silicon-on-sapphire structure;
- oxidizing said ion-implanted silicon layer to form a silicon dioxide layer from a portion of said silicon layer so that a thinned, ion-implanted silicon layer remains;
- removing said silicon dioxide layer to expose said thinned ion-implanted silicon layer;
- fabricating transistors wherein each of said transistors is formed by patterning said thinned ion-implanted silicon layer to create a patterned silicon layer;
- growing a gate oxide on said patterned silicon layer;
- forming a polysilicon layer over said silicon-on-sapphire structure;
- doping said polysilicon layer;
- patterning said polysilicon layer and said gate oxide to form a gate region and to expose selected regions of said thinned, ion-implanted silicon layer;
- ion-implanting said selected regions of said silicon layer to create source and drain regions in said silicon layer that are self-aligned with said gate region;
- fabricating electrical contacts that are electrically connected to said transistors;
- monolithically fabricating an audio transducer on said silicon-on-sapphire structure; and
- fabricating liquid crystal capacitors on said silicon-on-sapphire structure that are electrically connected to said transistors by said electrical contacts.

10. The method of claim 9 wherein said sapphire substrate has an r-plane orientation and said single crystal silicon structure has a (100)-orientation.

11. The method of claim 9 wherein said transistors include nonlinear circuit elements.

12. The method of claim 9 wherein said liquid crystal capacitors include nematic liquid crystal capacitors.

13. The method of claim 9 wherein said liquid crystal capacitors include ferroelectric liquid crystal capacitors.

14. The method of claim 9 further including the step of fabricating polarizers on said silicon-on-sapphire structure.

15. The method of claim 9 further including the step of forming a layer of optical filters on said silicon-on-sapphire structure.

专利名称(译)	具有音频换能器的蓝宝石上硅显示器及其制造方法		
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摘要(译)

液晶显示器包括：a) 蓝宝石衬底;b) 设置在蓝宝石衬底上的单晶硅结构，以形成蓝宝石上硅结构;c) 设置在蓝宝石上硅结构上的多个液晶电容器;d) 由晶体硅结构形成的集成自对准电路，其中电路调制液晶电容器，从而产生视频图像;e) 设置在蓝宝石上硅结构上的集成音频换能器，用于产生可听信号。

