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(54) **MULTI-CASSETTE CARRYING CASE**

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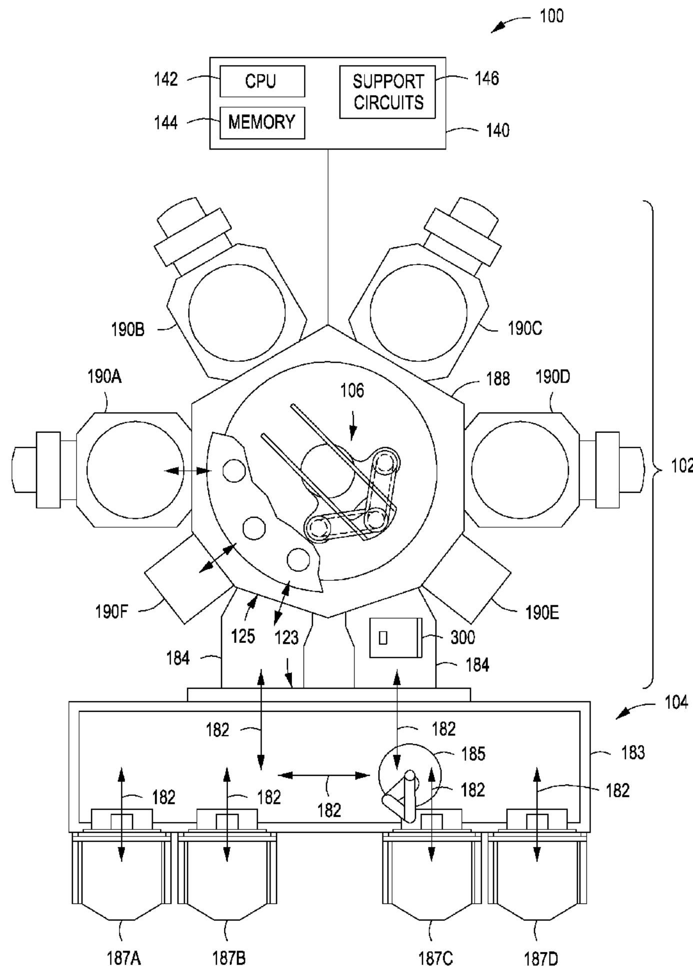
(57) **ABSTRACT**

Embodiments of multi-cassette carrying cases are provided herein. In some embodiments a multi-cassette carrying case includes: a body having an inner volume; a door coupled to the body to selectively seal off the inner volume; and a plurality of cassette holders disposed in the inner volume to hold one or more substrate cassettes. In some embodiments, a method of transferring substrates includes: placing a substrate in a substrate cassette, wherein an inner volume of the substrate cassette is sealed from an environment outside of the substrate cassette; and placing the substrate cassette in a multi-cassette carrying case.



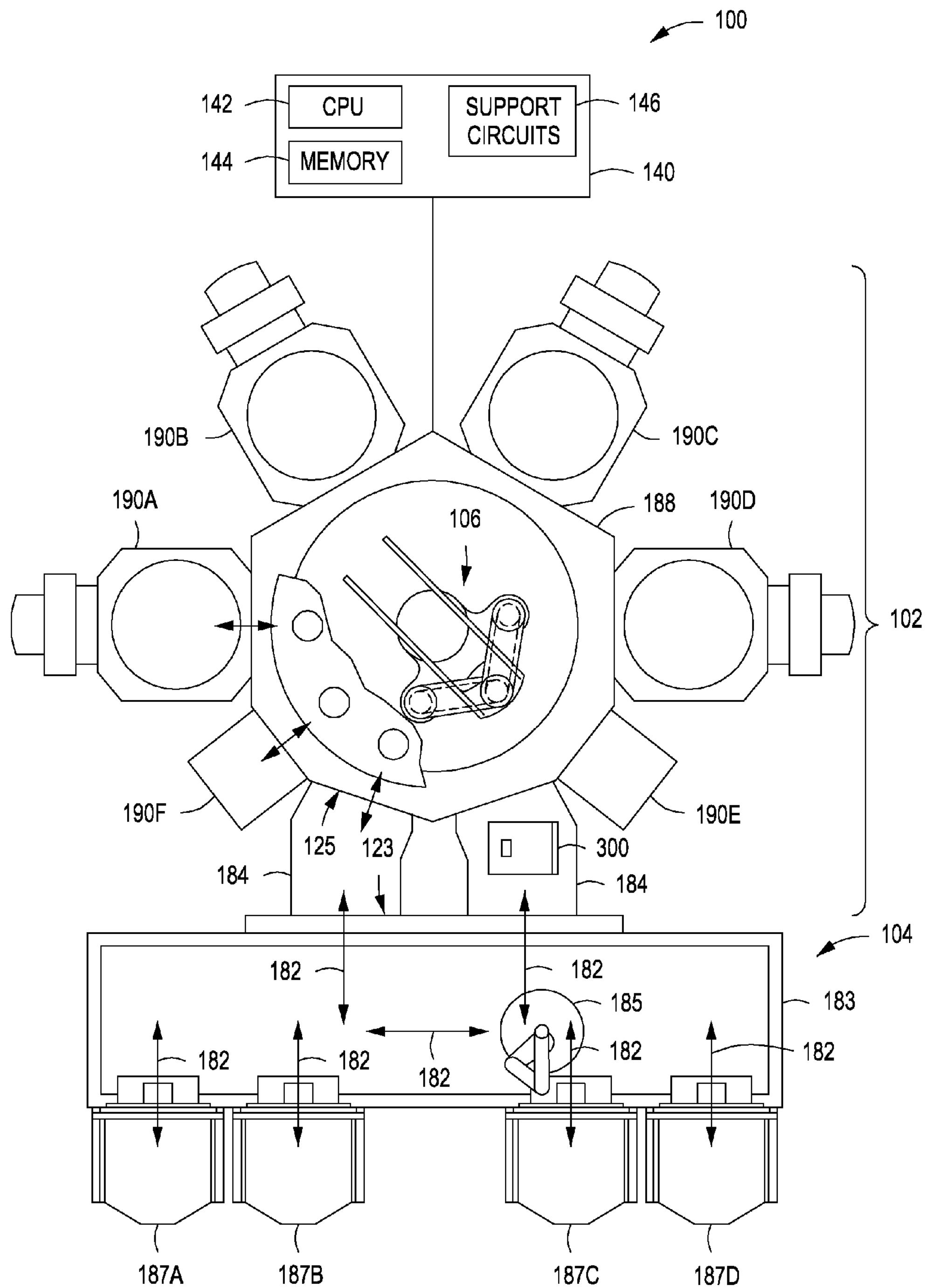


FIG. 1

FIG. 2

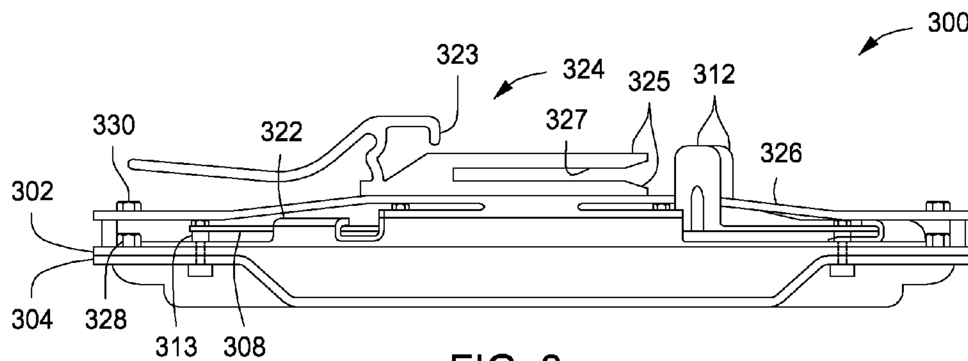


FIG. 3

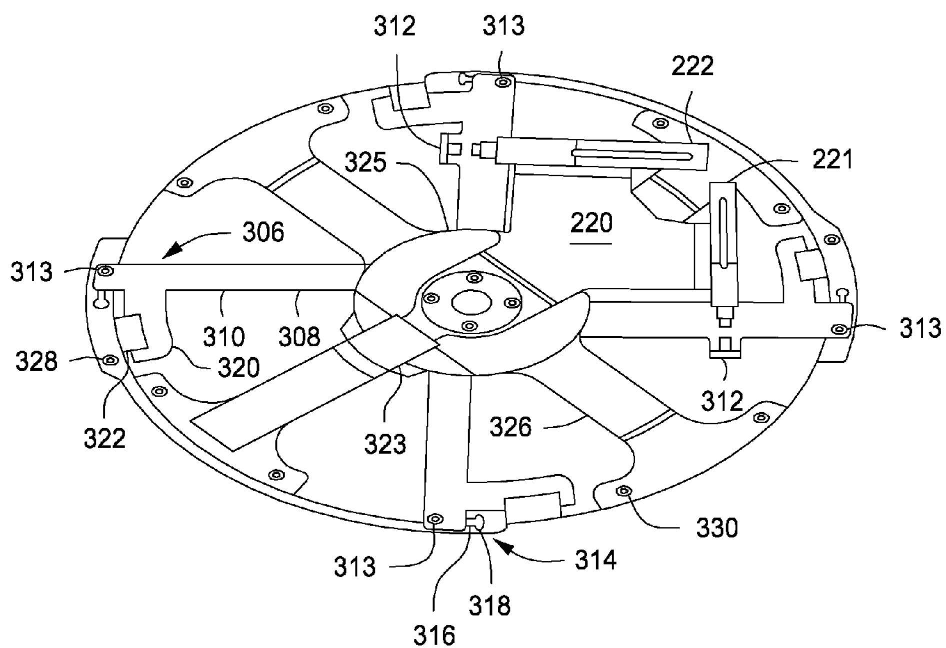


FIG. 4

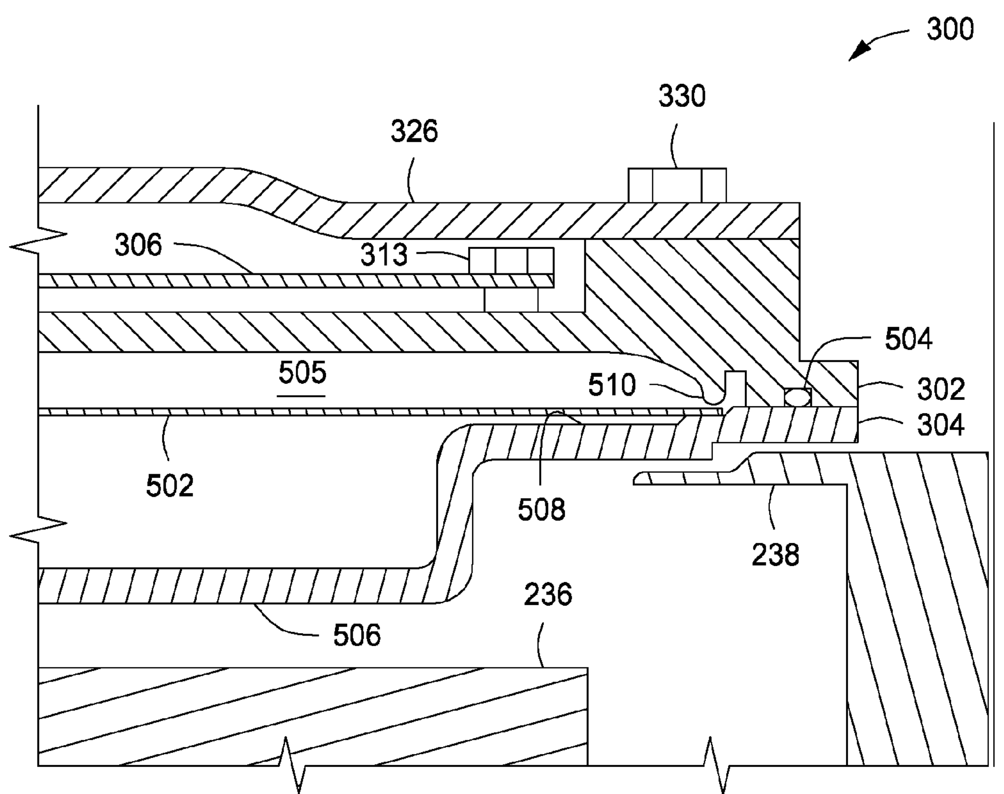


FIG. 5

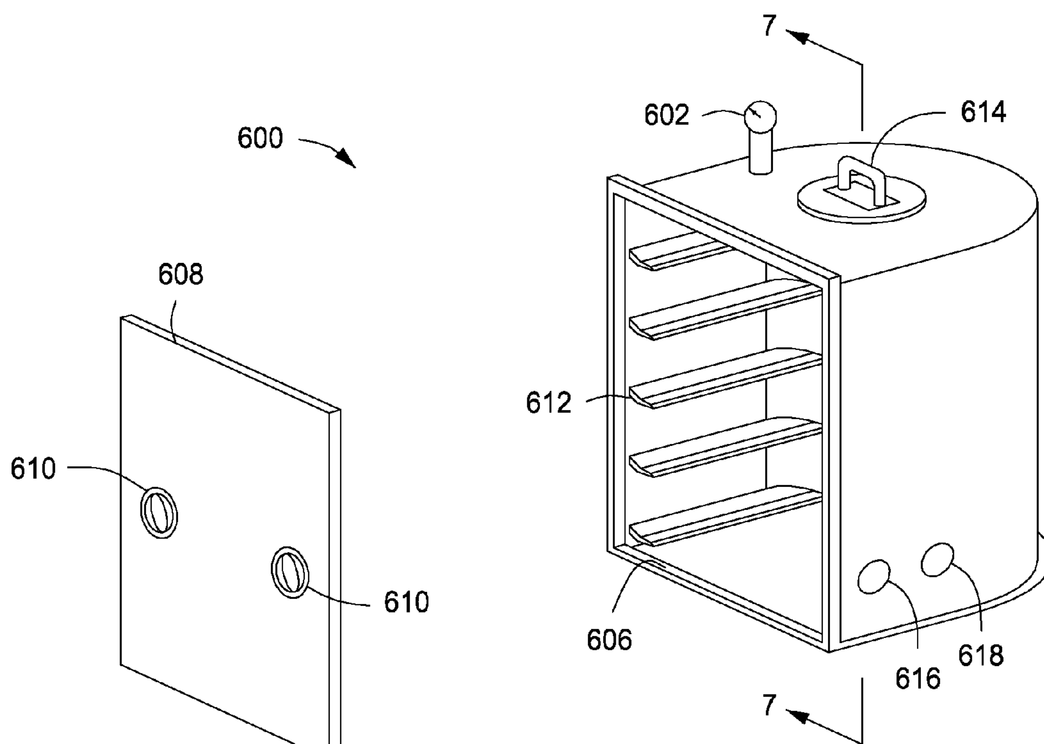


FIG. 6

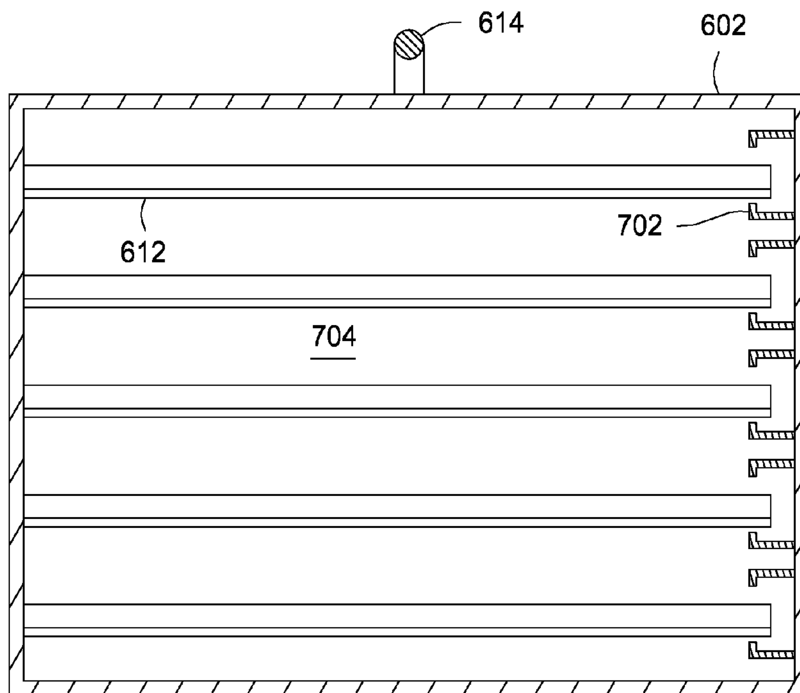


FIG. 7

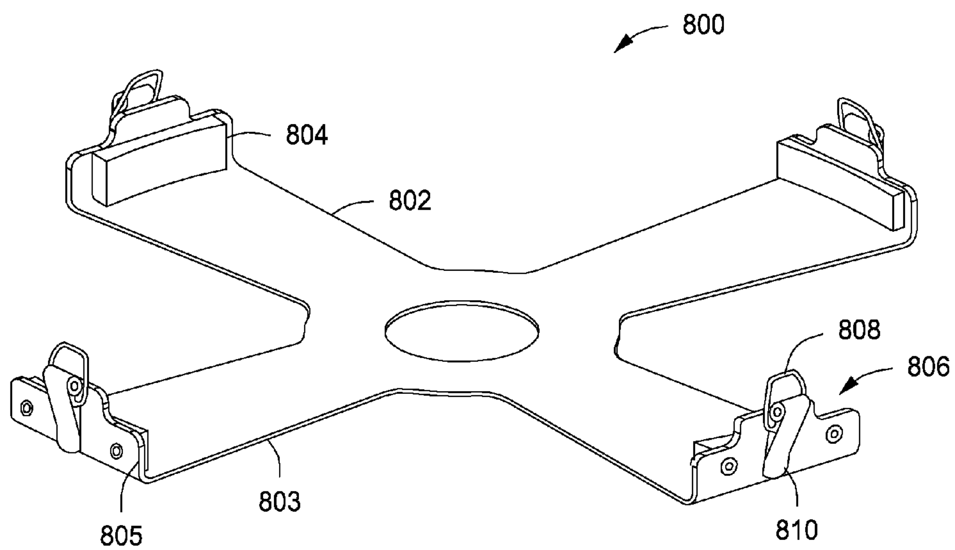


FIG. 8

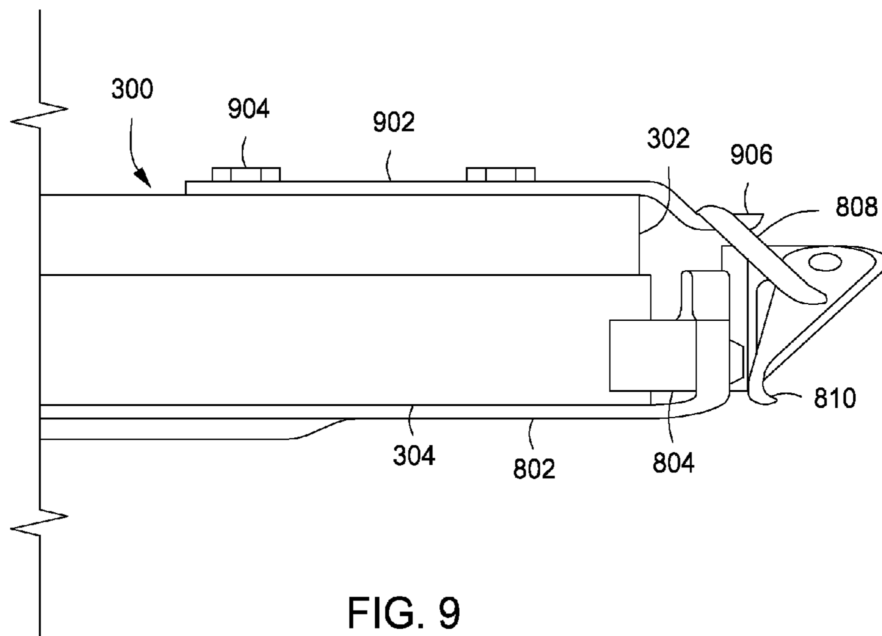


FIG. 9

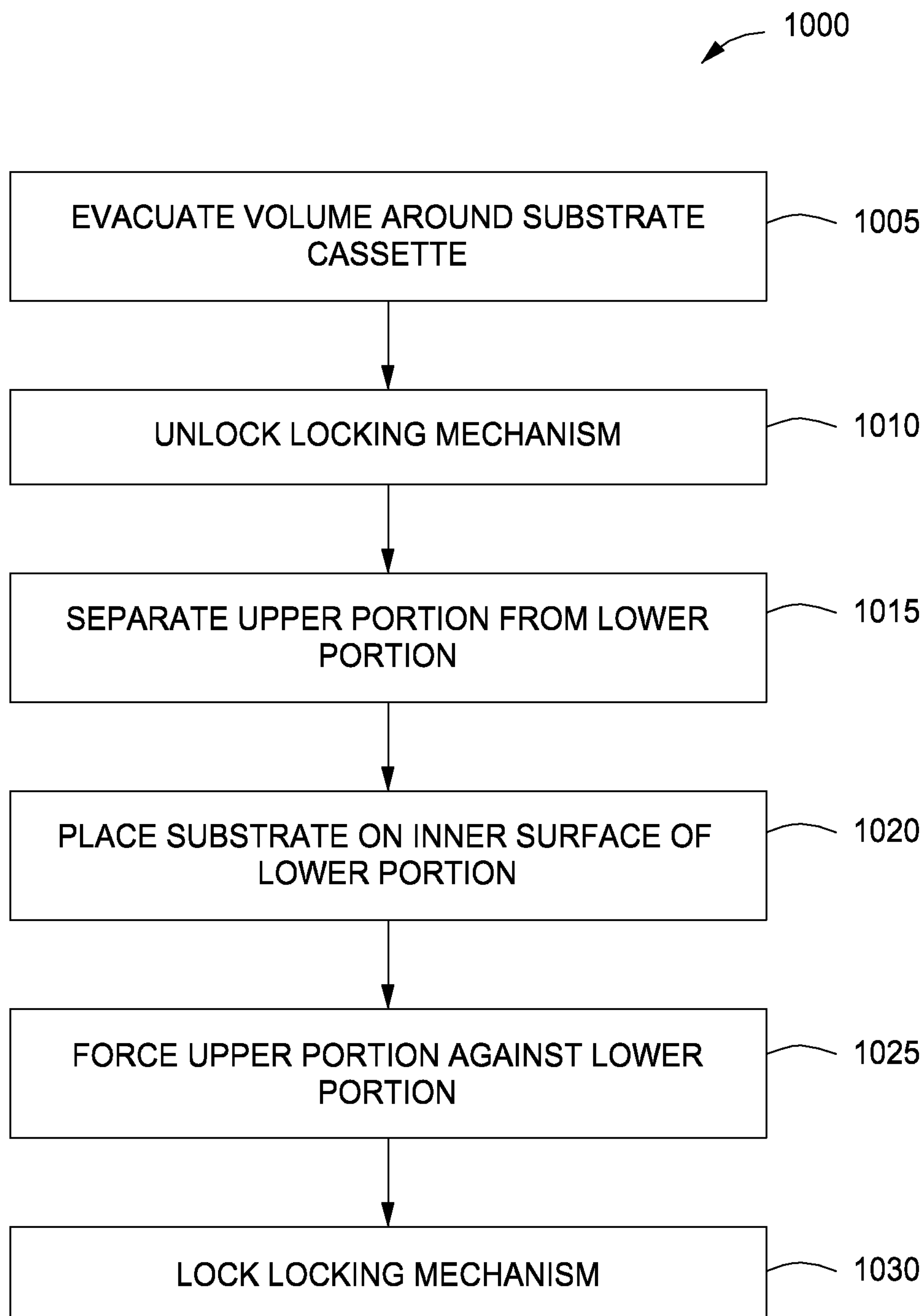


FIG. 10

MULTI-CASSETTE CARRYING CASE

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims benefit of U.S. provisional patent application Ser. No. 62/078,401, filed Nov. 11, 2014, which is herein incorporated by reference in its entirety.

FIELD

[0002] Embodiments of the present disclosure generally relate to substrate processing equipment, and more specifically, methods and apparatus for handling a substrate.

BACKGROUND

[0003] During processing of a substrate in for example, microelectronic device fabrication, the substrate may be transferred to multiple chambers to perform various processes. The substrate is in a vacuum during processing and at atmospheric pressure during transfer. Oxidation forms on the substrates upon leaving the vacuum environment and returning to atmospheric pressure. As such, the substrate undergoes a degas and/or preclean procedure to remove any oxidation prior to any further processing, resulting in processing delays.

[0004] Therefore, the inventors have provided improved methods and apparatus for substrate transfer.

SUMMARY

[0005] Embodiments of a multi-cassette carrying case are provided herein. In some embodiments, a multi-cassette carrying case includes a body having an inner volume; a door coupled to the body to selectively seal off the inner volume; and a plurality of cassette holders disposed in the inner volume to hold one or more substrate cassettes.

[0006] In some embodiments, a multi-cassette carrying case includes a body having an inner volume; a door coupled to the body to selectively seal off the inner volume; a plurality of ledges disposed on opposite sides of the inner volume; and a plurality of snap locks disposed in a rear portion of the inner volume, wherein the plurality of ledges and the plurality of snap locks are configured to hold one or more substrate cassettes.

[0007] In some embodiments, a method of transferring substrates includes: placing a substrate in a substrate cassette, wherein an inner volume of the substrate cassette is sealed from an environment outside of the substrate cassette; and placing the substrate cassette in a multi-cassette carrying case.

[0008] Other and further embodiments of the present disclosure are described below.

BRIEF DESCRIPTION OF THE DRAWINGS

[0009] Embodiments of the present disclosure, briefly summarized above and discussed in greater detail below, can be understood by reference to the illustrative embodiments of the disclosure depicted in the appended drawings. However, the appended drawings illustrate only typical embodiments of the disclosure and are therefore not to be considered limiting of scope, for the disclosure may admit to other equally effective embodiments.

[0010] FIG. **1** depicts a schematic view of a processing system having a substrate transfer apparatus in accordance with some embodiments of the present disclosure.

[0011] FIG. **2** depicts a cross-sectional view of a substrate transfer apparatus in accordance with some embodiments of the present disclosure.

[0012] FIG. **3** depicts a side view of a substrate cassette in accordance with some embodiments of the present disclosure.

[0013] FIG. **4** depicts a top view of a substrate cassette in accordance with some embodiments of the present disclosure.

[0014] FIG. **5** depicts a cross-sectional close up view of a substrate cassette in accordance with some embodiments of the present disclosure.

[0015] FIG. **6** depicts an isometric view of a multi-cassette carrying case in accordance with some embodiments of the present disclosure.

[0016] FIG. **7** depicts a cross-section view of the multi-cassette carrying case of FIG. **6**.

[0017] FIG. **8** depicts an isometric view of a cassette protector for use with the substrate cassette carrying apparatus of FIG. **6** in accordance with some embodiments of the present disclosure.

[0018] FIG. **9** depicts a close-up view of the cassette protector of FIG. **8**.

[0019] FIG. **10** is a flowchart illustrating a method of loading a substrate to be processed into a substrate cassette in accordance with some embodiments of the present disclosure.

[0020] To facilitate understanding, identical reference numerals have been used, where possible, to designate identical elements that are common to the figures. The figures are not drawn to scale and may be simplified for clarity. Elements and features of one embodiment may be beneficially incorporated in other embodiments without further recitation.

DETAILED DESCRIPTION

[0021] Embodiments of the present disclosure generally relate to methods and apparatus for transferring a substrate. Embodiments of the inventive apparatus may include a substrate transfer chamber that advantageously mounts directly to a load lock chamber of a substrate processing tool, thus minimizing any negative impact on the floor space occupied by the substrate processing tool and avoiding unnecessary and costly modification of existing processing systems. The inventive substrate cassette of the present disclosure advantageously allows for the transport of a substrate in a vacuum, thus avoiding any oxidation that may occur on the substrate when moving from a vacuum environment to atmosphere.

[0022] FIG. **1** is a schematic top-view diagram of an exemplary multi-chamber processing system **100** that may be suitable for use with the present inventive apparatus disclosed herein. Examples of suitable multi-chamber processing systems that may be suitably modified in accordance with the teachings provided herein include the ENDURA®, CENTURA®, and PRODUCER® processing systems or other suitable processing systems commercially available from Applied Materials, Inc., located in Santa Clara, Calif. Other processing systems (including those from other manufacturers) may be adapted to benefit from the present disclosure.

[0023] In some embodiments, the multi-chamber processing system **100** may generally comprise a vacuum-tight processing platform (processing platform **102**), a factory interface **104**, and a controller **140**. The processing platform **102** may include a plurality of process chambers **190**A-F and at least one load lock chamber **184** (two shown) that are coupled

to a transfer chamber **188**. A substrate transfer robot **106** (described below with respect to FIGS. **2** and **3**) is centrally disposed in the transfer chamber **188** to transfer substrates between the load lock chambers **184** and the process chambers **190**A-F. The process chambers **190**A-F may be configured to perform various functions including layer deposition including atomic layer deposition (ALD), chemical vapor deposition (CVD), physical vapor deposition (PVD), etch, pre-clean, de-gas, orientation and center-finding, annealing, and other substrate processes Each of the process chambers **190**A-F may include a slit valve or other selectively sealable opening to selectively fluidly couple the respective inner volumes of the process chambers **190**A-F to the inner volume of the transfer chamber **188**. Similarly, each load lock chamber **184** may include a port to selectively fluidly couple the respective inner volumes of the load lock chambers **184** to the inner volume of the transfer chamber **188**.

[0024] The factory interface **104** is coupled to the transfer chamber **188** via the load lock chambers **184**. In some embodiments, each of the load lock chambers **184** may include a first port **123** coupled to the factory interface **104** and a second port **125** coupled to the transfer chamber **188**. The load lock chambers **184** may be coupled to a pressure control system which pumps down and vents the load lock chambers **184** to facilitate passing the substrate between the vacuum environment of the transfer chamber **188** and the substantially ambient (e.g., atmospheric) environment of the factory interface **104**.

[0025] In some embodiments, the factory interface **104** comprises at least one docking station **183** and at least one factory interface robot **185** (one shown) to facilitate transfer of substrates from the factory interface **104** to the processing platform **102** for processing through the load lock chambers **184**. The docking station **183** is configured to accept one or more (four shown) front opening unified pods (FOUPs) **187**A-D. Optionally, one or more metrology stations (not shown) may be coupled to the factory interface **104** to facilitate measurement of the substrate from the FOUPs **187**A-D. The factory interface robot **185** disposed in the factory interface **104** is capable of linear and rotational movement (arrows **182**) to shuttle cassettes of substrates between the load lock chambers **184** and the one or more FOUPs **187**A-D.

[0026] In some embodiments, the inventive substrate transfer chamber **200** is disposed on a load lock chamber **184** to facilitate transfer of a substrate to or from the processing platform **102** while keeping the substrate in a vacuum atmosphere at all times. The processing platform, and the substrate transfer chamber, may be configured to process and handle substrates of varying sizes, including round wafers (e.g., semiconductor wafers) such as 150 mm, 200 mm, 300 mm, 450 mm, or the like.

[0027] FIG. **2** depicts a substrate transfer chamber **200** in accordance with some embodiments of the present disclosure. The substrate transfer chamber **200** includes a body **202** that defines an interior volume **204**. A bottom portion of the body **202** includes an opening **206** that fluidly couples the interior volume **204** with the load lock chamber **184**. The body **202** further includes a door **208** to allow access to the interior volume **204**. In order to facilitate coupling of the substrate transfer chamber **200** to the load lock chamber **184**, the substrate transfer chamber **200** may include an adapter plate **209** having an opening **203** aligned with the opening **206** to couple the interior volume **204** of the substrate transfer chamber **200** with an inner volume **205** of the load lock chamber **184**. The adapter plate **209** will very in dimension and configuration depending upon the structure of the load lock chamber **184** of the specific processing system, which advantageously minimizes the cost of retrofitting the substrate transfer chamber **200** to existing processing systems. The adapter plate **209** may be coupled to the substrate transfer chamber **200** and the load lock chamber **184** using a plurality of fasteners such as, for example, screws (not shown). The adapter plate **209** includes seals **211**, **213** (e.g., gaskets, or o-rings) at the interface with the substrate transfer chamber **200** and at the interface with the load lock chamber **184** to ensure a proper seal and avoid any vacuum leaks. Similarly, the door **208** also includes a seal **207** at the interface between the door and the body **202**. Because the substrate transfer chamber **200** is fluidly coupled to the load lock chamber **184**, a vacuum source **230** that evacuates the load lock chamber **184** also evacuates the substrate transfer chamber **200**.

[0028] The substrate transfer chamber **200** further includes a cassette support **210** to support a substrate cassette **300** (described below with respect to FIGS. **3** and **4**). In some embodiments, the cassette support **210** includes a collar **212** having protrusions **215** that extend from opposite sides of the collar **212** to engage a corresponding mounting apparatus **324** on the substrate cassette **300** and support the substrate cassette **300** in the interior volume **204**. However, the cassette support **210** may include any type of device capable of holding onto the substrate cassette **300**. The cassette support **210** further includes a shaft **214** coupling the collar **212** to a first end of an arm **216**. A lift actuator **218** is coupled to a second end of the arm **216** to raise and lower the cassette support **210** in the direction indicated by arrow **217**. The cassette support **210** may include any type of actuator capable of raising and lowering the cassette support **210**. In some embodiments, for example, the lift actuator **218** may be a linear actuator. The cassette support **210** further includes a locking device **220**, which may be coupled to the cassette support **210** between the collar **212** and the shaft **214**. The locking device **220** includes a first piston actuator **221** and a second piston actuator **222** on one side of the collar **212** and a protruding element **219** (e.g., a hook) at an opposite side. The first and second piston actuators **221**, **222** are described below together with the locking plate **308** of the substrate cassette **300**.

[0029] In some embodiments, the substrate transfer chamber **200** may optionally include a seal plate **250** having a shape corresponding to the lower surface of the substrate transfer chamber **200**. The seal plate **250** may be placed on the lower surface of the chamber to block the opening **206** to allow the multi-chamber processing system **100** and the load lock chamber **184** to function normally without use of the substrate transfer chamber **200**. The seal plate **250** may be secured to the lower surface via any conventional means such as, for example, screws or the like. A seal may be disposed between the seal plate **250** and the lower surface of the substrate transfer chamber **200** to prevent any vacuum leaks during normal operation of the load lock chamber **184**.

[0030] The load lock chamber **184** includes a first opening **232**, a second opening **234**, a pedestal **236**, and a lift hoop **238**. The first opening **232** facilitates interfacing with the docking station **183** to allow the factory interface robot **185** to insert or remove a substrate from the load lock chamber **184**. The second opening **234** facilitates interfacing with the processing platform **102** to allow the substrate transfer robot **106** to insert or remove a substrate from the load lock chamber **184**. As shown in FIG. **2**, the first and second openings **232**,

234 may be vertically offset so that the lift hoop is raised to receive/supply a substrate from/to the factory interface robot **185** and lowered to receive/supply a substrate from/to the substrate transfer robot **106**. A lift actuator **240** is coupled to the lift hoop **238** to raise or lower the lift hoop **238**.

[0031] FIG. **3** depicts a side view a substrate cassette **300** in accordance with some embodiments of the present disclosure. FIG. **4** depicts a top view of the substrate cassette **300** attached to the cassette support **210** of the substrate transfer chamber **200**. The substrate cassette **300** includes an upper portion **302** and a lower portion **304** which, when coupled, define an interior volume **505** (shown in FIG. **5**). The substrate cassette **300** also includes a locking mechanism **306**, which couples the upper portion **302** to the lower portion **304**, and a mounting apparatus **324** having prongs **325** and a latch **323**. The mounting apparatus **324** is shaped so that the protrusions **215** of the collar **212** are inserted into a space **327** between the prongs **325**, which rest on the protrusions **215** to support the substrate cassette **300**. As the substrate cassette **300** is moved further into the interior volume **204**, the protrusions **215** move further into the space **327** and the latch **323** approaches the protruding element **219**. The substrate cassette **300** is pushed until the latch **323** latches onto the protruding element **219**, thus locking the substrate cassette **300** in place and allowing the substrate cassette **300** to hang on the cassette support **210**.

[0032] The locking mechanism **306** may include a locking plate **308** disposed on the upper portion **302** and having a plurality of arms **310** extending from a center of the locking plate **308**. Two of the plurality of arms **310** include upwardly extending tabs **312** that are perpendicular to the locking plate **308**. A plurality of locking pins **313** extend through ends of the plurality of arms **310** and into a corresponding plurality of slots **314** formed in both the upper portion **302** and the lower portion **304**. Each of the plurality of locking pins **313** includes a reduced diameter midsection whose diameter is less than a width of each slot **314** to allow the locking pin **313** to slide along the slot **314**. Both ends of each locking pin **313** have a diameter that is greater than a width of the slot to prevent the locking pin **313** from passing through the slot **314**. Each of the plurality of slots **314** includes an elongated portion **316** and a hole **318** at one end of the elongated portion **316**. A thickness of the elongated portion **316** is less than a diameter of the hole **318**.

[0033] In a locked position (e.g., when the upper portion **302** and the lower portion **304** are coupled), each locking pin **313** extends through the elongated portion **316**. Because the ends of the locking pins **313** are too large to pass through the elongated portion **316**, the upper portion **302** and the lower portion **304** are sandwiched together between the enlarged ends. In an unlocked position, each locking pin **313** extends through the hole **318**. The ends of the locking pin **313** are sized to allow the locking pin **313** to pass through the holes **318**. When each locking pin **313** extends through the hole **318**, the upper and lower portions **302**, **304** can be separated. To ensure that the locking plate **308** remains coupled to the upper portion **302**, each of the plurality of arms **310** includes a protrusion **320** that extends beneath a corresponding tab **322** formed on the upper portion **302**. As shown in FIG. **4**, the protrusions **320** are substantially perpendicular to the arms **310**.

[0034] Referring to FIG. **4**, the locking device **220** includes a first piston actuator **221** and a second piston actuator **222** perpendicular to the first piston actuator **221**. The first and second piston actuators **221**, **222** are each disposed adjacent to one of the upwardly extending tabs **312** to push the upwardly extending tabs **312** and move the locking mechanism **306** in a first direction and a second direction opposite the first direction (e.g., between the locked and unlocked positions). In some embodiments, the first and second piston actuators **221**, **222** may be actuated using software.

[0035] In some embodiments, the upper portion **302** may include a load distribution plate **326** coupled to an upper surface of the upper portion **302** to evenly distribute a downwardly projecting force by the cassette support **210** pressing the upper portion **302** against the lower portion **304** for coupling. The load distribution plate **326** is coupled to the upper portion **302** via a plurality of fastening elements **330** (e.g., bolts, screws, or the like). In some embodiments, the upper portion **302** may further include a plurality of locating pins **328** to interface with a corresponding plurality of holes in the lower portion **304** to correctly align the upper and lower portions **302**, **304** during coupling.

[0036] FIG. **5** depicts a close up cross-sectional view of the substrate cassette **300** containing a substrate **502**. The substrate **502** rests on an inner surface **508** of the lower portion **304**. In some embodiments, the inner surface may be shaped so that the number of contact points between the substrate **502** and the inner surface **508** is minimal to prevent any damage to a backside of the substrate **502**. For example, the number of contact points may be limited to four contact points. In, some embodiments, the upper portion **302** may include an annular ring **510** proximate a periphery of the substrate **502** to limit or substantially eliminate any movement of the substrate **502** during transport. The upper and lower portions **302**, **304** may be formed of any material that will not damage the substrate **502**. For example, in some embodiments the upper and lower portions **302**, **304** are formed of polyether ether ketone (PEEK). The lower portion **304** may include a seal **504** (e.g., gasket, o-ring, or the like) around a periphery of the lower portion at the interface between the lower portion **304** and the upper portion **302**. The seal **504** prevents any vacuum leaks when the substrate cassette **300** is removed from the vacuum environment inside of the substrate transfer chamber **200**. The seal **504** is formed of a material that is non-sticky, vacuum-compatible material to ensure that the separation of the upper and lower portions **302**, **304** does not damage the seal **504**.

[0037] As shown in FIG. **5**, the lower portion **304** includes a recessed section **506** through which the substrate transfer robot **106** can extend to lift the substrate **502** after the upper portion **302** has been separated from the lower portion **304**.

[0038] In operation, the substrate cassette **300** is inserted onto the collar **212** of the substrate transfer chamber **200**. When the door **208** is closed, the vacuum source **230** coupled to the load lock chamber **184** evacuates the interior volume **204** and the inner volume **205**. The lift actuator **218** then lowers the substrate cassette **300** onto one of the lift hoop **238** (if the lift hoop **238** is raised) or the pedestal **236** (if the lift hoop **238** is lowered). If the substrate cassette **300** is lowered onto the raised lift hoop **238**, the lift hoop **238** is lowered until the substrate cassette **300** rests on the pedestal **236**. The locking device **220** is subsequently activated to rotate the locking mechanism **306** towards the unlocked position. Next, the lift actuator **218** lifts the upper portion **302** up, leaving the lower portion **304** resting on the pedestal **236**. A substrate **502** is either placed in or removed from the substrate cassette **300**. Subsequently, the lift actuator **218** lowers the upper portion **302** onto the lower portion **304** and forces the two portions together. The load distribution plate **326** ensures that the force is evenly distributed about the substrate cassette **300**. The locking device **220** then rotates the locking mechanism

towards the locked position, thus locking the upper and lower portions **302**, **304** together. After the interior volume **204** and the inner volume **205** return to atmosphere, the lift actuator **218** lifts the substrate cassette **300** back up into the substrate transfer chamber **200** for removal.

[0039] FIGS. **6** and **7** depict a multi-cassette carrying case **600** in accordance with some embodiments of the present disclosure. The multi-cassette carrying case **600** includes a body **602** that defines an inner volume **704** and has an opening **606**. At least one handle **614** may be disposed on an outer surface of the body **602** to enable carrying of the multi-cassette carrying case **600**. The multi-cassette carrying case **600** further includes a door **608** that is placed in the opening **606** to seal off the inner volume **704**. Although in FIG. **6** the door **608** is shown as fully detachable, the door **608** may alternatively be attached to a side of the body **602** via a hinge assembly. The door **608** includes locking mechanisms **610** that facilitate locking the door **608** in the opening **606**. The locking mechanisms **610** may include any locking mechanisms suitable to fix the door **608** shut.

[0040] The multi-cassette carrying case **600** further includes a plurality of cassette holders to hold one or more substrate cassettes **300**. The cassette holders include a plurality of ledges **612** on opposite sides of the inner volume **704** to support one or more substrate cassettes **300**. To ensure that the substrate cassettes **300** do not move during transport, the plurality of cassette holders may further include a plurality of snap locks **702** disposed at a rear portion of the inner volume **704**. To place a substrate cassette **300** in the multi-cassette carrying case **600**, the substrate cassette **300** is placed on a set of ledges **612** and pushed towards the corresponding snap lock **702**. When the substrate cassette **300** contacts the snap lock **702**, the substrate cassette **300** is pushed further so that the snap lock **702** deforms outwardly and subsequently latches onto the substrate cassette **300**, thus locking the substrate cassette **300** in place.

[0041] In some embodiments, the multi-cassette carrying case **600** may include a vacuum port **616** and a vent port **618** to allow coupling of the multi-cassette carrying case to a vacuum source. In embodiments in which the inner volume **704** of the multi-cassette carrying case **600** is evacuated, the door **608** may include a seal around the periphery of the door to prevent any vacuum leaks during transport. In some embodiments, the multi-cassette carrying case **600** may also include a pressure monitoring device **620** to monitor and display a pressure of the inner volume **704**. Alternatively or in combination, the vacuum port **616**, vent port **618**, or another port (not shown), may be coupled to a gas source, for example an inert gas source, to provide an inert gas to the interior of the multi-cassette carrying case.

[0042] FIGS. **8** and **9** depict a cassette protector **800** in accordance with some embodiments of the disclosure. In some embodiments, the cassette protector **800** may be used in combination with the multi-cassette carrying case **600** to provide added protection to the substrate cassette **300**. The cassette protector **800** includes a plate **802** having a plurality of arms **803**. Each of the plurality of arms **803** includes an upwardly projecting edge **805**. A plurality of bumpers **804** are respectively disposed on inner surfaces of the upwardly projecting edges **805**. The distance from a first bumper **804** to a second bumper **804** disposed across from the first bumper **804** is approximately equal to a diameter of the substrate cassette **300**. Each of the projecting edges **805** includes a latching apparatus **806** having a latch **808** and a latch handle **810** to secure the cassette protector to a substrate cassette.

[0043] Referring to FIG. **9**, a plurality of latch plates **902** corresponding to the plurality of arms **803** are coupled to the upper portion **302** of the substrate cassette **300** via fixation elements **904**. The latch plate **902** includes a hook **906** which, when the substrate cassette **300** is placed in the cassette protector **800**, is disposed adjacent the latch **808**. To engage the latch **808**, the latch handle **810** is lifted, the latch **808** is placed on the hook **906**, and the latch handle **810** is pushed down again, thus coupling the cassette protector **800** to the substrate cassette **300**.

[0044] FIG. **10** is a flowchart illustrating a method **1000** of loading a substrate **502** to be processed into a substrate cassette **300** in accordance with some embodiments of the present disclosure. At **1005**, a volume (interior volume **204**) in which the substrate cassette **300** is disposed is evacuated. At **1010**, a locking mechanism **306** of the substrate cassette **300** is unlocked to uncouple an upper portion **302** from a lower portion **304** of the substrate cassette **300**. At **1015**, the upper portion **302** is separated from the lower portion **304**. At **1020**, the substrate **502** is placed on an inner surface **508** of the lower portion **304**. At **1025**, the upper portion **302** is forced against the lower portion **304**. At **1030**, the locking mechanism **306** is locked to couple the upper portion **302** to the lower portion **304**. Thus, the substrate may be disposed in the substrate cassette **300** in a vacuum environment while located outside of the vacuum processing tool.

[0045] Returning to FIG. **1**, the controller **140** may be provided and coupled to various components of the multi-chamber processing system **100** to control the operation of the multi-chamber processing system **100**. The controller **140** includes a central processing unit (CPU) **142**, a memory **144**, and support circuits **146**. The controller **140** may control the multi-chamber processing system **100** directly, or via computers (or controllers) associated with particular process chamber and/or support system components. The controller **140** may be any form of general-purpose computer processor that can be used in an industrial setting for controlling various chambers and sub-processors. The memory, or computer readable medium, **144** of the controller **140** may be one or more of readily available memory such as random access memory (RAM), read only memory (ROM), floppy disk, hard disk, optical storage media (e.g., compact disc or digital video disc), flash drive, or any other form of digital storage, local or remote. The support circuits **146** are coupled to the CPU **142** for supporting the processor in a conventional manner. These circuits include cache, power supplies, clock circuits, input/output circuitry and subsystems, and the like. Inventive methods as described herein, such as the method **1000**, may be stored in the memory **144** as software routine that may be executed or invoked to control the operation of the multi-chamber processing system **100** in the manner described herein. The software routine may also be stored and/or executed by a second CPU (not shown) that is remotely located from the hardware being controlled by the CPU **142**.

[0046] While the foregoing is directed to embodiments of the present disclosure, other and further embodiments of the disclosure may be devised without departing from the basic scope thereof.

1. A multi-cassette carrying case; comprising:

a body having an inner volume;

a door coupled to the body to selectively seal off the inner volume; and

a plurality of cassette holders disposed in the inner volume to hold one or more substrate cassettes.

2. The multi-cassette carrying case of claim **1**, wherein the plurality of cassette holders comprises:

a plurality of ledges disposed on opposite sides of the inner volume; and

a plurality of snap locks disposed in a rear portion of the inner volume, wherein the plurality of ledges and the plurality of snap locks cooperate to hold substrate cassettes when disposed in respective ones of the plurality of cassette holders.

3. The multi-cassette carrying case of claim **1**, further comprising:

a vacuum port to couple a vacuum source to the multi-cassette carrying case to evacuate the inner volume.

4. The multi-cassette carrying case of claim **1**, further comprising:

a pressure monitoring device to monitor and display a pressure of the inner volume.

5. The multi-cassette carrying case of claim **1**, further comprising:

at least one handle disposed on an outer surface of the body to facilitate carrying of the multi-cassette carrying case.

6. The multi-cassette carrying case of claim **1**, further comprising:

a cassette protector to protect a substrate cassette when disposed in a one of the plurality of cassette holders.

7. The multi-cassette carrying case of claim **1**, further comprising:

a plurality of cassette protectors to protect substrate cassettes when disposed in the plurality of cassette holders, wherein each cassette protector comprises:

a plate having a plurality of arms each having an upwardly projecting edge;

a bumper disposed on an inner surface of the upwardly projecting edge to protect a substrate cassette;

a plurality of latch plates coupled to an upper portion of the substrate cassette; and

a latching apparatus disposed on an outer surface of the upwardly projecting edge to couple the plate to the substrate cassette.

8. The multi-cassette carrying case of claim **7**, wherein the latching apparatus includes a latch configured to latch onto one of the plurality of latch plates.

9. The multi-cassette carrying case of claim **7**, wherein a distance from one from a first bumper to a second bumper disposed across from the first bumper is equal to a diameter of the substrate cassette.

10. The multi-cassette carrying case of claim **1**, wherein the plurality of cassette holders comprises a plurality of ledges disposed on opposite sides of the inner volume, and a plurality of snap locks disposed in a rear portion of the inner volume, wherein the plurality of ledges and the plurality of snap locks cooperate to hold substrate cassettes when disposed in respective ones of the plurality of cassette holders, and further comprising:

a plurality of cassette protectors to protect substrate cassettes when disposed in respective ones of the plurality of cassette holders.

11. The multi-cassette carrying case of claim **1**, further comprising:

a plurality of cassette protectors to protect substrate cassettes when disposed in respective ones of the plurality of cassette holders;

a vacuum port to couple a vacuum source to the multi-cassette carrying case to evacuate the inner volume;

a pressure monitoring device to monitor and display a pressure of the inner volume; and

at least one handle disposed on an outer surface of the body to facilitate carrying of the multi-cassette carrying case.

12. A multi-cassette carrying case; comprising:

a body having an inner volume;

a door coupled to the body to selectively seal off the inner volume;

a plurality of ledges disposed on opposite sides of the inner volume; and

a plurality of snap locks disposed in a rear portion of the inner volume, wherein the plurality of ledges and the plurality of snap locks are configured to hold one or more substrate cassettes.

13. The multi-cassette carrying case of claim **12**, further comprising:

a vacuum port to couple a vacuum source to the multi-cassette carrying case to evacuate the inner volume.

14. The multi-cassette carrying case of claim **12**, further comprising:

a pressure monitoring device to monitor and display a pressure of the inner volume.

15. The multi-cassette carrying case of claim **12**, further comprising:

at least one handle disposed on an outer surface of the body to facilitate carrying of the multi-cassette carrying case.

16. The multi-cassette carrying case of claim **12**, further comprising:

one or more cassette protectors, each of the one or more cassette protectors comprising:

a plate having a plurality of arms each having an upwardly projecting edge;

a bumper disposed on an inner surface of the upwardly projecting edge to protect a substrate cassette;

a plurality of latch plates coupled to an upper portion of the substrate cassette; and

a latching apparatus disposed on an outer surface of the upwardly projecting edge to couple the plate to the substrate cassette.

17. The multi-cassette carrying case of claim **16**, wherein the latching apparatus includes a latch configured to latch onto one of the plurality of latch plates.

18. The multi-cassette carrying case of claim **16**, wherein a distance from one from a first bumper to a second bumper disposed across from the first bumper is equal to a diameter of the substrate cassette.

19. A method of transferring substrates, comprising:

placing a substrate in a substrate cassette, wherein an inner volume of the substrate cassette is sealed from an environment outside of the substrate cassette; and

placing the substrate cassette in a multi-cassette carrying case.

20. The method of claim **19**, further comprising:

placing a plurality of substrate cassettes in the multi-cassette carrying case.

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