

Breadth of Hazards

Process:

At CNM2, you will work near a wide variety of concentrated hazardous chemicals. To keep safe, you must understand the potential hazards of these chemicals. You will not need to know how to work with every chemical, but you must be aware of their hazardous properties in order to work around them safely.

Materials:

CNM2 has many classes (types) of liquid chemicals: acids, bases, fluorides, organics (aka. solvents or fuels) and oxidizers. Using a chemicals name, you can tell which class (or classes) it will be:

Acids' names end in "Acid" .

Bases' names end in "Hydroxide".

Fluorides' names contain "Fluori-"; Names containing "Fluoro-" are not considered fluorides for this.

Organics' names end in "ane" "ene" "one" "ol" or "yde".

Oxidizers' names contain "Peroxide" or "Nitr-".

Common examples at CNM2 include: Acetic Acid, Ammonium Fluoride, Ammonium Hydroxide, Hydrochloric Acid (HCl), Hydrofluoric Acid (HF), Hydrogen Peroxide, Nitric Acid, Potassium Hydroxide, Phosphoric Acid, and Sulphuric Acid. When combined, the above materials can form the following common mixtures: Aqua Regia, BOE, HNA, PAN, Piranha, RCA1, RCA2, and SulphoNitric.

Almost every chemical and mixture looks like water, so you will need to handle unknown chemicals with enough care that you won't get hurt regardless of the possibilities.¹

Incompatible Materials:

Avoid mixing chemicals from different classes (or unknowns) because some mixtures will boil, make toxic gasses, or explode. Mixing compatible chemicals correctly³ creates little additional hazard.

Mixing acids and bases creates extreme heat and can splatter chemicals from floor to ceiling. Mixing oxidizers and organics can create explosive solids or highly flammable liquids. Mixing oxidizers with acids or bases often powerfully amplifies the oxidizer's reactivity and creates toxic gasses and explosives. Mixing organics with acids or bases occasionally makes 'condensate' gunk. Although there are hazards to mixing chemicals of different classes, these sorts of mixtures are still commonly made at CNM2. Almost all of the mixtures listed in the Materials section above contain at least two classes of chemical.

Hazards:

You will need to learn the possible exposure routes, time frame and symptoms of CNM2 hazards. Through the negligence of other lab members, you may be exposed to any of these at any time, so keep a watchful eye for trouble. Processes at CNM2 regularly use chemicals in volumes sufficient to kill. Key words are bolded or italicized, and will appear throughout this SOP and others.

Chemical hazards at CNM2 have three plausible routes: Inhalation, Contact and Explosion.

Inhalation hazards cause harm when breathed. Inhalation hazards primarily arise from materials that evaporate quickly (*high vapor pressure*), from the steam of boiling chemicals (*entraining*), and from plumes of mist (*aerosols*) created when mixing water into acids or bases. You will be able to smell any of CNM2's inhalation hazards before they reach hazardous levels, but some inhalation hazards can quickly anesthetize your nose so you can't smell (see Anesthetics below). No personal protective equipment (*PPE*) at CNM2 will protect you from inhalation hazards, so if you notice an inhalation hazard your only available safety is to hold your breath and leave the area¹. Working over plenums² will help prevent inhalation hazards from ever reaching you, like a fume hood would. Lastly, some CNM2 equipment uses large amounts of toxic gasses from cylinders, but these gasses are difficult to expose yourself to. Gas sensors monitor most of these gasses, and a dedicated gas alarm will sound when they detect a leak.

Contact hazards cause harm when touched or splashed by. The most common forms of contact are caused either from chemical *residues*, from being careless around unknown chemicals, or from splattering/mist caused when pouring and mixing chemicals¹. The hazardous residues left by chemicals can look like water, white crystals or even be invisible. Your mandatory white nitrile gloves will protect you from any invisible residues, but you can still burn yourself by touching a contaminated surface and then touching your face. In addition, to prevent spreading residues never touch common surfaces (doors, phones, etc.) while wearing heavy chemical gloves. Finally, some chemicals can soak through CNM2 provided PPE, often without marking the PPE in the process (*PPE Penetrators*). The PPE SOP¹ discusses habits to mitigate this risk, and discusses the few PPE penetrator hazards that cannot be avoided.

Explosions are rare but still a risk. They are typically caused by one of these three routes⁵:

1. Tightly capping spent oxidizers** bottled for disposal ('bottle pops')
2. Mixing organics into oxidizers**, or using the wrong plastic tweezers (like Delrin or Celcon) in oxidizers.
3. Opening several year old bottles of '*peroxide former*' organics. Notify CNM2 staff if you see such bottles.

** The most common oxidizers at CNM2 are Hydrogen Peroxide and Nitric Acid.

Chemical hazards at CNM2 have three plausible time frames: Acute, Chronic and Sensitizer^{1,5}.

Acute Hazards will hurt you immediately after exposure or up to a day later. Typically, they burn, but they can also poison. Acids, bases, oxidizers and fluorides all tend to exhibit acute hazards¹.

Chronic Hazards will harm you eventually, sometimes years after exposure. Though even small amounts can be harmful, the effect isn't bad enough to be noticeable until years after exposed, or until many small exposures have accumulated. Chronic hazards in massive doses often become acute hazards. Organics most often present chronic hazards.

Sensitizers will harm you only after repeated exposures (often over many years), and are harmless in the meantime. CNM2's Nitrile gloves are sensitizers, as are many organics¹.

Chemical hazards at CNM2 have many ways they can harm you. The common mechanisms are: Anesthetic, Carcinogenic, Corrosive, Paralyzing, Skin Penetrators, Toxic, and Teratogens.

Anesthetics remove your ability to feel or smell a chemical as it burns you, making them extremely dangerous. If your nose ever tingles from inhaling a chemical you may lose your sense of smell and should leave the area. If you notice 'water' on yourself and there's any possibility it's a fluoride (an anesthetic), treat it as such^{1,2}.

(Continued...)

(Cont.)

Carcinogenic hazards will greatly increase your likelihood of cancer. They tend to be chronic hazards and don't show symptoms until it's too late, making it very difficult to determine if you're being exposed. The best defense against carcinogenic materials is to consistently wear the right protective equipment¹ and to build careful working habits³⁵.

Corrosive hazards (aka Caustic in some cases) will burn your skin upon contact, often terribly. Corrosives are all acute hazards, so symptoms appear within 24 hours and often begin with a painful tingle or rash.

Paralyzing agents make it very difficult to breath and in extreme cases can cause cardiac arrest. They tend to be acute.

Skin Penetrators will quickly absorb into your skin and through your body. They aren't necessarily hazardous on their own, but this property massively amplifies other hazards. Also, anything dissolved in a skin penetrator will be able to diffuse into your body much more readily.

Toxic hazards (aka poisons) will disrupt one of your internal organs, inducing sickness.

Teratogens, or developmental toxins, will only harm you if you're pregnant or nursing, but don't otherwise have ill effect in adults. CNM2 commonly uses many extremely devastating teratogens, so if you're expecting or unsure, please ask for advice and ask a colleague or CNM2 staff to perform your teratogen chemistries.

CNM2 supplies many highly flammable liquids, often in squirt bottles.

Flammables will readily ignite by spark or flame. Because flammable organics are very common at CNM2 the only way to avoid fires is to avoid creating sparks and flames. To that end, avoid bringing in electric equipment unless you can verify it's spark free. Fortunately, the high airflow at CNM2 typically prevents flammable gasses from accumulating to explosive levels, especially over the plenums.

CNM2 also presents a few non-chemical hazards: UV light, laser light, extreme temperatures, and sharps.

UV Light is generated by various machines at CNM2, and can damage your eyes. For CNM2's UV sources you would need to look directly at the source or work around it for a couple minutes to become noticeably injured. All CNM2 UV sources also create a bright white, cool blue, or dim purple light while they are active. CNM2 provides eye protection for working around these tools. Users will also post signs around hazardous UV sources when activated.

Laser Light is also produced by various machines at CNM2, and can damage your eyes. Most lasers at CNM2 are low power and visible, which limits the likelihood of hazardous exposure.

Extreme Temperatures are present on samples coming out of furnace and anneal systems, and can be as high as 1000C. These temperatures will readily ignite tek wipes and solvents, and can burn you through metal tweezers. When working with these tools, you should wear thermal gloves provided by CNM2 and avoid flammable organics. Hotplates and ovens can also become quite hot (400C) and should be treated with similar care when used at these temperatures. Extreme cold (*cryogenic*) temperatures are present at CNM2 in certain pumps and tanks, but are nearly impossible to expose yourself to.

Sharps commonly include broken glassware, razor blades and syringes. Because these are so common at CNM2, sharps are a common source of minor injury. For more information see the Sharps SOP⁴.

Chemical Exposure Actions: Do what's below, and then notify CNM2 staff within a few hours. For advice, call CNM2 Staff.

Eyes: Hold eyes open in running eyewash station for 15 minutes and call 911 as soon as possible.

Skin (non-Fluoride Chemicals): Remove splashed clothing, wash for 15 minutes and seek medical aid if irritation persists.

Skin (Fluorides): Remove splashed clothing, wash for 3 minutes, apply Calcium Gluconate gel and call 911.

*Additional SOPs available, see: 1. PPE Choice and Cleaning 2. Work Station Use
5. Spent Chemical Management

3. Pouring and Mixing

4. Sharps

Personal Protective Equipment¹:

If approaching an unknown chemical, you need to wear protective equipment for any possibility. Wear goggles, a face shield, heavy chemical gloves (black Butyl/Viton)¹, and a heavy chemical apron. The outer layer of the black gloves will break down in some materials at CNM2, but the inner layer will protect you from any of these. Keep an attentive nose out for inhalation hazards, because no personal protective equipment at CNM2 will protect you from these.

Additional Process Notes:

Following is a selection of 8 common chemicals at CNM2, and the hazards they present. These were chosen from hundreds of chemicals at CNM2 to represent what you might come across in a typical day- they are not the most hazardous materials you might come across. For more information, most of the following chemicals (and many others) have dedicated SOPs already available at CNM2. Also, never forget that the CNM2 staff is happy to work with you for learning chemical awareness.

Sulphuric Acid (H_2SO_4) is an acid, an acute contact corrosive, and leaves persistent wet residues. In addition, it is a PPE penetrator when undiluted.

Hydrochloric Acid (HCl) is an acid, an acute contact corrosive, and an acute inhalation hazard.

Potassium Hydroxide (KOH) is a base, an acute contact corrosive, and leaves persistent crystalline residues.

Hydrofluoric Acid (HF) is an acid and a fluoride. It's a devastating acute contact toxin, an acute contact corrosive, a chronic contact toxin and an acute inhalation hazard. It's also a skin penetrator and an anesthetic. For its breadth of hazards and anesthetic properties, HF is one of the most dangerous chemicals at CNM2.

Tetramethylammonium Hydroxide (TMAH) is a base, a chronic carcinogen, and an acute paralyzing agent. At CNM2's concentrations, it's a mild contact corrosive.

Acetone is an organic, a skin penetrator, and a very mild chronic inhalation toxin. It is exceptionally acutely hazardous when it contacts the eyes, and exceptionally explosive when mixed with oxidizers³.

Dimethyl Sulphoxide (DMSO) is an organic, an exceptional skin penetrator, and a very mild chronic contact toxin. It is unfortunately a devastating teratogen.

Nitric Acid (HNO_3)³ is an acid and an oxidizer. It's an acute contact corrosive, an inhalation hazard and can explode when mixed with organics or when improperly stored for disposal.

*Additional SOPs available, see: 1. PPE Choice and Cleaning 2. Work Station Use
5. Spent Chemical Management

3. Pouring and Mixing

4. Sharps

Labeling Experiments or Bottles

Process:

Labeling chemicals to be left for 5 minutes or overnight.

Materials:

Chemicals in a bath, beaker or bottle

Incompatible Materials:

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Hazards, Exposure Actions and PPE:

Unlabeled chemicals are a constant risk for CNM2 staff, so please label your chemicals consistently. The highly toxic BOE is nearly indistinguishable from water without a label.

Acceptable Locations For Use:

Refer to chemical specific SOPs.

Additional Process Notes:

A good chemical label should include the following: The chemical name, and your name. If you plan on leaving the chemicals for more than 5 minutes, you should also include the date, your phone number (or email) and when you will return. If the chemical is particularly hazardous, make sure to represent this on your label. Though you can always use the full name of a chemical, you can also use a common acronym provided it's easily internet searchable or on our list of acronyms. Baths and beakers can be labeled with a nearby paper, tek wipe, or even directly on the beaker. Label baths and beakers accordingly:

NMP (Solvent)
Jane Doe 9/10/11
530-752-2241
I'm around the lab gathering supplies

Hydrofluoric, Acetic and Nitric Acids
(Very hazardous! Do not approach.)
Dirk Pitt Tue (May 5?)
530-752-2241
Overnight bath will clean up tomorrow (wed) morning.

Labels on bottles used for long-term chemical storage should include the above information minus your return time which is assumed to be one year after the present date.

Pouring and Mixing

Pouring

Materials:

Bottled chemicals, typically in the 1gallon plastic bottles provided by CNM2.

Incompatible Materials:

Refer to chemical specific SOPs.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. Pouring water into concentrated acid or bases will often cause splattering and fumes. Chemicals with vapor hazards are somewhat more hazardous as they are being poured. Pouring with the bottle's base out over your feet (instead of over the plenum) invites stray drips to splash on your poorly protected legs.

Acceptable Locations For Use:

Refer to chemical specific SOPs.

Additional Process Notes:

If your chemical bottle is nearly empty after pouring, discard the rest and rinse it clean¹.

Whenever possible, pour chemicals where you intend to use the bath. When pouring into a spent chemical bottle, put the bottle in a sink and use a funnel to help. To pour, use two hands to hold the bottle, typically one at the bottle's neck and the other at its base. To prevent splattering, try not to let the chemical glug out as you pour, instead pour slowly enough that the chemical comes out in one steady stream. Make certain the bottle's base hangs over the bench as you pour, and not over your feet. Should the bottle dribble and drip it is much better to drip on the bench than on your feet.

After pouring a photoresist, clean off the bottle's threads using tek wipes dampened with acetone. These tek wipes can typically be discarded in normal trash. After pouring a concentrated acid, base or oxidizer, cap the bottle and briefly rinse off the outside of the bottle with DI water to remove any hazardous material that dribbled down the side of the bottle while pouring. After rinsing, briefly dry the bottle so others don't mistake the wet bottle for a chemical leak. Alternatively, if careful inspection reveals that no chemical dripped on the bottle while pouring, you can skip rinsing.

*Additional SOPs available, see:

1. Spent Chemical Management

Mixing

Materials:

Chemicals to be mixed.

Incompatible Materials:

Refer to chemical specific SOPs. However, in general avoid mixing chemicals from these different classes: Oxidizers, Organics (reducers), Acids and Bases. Some mixtures will create heat, toxic gasses, or explosives.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. Mixing compatible chemicals correctly creates little additional hazard. Mixing acids and bases creates heat and can splatter chemicals from floor to ceiling. Mixing oxidizers and organics can form explosive solids or highly flammable liquids. Mixing oxidizers with acids or bases often powerfully amplifies the oxidizer's reactivity and creates toxic gasses and explosives. Mixing organics with acids or bases occasionally makes 'condensate' gunk. Many of these mixtures are dangerous, but still used in the cleanroom.

Acceptable Locations For Use:

Refer to chemical specific SOPs.

Additional Process Notes:

If your chemical bottle is nearly empty after pouring, discard the rest and rinse it clean¹.

Mixing Solids into liquids: To avoid clumping and promote dissolution, mix a small amount of liquid into the solid and stir vigorously; then pour the solution into the rest of the liquid and stir again.

Mixing liquids: When mixing concentrated (>10%) aqueous chemicals (such as acids, bases and oxidizers), always pour the more concentrated solution into the less concentrated one to avoid splattering. This common rule has two convenient mnemonics:

- 1) (AAA) Always Add Acid to water.
- 2) (Boston Accent) Do as you oughta add acid to watta.

Though we suggest you always follow this rule, some institutions instead suggest mixing less concentrated oxidizers into more concentrated acids. The concentrations of chemicals provided by CNM2 allow either order of mixing.

After pouring the liquids together, stir for about 20 seconds with an appropriate stir rod (Teflon is always acceptable). Mixing concentrated solutions takes longer than most people expect, especially when mixing water with 'oily' liquids, such as Potassium Hydroxide, Acetic Acid or Sulphuric Acid. Also, expect the solutions to exotherm (heat up) upon mixing.

Typically, no special rules need to be followed when mixing organics with organics.

*Additional SOPs available, see:

1. Spent Chemical Management

PPE Choice and Cleaning

PPE for Lab Entry

Materials:

CNM2 provided cleanroom nitrile gloves, CNM2 provided (or ANSI approved) safety glasses, and user provided closed toed shoes.

Incompatible Materials:

Refer to chemical specific SOPs. CNM2 provided cleanroom nitrile gloves are permeated by acetone, most resists, most strippers, some acids and a some bases. CNM2 provided safety glasses will permanently fog on contact with Acetone.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. When walking through the lab you will face several potentially dangerous but unlikely hazards. Grossly malfunctioning equipment can throw shrapnel, which is primarily hazardous to the eyes. Hazardous chemical residues left on common surfaces can cause rash and severe irritation on hands. Residual chemical droplets on processing benches can drip down, making the feet a vulnerable target. If you suspect your hand has been exposed to chemicals through your gloves, take especial care to wash under your fingernails when washing for 15 min.

Acceptable Locations For Use:

Standard PPE can be used anywhere and on any equipment in the lab. However, it will not be sufficient for working with most chemicals.

Additional Process Notes:

ANSI approved safety glasses provide protection from both flying shrapnel and spray solvents (like acetone) which can be very damaging to the eyes. When safety glasses become smudged, feel free to clean them using spray bottle Isopropanol and a Tekwipe. Wipe gently as the tekwipes can scuff most plastics. If you need to see around the safety glasses and conditions are safe, you may temporarily lift the glasses higher on your head. Removing the safety glasses completely often leads to forgetting to replace them. ANSI approved safety glasses or goggles must be worn at all times in the cleanroom, regardless of whether you already wear prescription eyewear. CNM2 provides ANSI approved safety glasses, though you can provide your own if desired.

White nitrile cleanroom gloves do not provide appreciable protection to most liquid chemicals, though they will provide protection to many hazardous residues throughout the lab. Keep in mind that your gloves may pick up hazardous residues while working, and avoid touching your face.

PPE for non-acutely hazardous Organics

Materials:

In addition to Lab entry requirements also wear black, inside-out Butyl/Viton gloves.

Incompatible Materials:

Refer to chemical specific SOPs and/or Ansell's glove choice guide from www.ansellpro.com. The black Butyl/Viton gloves have very few incompatibles and provide immersion protection against almost all chemicals provided by CNM2. However, some chemicals (aromatics, chlorosolvents, alkanes) will degrade the outer layer.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. Occasional, small splashes of CNM2's organics will cause relatively little harm, though small consistent (Chronic) exposures can vastly increase your likelihood of poisoning or cancer. Most of our solvents are not acute hazards, but can be potent carcinogens.

Acceptable Locations For Use:

Organics PPE can be used in any chemical bay and should never be used to press buttons on equipment for risk of spreading contaminants. However, if the PPE is clean you can use your knuckles to push buttons.

Additional Process Notes:

Wear the black Ansell Butyl/Viton gloves inside out, and rinse them off after use to keep them clean. These gloves are very expensive, so if you're working messily with photoresist, please wear disposable nitrile gloves over the black Viton/butyls. These gloves have two layers- when you correctly wear them inside out, the outer layer is butyl rubber, and the inner layer is Viton. This gives excellent resistance to most strippers, thinners and resist, as well as splash resistance to most other organics. On the off chance you instead want excellent resistance to aromatics (toluene), chlorosolvents or alkanes, you may flip the gloves right-side-in. However please make sure to thoroughly wash/scrub them, dry them, and flip them back inside out when you're done. These gloves naturally smell lightly of solvents.

Spray bottle solvents and resist spinners can splash and spray solvents which are hazardous to the eyes, so make sure to wear safety glasses or goggles when working with these.

CNM2 provided face masks will not protect you from vapors so use solvents in the well-ventilated solvent workstations.

PPE for acutely hazardous Acids, Bases, Oxidizers and Fluorides

Materials:

In addition to Lab entry requirements also wear blue Nitridex disposable gloves, a chemical apron and a face shield. Goggles are preferred to safety glasses for most applications.

Incompatible Materials:

Refer to chemical specific SOPs and/or Showa's glove choice guide from:

http://www.newpig.com/wcsstore/NewPigUSCatalogAssetStore/Attachment/documents/ccg/N-DEX_PLUS.pdf. The blue disposable Nitridex gloves provide immersion protection against most aqueous chemicals provided by CNM2. However, they will only provide splash protection to concentrated (>40%) Sulphuric or Acetic acid (or undiluted cocktails of these chemicals like Piranha). Also, many organics will readily permeate the blue gloves.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. In general, our acutely hazardous chemicals are hazardous enough to cause painful burns from just a drop, so you should exercise great care even when wearing the appropriate PPE. Your feet will be particularly vulnerable to drops, so you must wear closed toed shoes. If splashed with acutely hazardous chemicals, typically you should remove any contaminated clothing first, use a safety shower for 15 minutes and call 911.

Acceptable Locations For Use:

Acid/Base/Oxidizer/Flouride PPE can be used in any chemical bay, but should never be used to press buttons on equipment for risk of spreading contaminants. However, if the PPE is clean you can use your knuckles to push buttons.

Additional Process Notes:

The blue gloves are disposable- at the end of your work day, just rinse off your gloves and discard them in the normal trash. These gloves can stand several re-uses, but by consistently using new gloves you can help reduce the risk of re-using a holey glove, or tracking someone else's chemical residues around the lab. These gloves give minutes of resistance to most aqueous chemicals, but are only splash resistant to concentrated (>40%) Sulphuric acid and Acetic acid. If you need better resistance, let us know, and we can set you up with an alternative. These gloves are naturally a little tacky.

Vinyl aprons provide excellent protection to most chemicals at CNM2, though you should inspect them for residues before use. Also, if you remove a vinyl apron after wearing it for an extended period, the built-up sweat may make it feel like you've splashed your arms

The face masks are size-adjustable and cleanable with Isopropanol. We stock replacement windows, so please tell us when the windows become overly smudged.

PPE for photolithography

Materials:

In addition to Lab entry requirements you may opt to wear a second pair of white nitrile gloves instead of the standard black, inside-out Butyl/Viton gloves. This is called 'double gloving'.

Incompatible Materials:

Refer to chemical specific SOPs. Besides alcohols, almost all solvents can permeate the cleanroom standard Nitrile gloves. However two pairs will provide limited splash resistance to photoresist and acetone.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. Occasional, small splashes of photoresist will cause relatively little harm, though small consistent (Chronic) exposures can vastly increase your likelihood of poisoning or cancer. Keep in mind, acetone and photoresist will readily permeate the white gloves, so strip off your outer glove quickly (within 10 seconds) if you suspect you've been exposed. If you suspect your hand has been exposed, take especial care to wash under your fingernails when washing for 15 minutes.

Acceptable Locations For Use:

Double gloving can be used in any chemical bay, and can be used on equipment and buttons provided the gloves are kept clean.

Additional Process Notes:

For performing photolithography or develop, experienced lab members can opt to double glove with our standard thin white nitrile gloves. This provides additional dexterity, necessary for some projects. Check the hands of your gloves for photoresist contamination before touching anything outside the photolithography bay (like the phone or door handles). Both pairs of gloves should be discarded when exiting the cleanroom.

Sharps

Process:

Using and discarding sharps for standard cleanroom procedures. Cleaning broken glass and wafers.

Materials:

Razor blades, syringes, scalpels, chipped wafers, broken glassware and others.

Incompatible Materials:

When possible, try to avoid contaminating sharps with hazardous chemicals as it makes them more difficult to discard.

Hazards:

Many cleanroom sharps such as razor blades have extremely fine edges, which can create deep, clean, bloody cuts (incisions) on the hands. If sharps are contaminated with hazardous compounds (like photoresist), they can expose you to the material.

Exposure Actions: Do what's below, and then notify CNM2 staff within a few hours. For advice, call CNM2 Staff.

Eyes: Very rare due to mandatory shop glasses. Call 911. If sensible, apply gentle pressure with a trauma pad or gauze.

Skin: When possible grab another user to help you dress the wound in the gowning area, however when necessary you may dress your wounds in the cleanroom. Gauze and trauma pads are available in first aid kits located in the main office, gowning area, 1246 and the cleanroom safety stations. For deep cuts from a razor blade you can use the following advice:

If the cut lets a lot of blood, use gauze/trauma pad and gentle pressure to soak away blood, replacing the pads as needed. - If bleeding does not remit, call 911. - If bleeding continues very slightly, use a butterfly bandage to hold the cut closed, wrap the area with plenty of gauze and tape the gauze in place with slight pressure. Replace the gauze regularly. - If bleeding stops, apply antiseptic to a bandaid or the surrounding skin (do not apply antiseptic into a cut), and apply bandaid. Your cut will likely need stitches if the cut is deeper than a couple millimeters or bleeds for more than 5min. Your cut may be infected and will require medical attention if it becomes red, swollen, itchy, hot, rashed, smelly, oddly uncomfortable, red-lined, or discharges puss. Though tetanus is unlikely in a cleanroom, always defer to your doctor's advice.

Acceptable Locations For Use:

Sharps are common and allowed throughout the cleanroom².

Additional Process Notes:

When cutting with unmounted blades, always double check which side is the sharp side, and make sure your other hand is far away from the cut path in case of slips. When using syringes, beware their impressive ability to slash and cut. The edges of chipped wafers are sharp enough to cut, though rarely do when properly handled. Discard any used or broken sharps in the sharps bucket⁶. Except for shop glasses, none of the CNM2 PPE is designed to protect you from sharps. That said, heavy chemical gloves can somewhat reduce the risk of cuts from broken wafers and glass wear. When in doubt, ask the lab staff to help with handling broken glassware.

Spent Chemical Management

Process:

Once finished with a hazardous chemical, you will need to dispose of it by aspiration, decanting or bottling. Aspirate whenever possible! You will also need to rinse clean any empty or nearly empty chemical bottles. For hazardous solids, you can discard in the chemical bucket or sharps bucket.

Aspiration

(Suctioning away chemicals)

Materials:

Spent inorganic liquid chemicals like acids, bases and fluorides. Water for rinsing.

Incompatible Materials:

No organics like solvents, strippers, or the TMAH common in developers. No toxic “heavy” metals like Chrome or Aluminum ions. No concentrated Sulfuric Acid or concentrated Acetic Acid, though these are ok if diluted by more than 5 volumes of water.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOP. Aspiration creates little additional hazard.

Acceptable Locations For Use:

Wet process stations 3, 8, 9, acid & base fume hood².

Additional Process Notes:

Often the safest and most convenient option for chemical disposal, the aspirator is a plastic tube available at some benches that sucks chemicals to the neutralization system. If chemical is heated, allow it to cool beneath 45C⁴. Press the plenum² flush button to start the aspirator suction. Any material sucked into the aspirator will be flushed to CNM2’s neutralization system along with many volumes of water. Submerge the aspirator tube into the bath, and hold it there until bath’s contents have been removed as completely as possible. It is ok for the aspirator to ‘slurp’, though stop aspirating if you notice any splatter. At this point, rinse the bath with DI water and use the Aspirator to flush the water away- you may notice a puff of hazardous mist if too much chemical remained in the bath. Repeat water rinse and flush a few times, or until pH paper shows the bath to be clean. The aspirator is on a timer, so you may need to restart it by pushing the plenum² flush button again. Finally, give the bath a final rinse using a DI water gun over a sink to remove the last remnants of chemicals. To prevent spreading hazardous residues, always rinse off your gloves before leaving¹.

Decanting to Sink

(Pouring chemicals down the drain)

Materials:

Spent inorganic liquid chemicals like etchants or cleaners. Water for rinsing.

Incompatible Materials:

No organics like solvents, strippers, or the TMAH common in developers. No toxic “heavy” metals like Chrome or Aluminum ions. No toxic “heavy” metals like Chrome or Aluminum ions.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOP. Take special care to not fumble your bath when decanting.

Acceptable Locations For Use:

Wet process stations 3, 8, 9, acid & base fume hood².

Additional Process Notes:

If chemical is heated, allow it to cool beneath 45C⁴. Run the sink’s water for 15 seconds. Carefully pour³ the bath’s contents into the sink, while keeping your hands and face either protected or away from the sink in case of hazardous fumes¹. Run water down the sink for another 30 seconds to dilute the chemical as it flushes away. At this point, rinse your bath with DI water and pour it down the sink as well- you may notice a puff of hazardous mist if too much chemical remained on your bath. Repeat water rinse a few times, or until pH paper shows the bath to be clean. To prevent spreading hazardous residues, always rinse off your gloves before leaving¹.

Bottling

Materials:

Inorganic liquid chemicals like etchants or cleaners. Water for rinsing.

Incompatible Materials:

Any material can be bottled, though each individual bottle will have incompatibles³.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOP. Bottling chemicals into the wrong accumulation bottle can cause explosions, fires, and violent eruptions of toxic fumes. Please ask us when in doubt! Expect heating if mixing concentrated chemicals into a spent chemical accumulation bottle. Never tightly cap bottles of spent oxidizers, even though they may generate toxic fumes. Tightly capping oxidizers with an improper cap can cause pressurization and an explosion.

Acceptable Locations For Use:

Bring spent chemical bottle to wherever your bath is. Most sinks are convenient².

Additional Process Notes:

Take care to choose the proper spent chemical bottle for your process as choosing the wrong bottle can be deadly³. Your process' SOP will suggest the bottle in the Disposal section. You can also refer to the spent process materials flow chart for information on choosing the right bottle.

If your chemical is heated, allow it to cool beneath 45C⁴. Place spent chemical bottles into a convenient sink, and insert a funnel. Carefully pour bath into the funnel. If any chemical spills out, keep pouring and rinse off the bottle when done³. At this point, rinse the bath with more DI water and pour it down the sink- you may notice a puff of hazardous fumes if too much chemical remained in the bath. Repeat water rinse and pour a few times, or until pH paper shows the bath to be clean. Rinse out funnel similarly. To prevent spreading hazardous residues, always rinse off your gloves before leaving¹.

Never tightly cap spent oxidizer bottles, or any other bottle you suspect might generate gas. Instead, leave the cap $\frac{1}{4}$ to $\frac{1}{2}$ turn from tight.

*Additional SOPs available, see: 1. PPE Choice and Cleaning

2. Work Station Use

3. Pouring and Mixing

4. Hotplates

Following is a list of common materials and what bottles they go in. If your chemical doesn't appear here feel free to prompt CNM2 lab staff for advice. Acronyms can be found on CNM2's list of acronyms or with an internet search.

Aqueous Developers

MF-319 MFCD-26 AZ422

Flammables (important incompatibilities: no metal ions or organometallics)

PR Su8 developer Acetone IPA Methanol Toluene NMP DMSO PGMEA Chloroform Anisole
Solid metals (lift off)

Organometallics (important incompatibilities: no solid metals)

Metal Ions Organometallics Silanes Spin-on-glass most adhesion promoters

Normal Fluorides (important incompatibilities: no strong acids / oxidizers)*

Metal ions HF BOE/BHF NH₃F

Aggressive Fluorides*

Metal ions HNA (mixed NH₄F, HNO₃ and Acetic acid) H₂O₂ HF HNO₃

Acetic Bearing Fluorides*

Metal ions HNA (mixed NH₄F, HNO₃ and Acetic acid)

Fluoride Strong Acid and Oxidizers*

Metal ions H₂O₂ HF HNO₃

Ordinary Acids* (important incompatibilities: no HNO₃, oxidizers or fluorides)

Metal ions HCl H₂SO₄ H₃PO₄ Acetic acid (mixed in water, not Glacial)

Acetate Bearing Acids* (important incompatibilities: no fluorides)

Metal ions Acetic acid PAN

Transiently Oxidizing Acids* (important incompatibilities: no fluorides)

Metal ions Piranha RCA2 H₂O₂

Persistently Oxidizing Acids* (important incompatibilities: no fluorides)

Metal ions HNO₃ SulphoNitric AquaRegia PAN

Ordinary Alkalis* (important incompatibilities: no oxidizers or fluorides)

Metal ions KOH NH₃ IPA H₂O Protek PR

Oxidizing Alkalis* (important incompatibilities: no fluorides)

Metal ions RCA1

* Best to aspirate or decant to neutralizer rather than bottling whenever possible. Only necessary to bottle if solution contains heavy metal ions or other un-neutralizable toxics.

Discarding to Spent-Chem Bucket

Materials:

Solids wetted with organic chemicals.

Incompatible Materials:

No Acids, Bases or Oxidizers. No Sharps³.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOP. Spent-chem buckets create little additional hazard.

Acceptable Locations For Use:

Wet process stations 3, 8, 9, acid & base fume hood².

Additional Process Notes:

Put unwanted materials in the bucket, and seal the lid when done. Notify lab staff when the spent chem Bucket becomes full. Small amounts of dry photoresist are non-hazardous, so discard slightly used tekwipes in the normal trash.

Discarding to Sharps Bucket

Materials:

Sharp or shatter-able objects such as razor blades, glass, wafers, or syringe needles.

Incompatible Materials:

Avoid acids, bases or oxidizers, though tenth of a gram quantities are ok. Avoid organics, though gram quantities are ok.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOP. Sharps buckets create little additional hazard.

Acceptable Locations For Use:

Specially labeled five gallon buckets on the floor of the photolithography bays.

Additional Process Notes:

Open bucket and drop sharps in. Replace bucket lid when done. Notify lab staff when sharps bucket becomes full.

Bottle Rinsing

Materials:

Empty bottle with chemical residues to be cleaned.

Incompatible Materials:

Small bottles of resist will not easily rinse clean and should be discarded to the organics pass through or the spent-chem bucket.

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOP. Rinsing bottles creates little additional hazard. Concentrated acid bottles can create a small puff of fumes during the first rinse if insufficiently emptied.

Acceptable Locations For Use:

Any sink

Additional Process Notes:

If your chemical bottle is nearly empty after pouring from it, discard the rest of the chemical and rinse the bottle clean.

To clean a bottle, fill it partially with DI water, cap it tightly, shake it vigorously and then pour out the rinse water. Repeat 3-5 times. You can use pH strips to test the rinse water of acid and base bottles to help determine when you're done. After rinsing, remove the bottle's cap, cross out the bottle's label and re-label the bottle "Rinsed Clean" with a sharpie. Finally, you can find storage space for the rinsed clean bottle near the PPE storage.

Work Station Use and Cleaning

Process:

Using plenums (also called work stations or chemical benches) for various chemistries, and cleaning after use.

Materials:

Plenum tops and labware to be used and cleaned.

Incompatible Materials:

- none -

Hazards, Exposure Actions and PPE:

Refer to chemical specific SOPs. Cleaning a plenum or labware of a chemical does not introduce significant additional hazards. DI spray guns might splatter contaminated cleaning water back at you, so make sure to wear appropriate eye protection.

Acceptable Locations For Use:

Any plenum may be cleaned in this way

Additional Process Notes:

Each plenum comes equipped with a DI faucet for washing, a DI spray gun for rinsing, and Nitrogen gun for drying samples. Many plenums additionally come equipped with a sink, dump rinser, a solvent strip bath, sunken chemical baths, plenum flushes and cleanroom squeegees.

Plenums are made of a high density polypropylene immune to all CNM2 provided chemicals including aggressive acids, oxidizers and organics. So when you do spill or dribble chemicals onto the plenum, you can take your time to cautiously clean it. To clean a plenum, alternate between spraying the plenum with a DI water gun, and squeegeeing the rinse water down the holes in the front or back of the plenum. Water and small amounts of chemicals can be rinsed and squeegeed directly down the holes in the plenum top where they will flow to the sanitary sewer or CNM2's acid and base neutralizer depending on the location. When in doubt, four or five quick repetitions of spraying and squeegeeing will clear away most small spills or residues. For acids and bases, you can also use pH paper provided by CNM2 to check the pH of your rinse water.

To maximize your safety from chemical residues, rinse off your plenum as above before using it each time. If confronted with questionable solids or residues you can use CNM2 provided pH paper to determine the nature of the residue. For testing solid, dry samples, first wet the pH paper with DI water. For more information on pH paper and its uses, talk to CNM2 lab staff.

To rinse off samples, use the DI water gun and hold the sample with a pair of tweezers over the sink or even over the plenum top if you intend to squeegee away the rinse water later. You can alternatively use the inset dump rinsers to rinse large numbers of wafers clean all at once. Dump rinsers are controlled by an On/Off button on the front face of the plenum. CNM2 dump rinsers are programmed to rinse through three cycles when run.