

**Full Integration and Reliability Evaluation of Phase-change RAM  
Based on 0.24 $\mu$ m-CMOS Technologies**

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We have fully integrated a nonvolatile random access memory by successfully incorporating a reversibly phase-changeable chalcogenide memory element with MOS transistor. As well as basic characteristics of the memory operation, we have also observed reliable performances of the device on hot temperature operation, endurance against repetitive phase transition, writing imprint, reading disturbance and data retention.