

**LIGHT EXTRACTION FILMS
FOR ORGANIC LIGHT EMITTING DEVICES (OLEDs)**

FIELD OF THE INVENTION

This invention relates generally to optical films having structured surfaces tailored to couple light out of solid state self-emissive lighting devices to increase the brightness thereof, with particular application to self-emissive lighting devices known as organic light emitting devices (OLEDs) (sometimes also referred to as organic light emitting diodes). The invention also pertains to related articles, systems, and methods.

BACKGROUND

A wide variety of OLEDs are known. Some OLEDs, referred to as “bottom emitting” OLEDs, emit light through a transparent substrate on which the OLED is fabricated. Others, referred to as “top emitting” OLEDs, emit light in the opposite direction, that is, away from the substrate on which the OLED is fabricated. Some OLEDs are patterned to form an array of individually addressable OLED emitters, referred to individually as pixels (picture elements) or subpixels (one of several neighboring emitters of different colors that are grouped together as a pixel but are individually addressable). Such pixelated OLEDs are becoming increasingly popular for use in digital display devices such as for mobile phones and similar end uses. In contrast to pixelated OLEDs, other OLEDs are designed to have only one emitting area, which may be small and narrow or large and extended depending on the intended application.

One issue of concern to some OLED manufacturers and designers is the less-than-ideal efficiencies exhibited by OLEDs due to peculiarities of their design. The external efficiency of an OLED, or of any other self-emissive light source, can be calculated as the power of all optical radiation emitted by the device divided by the total electrical power consumed by the device. OLED external efficiency is a significant design parameter for many different OLED applications, ranging for example from pixelated OLEDs used in high-resolution displays to non-pixelated OLEDs used in lighting systems, since the external efficiency affects such device characteristics as power consumption, luminance, and lifetime. A number of groups have demonstrated that OLED external efficiency is significantly limited by optical losses within the active emitting layers of the OLED stack itself (due to waveguiding modes within high refractive index organic layers and indium tin oxide), within intermediate-refractive index substrates, and finally due to exciton quenching at the cathode (anode) metal's surface plasmon polaritons. In an OLED device that exhibits the maximum possible *internal* efficiency (that is, 100% internal efficiency), about 75-

80% of the generated optical radiation is dissipated internally due to the above-mentioned losses, resulting in a corresponding reduction in external efficiency. If additional optical components such as color filters or circular polarizers are included as elements of the OLED device, such components can produce additional optical losses and even lower external efficiencies.

Some optical films have already been proposed to enhance light extraction from OLED devices. Reference in this regard is made to U.S. Patent Application Publications US 2009/0015142 (Potts et al.), US 2009/0015757 (Potts et al.), and US 2010/0110551 (Lamansky et al.).

BRIEF SUMMARY

We have developed a new family of optical films that can be used in combination with OLEDs and other self-emissive light sources to extract light from such devices so as to increase the emitted light and reduce losses. The disclosed optical extraction films are particularly effective in combination with various types of OLEDs. Some of the disclosed extraction films are designed to enhance light extraction by reducing the amount of light lost to waveguiding modes. Some of the extraction films are designed to enhance light extraction by reducing the amount of light that is totally internally reflected at an outermost surface or boundary of the OLED. Some of the extraction films are designed to enhance light extraction by reducing both of these types of loss mechanisms.

The disclosed optical films are useful for enhancing light extraction from self-emissive light sources such as bottom-emitting or top-emitting OLEDs. The extraction films typically include a flexible carrier film, and a first and second layer carried by the carrier film. The first or second layer may have a nanovoiced morphology and may include a polymer binder, and may also have a refractive index less than 1.35 or 1.3. An embedded structured surface of light extraction elements is formed between the first and second layers. The light extraction elements may be primarily diffractive elements adapted to be disposed within an evanescent zone of the OLED, or they may be primarily refractive elements, which may be disposed outside the evanescent zone. The extraction film may also include a third layer, and a second embedded structured surface may be formed between the third layer and the first layer.

The present application also discloses, *inter alia*, optical extraction films that includes a flexible carrier film, and a first and second layer carried by the carrier film. The first and second layers define therebetween a first embedded interface, which forms a first structured surface of first light extraction elements. The first layer has a nanovoiced morphology and comprises a polymer binder, the first layer also preferably having a refractive index less than 1.35. The second layer has a refractive index greater than that of the first layer.

In some cases, the first layer may have a refractive index less than 1.3. In some cases, the second layer may have a refractive index greater than 1.4. In some cases, a refractive index difference between the first and second layers is at least 0.3, or at least 0.4, or at least 0.5. In some cases, the first layer may be disposed between the carrier film and the second layer. In some cases, the first light extraction elements are small enough, and the second layer is thin enough, so that a substantial portion of the extraction elements are disposed within an evanescent zone of the self-emissive light source when the extraction film is combined with the self-emissive light source. In some cases, the first light extraction elements may comprise diffractive elements. In some cases, the first light extraction elements may have a pitch of less than 1 micrometer. In some cases, the first light extraction elements may have a pitch of greater than 1 micrometer. In some cases, the first light extraction elements may comprise refractive elements. In some embodiments, the first light extraction elements may have associated therewith a land, and the land may have a thickness of less than 50 microns. In some cases, the land thickness may be less than 25 microns. In other cases, the first light extraction elements may have no land. In some cases, the second layer may comprise a light transmissive viscoelastic material. In some cases, the film may further include a release liner covering a major surface of the second layer opposite the first structured surface.

In some cases, the extraction film may be adapted for application to the self-emissive light source which is fabricated separately from the extraction film. In some cases, the extraction film may be adapted as a substrate on which the self-emissive light source can be fabricated. In some cases, the carrier film may have physical characteristics making it suitable as a free-standing support film in roll-to-roll processing. In some cases, neither the first layer nor the second layer may have physical characteristics making it suitable as a free-standing support film in roll-to-roll processing.

In some cases, the extraction film may further include a third layer carried by the carrier film, the first and third layers defining therebetween a second embedded interface, and the second embedded interface may form a second structured surface of second light extraction elements. In some cases, the first light extraction elements may have a pitch less than 1 micron, and the second light extraction elements may have a pitch greater than 1 micron. In some cases, a substantial portion of the first light extraction elements may be adapted to be disposed within an evanescent zone of the self-emissive light source when the extraction film is combined with the self-emissive light source. In some cases, the second light extraction elements may have associated therewith a land, and the land may have a thickness of less than 50 microns. In some cases, the land thickness may be less than 25 microns. In some cases, the self-emissive light source may comprise an OLED. In some cases, the extraction film may be combined with the self-emissive light source,

and the first and second layers may be disposed between the flexible carrier film and the self-emissive light source.

We also disclose devices that include an OLED and an optical extraction film attached to the OLED. The optical extraction film may include a flexible carrier film and a first and second layer carried by the carrier film, the first and second layers defining therebetween a first embedded interface that forms a first structured surface of first light extraction elements. The first layer may have a nanovoiced morphology and comprise a polymer binder, and may also have a refractive index less than 1.35. The second layer may also have a refractive index greater than that of the first layer, and may be disposed between the first layer and the OLED. In some cases, a high refractive index region is associated with the OLED, the high refractive index region including at least one organic light generating layer and at least one transparent electrode layer, and a substantial portion of the first light extraction elements may be disposed within an evanescent zone of the high refractive index region. In some cases, the at least one transparent electrode layer may be part of the optical extraction film. In some cases, the first light extraction elements may include refractive elements and have a pitch of greater than 1 micron. In some cases, the first light extraction elements may have associated therewith a land, and the land may have a thickness of less than 50 microns. In some cases, the land may have a thickness of less than 25 microns.

Related methods, systems, and articles are also discussed.

These and other aspects of the present application will be apparent from the detailed description below. In no event, however, should the above summaries be construed as limitations on the claimed subject matter, which subject matter is defined solely by the attached claims, as may be amended during prosecution.

BRIEF DESCRIPTION OF DRAWINGS

FIG. 1 is a schematic side or cross-sectional view of generalized OLED light source;

FIG. 2 is a schematic diagram of an illustrative process of forming a backfilled nanovoiced microstructured article;

FIG. 3 is a schematic side elevational view of a portion of a nanovoiced microstructured layer;

FIG. 3a is a schematic cross-sectional view of a portion of an interface between a first nanovoiced layer and a second layer, demonstrating interpenetration of the second layer with the first layer;

FIGS. 4a-4c are schematic side or cross-sectional views of optical extraction films that can be used with top-emitting OLEDs;

FIG. 5a is a schematic side or cross-sectional view which shows how any of three different optical extraction films can be applied to a top-emitting OLED;

FIG. 5b is a schematic side or cross-sectional view which shows how a particular optical extraction film can be applied to a top-emitting OLED;

5 FIG. 5c is a schematic side or cross-sectional view of an optical device in which a top-emitting OLED has been combined with a particular optical extraction film;

FIGS. 6a-6c are schematic side or cross-sectional views optical extraction films that can be used with bottom-emitting OLEDs;

10 FIG. 7a is a schematic side or cross-sectional view which shows how any of three different optical extraction films can be used as substrates on which a bottom-emitting OLED can be formed;

FIG. 7b is a schematic side or cross-sectional view of an optical device in which a bottom-emitting OLED has been formed on a particular optical extraction film;

FIG. 8 is a schematic top view of a representative pixelated OLED device;

15 FIG. 9a is a schematic side or cross-sectional view of a device that results from an ordinary optical extraction film being applied to a pixelated top-emitting OLED;

FIG. 9b is a schematic side or cross-sectional view of a device that results from an optical extraction film as disclosed herein being applied to the pixelated top-emitting OLED.

20 FIG. 10a is an illustration that shows how an arc of circle can be defined, and FIG. 10b is an illustration that shows how that defined arc can be used to define a three-dimensional bullet-like shape useable as an extraction element, and FIG. 10c is a micrograph showing a top view of a fabricated material having a structured surface comprising an array of such extraction elements;

FIG. 11a is a graph that compares the actual measured color variation of a particular top-emitting OLED with the calculated color variation of a modeled device in which an optical
25 extraction film is applied to that same OLED;

FIGS. 11b and 11c are graphs similar to that of FIG. 11a but for modeled devices in which different optical extraction films are applied to the OLED;

FIG. 12 is an SEM photograph showing a perspective view of a structured surface cut into a copper substrate;

30 FIG. 13a is a graph that compares the total gain of an OLED device made with an optical extraction film as disclosed herein with that of two other OLED devices; and

FIG. 13b is a graph that compares the on-axis gain of that OLED device made with the optical extraction film as disclosed herein (see FIG. 9a) with that of the two other OLED devices;

In the figures, like reference numerals designate like elements.

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DETAILED DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

FIG. 1 depicts in an oversimplified schematic fashion a portion of one embodiment of an OLED **100**. The OLED **100**, which may be either a bottom-emitting or a top-emitting OLED, includes a thin emitting region **110** sandwiched between two optically thick layers **112**, **114**. The layers **112**, **114** may serve as barrier layers to keep water vapor and oxygen away from the emitting region **110**, and one of the layers **112**, **114** may serve as a substrate upon which the other components of the OLED **100** are grown, deposited, or laminated. In alternative embodiments one of the thick layers **112**, **114** may be omitted or replaced with an inert gas or vacuum. The emitting region **110** may include one or more conventional organic layers tailored to emit light of a desired wavelength in response to an applied electric current or field. The applied electric current may be supplied by electrodes whose major surfaces may coincide with the outer surfaces **110a**, **110b** of the emitting region. At least one electrode, for example, the one disposed at surface **110a**, is transparent. The electrodes and organic emitting layer(s) are typically made of materials whose refractive indices are substantially greater than about 1.5. For example, a transparent electrode made of indium tin oxide (ITO) has a refractive index of about 1.8, and typical light-emissive organic materials may have a refractive index in a range from 1.6 to 1.8. Besides having a relatively high refractive index, the emitting region is also typically very thin, for example, on the order of a wavelength of visible light or less. For example, an ITO electrode layer may have a thickness on the order of about 150 nm, and an emissive organic layer may have a thickness on the order of about 100 nm, although of course other thicknesses may be used.

In contrast to the emitting region, the layers **112**, **114** are not only optically thick, that is, have thicknesses substantially greater than a wavelength of visible light, but they also have refractive indices that are less than those of the emitting region **110**. For example, the layers **112**, **114** may comprise glass or plastic whose refractive index is on the order of 1.5. As a result, the thin emitting region **110** can trap some of the light emitted by the organic material in one or more waveguiding modes, depicted generally in FIG. 1 as a waveguiding electromagnetic field **116**. When electric current is applied to energize the organic material in the emitting region **110**, light is emitted in all directions. Some of this light, represented by light rays **115**, propagates in directions that allow the light to refract into the layer **112** or **114** and escape the emitting region **110**.

Another portion of the emitted light becomes trapped in the high refractive index region **110**, propagating along that region as one or more waveguiding modes represented by field **116**. The field **116** typically has a field strength that decays exponentially as a function of distance from the boundaries or surfaces **110a**, **110b**, the details of the decay depending on factors such as the refractive index difference between the region **110** and the adjacent optically thick layer **112** or **114**, as well as the particular waveguiding mode if more than one mode is supported. The

exponentially decaying portion of the field **116** outside of the region **110** is referred to as an evanescent wave. In most practical cases, the evanescent wave can be considered to be present within only a very short distance of the emitting region **110**, for example, in a boundary region of layer **112** or **114** adjacent the corresponding outer surface of region **110** and whose thickness may
5 be on the order of a wavelength of visible light, for example, on the order of 1 micrometer or less, or may be somewhat greater if the optically thick layer has a refractive index that is closer to that of the high refractive index region.

Of the light **115** that escapes the emitting region **110**, some of that light travels along directions that deviate from the thickness axis or optical axis of the OLED **110** by angles that are
10 small enough so that the light is refracted out of the layer **112**. Such light is thus able to escape the OLED **100** into the surrounding air medium (note that the “air” medium of FIG. 1 may refer to any one of standard atmospheric air, or vacuum, or a suitable inert gas) and eventually reach an observer **120** or other optical component. Light rays **115a** and **115b** are exemplary of this escaping light. Ray **115a** strikes the air interface at outer surface **112a** at an angle θ_1 , which angle
15 is small enough so that the light is refracted out of the OLED device and into the surrounding air medium. Ray **115b** strikes the air interface at an angle θ_2 , which is greater than θ_1 and close to the critical angle for layer **112** but still slightly smaller than the critical angle, such that the refracted light exits into the surrounding air medium at a near-glancing angle. If we follow this progression to light ray **115c**, we see that some of the light **115** that escapes the emitting region **110** travels
20 along directions that deviate from the thickness or optical axis of the OLED **100** by angles that are too large to be refracted out of the layer **112**. Thus, light ray **115c** strikes the air interface at an angle θ_3 that is greater than the critical angle for layer **112**, thus causing the ray **115c** to be totally internally reflected at the surface **112** and trapped within the OLED **100**.

We thus see that light can be trapped within the OLED device **100** in one of two ways: in
25 a waveguiding mode associated with emitting region **110**, and by total internal reflection (TIR) at an air interface **112a** of the device. In both cases, the trapped light is typically eventually absorbed, and results in reduced brightness, reduced efficiency, and increased losses for the OLED **100**. We refer to losses associated with light trapped in the emitting region as waveguide losses, and losses associated with light trapped by TIR at the outer surface of the OLED as substrate
30 losses. Further discussion of loss mechanisms in OLEDs can be found in Lu et al., “Optimization of external coupling and light emission in organic light-emitting devices: modeling and experiment”, 91 J. Appl. Phys. (Jan. 15, 2002), pp. 595-604.

Nanovoided Layers

Exemplary optical extraction films disclosed herein incorporate at least one nanovoided layer. The nanovoided layer may include a plurality of interconnected voids or a network of voids dispersed in a binder. At least some of the voids in the plurality or network are connected to one another via hollow tunnels or hollow tunnel-like passages. The voids preferably occupy a sufficiently large fraction of the volume of the layer, but are individually of a small enough size, so that the nanovoided layer behaves optically like a material of very low refractive index, for example, less than 1.35 or less than 1.3. Such a layer is particularly advantageous for use in an optical extraction film as demonstrated more fully below. In some cases, the nanovoided layer may exhibit a refractive index in a range from 1.15 to 1.35, or from 1.15 to 1.3, for example. The nanovoided layer preferably has at least one major surface that is microstructured, that is, deliberately tailored to have a non-smooth or non-flat surface with relief features that have at least one dimension that is less than 1 millimeter, and in some cases the at least one dimension may be in a range from 50 nanometers to 500 micrometers, or from 50 nanometers to 100 microns, or from 50 nanometers to 1 micron.

In connection with FIGS. 2 and 3, we describe exemplary methods of fabricating a nanovoided layer, as well as features and characteristics that such layers may exhibit. Further details regarding suitable nanovoided layers and their manufacture can be found in commonly assigned U.S. patent application XXX (Attorney Docket 66015US005) entitled "Optical Films With Microstructured Low Refractive Index Nanovoided Layers and Methods Therefor", filed on even date herewith and incorporated herein by reference in its entirety.

Turning first to FIG. 2, we see there an exemplary process **220** of forming a backfilled nanovoided microstructured article **250**, and a corresponding system for manufacturing such articles. The process **220** includes disposing a coating solution **215** onto a substrate **216**. The substrate **216** is preferably a flexible film made of a polymer and/or other suitable material, the film having a thickness, composition, and other physical characteristics that make it suitable for use as a free-standing support film or carrier film in roll-to-roll processing systems such as that depicted in FIG. 2. Typically, such a substrate or carrier film, if made with a conventional light-transmissive polymer material, has a physical thickness of at least 0.002 inches (about 50 micrometers) in order to have sufficient strength to be unwound, processed in the roll-to-roll processing system, and wound up again or subjected to one or more converting operations (such as slitting or singulating into individual sheets or pieces) without excessive unintended stretching, curling, or warping.

In some cases the coating solution **215** may be applied using a die **214** such as a slot coater die for example. The coating solution **215** includes a polymerizable material and a solvent. Then

the process **220** includes polymerizing the polymerizable material while the coating solution **215** is in contact with a microreplication tool **212** to form a microstructured layer **230**. Solvent is then removed, for example by an oven **235**, from the microstructured layer **230** to form a nanovoiced microstructured article **240**. Then the process **220** includes disposing a polymeric material **245** on the nanovoiced microstructured article **240** to form a backfilled nanovoiced microstructured article **250**. The polymeric material **245** may be applied using a die **244** such as a slot coater die for example, or by other suitable means. The polymeric material **245** may alternatively be laminated onto the nanovoiced microstructured article **240** to form the nanovoiced microstructured article **250**.

The microreplication tool **212** can be any useful microreplication tool. The microreplication tool **212** is illustrated as a roll where the microreplication surface is on the exterior of the roll. It is also contemplated that the microreplication apparatus can include a smooth roll where the microreplication tool is a structured surface of the substrate **216** that contacts the coating solution **215**. The illustrated microreplication tool **212** includes a nip roll **221** and a take-away roll **222**. A curing source **225**, such as a bank of UV lights, is illustrated as being directed toward the substrate **216** and coating solution **215** while the coating solution **215** is in contact with the microreplication tool **212** to form a microstructured layer **230**. In some embodiments, the substrate **216** can transmit the curing light to the coating solution **215** to cure the coating solution **215** and form the microstructured layer **230**. In other embodiments the curing source **225** is a heat source and the coating solution **215** includes a thermal curing material. The curing source **225** can be disposed either as illustrated or within the microreplication tool **212**. When the curing source **225** is disposed within the microreplication tool **212**, the microreplication tool **212** can transmit light to the coating solution **215** to cure the coating solution **215** and form the microstructured layer **230**.

The processes to form the nanovoiced microstructured articles can include additional processing steps such as post-cure or further polymerization steps, for example. In some cases, a post-cure step is applied to the nanovoiced microstructured article following the solvent removal step. In some embodiments, these processes can include additional processing equipment common to the production of web-based materials, including, for example, idler rolls, tensioning rolls, steering mechanisms, surface treaters such as corona or flame treaters, lamination rolls, and the like. In some cases, these processes can utilize different web paths, coating techniques, polymerization apparatus, positioning of polymerization apparatus, drying ovens, conditioning sections, and the like, and some of the sections described can be optional. In some cases, one, some, or all steps of the process can be carried out as a “roll-to-roll” process wherein at least one

roll of substrate is passed through a substantially continuous process and ends up on another roll or is converted via sheeting, laminating, slitting, or the like.

Turning now to FIG. 3, we see there a schematic elevational view of a portion of a nanovoiced microstructured layer **300**. Although the nanovoiced microstructured layer **300** is illustrated having two planar outer surfaces **330**, **332**, it is understood that at least one of the outer surfaces **330**, **332** is microstructured to form relief or extraction features as discussed further herein.

Exemplary nanovoiced microstructured layers **300** include a plurality of interconnected voids or a network of voids **320** dispersed in a binder **310**. At least some of the voids in the plurality or network are connected to one another via hollow tunnels or hollow tunnel-like passages. The interconnected voids may be the remnant of an interconnected mass of solvent that formed part of the originally coated film, and that was driven out of the film by the oven or other means after curing of the polymerizable material. The network of voids **320** can be regarded to include interconnected voids or pores **320A-320C** as shown in FIG. 3. The voids are not necessarily free of all matter and/or particulates. For example, in some cases, a void may include one or more small fiber- or string-like objects that include, for example, a binder and/or nanoparticles. Some disclosed nanovoiced microstructured layers include multiple sets of interconnected voids or multiple networks of voids where the voids in each set or network are interconnected. In some cases, in addition to multiple pluralities or sets of interconnected voids, the nanovoiced microstructured layer may also include a plurality of closed or unconnected voids, meaning that the voids are not connected to other voids via tunnels. In cases where a network of voids **320** forms one or more passages that extend from a first major surface **330** to an opposed second major surface **332** of the nanovoiced layer **300**, the layer **300** may be described as being a porous layer.

Some of the voids can reside at or interrupt a surface of the nanovoiced microstructured layer and can be considered to be surface voids. For example, in the exemplary nanovoiced microstructured layer **300**, voids **320D** and **320E** reside at second major surface **332** of the nanovoiced microstructured layer and can be regarded as surface voids **320D** and **320E**, and voids **320F** and **320G** reside at first major surface **330** of the nanovoiced microstructured layer and can be regarded as surface voids **320F** and **320G**. Some of the voids, such as voids **320B** and **320C**, are disposed within the interior of the optical film and away from the exterior surfaces of the optical film, and can thus be regarded as interior voids **320B** and **320C** even though an interior void may be connected to a major surface via one or more other voids.

Voids **320** have a size **d1** that can generally be controlled by choosing suitable composition and fabrication, such as coating, drying, and curing conditions. In general, **d1** can be

any desired value in any desired range of values. For example, in some cases, at least a majority of the voids, such as at least 60% or 70% or 80% or 90% or 95% of the voids, have a size that is in a desired range. For example, in some cases, at least a majority of the voids, such as at least 60% or 70% or 80% or 90% or 95% of the voids, have a size that is not greater than about 10 micrometers, or not greater than about 7, or 5, or 4, or 3, or 2, or 1, or 0.7, or 0.5 micrometers.

In some cases, a plurality of interconnected voids **320** has an average void or pore size that is not greater than about 5 micrometers, or not greater than about 4 micrometers, or not greater than about 3 micrometers, or not greater than about 2 micrometers, or not greater than about 1 micrometer, or not greater than about 0.7 micrometers, or not greater than about 0.5 micrometers.

In some cases, some of the voids can be sufficiently small so that their primary optical effect is to reduce the effective refractive index, while some other voids can reduce the effective index and scatter light, while still some other voids can be sufficiently large so that their primary optical effect is to scatter light. In some cases the voids are sufficiently small as to reduce the effective refractive index without appreciably scattering light.

The nanovoiced microstructured layer **300** may have any useful thickness **t1** (linear distance between first major surface **330** and second major surface **332**). In many embodiments the nanovoiced microstructured layer may have a thickness **t1** that is not less than about 100 nm, or not less than about 500 nm, or not less than about 1,000 nm, or in a range from 0.1 to 10 micrometers, or in a range from 1 to 100 micrometers.

In some cases, the nanovoiced microstructured layer may be thick enough so that the nanovoiced microstructured layer can reasonably have an effective refractive index that can be expressed in terms of the indices of refraction of the voids and the binder, and the void or pore volume fraction or porosity. In such cases, the thickness of the nanovoiced microstructured layer is not less than about 500 nm, or not less than about 1,000 nm, or in a range from 1 to 10 micrometers, or in a range from 500 nm to 100 micrometers, for example.

When the voids in a disclosed nanovoiced microstructured layer are sufficiently small and the nanovoiced microstructured layer is sufficiently thick, the nanovoiced microstructured layer has an effective permittivity ϵ_{eff} that can be expressed as:

$$\epsilon_{\text{eff}} = (f)\epsilon_v + (1 - f)\epsilon_b, \quad (1)$$

where ϵ_v and ϵ_b are the permittivities of the voids and the binder respectively, and f is the volume fraction of the voids in the nanovoiced microstructured layer. In such cases, the effective refractive index n_{eff} of the nanovoiced microstructured layer can be expressed as:

$$n_{\text{eff}}^2 = (f)n_v^2 + (1 - f)n_b^2, \quad (2)$$

where n_v and n_b are the refractive indices of the voids and the binder respectively. In some cases, such as when the difference between the indices of refraction of the voids and the binder is sufficiently small, the effective index of the nanovoided microstructured layer can be approximated by the following expression:

$$n_{eff} \approx (f)n_v + (1 - f)n_b, \quad (3)$$

In such cases, the effective index of the nanovoided microstructured layer is the volume weighted average of the indices of refraction of the voids and the binder. For example, a nanovoided microstructured layer that has a void volume fraction of 50% and a binder that has an index of refraction of 1.5 has an effective index of about 1.25 as calculated by equation (3), and an effective index of about 1.27 as calculated by the more precise equation (2). In some exemplary embodiments the nanovoided microstructured layer may have an effective refractive index in a range from 1.15 to 1.35, or from 1.15 to 1.3, but values outside these ranges are also contemplated.

The nanovoided layer **300** of FIG. 3 is also shown to include, in addition to the plurality of interconnected voids or network of voids **320** dispersed in the binder **310**, an optional plurality of nanoparticles **340** dispersed substantially uniformly within the binder **310**.

Nanoparticles **340** have a size **d2** that can be any desired value in any desired range of values. For example, in some cases at least a majority of the particles, such as at least 60% or 70% or 80% or 90% or 95% of the particles, have a size that is in a desired range. For example, in some cases, at least a majority of the particles, such as at least 60% or 70% or 80% or 90% or 95% of the particles, have a size that is not greater than about 1 micrometer, or not greater than about 700, or 500, or 200, or 100, or 50 nanometers. In some cases, the plurality of nanoparticles **340** may have an average particle size that is not greater than about 1 micrometer, or not greater than about 700, or 500, or 200, or 100, or 50 nanometers.

In some cases, some of the nanoparticles can be sufficiently small so that they primarily affect the effective refractive index, while some other nanoparticles can affect the effective index and scatter light, while still some other particles can be sufficiently large so that their primary optical effect is to scatter light.

The nanoparticles **340** may or may not be functionalized. In some cases, some, most, or substantially all of the nanoparticles **340**, such as nanoparticle **340B**, are not functionalized. In some cases, some, most, or substantially all of the nanoparticles **340** are functionalized or surface treated so that they can be dispersed in a desired solvent or binder **310** with no, or very little, clumping. In some embodiments, nanoparticles **340** can be further functionalized to chemically bond to binder **310**. For example, nanoparticles such as nanoparticle **340A**, can be surface modified or surface treated to have reactive functionalities or groups **360** to chemically bond to binder **310**. Nanoparticles can be functionalized with multiple chemistries, as desired. In such

cases, at least a significant fraction of nanoparticles **340A** are chemically bound to the binder. In some cases, nanoparticles **340** do not have reactive functionalities to chemically bond to binder **310**. In such cases, nanoparticles **340** can be physically bound to binder **310**.

5 In some cases, some of the nanoparticles have reactive groups and others do not have reactive groups. An ensemble of nanoparticles can include a mixture of sizes, reactive and nonreactive particles, and different types of particles (for example, silica and zirconium oxide). In some cases, the nanoparticles may include surface treated silica nanoparticles.

The nanoparticles may be inorganic nanoparticles, organic (for example, polymeric) nanoparticles, or a combination of organic and inorganic nanoparticles. Furthermore, the nanoparticles may be porous particles, hollow particles, solid particles, or combinations thereof. Examples of suitable inorganic nanoparticles include silica and metal oxide nanoparticles including zirconia, titania, ceria, alumina, iron oxide, vanadia, antimony oxide, tin oxide, alumina/silica, and combinations thereof. The nanoparticles can have an average particle diameter less than about 1000 nm, or less than about 100 or 50 nm, or the average may be in a range from about 3 to 50 nm, or from about 3 to 35 nm, or from about 5 to 25 nm. If the nanoparticles are aggregated, the maximum cross sectional dimension of the aggregated particle can be within any of these ranges, and can also be greater than about 100 nm. In some embodiments, "fumed" nanoparticles, such as silica and alumina, with primary size less than about 50 nm, are also included, such as CAB-O-SPERSE® PG 002 fumed silica, CAB-O-SPERSE® 2017A fumed silica, and CAB-O-SPERSE® PG 003 fumed alumina, available from Cabot Co. Boston, MA.

The nanoparticles may include surface groups selected from the group consisting of hydrophobic groups, hydrophilic groups, and combinations thereof. Alternatively, the nanoparticles may include surface groups derived from an agent selected from the group consisting of a silane, organic acid, organic base, and combinations thereof. In other embodiments, the nanoparticles include organosilyl surface groups derived from an agent selected from the group consisting of alkylsilane, arylsilane, alkoxysilane, and combinations thereof.

The term "surface-modified nanoparticle" refers to a particle that includes surface groups attached to the surface of the particle. The surface groups modify the character of the particle. The terms "particle diameter" and "particle size" refer to the maximum cross-sectional dimension of a particle. If the particle is present in the form of an aggregate, the terms "particle diameter" and "particle size" refer to the maximum cross-sectional dimension of the aggregate. In some cases, particles can be large aspect ratio aggregates of nanoparticles, such as fumed silica particles.

The surface-modified nanoparticles have surface groups that modify the solubility characteristics of the nanoparticles. The surface groups are generally selected to render the particle compatible with the coating solution. In one embodiment, the surface groups can be

selected to associate or react with at least one component of the coating solution, to become a chemically bound part of the polymerized network.

A variety of methods are available for modifying the surface of nanoparticles including, for example, adding a surface modifying agent to nanoparticles (for example, in the form of a powder or a colloidal dispersion) and allowing the surface modifying agent to react with the nanoparticles. Other useful surface modification processes are described in, for example, U.S. Patents 2,801,185 (Iler) and 4,522,958 (Das et al.).

The nanoparticles may be provided in the form of a colloidal dispersion. Examples of useful commercially available unmodified silica starting materials include nano-sized colloidal silicas available under the product designations NALCO 1040, 1050, 1060, 2326, 2327, and 2329 colloidal silica from Nalco Chemical Co., Naperville, Ill; the organosilica under the product name IPA-ST-MS, IPA-ST-L, IPA-ST, IPA-ST-UP, MA-ST-M, and MA-ST sols from Nissan Chemical America Co. Houston, TX and the SnowTex® ST-40, ST-50, ST-20L, ST-C, ST-N, ST-O, ST-OL, ST-ZL, ST-UP, and ST-OUP, also from Nissan Chemical America Co. Houston, TX. The weight ratio of polymerizable material to nanoparticles can range from about 30:70, 40:60, 50:50, 55:45, 60:40, 70:30, 80:20 or 90:10 or more. The preferred ranges of wt% of nanoparticles range from about 10% by weight to about 60% by weight, and can depend on the density and size of the nanoparticles used.

In some cases, the nanovoiced microstructured layer **300** may have a low optical haze value. In such cases, the optical haze of the nanovoiced microstructured layer may be no more than about 5%, or no greater than about 4, 3.5, 3, 2.5, 2, 1.5, or 1%. For light normally incident on nanovoiced microstructured layer **300**, "optical haze" may (unless otherwise indicated) refer to the ratio of the transmitted light that deviates from the normal direction by more than 4 degrees to the total transmitted light. Index of refraction values of the disclosed films and layers may be measured by any suitable means, for example, using a Metricon Model 2010 Prism Coupler, available from Metricon Corp., Pennington, NJ. Optical transmittance, clarity, and haze values of the disclosed films and layers can also be measured by any suitable means, for example, using a Haze-Gard Plus haze meter, available from BYKGardiner, Silver Springs, MD.

In some cases, the nanovoiced microstructured layer **300** may have a high optical haze. In such cases, the haze of the nanovoiced microstructured layer **300** is at least about 40%, or at least about 50, 60, 70, 80, 90, or 95%.

In general, the nanovoiced microstructured layer **300** can have any porosity or void volume fraction that may be desirable in an application. In some cases, the volume fraction of plurality of voids **320** in the nanovoiced microstructured layer **300** is at least about 10%, or at least about 20, 30, 40, 50, 60, 70, 80, or 90%.

Binder **310** can be or include any material that may be desirable in an application. For example, binder **310** can be a light curable material that forms a polymer, such as a crosslinked polymer. In general, binder **310** can be any polymerizable material, such as a polymerizable material that is radiation-curable. In some embodiments binder **310** can be any polymerizable material, such as a polymerizable material that is thermally-curable.

Polymerizable material **310** can be any polymerizable material that can be polymerized by various conventional anionic, cationic, free radical, or other polymerization techniques, which can be initiated chemically, thermally, or by actinic radiation. Processes using actinic radiation include, for example, visible and ultraviolet light, electron beam radiation and combinations thereof, among other means. The media that polymerizations can be carried out in include, for example, solvent polymerization, emulsion polymerization, suspension polymerization, bulk polymerization, and the like.

Actinic radiation curable materials include monomers, and reactive oligomers, and polymers of acrylates, methacrylates, urethanes, epoxies, and the like. Representative examples of actinic radiation curable groups suitable in the practice of the present disclosure include epoxy groups, ethylenically unsaturated groups such as (meth)acrylate groups, olefinic carbon-carbon double bonds, allyloxy groups, alpha-methyl styrene groups, (meth)acrylamide groups, cyanoester groups, vinyl ether groups, combinations of these, and the like. Free radically polymerizable groups are preferred. In some embodiments, exemplary materials include acrylate and methacrylate functional monomers, oligomers, and polymers, and in particular, multifunctional monomers that can form a crosslinked network upon polymerization can be used, as known in the art. The polymerizable materials can include any mixture of monomers, oligomers, and polymers; however the materials should be at least partially soluble in at least one solvent. In some embodiments, the materials should be soluble in the solvent monomer mixture.

Solvent can be any solvent that forms a solution with the desired polymerizable material. The solvent can be a polar or a non-polar solvent, a high boiling point solvent or a low boiling point solvent, and in some embodiments the solvent includes a mixture of several solvents. The solvent or solvent mixture may be selected so that the microstructured layer **230** formed is at least partially insoluble in the solvent (or at least one of the solvents in a solvent mixture). In some embodiments, the solvent mixture can be a mixture of a solvent and a non-solvent for the polymerizable material. In one particular embodiment, the insoluble polymer matrix can be a three-dimensional polymer matrix having polymer chain linkages that provide the three dimensional framework. The polymer chain linkages can prevent deformation of the microstructured layer **230** after removal of the solvent.

In some cases, solvent can be easily removed from the solvent-laden microstructured layer **130, 230** by drying, for example, at temperatures not exceeding the decomposition temperature of either the insoluble polymer matrix or the substrate **216**. In one particular embodiment, the temperature during drying is kept below a temperature at which the substrate is prone to deformation, for example, a warping temperature or a glass-transition temperature of the substrate. Exemplary solvents include linear, branched, and cyclic hydrocarbons, alcohols, ketones, and ethers, including for example, propylene glycol ethers such as DOWANOL™ PM propylene glycol methyl ether, isopropyl alcohol, ethanol, toluene, ethyl acetate, 2-butanone, butyl acetate, methyl isobutyl ketone, methyl ethyl ketone, cyclohexanone, acetone, aromatic hydrocarbons, isophorone, butyrolactone, N-methylpyrrolidone, tetrahydrofuran, esters such as lactates, acetates, propylene glycol monomethyl ether acetate (PM acetate), diethylene glycol ethyl ether acetate (DE acetate), ethylene glycol butyl ether acetate (EB acetate), dipropylene glycol monomethyl acetate (DPM acetate), iso-alkyl esters, isohexyl acetate, isoheptyl acetate, isooctyl acetate, isononyl acetate, isodecyl acetate, isododecyl acetate, isotridecyl acetate or other iso-alkyl esters, water; combinations of these and the like.

The coating solution **215** can also include other ingredients including, for example, initiators, curing agents, cure accelerators, catalysts, crosslinking agents, tackifiers, plasticizers, dyes, surfactants, flame retardants, coupling agents, pigments, impact modifiers including thermoplastic or thermoset polymers, flow control agents, foaming agents, fillers, glass and polymer microspheres and microparticles, other particles including electrically conductive particles, thermally conductive particles, fibers, antistatic agents, antioxidants, optical down converters such as phosphors, UV absorbers, and the like.

An initiator, such as a photoinitiator, can be used in an amount effective to facilitate polymerization of the monomers present in the coating solution. The amount of photoinitiator can vary depending upon, for example, the type of initiator, the molecular weight of the initiator, the intended application of the resulting microstructured layer, and the polymerization process including, for example, the temperature of the process and the wavelength of the actinic radiation used. Useful photoinitiators include, for example, those available from Ciba Specialty Chemicals under the IRGACURE™ and DAROCURE™ trade designations, including IRGACURE™ 184 and IRGACURE™ 819.

The microstructured layer **230** may be cross-linked to provide a more rigid polymer network. Cross-linking can be achieved with or without a cross-linking agent by using high energy radiation such as gamma or electron beam radiation. In some embodiments, a cross-linking agent or a combination of cross-linking agents can be added to the mixture of polymerizable

monomers, oligomers or polymers. The cross-linking can occur during polymerization of the polymer network using any of the actinic radiation sources described elsewhere.

Useful radiation curing cross-linking agents include multifunctional acrylates and methacrylates, such as those disclosed in U.S. Patent 4,379,201 (Heilmann et al.), which include 1,6-hexanediol di(meth)acrylate, trimethylolpropane tri(meth)acrylate, 1,2-ethylene glycol di(meth)acrylate, pentaerythritol tri/tetra(meth)acrylate, triethylene glycol di(meth) acrylate, ethoxylated trimethylolpropane tri(meth)acrylate, glycerol tri(meth)acrylate, neopentyl glycol di(meth) acrylate, tetraethylene glycol di(meth)acrylate, 1,12-dodecanol di (meth)acrylate, copolymerizable aromatic ketone co-monomers such as those disclosed in U.S. Patent 4,737,559 (Kellen et al.) and the like, and combinations thereof.

The coating solution **215** may also include a chain transfer agent. The chain transfer agent is preferably soluble in the monomer mixture prior to polymerization. Examples of suitable chain transfer agents include triethyl silane and mercaptans. In some embodiments, chain transfer can also occur to the solvent; however this may not be a preferred mechanism.

The polymerizing step preferably includes using a radiation source in an atmosphere that has a low oxygen concentration. Oxygen is known to quench free-radical polymerization, resulting in diminished extent of cure. The radiation source used for achieving polymerization and/or crosslinking may be actinic (for example, radiation having a wavelength in the ultraviolet or visible region of the spectrum), accelerated particles (for example, electron beam radiation), thermal (for example, heat or infrared radiation), or the like. In some embodiments, the energy is actinic radiation or accelerated particles, because such energy provides excellent control over the initiation and rate of polymerization and/or crosslinking. Additionally, actinic radiation and accelerated particles can be used for curing at relatively low temperatures. This avoids degrading or evaporating components that might be sensitive to the relatively high temperatures that might be required to initiate polymerization and/or crosslinking of the energy curable groups when using thermal curing techniques. Suitable sources of curing energy include UV LEDs, visible LEDs, lasers, electron beams, mercury lamps, xenon lamps, carbon arc lamps, tungsten filament lamps, flashlamps, sunlight, low intensity ultraviolet light (black light), and the like.

In some embodiments, binder **310** includes a multifunctional acrylate and polyurethane. This binder **310** can be a polymerization product of a photoinitiator, a multifunctional acrylate, and a polyurethane oligomer. The combination of a multifunctional acrylate and a polyurethane oligomer can produce a more durable nanovoided microstructured layer **300**. The polyurethane oligomer is ethylenically unsaturated. In some embodiments, the polyurethane or polyurethane oligomer is capable of reacting with acrylates or "capped" with an acrylate to be capable of reacting with other acrylates in the polymerization reaction described herein.

In one illustrative process described above in FIG. 2, a solution is prepared that includes a plurality of nanoparticles (optional), and a polymerizable material dissolved in a solvent, where the polymerizable material can include, for example, one or more types of monomers. The polymerizable material is coated onto a substrate and a tool is applied to the coating while the polymerizable material is polymerized, for example by applying heat or light, to form an insoluble polymer matrix in the solvent. In some cases, after the polymerization step, the solvent may still include some of the polymerizable material, although at a lower concentration. Next, the solvent is removed by drying or evaporating the solution resulting in nanovoiced microstructured layer **300** that includes a network or plurality of voids **320** dispersed in polymer binder **310**. The nanovoiced microstructured layer **300** includes a plurality of nanoparticles **340** dispersed in the polymer binder. The nanoparticles are bound to the binder, where the bonding can be physical or chemical.

The fabrication of the nanovoiced microstructured layer **300** and microstructured articles described herein using the processes described herein can be performed in a temperature range that is compatible with the use of organic substances, resins, films, and supports. In many embodiments, the peak process temperatures (as determined by an optical thermometer aimed at the nanovoiced microstructured layer **300** and microstructured article surface) is 200 degrees centigrade or less, or 150 degrees centigrade or less or 100 degrees centigrade or less.

In general, nanovoiced microstructured layer **300** can have a desirable porosity for any weight ratio of binder **310** to plurality of nanoparticles **340**. Accordingly, in general, the weight ratio can be any value that may be desirable in an application. In some cases, the weight ratio of binder **310** to a plurality of nanoparticles **340** is at least about 1:2.5, or at least about 1:2.3, or 1:2, or 1:1, or 1.5:1, or 2:1, or 2.5:1, or 3:1, or 3.5:1, or 4:1, or 5:1. In some cases, the weight ratio is in a range from about 1:2.3 to about 4:1.

We now pause to consider, in connection with FIG. 3a, whether there is any structural difference between (a) an article made by first forming a nanovoiced layer with a microstructured surface, and then backfilling that microstructured surface with a conventional (non-nanovoiced) material, for example a conventional polymer material, and (b) an article made by first forming a microstructured surface in a layer of conventional material, and then backfilling that microstructured surface with a nanovoiced material layer. In both cases, the resulting article has an embedded interface, that is, the microstructured surface, on one side of which is the nanovoiced material layer and on the other side of which is the conventional material layer.

We have found that at least one structural difference can occur between the two articles, and that structural difference relates to the mechanism of interpenetration. In the article of case (b), where the layer of conventional material is microstructured before backfilling the microstructured surface with the nanovoiced material, the nanovoiced material would not typically

migrate into the layer of conventional material because that layer typically presents a substantially solid, non-porous barrier at each facet or portion of the microstructured surface beyond which the nanovoiced material cannot penetrate. In contrast, the article of case (a) is made in such a way that, at the time the conventional material (or precursor to such material, for example, an uncured liquid polymer resin) is applied to the microstructured surface of the nanovoiced layer, the facets or portions of the microstructured surface may contain surface voids, for example, in the form of pits, pockets, or tunnels, into which the conventional material may migrate depending on properties of the surface voids, properties of the conventional material, and process conditions such as residence time of the conventional material in an uncured state. With suitable material properties and process conditions, the conventional material layer may interpenetrate the nanovoiced layer, as shown schematically in FIG. 3a.

FIG. 3a shows in schematic cross-section a portion of an interface between a first nanovoiced layer 372 and a second layer 370 of conventional material. The interface portion may, for example, be a microscopic portion of a structured surface defined between the two layers. The nanovoiced layer 372 is shown to have a shallow surface void or depression 374A, as well as a deeper surface void 374B. The surface void 374B is characterized by a first transverse dimension S1 that is closer to the interface than a second transverse dimension S2, and the deeper dimension S2 is greater than the shallower dimension S1. We may characterize layer 370 as interpenetrating the layer 372 if the layer 370 not only conforms to the general shape of the layer 372 (for example, depression 374A), but also if material from layer 370 migrates into or substantially fills at least some deep surface voids such as void 374a, in which a transverse dimension of the void nearer the interface is smaller than a transverse dimension farther from the interface. Such interpenetration can be achieved with nanovoiced materials described herein.

In a first approach for characterizing an interpenetration depth of the conventional layer with the nanovoiced layer, one may determine the amount by which material of the conventional layer has advanced beyond an interface average surface (along a direction or measurement axis perpendicular to the average surface), and one may characterize this amount in terms of the diameter of an average-sized void.

In a second approach for characterizing the interpenetration depth, one may again measure the amount by which the material of the conventional layer has advanced beyond the average surface, and then simply report this amount in terms of standard units of distance, for example, micrometers or nanometers.

In a third approach for characterizing the interpenetration depth, one may again measure the amount by which the material of conventional layer has advanced beyond the average surface, but then characterize this amount in terms of the feature height of the structured surface at issue.

In exemplary embodiments, the interpenetration depth may be for example: with regard to the first approach, in a range from 1 to 10 average void diameters; with regard to the second approach, no more than 1, 10, 100, or 500 microns; with regard to the third approach, at least 5% of the feature height, or at least 10%, or at least 50%, or at least 95%, or at least 100%, or no more than 5%, or no more than 10%, or no more than 25%, or in a range from 5 to 25%, of the feature height. These exemplary ranges, however, should not be construed as limiting. The third approach of characterizing the interpenetration depth may be particularly suitable when dealing with microstructured surfaces that have particularly small feature sizes, for example, in which the feature-to-feature pitch is less than 1 micron.

Further discussion regarding interpenetration can be found in commonly assigned U.S. patent application XXX (Attorney Docket 66015US005) entitled "Optical Films With Microstructured Low Refractive Index Nanovoiced Layers and Methods Therefor", filed on even date herewith.

That U.S. application also discusses shrinkage issues that have been observed when microreplicating nanovoiced polymer materials, and how issues regarding shrinkage relate to the feature height of the structured surface (for example, axial distance between the highest point and the lowest point on the structured surface), the aspect ratio of the features of the structured surface (for example, feature height divided by feature pitch, where feature pitch may be the center-to-center spacing between nearest neighbor features in the structured surface), void volume fraction of the nanovoiced material (the fractional volume of the nanovoiced material occupied by the voids), refractive index of the nanovoiced material, and formulation (for example weight % solids) of the coating solution precursor to the nanovoiced layer. For example, in order to replicate larger microstructures using low concentration formulations of the coating solution, in the range of 30-45% solids, compensation of the microstructure geometry on the tool may be used to account for material shrinkage, so that the desired feature shape can be successfully made. The application discusses certain desirable relationships associated with a reduced amount of shrinkage or of other distortion of the microstructured surface. In one such relationship, the microstructured surface is characterized by a structure height (for example, the difference between dimension 419b and 419a in FIG. 4a) of at least 15 microns and an aspect ratio (structure height divided by structure pitch, see for example, pitch P1 in FIG. 4a or P2 in FIG. 4b) greater than 0.3, and: the nanovoiced layer has a void volume fraction in a range from 30% to 55%; and/or the nanovoiced layer has a refractive index in a range from 1.21 to 1.35, or 1.21 to 1.32; and/or the coating solution precursor to the nanovoiced layer has a wt% solids in a range from 45% to 70%, or from 50% to 70%. Relationships such as these can be advantageously applied to the present disclosure as well.

Optical Extraction Films and Film/Light Source Combinations

The disclosed nanovoiced layers can be advantageously incorporated into optical films that can be combined in some fashion with OLEDs or other self-emissive light sources so as to enhance light extraction and reduce losses in such sources. In some cases, the films can be designed to be applied to an exterior light-emitting surface of the light source, which is manufactured separately from the optical film. Some such films are described in connection with FIGS. 4a-c and 5a-c. In other cases, the films can be designed to function as a substrate on which the light source can then be fabricated. Some such films are described in connection with FIGS. 6a-c, 7a, and 7b.

Other aspects of the disclosed films relate to the loss mechanism of the light source that the optical film is primarily designed to reduce. In some cases, the films can be designed to primarily reduce waveguide losses. Some such films are described in connection with FIGS. 4b, 4c, 5a, 5c, 6b, 6c, 7a, and 7b. In some cases, the films can be designed to primarily reduce substrate losses associated with TIR. Some such films are described in connection with FIGS. 4a, 5a, 5b, 6a, and 7a. Note that some of the optical extraction films can be designed to reduce both waveguide losses and substrate losses.

FIGS. 4a-4c are schematic side or cross-sectional views of optical extraction films that can be used with top-emitting OLEDs. In FIG. 4a, an optical extraction film **410** includes a flexible carrier film **412** and various layers carried by (for example, attached to) the film **412**. Among these layers is a nanovoiced layer **414** and another layer **416**, between which an embedded interface forming a structured surface **414a** is formed. The nanovoiced layer preferably has a refractive index for visible light well below that of conventional polymeric materials, for example, below 1.35 or 1.3, or in a range from 1.15 to 1.3 or 1.15 to 1.35, for example. The other layer **416** is preferably composed of a polymer material or other suitable material that is not nanovoiced and that has a refractive index greater than that of the nanovoiced layer. The difference in refractive index between the layers **414**, **416** is desirably relatively large, for example, at least 0.2, or 0.3, or 0.4, or 0.5 or more. The difference in refractive indices allows the structured surface **414a** to function as an optical interface capable of extracting light from an OLED or other self-emissive light source, as described elsewhere herein.

The structured surface **414a** may be tailored to have any contour or shape that is effective in extracting light from the light source, that is, coupling “wasted” light out of the light source so that it can be used in the intended application. Wasted light in this regard refers to light that would be trapped in the light source or otherwise lost, for example, emitted from an edge of the light source in directions that do not contribute to useful illumination in the display or other intended lighting applications. In exemplary embodiments, the structured surface is shaped to define

individual light extraction elements **415**. The elements **415** are shown as having curved surfaces which may represent curved linear prisms or an array of lenticular elements arranged in two orthogonal directions (for example, directions that define a plane along which the structured surface generally extends), but the extraction elements may in general have any suitable shape without limitation, for example, lenticular, prismatic, 1-dimensional (linearly extending) or 2-dimensional, for example, and the extraction elements of a given structured surface need not all have the same size and/or shape, although they may have the same size and/or shape if desired. In exemplary embodiments, the extraction elements **415** are characterized by a center-to-center spacing or pitch P1 between nearest neighbors. In cases where the extraction elements are not uniformly distributed or spaced from each other, the pitch P1 may represent an average center-to-center spacing of the extraction elements.

The structured surface **414a** and/or extraction elements **415** may also be characterized by a distance or thickness from a surface of the extraction film that is adapted to couple to the self-emissive light source. In the case of extraction film **410**, this coupling surface is the outer major surface **416a** of layer **416**. A release liner **418**, which is shown covering the layer **416**, is preferably incorporated into the product so as to protect the coupling surface **416a** from damage until the extraction film is ready to be applied to the light source. Two characteristic distances are labeled in the figure. Distance **419a** is the thickness of the continuous land portion of the layer **416** between the coupling surface **416a** and the structured surface **414a**. The land is thus bounded on one side by the coupling surface, and on the opposite side by a plane that is parallel to the coupling surface and that intersects the structured surface at the point(s) of the structured surface that is/are closest to the coupling surface. The other characteristic distance, **419b**, is the distance between the coupling surface **416a** and a plane that is parallel to the coupling surface and that intersects the structured surface at the point(s) of the structured surface that is/are farthest away from the coupling surface. Stated differently, the land thickness or distance **419a** can be considered to be the smallest axial distance between the coupling surface **416a** and the structured surface **414a**, and the distance **419b** can be considered to be the largest axial distance between the coupling surface **416a** and the structured surface **414a**.

In cases where the extraction film **410** is intended to enhance light extraction by reducing the amount of light that is totally internally reflected at an outermost surface or boundary of the self-emissive light source, we have found it advantageous to design the extraction film **410** such that the land thickness **419a** is relatively small. For example, the land thickness **419a** may be less than 50 microns, or less than 25 microns, or less than 10 microns, although these values should not be construed as limiting. In some cases there may be no land. In yet other cases the structured nanovoided features may be non-contiguous. The land thickness **419a** may also be less than a

thickness of the flexible substrate **412**. The land thickness **419a** may also be so thin that the layer **416** is not suitable as a free-standing support film in roll-to-roll processing systems such as is depicted in FIG. 2. Stated differently, if the layer **416** could be separated from all the other portions of extraction film **410**, it may not have sufficient physical strength or integrity to be subjected to forces ordinarily encountered in industrial roll-to-roll processing systems without excessive tearing, warping, or curling, for example. The land thickness **419a** may also if desired be chosen to be large enough so that a substantial portion of the light extraction elements **415** is not disposed within an evanescent zone of the self-emissive light source.

We have also found it advantageous, again in cases where the film **410** is intended to enhance light extraction by reducing TIR, to tailor the extraction features **415** such that their pitch P_1 is relatively large, for example, greater than 1 micron. The feature heights, that is, the difference between distance **419b** and distance **419a**, may also if desired be greater than 1 micron. The feature heights and transverse dimensions may be sufficiently large, for example, greater than 1, 5, 10, or 20 microns, that the functionality of the extraction features is principally governed by principles of optical refraction rather than, for example, optical diffraction.

The optical extraction film **410** may be fabricated using a wide variety of manufacturing techniques, including without limitation continuous techniques and batch techniques. A particularly advantageous manufacturing technique is a continuous cast and cure (3C) roll-to-roll process such as that shown schematically in FIG. 2. Such a technique allows the film to be made continuously in potentially high volumes, and then converted (for example, cut or slit) into large numbers of piece parts or sheets whose sizes are tailored for the intended end-use application(s). In such cases, the flexible carrier film **412** may have physical characteristics, such as a composition and thickness, that make it suitable as a free-standing support film similar to substrate **216** in FIG. 2. In many cases, a film composed of a conventional light-transmissive polymer such as polyethylene terephthalate (PET) or polyethylene naphthalate (PEN), or copolymers thereof, would need to have a film thickness greater than about 2 mils (about 50 microns) in order to possess the necessary film strength to allow it to be used for such a purpose.

In some cases, the structured surface **414a** may be fabricated not with a casting-and-curing technique but with any other suitable technique capable of producing the desired extraction features in the desired layers. For example, imprinting, embossing, and injection molding may also be used to form the structured surface **414a** in some cases. However, if the extraction film **410** is made using a process similar to that of FIG. 2, the layer **416** may constitute a backfill layer that was produced after the formation of the nanovoided layer **414** and the structured surface **414a**. Consequently, depending on materials selection and process conditions, the layer **416** may interpenetrate the nanovoided layer **414** as discussed in connection with FIG. 3a.

The carrier film **412**, the nanovoiced layer **414**, and the other layer **416** are preferably all highly transmissive to light from the light source, although small to moderate amounts of haze in one, some, or all of these layers may be tolerable and/or desirable in specific applications. The layers preferably transmit light emitted by the light source with low loss so that, after the extraction film is attached to the light source, a large fraction of light from the light source that traverses the coupling surface **416a** will exit the extraction film at the opposite outer surface **412b** and contribute to system illumination. The carrier film **412** may comprise PET, PEN, copolymers thereof, glass (including flexible glass), or other suitable transparent or translucent materials. The carrier film **412** may also comprise a multilayer film of alternative layer of PET, PEN, and copolymers thereof. The carrier film may additionally comprise birefringence, fluorescence, and absorption layer(s) to enable advanced optical functions such as polarization and wavelength selection/conversion. The carrier film **412** may also function as a barrier layer to prevent water vapor and oxygen from reaching the light source after the extraction film is attached to the light source. Exemplary ultrabARRIER films include multilayer films made, for example, by vacuum deposition of two inorganic dielectric materials sequentially in a multitude of layers on a glass or other suitable substrate, or alternating layers of inorganic materials and organic polymers, as described in U.S. Patents 5,440,446 (Shaw et al.), 5,877,895 (Shaw et al.), and 6,010,751 (Shaw et al.). The nanovoiced layer **414** may comprise any of the light-transmissive nanovoiced materials disclosed herein. The other layer **416** may comprise any suitable light-transmissive material. In exemplary embodiments the layer **416** may be or comprise a light-transmissive pressure-sensitive adhesive or other visco-elastic material. Representative visco-elastic materials are discussed in the commonly assigned U.S. patent application (Attorney Docket 66015US005) referenced elsewhere herein. Use of a transparent adhesive for layer **416** allows the extraction film to be attached directly to an outer surface of the self-emissive light source with no intervening material layers. Use of a viscoelastic material for layer **416** allows the extraction film (and in particular the coupling surface **416a** of the extraction film) to flow to some extent so as to conform to a non-planar emitting surface of an OLED.

The light extraction film **410** may of course include other layers in addition to those depicted in FIG. 4a, and other features or characteristics in addition to those already discussed. For example, materials may be incorporated within the film to enhance light extraction through scattering or to filter, color shift, or polarize the light. Surface coatings or structures, for example functional layers, can be applied to the air surface of the light extraction film in order to further increase the functionality and possibly the value of the light extraction film. Such surface coatings can have, for example, optical, mechanical, chemical, or electrical functions. Examples of such coatings or structures include those having the following functions or properties: antifog;

antistatic; antiglare; antireflection; antiabrasion (scratch resistance); antismudge; hydrophobic; hydrophilic; adhesion promotion; refractive elements; color filtering; ultraviolet (UV) filtering; spectral filtering; color shifting; color modification; polarization modification (linear or circular); light redirection; diffusion; or optical rotation. Other possible layers to be applied to the air surface include a barrier layer or a transparent electrically conductive material. The release liner **418** may be omitted, and/or another release liner may be provided on the other side of the extraction film to protect the output surface **412b**.

FIG. 4b is a schematic side or cross-sectional view of another optical extraction film that can be used with a top-emitting OLED. In FIG. 4b, an optical extraction film **440** includes a flexible carrier film **442** and various layers carried by (for example, attached to) the film **442**. Among these layers is a nanovoiced layer **444** and another layer **446**, between which an embedded interface forming a structured surface **444a** is formed (see inset). The nanovoiced layer preferably has a refractive index for visible light well below that of conventional polymeric materials, for example, below 1.35 or 1.3, or in a range from 1.15 to 1.3 or 1.15 to 1.35, for example. The other layer **446** is preferably composed of a polymer material or other suitable material that is not nanovoiced and that has a refractive index greater than that of the nanovoiced layer. The difference in refractive index between the layers **444**, **446** is desirably relatively large, for example, at least 0.2, or 0.3, or 0.4, or 0.5 or more. The difference in refractive indices allows the structured surface **444a** to function as an optical interface capable of extracting light from an OLED or other self-emissive light source, as described elsewhere herein.

The structured surface **444a** may be tailored to have any contour or shape that is effective in extracting light from the light source, that is, coupling wasted light out of the light source so that it can be used in the intended application as discussed above. In exemplary embodiments, the structured surface is shaped to define individual light extraction elements **445**. The elements **445** are shown as having rectangular profiles which may represent flat linear ridges or an array of box-shaped protuberances arranged in two orthogonal directions (for example, directions that define a plane along which the structured surface generally extends), but the extraction elements may in general have any suitable shape without limitation, for example, lenticular, prismatic, 1-dimensional (linearly extending) or 2-dimensional, for example, and the extraction elements of a given structured surface need not all have the same size and/or shape, although they may have the same size and/or shape if desired. In exemplary embodiments, the extraction elements **445** are characterized by a center-to-center spacing or pitch P2 between nearest neighbors. In cases where the extraction elements are not uniformly distributed or spaced from each other, the pitch P2 may represent an average center-to-center spacing of the extraction elements.

The structured surface **444a** and/or extraction elements **445** may also be characterized by a distance or thickness from a surface of the extraction film that is adapted to couple to the self-emissive light source. In the case of extraction film **440**, this coupling surface is the outer major surface **446a** of layer **446**. A liner **448**, which is shown covering the layer **446**, is preferably incorporated into the product so as to protect the coupling surface **446a** from damage until the extraction film is ready to be applied to the light source. When the layer **446** comprises an adhesive, the liner **448** is preferably a release liner. When the layer **446** is not an adhesive, the liner **448** may be a premask designed to protect the surface prior to use. Two characteristic distances are labeled in the figure. Distance **449a** is the thickness of the continuous land portion of the layer **446** between the coupling surface **446a** and the structured surface **444a**. The land is thus bounded on one side by the coupling surface, and on the opposite side by a plane that is parallel to the coupling surface and that intersects the structured surface at the point(s) of the structured surface that is/are closest to the coupling surface. The other characteristic distance, **449b**, is the distance between the coupling surface **446a** and a plane that is parallel to the coupling surface and that intersects the structured surface at the point(s) of the structured surface that is/are farthest away from the coupling surface. Stated differently, the land thickness or distance **449a** can be considered to be the smallest axial distance between the coupling surface **446a** and the structured surface **444a**, and the distance **449b** can be considered to be the largest axial distance between the coupling surface **446a** and the structured surface **444a**.

In cases where the extraction film **440** is intended to enhance light extraction by reducing the amount of light that is trapped as waveguiding modes in a high refractive index light emitting region of the self-emissive light source, we have found it advantageous to design the extraction film **440** such that the land thickness **449a** is very small, for example, small enough so that a substantial portion of the light extraction elements **445** is disposed within an evanescent zone of the self-emissive light source when the coupling surface **446a** is placed against an emitting surface of the light source. The extent to which the evanescent zone extends beyond the coupling surface **446a** into the layer **446** depends on a number of factors, including the refractive index of layer **446** and the refractive index of the portion of the light source against which coupling surface **446a** is placed. In many cases, however, the land thickness **449a** may be less than 20 microns, or less than 10 microns, or less than 5 microns, although these values should not be construed as limiting in view of the many factors that can affect the size of the evanescent zone. The land thickness **449a** may also be less than a thickness of the flexible substrate **442**, and may be so thin that the layer **446** is not suitable as a free-standing support film in roll-to-roll processing systems such as is depicted in FIG. 2.

With regard to the discussion concerning the evanescent zone, the reader will understand that the evanescent field of any single waveguiding mode associated with a high refractive index light emitting region of the light source typically decays exponentially as a function of distance from the boundary of the high index region. Furthermore, to the extent more than one
5 waveguiding mode (for example, tens or hundreds of modes) is supported by the high index region, each waveguiding mode may have a different exponentially decaying function, and the decaying function is also dependent on the refractive index of the layer **446**. In view of these complications, one may choose to select a practical limit or boundary of an evanescent zone as the position (measured for example, in the medium of layer **446**) beyond which a suitably designed
10 structured surface cannot couple an appreciable amount of light out of the high index region.

We have also found it advantageous, again in cases where the film **440** is intended to enhance light extraction by reducing light trapped as waveguiding modes, to tailor the extraction features **445** such that their pitch P2 is relatively small, for example, less than 1 micron, in order to couple light out of the waveguiding modes. The feature heights, that is, the difference between
15 distance **449b** and distance **449a**, may also, if desired, be less than 1 micron. The feature heights and transverse dimensions may be sufficiently small that the functionality of the extraction features is principally governed by principles of optical diffraction rather than, for example, optical refraction. The structured surface **444a** may have a periodic, quasi-periodic, or random distribution of extraction features, and the extraction features may in some cases be arranged to
20 form a photonic crystal structure. In some cases, the structured surface **444a** may comprise multiple pitches, for example to tune the extraction of red, green, and blue sub-pixels of an OLED display. It may also be useful to have a “chirped” or periodic structure to provide broadband extraction from a broadband emitter.

The optical extraction film **440** may be fabricated using many different manufacturing
25 techniques as discussed in connection with FIG. 4a. The flexible carrier film **442** may have physical characteristics that make it suitable as a free-standing support film similar to substrate **216** in FIG. 2.

In some cases, the structured surface **444a** may be fabricated not with a casting-and-curing technique but with other suitable techniques capable of producing the desired extraction features in
30 the desired layers. For example, imprinting, embossing, and injection molding may also be used to form the structured surface **444a** in some cases. However, if the extraction film **440** is made using a process similar to that of FIG. 2, the layer **446** may constitute a backfill layer that was produced after the formation of the nanovoided layer **444** and the structured surface **444a**. Consequently, depending on materials selection and process conditions, the layer **446** may interpenetrate the
35 nanovoided layer **444** as discussed in connection with FIG. 3a.

The carrier film **442**, the nanovoiced layer **444**, and the other layer **446** are preferably all highly transmissive to light from the light source, although small to moderate amounts of haze in one, some, or all of these layers may be tolerable and/or desirable in specific applications. The layers preferably transmit light emitted by the light source with low loss so that, after the extraction film is attached to the light source, a large fraction of light from the light source that traverses the coupling surface **446a** will exit the extraction film at the opposite outer surface **442b** and contribute to system illumination. The carrier film **442**, nanovoiced layer **444**, and other layer **446** may all have similar compositions and characteristics as corresponding elements of the carrier film of FIG. 4a. For example, the carrier film **442** may comprise PET, PEN, copolymers thereof, glass (including flexible glass), or other suitable transparent or translucent materials, and it may also function as a barrier layer to prevent water vapor and oxygen from reaching the light source.

Similar to extraction film of FIG. 4a, the extraction film **440** may also include other layers in addition to those depicted in FIG. 4b, and other features or characteristics in addition to those already discussed. Refer for example, to the discussion above regarding the film of FIG. 4a. The release liner **448** may be omitted, and/or another release liner or premask may be provided on the other side of the extraction film to protect the output surface **442b**.

FIG. 4c is a schematic side or cross-sectional view of still another optical extraction film that can be used with a top-emitting OLED. In FIG. 4c, an optical extraction film **470** includes a flexible carrier film **472** and various layers carried by (for example, attached to) the film **472**. Among these layers is a nanovoiced layer **476** and another layer **474**, between which an embedded interface forming a structured surface **474a** is formed. A second embedded interface forming a second structured surface **476a** (see inset) is formed between the nanovoiced layer **476** and another layer **480**. The nanovoiced layer preferably has a refractive index for visible light well below that of conventional polymeric materials, for example, below 1.35 or 1.3, or in a range from 1.15 to 1.3 or 1.15 to 1.35, for example. The other layers **474**, **480** are preferably composed of polymer materials or other suitable materials that are not nanovoiced and that have refractive indices greater than that of the nanovoiced layer. The difference in refractive index between the layers **474**, **476**, and between the layers **476**, **480**, is desirably relatively large, for example, at least 0.2, or 0.3, or 0.4, or 0.5 or more. The differences in refractive indices allow each of the structured surfaces **474a**, **476a** to function as an optical interface capable of extracting light from an OLED or other self-emissive light source, as described elsewhere herein.

The structured surfaces **474a**, **476a** may each be tailored to have any contour or shape that is effective in extracting light from the light source, that is, coupling wasted light out of the light source so that it can be used in the intended application as discussed above. In exemplary embodiments, the structured surfaces **474a**, **476a** are each shaped to define individual light

extraction elements **475**, **482** respectively. The elements **475** are shown as having curved surfaces which may represent curved linear prisms or an array of lenticular elements arranged in two orthogonal directions, but the extraction elements **475** may in general have any suitable shape without limitation. The elements **482** are shown as having rectangular profiles which may represent flat linear ridges or an array of box-shaped protuberances arranged in two orthogonal directions, but the extraction elements **482** may in general have any suitable shape without limitation. The extraction elements of a given structured surface **474a**, **476a** need not all have the same size and/or shape, although they may have the same size and/or shape if desired. In exemplary embodiments, the extraction elements **475** are characterized by a center-to-center spacing or pitch P1 between nearest neighbors, and the extraction elements **482** are characterized by a center-to-center spacing or pitch P2 between nearest neighbors. In cases where the extraction elements are not uniformly distributed or spaced from each other, the pitches P1 and/or P2 may represent an average center-to-center spacing of the respective extraction elements.

Each of structured surfaces **474a**, **476a** (and/or their respective extraction elements **475**, **482**) may also be characterized by a distance or thickness from a surface of the extraction film that is adapted to couple to the self-emissive light source. In the case of extraction film **470**, this coupling surface is the outer major surface **480a** of layer **480**. A release liner or premask **478**, which is shown covering the layer **480**, is preferably incorporated into the product so as to protect the coupling surface **480a** from damage until the extraction film is ready to be applied to the light source. Four characteristic distances are labeled in the figure, two for each of the embedded structured surfaces. With regard to structured surface **474a**, distance **479a** is the axial distance from the coupling surface **480a** to the nearest portion of the structured surface **474a**. Despite the fact that this distance does not precisely correspond to the thickness of a continuous land of layer **476** (due to the presence of layer **480** and structured surface **476a**), it may nevertheless be considered to substantially correspond to the continuous land portion of layer **476** if the layer **480** is much thinner than the layer **476**. Distance **479b** is the axial distance from the coupling surface **480a** to the farthest portion of the structured surface **474a**. With regard to structured surface **476a**, distance **489a** is the thickness of the continuous land portion of the layer **480** between the coupling surface **480a** and the structured surface **476a**. The land of layer **480** is thus bounded on one side by the coupling surface, and on the opposite side by a plane that is parallel to the coupling surface and that intersects the portion(s) of the structured surface closest to the coupling surface. The distance **489b** is the axial distance from the coupling surface **480a** to the farthest portion of the structured surface **476a**.

Preferably, the extraction film **470** combines aspects of extraction films **410** and **440**. For example, the extraction film **470** can be tailored to enhance light extraction from an OLED or

other self-emissive light source both by reducing the amount of light that is totally internally reflected at an outermost surface or boundary of the self-emissive light source (via structured surface **474a**), and by reducing the amount of light that is trapped as waveguiding modes in a high refractive index light emitting region of the self-emissive light source (via structured surface **476a**). In this regard we have found it advantageous to design the extraction film **470** such that the substantial land thickness **479a** is relatively small, for example, less than 50 microns, or less than 25 microns, or less than 10 microns, and to further design the film **470** such that the land thickness **489a** is smaller still, for example, small enough so that a substantial portion of the light extraction elements **482** is disposed within an evanescent zone of the self-emissive light source when the coupling surface **480a** is placed against an emitting surface of the light source. The land thickness **489a** may, for example, be less than 20 microns, or less than 10 microns, or less than 5 microns, and it may be a small fraction of the substantial land thickness **479a** associated with the larger structured surface **474a**. The thicknesses **479a**, **489a** may each be less than a thickness of the flexible substrate **472**, and each may be so small that neither of the layers **476**, **480** is suitable as a free-standing support film in roll-to-roll processing systems such as is depicted in FIG. 2. The thickness **479a** may also if desired be chosen to be large enough so that a substantial portion of the light extraction elements **475** is not disposed within an evanescent zone of the self-emissive light source.

We have also found it advantageous to tailor the extraction features **475** such that their pitch P_1 is relatively large, for example, greater than 1 micron, while also tailoring the extraction features **482** such that their pitch P_2 is relatively small, for example, less than 1 micron. The corresponding feature heights may if desired be similarly sized, for example, the feature heights of structured surface **474a** may be greater than 1 micron, and the feature heights of structured surface **476a** may be less than 1 micron. The feature heights and transverse dimensions of the extraction features **475** may be sufficiently large (for example, greater than 5, or greater than 10, or greater than 20 microns) such that their functionality is principally governed by principles of optical refraction rather than optical diffraction, while the feature heights and transverse dimensions of extraction features **482** may be sufficiently small that the functionality of the extraction features is principally governed by principles of optical diffraction rather than optical refraction.

The optical extraction film **470** may be fabricated using many different manufacturing techniques as discussed in connection with FIGS. 4a and 4b. The flexible carrier film **472** may have physical characteristics that make it suitable as a free-standing support film similar to substrate **216** in FIG. 2.

In some cases, the structured surface **474a** and/or the structured surface **476a** may be fabricated not with a casting-and-curing technique but with other suitable techniques capable of

producing the desired extraction features in the desired layers. For example, imprinting, embossing, and injection molding may also be used to form the structured surface **474a** and/or the structured surface **476a** in some cases. However, if the extraction film **470** is made using a process similar to that of FIG. 2, the nanovoiced layer **476** may constitute a backfill layer that was produced after the formation of the layer **474** and the structured surface **474a**, and the layer **480** may likewise constitute another backfill layer that was produced after the formation of nanovoiced layer **476** and structured surface **476a**. Consequently, depending on materials selection and process conditions, the layer **480** may interpenetrate the nanovoiced layer **476** as discussed in connection with FIG. 3a, while the nanovoiced layer **476** may not interpenetrate the layer **474**.

The carrier film **472**, the nanovoiced layer **476**, and the other layers **474**, **480** are preferably all highly transmissive to light from the light source, although small to moderate amounts of haze in one, some, or all of these layers may be tolerable and/or desirable in specific applications. The layers preferably transmit light emitted by the light source with low loss so that, after the extraction film is attached to the light source, a large fraction of light from the light source that traverses the coupling surface **480a** will exit the extraction film at the opposite outer surface **472b** and contribute to system illumination. The carrier film **472**, nanovoiced layer **476**, and other layers **474**, **480** may all have similar compositions and characteristics as corresponding elements of the carrier films of FIGS. 4a and 4b. For example, the carrier film **472** may comprise PET, PEN, copolymers thereof, glass (including flexible glass), or other suitable transparent or translucent materials, and it may also function as a barrier layer to prevent water vapor and oxygen from reaching the light source.

Similar to extraction films of FIGS. 4a and 4b, the extraction film **470** may also include other layers in addition to those depicted in FIG. 4c, and other features or characteristics in addition to those already discussed. Refer for example, to the discussion above regarding the films of FIGS. 4a and 4b. The release liner **478** may be omitted, and/or another release liner or premask may be provided on the other side of the extraction film to protect the output surface **472b**.

FIG. 5a shows how any of the optical extraction films of FIGS. 4a-c can be applied to a top-emitting OLED or other suitable self-emissive light source which is fabricated separately from the extraction film, so as to produce an enhanced light-emitting optical device. A top-emitting OLED **510** is depicted only schematically for ease of discussion. The OLED includes at least a substrate **512** and a thin, high refractive index light emitting core or region **514**. The substrate may function as a barrier layer to prevent water vapor and oxygen from reaching the region **514** from one side, and the substrate may also have mechanical and thermal functionality, such as a heat sink to draw heat away from the region **514**. The substrate **512** may also comprise a backplane.

Individual layers that make up the region **514** may be deposited, formed, or applied in a suitable

sequence atop the substrate **510**. The high index region **514** typically includes at least one organic layer tailored to emit light of a desired wavelength in response to an applied electric current or field, and at least one transparent electrode. Other high refractive index layers can also be included in the thin high index region **514**. An outer surface **514a** of the region **514** can be considered to be a light emitting surface of the OLED **510**.

In order to provide enhanced optical performance of the OLED, one of the desired optical extraction films **410**, **440**, **470** is applied to the light emitting surface **514a** of the OLED. Before application, the appropriate release liner or premask (see items **418**, **448**, **478** in FIGS. 4a-c) is removed from the film to expose a pristine optical coupling surface (see items **416a**, **446a**, **480a**).

In some cases, the optical coupling surface of the optical extraction film may be placed directly against the light emitting surface **514a** of the OLED. If the outermost layer of the extraction film is a pressure sensitive adhesive or other suitable light transmissive adhesive, the direct contact between the optical coupling surface of the optical extraction film and the light emitting surface of the OLED may be sufficient to produce a firm bond between the two components with no significant air gap therebetween.

In other cases, a thin optical coupling layer may be provided between the optical coupling surface of the optical extraction film and the light emitting surface **514a** of the OLED. The optical coupling layer may serve several functions. One function may be to planarize the emitting surface of the OLED. In many pixelated top-emissive OLEDs, for example, the substrate may have surface features associated with pixel and sub-pixel wells. The optical coupling layer may be used to fill the wells or other surface features so as to provide a planar surface that the coupling surface of the optical extraction film (see for example, **416a**, **446a**, **480a**) can attach to with no air gaps or pockets. Another function of the optical coupling layer may be to attach the optical extraction film to the OLED, for example, in cases where the outermost layer of the extraction film is not a pressure sensitive adhesive or other suitable adhesive. In some cases, the optical coupling layer, if included in the construction, may have a refractive index as close to that of the high index region **514** of the OLED as possible so that waveguiding modes within the high index region, or their associated evanescent zone, can be extended closer to the coupling surface of the extraction film. The optical coupling layer may, for example, have a refractive index between that of the high index region **514** and the layer whose outer surface corresponds to the coupling surface of the optical extraction film. Suitable optical coupling layers comprise light-transmissive material such as high-index adhesives and nanoparticle-filled polymers. Suitable optical coupling layers are also typically as thin as possible while performing their necessary function(s) so as to minimize the distance between the coupling surface of the extraction film and the light emitting surface of the

OLED. A typical optical coupling layer may, for example, have a thickness in a range from 0.5 to 5 microns, or from 0.5 to 20 microns, but other thicknesses may also be used.

Whether or not an optical coupling layer is used, attachment of the optical extraction film to the OLED results in enhanced operation of the resulting OLED device. The optical extraction film, whether by reducing waveguiding modes, reducing total internal reflection of light, or by other mechanisms, can provide increased useful illumination, sometimes also referred to as increased gain, of the OLED when used in a given optical system. The increased illumination or gain may be characterized or measured in terms of the total luminance integrated over the hemisphere of possible output directions from the output surface of the OLED device, or may be measured in other ways such as increased illumination along a particular direction of interest, for example, increased on-axis illumination or gain along the direction perpendicular to the OLED output surface.

Besides increasing the useful illumination or gain of the OLED device, exemplary optical extraction films also have the advantage that they can provide a flat or planar outer surface that serves as the output surface of the OLED/film combination. Each of extraction films **410**, **440**, **470** is shown as having a flat surface (labeled in FIGS. 4a-c as surfaces **412b**, **442b**, **472b** respectively), and it is this surface that may become the output surface of the OLED device after the film is applied. Advantageously, the delicate structured surface(s) responsible for the increased output of the OLED, for example, structured surfaces **414a**, **444a**, **474a**, and **476a**, are in each case embedded within the film and within the device, being safely protected from abrasion, dirt, dust, oils, and other detrimental agents by the flexible carrier layer (labeled in FIGS. 4a-c as **412**, **442**, **472**). A flat output surface can thus be seen to be beneficial in many applications, but in some cases it may be desirable to emboss or otherwise pattern the output surface of the OLED/film combination (for example, surfaces **412b**, **442b**, **472b**) to provide an exposed structured surface that further modifies the light distribution emitted by the device.

FIG. 5b demonstrates the application of one specific optical extraction film to a top-emitting OLED. Initially, the optical extraction film **410**, described in detail elsewhere herein, and the top-emitting OLED **510**, also described elsewhere herein, are separately manufactured and provided as starting elements. The release liner **418** is removed from the extraction film to expose the optical coupling surface **416a**. The extraction film **410** and the OLED **510** are then pressed together to form the combined OLED device **520** with enhanced output. The extraction film is preferably firmly bonded to the OLED, for example, by use of a pressure sensitive adhesive or other suitable adhesive to form layer **416**, or by use of a suitable light-transmissive adhesive as an optical coupling layer.

In the device **520**, the optical coupling surface **416a** of the extraction film and the light emitting surface **514a** of the OLED contact or coincide with each other. As a result, the distances **419a**, **419b** represent not only the minimum and maximum axial distance from the structured surface **414a** to the optical coupling surface **416a**, but also the minimum and maximum axial distance (respectively) from the structured surface **414a** to the light emitting surface **514a** of the OLED. Note that in alternative embodiments, a thin optical coupling layer as described above may be included between surface **416a** and surface **514a**. In any case, light generated within the high index region **514** is refractively coupled out of the OLED device by the extraction elements of the embedded structured surface, and eventually exits the device **520** through surface **412b**, which may now be considered the output surface of the device **520**.

FIG. 5c is a schematic side or cross-sectional view of an OLED device **530** in which a top-emitting OLED, such as OLED **510** described in connection with FIG. 5a, has been combined with another optical extraction film, in this case, the extraction film **470** of FIG. 4c. In producing this combination, the release liner **478** has been removed from the extraction film to expose the optical coupling surface **480a**, which surface is then pressed against the light emitting surface **514a** of the OLED **510**. In this enlarged view, both light extraction elements **482** from structured surface **476a**, and one of the light extraction elements **475** from the structured surface **474a**, can be seen so as to give the reader some sense of size and thickness differences that may be realized between refractive elements and diffractive elements in some embodiments. The enlarged view of FIG. 5c also shows some additional detail regarding the high index region **514**. Region **514** is shown as comprising at least three separate layers, **515**, **516**, and **517**. The layer **516** may be an organic light generating layer, and one or both of layers **515**, **517** may be a transparent electrode layer, for example, composed of a transparent conductive oxide (TCO) such as indium tin oxide (ITO). In any case, all of the layers **515**, **516**, **517** are composed of high refractive index materials, for example, in a range from 1.6 to 1.8.

In the device **530**, the optical coupling surface **480a** of the extraction film and the light emitting surface **514a** of the OLED contact or coincide with each other. As a result, the distances **489a**, **489b** represent not only the minimum and maximum axial distance from the structured surface **476a** to the optical coupling surface **480a**, but also the minimum and maximum axial distance (respectively) from the structured surface **476a** to the light emitting surface **514a** of the OLED. Note that in alternative embodiments, a thin optical coupling layer as described above may be included between surface **416a** and surface **514a**. In any case, light generated within the high index region **514** is refractively coupled out of the OLED device by the extraction elements of the embedded structured surface, and eventually exits the device **520** through surface **412b**, which may now be considered the output surface of the device **520**.

FIGS. 6a-6c are schematic side or cross-sectional views optical extraction films that can be used with bottom-emitting OLEDs. Many of the elements and features of these films are direct counterparts to corresponding elements and features of the extraction films described in connection with FIGS. 4a-c. For example, the flexible carrier films of FIGS. 6a-c may substantially
5 correspond to the flexible carrier films discussed in connection with FIGS. 4a-c. Larger structured surfaces adapted for refractive coupling of TIR light, and smaller structured surfaces adapted for diffractive coupling of waveguiding modes, and their constituent light extraction elements, are depicted in FIGS. 6a-c, and may substantially correspond to the analogous structured surfaces described in connection with FIGS. 4a-c. Nanovoiced layers, and other layers that interface with a
10 nanovoiced layer at a structured surface, are depicted in FIGS. 6a-c, and may substantially correspond to the nanovoiced layers and other layers discussed in connection with FIGS. 4a-c. To avoid unnecessary repetition, details of such common elements and features will not be repeated here but will be understood as applying equally to these embodiments.

In contrast to the extraction films of FIGS. 4a-c, which are adapted to be applied to a self-emissive light source that is fabricated separately from the extraction film, the extraction films of
15 FIGS. 6a-c are adapted to be used as a substrate on which the self-emissive light source can be fabricated. In the former cases, light from the OLED is emitted out of the “top” of the structure, that is, through and out of the optical extraction film (acting as a “cover”), while in the latter cases, light from the OLED is emitted out of the “bottom” of the structure, that is, again through and out
20 of the optical extraction film (but now acting as a “substrate”). The reader will understand that “top”, “bottom”, “cover”, “substrate”, “carry”, and “atop” should not be construed for purposes of this application to require any particular orientation with respect to gravity, unless otherwise clearly indicated to the contrary.

In FIG. 6a, an optical extraction film **610** includes a flexible carrier film **612** and various
25 layers carried by (for example, attached to) the film **612**. Among these layers is a nanovoiced layer **614** and another layer **616**, between which an embedded interface forming a structured surface **614a** is formed. The nanovoiced layer preferably has a refractive index for visible light well below that of conventional polymeric materials, for example, below 1.35 or 1.3, or in a range from 1.15 to 1.3 or 1.15 to 1.35, for example. The other layer **616** is preferably composed of a
30 polymer material or other suitable material that is not nanovoiced and that has a refractive index greater than that of the nanovoiced layer. The difference in refractive index between the layers **614**, **616** is desirably relatively large, for example, at least 0.2, or 0.3, or 0.4, or 0.5 or more. The difference in refractive indices allows the structured surface **614a** to function as an optical interface capable of extracting light from an OLED or other self-emissive light source.

The structured surface **614a** may be tailored to have any contour or shape that is effective in extracting light from the light source, that is, coupling wasted light out of the light source so that it can be used in the intended application. In exemplary embodiments, the structured surface is shaped to define individual light extraction elements **615**. The elements **615** are shown as having curved surfaces which may represent curved linear prisms or an array of lenticular elements, but the extraction elements may in general have any suitable shape without limitation. In exemplary embodiments, the extraction elements **615** are characterized by a center-to-center spacing or pitch P1 between nearest neighbors. In cases where the extraction elements are not uniformly distributed or spaced from each other, the pitch P1 may represent an average center-to-center spacing of the extraction elements.

Unlike the extraction films of FIGS. 4a-c, the extraction films of FIGS. 6a-c are all depicted as having a transparent electrode layer as an outermost layer on one side of the film. The transparent electrode may be composed of ITO or other suitable light transmissive electrically conductive material. In the case of extraction film **610** of FIG. 6a, this layer is transparent electrode layer **618**, disposed atop layer **616**. Such a transparent electrode layer in the embodiments of FIGS. 6a-c is preferably adapted to function as an electrode on which one or more organic light generating layer can be formed so as to provide a high refractive index light generating region or core of an OLED. Thus, the transparent electrode layer may initially be considered to be part of the optical extraction film, and, after formation of the OLED atop the extraction film, may later be considered to be part of the high index region or core of the resulting OLED device.

The structured surface **614a** and/or extraction elements **615** may also be characterized by a distance or thickness from a surface of the extraction film that is adapted to couple to the self-emissive light source. In the case of extraction film **610**, this coupling surface may be considered to be the major surface **616a** of layer **616** because it adjoins the outer surface of what will later become the high refractive index light generating region of the OLED. Unlike surface **618a** of electrode layer **618**, surface **616a** is not an exterior surface. Two characteristic distances are labeled in the figure. Distance **619a** is the thickness of the continuous land portion of the layer **616** between the coupling surface **616a** and the structured surface **614a**. The other characteristic distance, **619b**, is the distance between the coupling surface **616a** and a plane that is parallel to the coupling surface and that intersects the structured surface at the point(s) of the structured surface that is/are farthest away from the coupling surface.

In cases where the extraction film **610** is intended to enhance light extraction by reducing the amount of light that is totally internally reflected at an outermost surface or boundary of the self-emissive light source, we have found it advantageous to design the extraction film **610** such

that the land thickness **619a** is relatively small. For example, the land thickness **619a** may be less than 50 microns, or less than 25 microns, or less than 10 microns, although these values should not be construed as limiting. The land thickness **619a** may also be less than a thickness of the flexible substrate **612**. The land thickness **619a** may also be so thin that the layer **616** is not suitable as a free-standing support film in roll-to-roll processing systems such as is depicted in FIG. 2. The land thickness **619a** may also if desired be chosen to be large enough so that a substantial portion of the light extraction elements **615** is not disposed within an evanescent zone of the self-emissive light source.

We have also found it advantageous, again in cases where the film **610** is intended to enhance light extraction by reducing TIR, to tailor the extraction features **615** such that their pitch P_1 is relatively large, for example, greater than 1 micron. The feature heights, that is, the difference between distance **619b** and distance **619a**, may also if desired be greater than 1 micron. The feature heights and transverse dimensions may be sufficiently large, for example, greater than 1, 5, 10, or 20 microns, that the functionality of the extraction features is principally governed by principles of optical refraction rather than, for example, optical diffraction.

The optical extraction film **610** may be fabricated using a wide variety of manufacturing techniques, including without limitation continuous techniques and batch techniques. A particularly advantageous manufacturing technique is a continuous cast and cure (3C) roll-to-roll process such as that shown schematically in FIG. 2. Other suitable manufacturing techniques are also contemplated. However, if the extraction film **610** is made using a process similar to that of FIG. 2, the layer **616** may constitute a backfill layer that was produced after the formation of the nanovoiled layer **614** and the structured surface **614a**. Consequently, depending on materials selection and process conditions, the layer **616** may interpenetrate the nanovoiled layer **614** as discussed in connection with FIG. 3a.

The carrier film **612**, the nanovoiled layer **614**, the layer **616**, and the electrode layer **618** are preferably all highly transmissive to light from the light source, although small to moderate amounts of haze in one, some, or all of these layers may be tolerable and/or desirable in specific applications. The layers preferably transmit light emitted by the light source with low loss so that, after the light source is fabricated atop the extraction film, a large fraction of light from the light source that traverses the coupling surface **616a** will exit the extraction film at the opposite outer surface **612b** and contribute to system illumination.

The light extraction film **610** may of course include other layers in addition to those depicted in FIG. 6a, and other features or characteristics in addition to those already discussed. For example, materials may be incorporated within the film to enhance light extraction through scattering or to filter, color shift, or polarize the light. Surface coatings or structures, for example

functional layers, can be applied to the air surface of the light extraction film in order to further increase the functionality and possibly the value of the light extraction film. Such surface coatings can have, for example, optical, mechanical, chemical, or electrical functions. Examples of such coatings or structures include those having the following functions or properties: antifog;
 5 antistatic; antiglare; antireflection; antiabrasion (scratch resistance); antismudge; hydrophobic; hydrophilic; adhesion promotion; refractive elements; color filtering; ultraviolet (UV) filtering; spectral filtering; color shifting; color modification; polarization modification (linear or circular); light redirection; diffusion; or optical rotation. Other possible layers to be applied to the air surface include a barrier layer or a transparent electrically conductive material. If desired, a
 10 release liner may be provided on the one side of the extraction film to protect the output surface **612b**, and another release liner may be provided on the opposite side of the extraction film **610** to protect the electrode layer **618** from damage until access to that surface is needed.

FIG. 6b is a schematic side or cross-sectional view of another optical extraction film that can be used with a bottom-emitting OLED. In FIG. 6b, an optical extraction film **640** includes a
 15 flexible carrier film **642** and various layers carried by (for example, attached to) the film **642**. Among these layers is a nanovoiced layer **644** and another layer **646**, between which an embedded interface forming a structured surface **644a** is formed (see inset). A transparent electrode layer **648** is also provided atop layer **646**. The nanovoiced layer preferably has a refractive index for visible light well below that of conventional polymeric materials, for example, below 1.35 or 1.3,
 20 or in a range from 1.15 to 1.3 or 1.15 to 1.35, for example. The other layer **646** is preferably composed of a polymer material or other suitable material that is not nanovoiced and that has a refractive index greater than that of the nanovoiced layer. The difference in refractive index between the layers **644**, **646** is desirably relatively large, for example, at least 0.2, or 0.3, or 0.4, or 0.5 or more. The difference in refractive indices allows the structured surface **644a** to function as
 25 an optical interface capable of extracting light from an OLED or other self-emissive light source, as described elsewhere herein.

The structured surface **644a** may be tailored to have any contour or shape that is effective in extracting light from the light source, that is, coupling wasted light out of the light source so that it can be used in the intended application as discussed above. In exemplary embodiments, the
 30 structured surface is shaped to define individual light extraction elements **645**. The elements **645** are shown as having rectangular profiles which may represent flat linear ridges or an array of box-shaped protuberances arranged in two orthogonal directions, but the extraction elements may in general have any suitable shape without limitation. In exemplary embodiments, the extraction elements **645** are characterized by a center-to-center spacing or pitch P_2 between nearest
 35 neighbors. In cases where the extraction elements are not uniformly distributed or spaced from

each other, the pitch P2 may represent an average center-to-center spacing of the extraction elements.

The structured surface **644a** and/or extraction elements **645** may also be characterized by a distance or thickness from a surface of the extraction film that is adapted to couple to the self-emissive light source. In the case of extraction film **640**, this coupling surface is the major surface **646a** of layer **646** because it adjoins the outer surface of what will later become the high refractive index light generating region of the OLED. Unlike surface **648a** of electrode layer **648**, surface **646a** is not an exterior surface. Two characteristic distances are labeled in the figure. Distance **649a** is the thickness of the continuous land portion of the layer **646** between the coupling surface **646a** and the structured surface **644a**. The other characteristic distance, **649b**, is the distance between the coupling surface **646a** and a plane that is parallel to the coupling surface and that intersects the structured surface at the point(s) of the structured surface that is/are farthest away from the coupling surface.

In cases where the extraction film **640** is intended to enhance light extraction by reducing the amount of light that is trapped as waveguiding modes in a high refractive index light emitting region of the self-emissive light source, we have found it advantageous to design the extraction film **640** such that the land thickness **649a** is very small, for example, small enough so that a substantial portion of the light extraction elements **645** is disposed within an evanescent zone of the self-emissive light source when the coupling surface **646a** is disposed against an emitting surface of the light source (for example, against a surface of the electrode layer **618** after the remaining portions of the OLED have been fabricated atop such layer **618**). In many cases, the land thickness **649a** may be less than 20 microns, or less than 10 microns, or less than 5 microns, although these values should not be construed as limiting. The land thickness **649a** may also be less than a thickness of the flexible substrate **642**, and may be so thin that the layer **646** is not suitable as a free-standing support film in roll-to-roll processing systems such as is depicted in FIG. 2.

We have also found it advantageous to tailor the extraction features **645** such that their pitch P2 is relatively small, for example, less than 1 micron, in order to couple light out of the waveguiding modes. The feature heights may also if desired be less than 1 micron. The feature heights and transverse dimensions may be sufficiently small that the functionality of the extraction features is principally governed by principles of optical diffraction rather than, for example, optical refraction. The structured surface **644a** may have a periodic, quasi-periodic, or random distribution of extraction features, and the extraction features may in some cases be arranged to form a photonic crystal structure.

The optical extraction film **640** may be fabricated using many different manufacturing techniques. If the film **640** is made using a process similar to that of FIG. 2, the layer **646** may constitute a backfill layer that was produced after the formation of the nanovoiced layer **644** and the structured surface **644a**. Consequently, depending on materials selection and process
5 conditions, the layer **646** may interpenetrate the nanovoiced layer **644** as discussed in connection with FIG. 3a.

The carrier film **642**, the nanovoiced layer **644**, the layer **646**, and the electrode layer **648** are preferably all highly transmissive to light from the light source, although small to moderate amounts of haze in one, some, or all of these layers may be tolerable and/or desirable in specific
10 applications. The extraction film **640** may also include other layers in addition to those depicted in FIG. 6b, and other features or characteristics in addition to those already discussed. Release liners may be provided on one or both sides of the film **640**.

FIG. 6c is a schematic side or cross-sectional view of still another optical extraction film that can be used with a bottom-emitting OLED. In FIG. 6c, an optical extraction film **670** includes
15 a flexible carrier film **672** and various layers carried by (for example, attached to) the film **672**. Among these layers is a nanovoiced layer **676** and another layer **674**, between which an embedded interface forming a structured surface **674a** is formed. A second embedded interface forming a second structured surface **676a** (see inset) is formed between the nanovoiced layer **676** and another layer **680**. A transparent electrode layer **678** is also provided atop layer **680**. The nanovoiced
20 layer preferably has a refractive index for visible light well below that of conventional polymeric materials, for example, below 1.35 or 1.3, or in a range from 1.15 to 1.3 or 1.15 to 1.35, for example. The other layers **674**, **680** are preferably composed of polymer materials or other suitable materials that are not nanovoiced and that have refractive indices greater than that of the nanovoiced layer. The difference in refractive index between the layers **674**, **676**, and between the
25 layers **676**, **680**, is desirably relatively large, for example, at least 0.2, or 0.3, or 0.4, or 0.5 or more. The differences in refractive indices allow each of the structured surfaces **674a**, **676a** to function as an optical interface capable of extracting light from an OLED or other self-emissive light source, as described elsewhere herein.

The structured surfaces **674a**, **676a** may each be tailored to have any contour or shape that
30 is effective in extracting light from the light source, that is, coupling wasted light out of the light source so that it can be used in the intended application as discussed above. The structured surfaces **674a**, **676a** may be each shaped to define individual light extraction elements **675**, **682** respectively. The elements **675** are shown as having curved surfaces which may represent curved linear prisms or an array of lenticular elements, but the extraction elements **675** may in general
35 have any suitable shape without limitation. The elements **682** are shown as having rectangular

profiles which may represent flat linear ridges or an array of box-shaped protuberances, but the extraction elements **682** may in general have any suitable shape without limitation. The extraction elements **675** may be characterized by a center-to-center spacing or pitch P1 between nearest neighbors, and the extraction elements **682** may be characterized by a center-to-center spacing or pitch P2 between nearest neighbors. In cases where the extraction elements are not uniformly distributed or spaced from each other, the pitches P1 and/or P2 may represent an average center-to-center spacing of the respective extraction elements.

The structured surfaces **674a**, **676a** and/or their respective extraction elements **675**, **682** may also be characterized by a distance or thickness from a surface of the extraction film that is adapted to couple to the self-emissive light source. In the case of extraction film **670**, this coupling surface is the major surface **680a** of layer **680** because it adjoins the outer surface of what will later become the high refractive index light generating region of the OLED. Unlike surface **678a** of electrode layer **678**, surface **680a** is not an exterior surface. Four characteristic distances are labeled in the figure, two for each of the embedded structured surfaces. With regard to structured surface **674a**, distance **679a** is the axial distance from the coupling surface **680a** to the nearest portion of the structured surface **674a**. Despite the fact that this distance does not precisely correspond to the thickness of a continuous land of layer **676** (due to the presence of layer **680** and structured surface **676a**), it may nevertheless be considered to substantially correspond to the continuous land portion of layer **676** if the layer **680** is much thinner than the layer **676**. Distance **679b** is the axial distance from the coupling surface **680a** to the farthest portion of the structured surface **674a**. With regard to structured surface **676a**, distance **689a** is the thickness of the continuous land portion of the layer **680** between the coupling surface **680a** and the structured surface **676a**. The distance **689b** is the axial distance from the coupling surface **680a** to the farthest portion of the structured surface **676a**.

Preferably, the extraction film **670** combines aspects of extraction films **610** and **640**. For example, the extraction film **670** can be tailored to enhance light extraction from an OLED or other self-emissive light source both by reducing the amount of light that is totally internally reflected at an outermost surface or boundary of the self-emissive light source (via structured surface **674a**), and by reducing the amount of light that is trapped as waveguiding modes in a high refractive index light emitting region of the self-emissive light source (via structured surface **676a**). In this regard we have found it advantageous to design the extraction film **670** such that the substantial land thickness **679a** is relatively small, for example, less than 50 microns, or less than 25 microns, or less than 10 microns, and to further design the film **670** such that the land thickness **689a** is smaller still, for example, small enough so that a substantial portion of the light extraction elements **682** is disposed within an evanescent zone of the self-emissive light source when the

coupling surface **680a** is disposed against an emitting surface of the light source. The land thickness **689a** may, for example, be less than 20 microns, or less than 10 microns, or less than 5 microns, and it may be a small fraction of the substantial land thickness **679a** associated with the larger structured surface **674a**.

5 We have also found it advantageous to tailor the extraction features **675** such that their pitch P1 is relatively large, for example, greater than 1 micron, while also tailoring the extraction features **682** such that their pitch P2 is relatively small, for example, less than 1 micron. The feature heights and transverse dimensions of the extraction features **675** may be sufficiently large that their functionality is principally governed by principles of optical refraction, while the feature
10 heights and transverse dimensions of extraction features **682** may be sufficiently small that the functionality of the extraction features is principally governed by principles of optical diffraction.

The optical extraction film **670** may be fabricated using many different manufacturing techniques. The flexible carrier film **672** may have physical characteristics that make it suitable as a free-standing support film similar to substrate **216** in FIG. 2.

15 In some cases, the structured surface **674a** and/or the structured surface **676a** may be fabricated not with a casting-and-curing technique but with other suitable techniques capable of producing the desired extraction features in the desired layers. However, if the extraction film **670** is made using a process similar to that of FIG. 2, the nanovoiced layer **676** may constitute a backfill layer that was produced after the formation of the layer **674** and the structured surface
20 **674a**, and the layer **680** may constitute another backfill layer that was produced after the formation of nanovoiced layer **676** and structured surface **676a**. Consequently, depending on materials selection and process conditions, the layer **680** may interpenetrate the nanovoiced layer **676** as discussed in connection with FIG. 3a, while the nanovoiced layer **676** may not interpenetrate the layer **674**.

25 The carrier film **672**, the nanovoiced layer **676**, the layers **474**, **480**, and transparent electrode layer **678** are preferably all highly transmissive to light from the light source, although small to moderate amounts of haze in one, some, or all of these layers may be tolerable and/or desirable in specific applications. The extraction film **470** may include other layers in addition to those depicted in FIG. 6c, and other features or characteristics in addition to those already
30 discussed. A release liner may be provided on one or both sides of the extraction film **670**.

FIG. 7a shows how any of the optical extraction films of FIGS. 6a-c can be combined with a bottom-emitting OLED or other suitable self-emissive light source which is fabricated on the extraction film, so as to produce an enhanced light-emitting optical device **720**.

A first step in producing such a combination may be to provide a light extraction film **600**,
35 which may be any of the extraction films **610**, **640**, **670** described above or variations thereof.

These films each include on one side thereof a transparent electrode layer. Atop this layer other high refractive index layers may be provided, including at least one organic light generating layer and an optional second electrode layer which may or may not be transparent. These additional high refractive index layers are represented in the figure by a schematic layer **714a**. Those layers, in combination with the transparent electrode layer from the optical extraction film, may form a high refractive index light emitting region **714** that generates light of a desired wavelength in response to an applied electrical current or field. The region is typically very thin, for example, on the order of a wavelength of light, or less than 1 or 2 microns, for example, although other thicknesses may be used.

One or more other layers, represented schematically in the figure by layer **712**, may be formed or applied atop the high index region **714**. The layer **712** may for example comprise a support film and/or a barrier film. In an exemplary embodiment, the layer **712** may comprise an ultrabARRIER film such as those described in U.S. Patents 5,440,446 (Shaw et al.), 5,877,895 (Shaw et al.), and 6,010,751 (Shaw et al.), or a sputtered layer of diamond-like glass. Alternatively, the layer **712** may be omitted and replaced with an inert gas or vacuum, which may be maintained in a sealed chamber between the OLED and a suitable cover glass member.

Since the device **720** is a bottom-emitting OLED, light generated in the high index region **714** travels through the extraction film **600** and exits the device through the "bottom" surface as seen from the perspective of FIG. 7a, for example, from surface **612b**, or surface **642b**, or surface **672b**. In some cases, the device **720** may be designed to emit little or no light emitted from the opposite side of the device. In those cases, one, some, or all of the constituent components of layer **712** may be substantially opaque. In other cases the device **720** may emit light from both sides, whereupon the components of layer **712** may all be light-transmissive. In such cases, where the device is emitting from both sides, it would be useful to apply extraction features on both sides of the device.

Turning now to FIG. 7b, we see there a schematic side or cross-sectional view of an optical device **730** in which a bottom-emitting OLED has been formed on a particular optical extraction film, namely, the extraction film **670** of FIG. 6c. Atop the outermost layer (transparent electrode layer **678**) of the extraction film has been formed or otherwise added thin high refractive index layers **716**, **717**, and one or more other layers depicted schematically (again) by layer **712**. At least one of the layers **716**, **717** comprise an organic light generating layer as described elsewhere herein, and one of the layers **716**, **717** may also comprise an electrode which may or may not be transparent. The layers **717**, **718**, in combination with the transparent electrode layer **678** of the extraction film, form a high refractive index light emitting region **714** that generates light of a desired wavelength in response to an applied electrical current or field. The refractive

indices of the constituent layers of region **714** may for example all fall within a range from 1.6 to 1.8. The region **714** is also typically very thin, for example, on the order of a wavelength of light, or less than 1 or 2 microns, for example, although other thicknesses may be used. The layer(s) comprising layer **712**, if present, are typically of substantially lower refractive index than those of the high index region **714**, and they are typically much thicker.

In the enlarged view of FIG. 7b, both light extraction elements **682** from structured surface **676a**, and one of the light extraction elements **675** from the structured surface **674a**, can be seen so as to give the reader some sense of size and thickness differences that may be realized between refractive elements and diffractive elements in some embodiments.

In the device **730**, the optical coupling surface **680a** of the extraction film is coincident with the light emitting surface of the OLED, since the outer boundary of the high index light emitting region **714** corresponds to a major surface of the transparent electrode layer **678**. As a result, the distances **689a**, **689b** represent not only the minimum and maximum axial distance from the structured surface **676a** to the optical coupling surface **680a**, but also the minimum and maximum axial distance (respectively) from the structured surface **676a** to the light emitting surface **680a** of the OLED. Some of the light generated within the high index region **714** is trapped in waveguiding modes for that region, and may be diffractively coupled out of the region **714** by light extraction elements **682**, and thereafter may be refractively coupled out of the OLED device by light extraction elements **675**, such light eventually exiting the device **730** through surface **672b**, which may now be considered the output surface of the device **730**.

Since the device **730** is a bottom-emitting OLED, light generated in the high index region **714** travels through the extraction film **670** and exits the device through the “bottom” surface as seen from the perspective of FIG. 7b, that is, from surface **672b**. In some cases, the device **720** may be designed to emit little or no light emitted from the opposite side of the device. In those cases, one, some, or all of the constituent components of layer **712** may be substantially opaque. In other cases the device **720** may emit light from both sides, whereupon the components of layer **712** may all be light-transmissive. In such cases, where the device is emitting from both sides, it would be useful to apply extraction features on both sides of the device.

Pixelated OLED Devices

The disclosed optical extraction films and film/OLED combinations can be practiced with a wide variety of different types of known OLEDs, including non-pixelated OLEDs that may typically be used in lighting applications, and pixelated OLEDs that may typically be used to generate images in an electronic display. FIG. 8 is a schematic top view of a typical pixelated OLED **810**. The OLED **810** is patterned to form distinct light-emitting areas **812a**, **812b**, **812c**,

and non-emitting areas between the emitting areas. Each of the emitting areas is preferably individually electronically addressable. The light-emitting areas are arranged in a repeating pattern to form a large array, such that any given light-emitting area or set of areas within the array can be illuminated at any given time to provide a static or video image.

5 In a monochrome display, the areas **812a-c** may emit light of the same spectral content or color. In this case, each individual area **812a**, **812b**, **812c** may represent a single pixel. In a color display, the areas **812a-c** may emit light of different colors, for example, areas **812a** may emit red light, areas **812b** may emit green light, and areas **812c** may emit blue light. Other colors and color combinations are also possible, and the OLED may include more or fewer than three different
10 colored areas, as is known in the pixelated display arts. In color displays, the different colored areas are typically grouped together to form pixels, in which case each individual emitting area within a given pixel may be referred to as a subpixel. In the case where OLED **810** is adapted for a color display, and where area **812a** emits red light, area **812b** emits green light, and area **812c** emits blue light, the area **814** may in one embodiment be considered to be a single pixel. The size
15 of that pixel may be characterized by various transverse dimensions, that is, dimensions measured in the plane of the figure. In cases where the pixel has a nominally rectangular shape, two relevant dimensions may be the length (span of the longer side) and the width (span of the shorter side) of the rectangle. Dimension **820** represents the width of pixel **814**. Another relevant dimension may be the maximum transverse dimension, such as the length of the diagonal of a rectangular pixel.
20 Note that if OLED **810** emitted monochrome light such that each individual area **812a**, etc. was a pixel, then that smaller pixel would have the same length as pixel **814**, but one-third the width of pixel **814**. Alternatively, if OLED **810** required four (rather than three) neighboring emitting areas to constitute a pixel, that pixel would have the same length as pixel **814**, but a width that was 4/3 times the width of pixel **814**.

25 FIGS. 9a and 9b demonstrate the difference between extracting light from a pixelated top-emitting OLED with an ordinary structured surface film, whose structured surface is exposed to air (non-embedded), and extracting light from the same pixelated top-emitting OLED with an extraction film that incorporates the disclosed nanovoiced layer and embedded structured surface. Stated simply, use of the nanovoiced layer and embedded structured surface allows the structured
30 surface to be disposed much closer to the OLED than that of the other film. This is because the nanovoiced layer allows the extraction film of FIG. 9b to be flipped over relative to that of FIG. 9a, such that the carrier film need not be interposed between the OLED and the structured surface. Instead, the (embedded) structured surface can be disposed between the carrier film and the OLED, and the land portion of the extraction film between the (embedded) structured surface and
35 the OLED can be made to have a thickness (for example, less than 50, 25, or 10 microns) that is

substantially less than that of a typical carrier film. Positioning the structured surface closer to the pixelated OLED can have significant advantages for reducing blurring of the pixels, particularly for OLEDs with small pixel sizes. Blurring of the pixels can arise when the structured surface of the extraction film contains refractive structures that scatter light in different directions.

5 An analogy can be drawn between such scattering and the scattering produced by an ordinary sheet of waxed paper. If a sheet of waxed paper is placed directly atop a page of printed text, an observer may still be able to discern the text through the waxed paper. However, if the waxed paper is slowly lifted so that the distance between the text and the scattering waxed paper increases, the text quickly becomes illegible because the boundaries of the letters of text become
10 too blurred by the scattering action of the waxed paper. Analogous to this, the embedded structured surface of FIG. 9b may produce little to no blurring of the pixelated OLED compared to the structured surface of FIG. 9a, as a result of the much closer proximity of the former structured surface to the OLED compared to that of the latter structured surface.

 Thus, FIG. 9a depicts a portion of a device **910** that results from an ordinary optical
15 extraction film **930** being applied to a pixelated top-emitting OLED **920**, and FIG. 9b depicts a portion of a device **950** that results from an optical extraction film **960**, which incorporates a nanovoiced layer and an embedded structured surface, being applied to the same pixelated top-emitting OLED **920**. In the figures, the labeled components of the OLED **920** include: a driver/controller **922**; a light emitting area (such as a pixel) **924**; an organic light generating layer
20 **926**; a transparent conductor **928**; and an optical coupling layer **929** that planarizes the OLED to provide a flat light-emitting surface **929a**. In FIG. 9a, an extraction film **930** having an exposed structured surface **934a** is applied to the OLED. The extraction film **930** includes: a carrier film **932**; an adhesive layer **931** to attach the carrier film to the OLED; and a coating layer **934** that has been embossed or otherwise formed to provide a structured surface **934a**, which may be shaped to
25 define light extraction elements such as lenticular prisms or lenses that are large enough to function based on principles of refraction. None of the individual layers of extraction film **930** are nanovoiced layers. In contrast, the extraction film **960** may have a construction similar to that described in connection with FIG. 4a, for example. Film **960** thus includes: a carrier film **912**; a nanovoiced layer **914**, which may have a refractive index in a range from 1.15 to 1.35, or 1.15 to
30 1.3; a layer **916** of higher refractive index than the nanovoiced layer **914**, the layer **916** preferably being a backfill and having an interface with the nanovoiced layer that defines a structured surface **914a** with extraction elements **915**, which elements **915** may be lenticular prisms or lenses that are large enough to function based on principles of refraction. A land portion of the layer **916** between the structured surface **914a** and the surface **916a** may be less than 50 microns, or less than 25
35 microns, or less than 10 microns, for example. Light from the pixelated OLED is in each case

emitted from an uppermost (from the viewpoint of FIGS. 9a and 9b) surface of the extraction film, that is, from structured surface **934a** in FIG. 9a, and from planar surface **912b** in FIG. 9b.

Further information on optical extraction films suitable for use with pixelated OLEDs can be found in commonly assigned U.S. Application XXX, "Light Extraction Films for Increasing Pixelated OLED Output With Reduced Blur" (Attorney Docket 67021US002), filed on even date
5 herewith and incorporated herein by reference in its entirety.

As explained above, the capability of the extraction film **960** to position the structured surface closer to the pixelated OLED than the extraction film **930** results in an advantage of reduced blurring for the extraction film **960**. Furthermore, the embedded nature of the structured
10 surface of film **960** provides advantage of robustness or resistance to damage from abrasion or other detrimental agents relative to the exposed nature of the structured surface of film **930**.

Examples

In the following examples, all parts, percentages, ratios, etc. are by weight, unless noted
15 otherwise. Solvents and other reagents used were obtained from Sigma-Aldrich Chemical Company, Milwaukee, Wisconsin unless specified differently.

Example 1: 50/60 Bullet-Shaped Extractors, Adhesive Backfill, No Haze in ULI

A computer simulation was performed of an OLED with an embedded extraction layer
20 using ray tracing methods and the modeling package LIGHTTOOLS (commercially available from Optical Research Associates, Pasadena, CA). The configuration that was simulated is shown generally as OLED device 520 in FIG. 5b. The microreplicated nanovoiced material of Ultra Low Index (ULI) (see for example, layer **414** in FIG. 5b) was modeled as having a refractive index of 1.2 and zero haze. The refractive index of the carrier film or substrate (see for example, layer **412**
25 in FIG. 5b) was selected to be 1.65 to model a polyethylene terephthalate (PET) substrate. The refractive index of the backfill layer (see for example, layer **416** of FIG. 5b) was selected to be 1.48 to model Soken 2032 pressure sensitive adhesive (commercially available from Soken Chemical & Engineering Co., Ltd, Japan). The substrate was assumed to have a thickness of 100 μm .

30 The extraction structure (see for example, the structured surface in FIG. 5b) was an array of bullet-shaped extraction elements with a 50 μm pitch, the array having a hexagonal arrangement of extraction elements in top or plan view. The shape of each extraction element is given by a surface of revolution generated by rotating a segment of a circle about an axis, explained more fully by reference to FIGS. 10a and 10b. The curved segment **1012** used to define the bullet-
35 shapes in Example 1 was the segment of a circle **1010** lying between an angle θ_1 and an angle θ_2

as measured from an axis **1005** in the plane of the circle that passes through the center of the circle. In the bullet shapes of Example 1, θ_1 was 50 degrees and θ_2 was 60 degrees. The segment **1012** was then rotated about an axis **1015**, the axis **1015** being parallel to axis **1005** but intersecting the endpoint of the curved segment, so as to generate the bullet-shaped surface of revolution **1020**.

5 The optical performance of this optical extraction film bonded onto the substrate side of an OLED was simulated and the color uniformity was determined as the maximum angular color deviation in the CIE 1976 $L^* u^* v^*$ color space (CIE Standard S 014-5/E:2009). In terms of the (u', v') chromaticity coordinates, the color deviation is given by

$$\Delta u'v' = \sqrt{(u' - u'_0)^2 + (v' - v'_0)^2},$$

10 where (u'_0, v'_0) are the chromaticity coordinates of a reference source - in this case the axial luminance of the OLED - to evaluate the angular color uniformity. The integral gain was determined as the integrated power ratio of the OLED with the extraction film and the OLED without the extraction film. The parameters of the OLED used in the simulation were based on experimental measurements of a Philips Lumiblade OLED (available from Philips Lighting U.S.,
15 Somerset, NJ). We used experimentally measured OLED characteristics in the model and optimization. The OLED was first apertured down to 1cm×1cm surface area, and then optically coupled at the substrate side with index-matching oil to a 2.5-inch-diameter BK7 half ball lens, whose spherical surface was antireflection-coated. Because the refractive index of the OLED substrate closely matches the BK7 half-ball lens, the reflection and refraction at the outer substrate
20 surface are eliminated, allowing accurate measurement of the OLED emission into the substrate and the OLED reflection at the OLED/substrate interface. Specifically, the angular-spectral luminance and reflectivity of the OLED were characterized and used in the simulation. When combined with computer-designed extraction layer profiles, the OLED device can be modeled accurately. The computed color deviation as a function of angle is given in Table 1 below, where
25 the angle is the observation angle in air relative to the optical axis or surface normal of the modeled device. The maximum angular color non-uniformity with and without the embedded extraction film was 0.0115 and 0.0242, respectively. The integral gain with the modeled extraction film was 1.48.

TABLE 1

Angle (degrees)	$\Delta u'v'$ OLED with Extraction Film	$\Delta u'v'$ Original OLED
88.5	0.0060	0.0242
85.5	0.0053	0.0219
82.5	0.0058	0.0202
79.5	0.0057	0.0193
76.5	0.0072	0.0189
73.5	0.0055	0.0182
70.5	0.0065	0.0178
67.5	0.0075	0.0174
64.5	0.0072	0.0171
61.5	0.0080	0.0166
58.5	0.0090	0.0158
55.5	0.0091	0.0150
52.5	0.0105	0.0143
49.5	0.0115	0.0134
46.5	0.0108	0.0124
43.5	0.0115	0.0115
40.5	0.0108	0.0102
37.5	0.0108	0.0088
34.5	0.0098	0.0073
31.5	0.0105	0.0061
28.5	0.0089	0.0048
25.5	0.0072	0.0036
22.5	0.0055	0.0027
19.5	0.0059	0.0015
16.5	0.0049	0.0010
13.5	0.0051	0.0005
10.5	0.0042	0.0005
7.5	0.0018	0.0003
4.5	0.0032	0.0006
1.5	0.0000	0.0000

These results are plotted in FIG. 11a, where curve **1110** is the color deviation of the modeled OLED/extraction film combination, and curve **1112** is the color deviation of the OLED with no extraction film.

Example 2: 50/60 Bullet-Shaped Extractors, Adhesive Backfill, Haze in ULI

An OLED with an optical extraction film was simulated in the same way as in Example 1, except that some haze was included in the nanovoiced Ultra Low Index (ULI) layer. This was simulated by adding scattering centers to the simulated nanovoiced layer, where the scattering centers scattered light primarily in the forward 45° cone angle, and with a scattering probability set

at 20% (that is, the probability for a light ray to be scattered at least once upon traveling through the layer was set to 20%). With this built-in haze in the nanovoiced layer of the simulated extraction film, the angular color non-uniformity was reduced to 0.010, and the integral gain was improved to 1.51.

5

Example 3: 50/60 Bullet-Shaped Extractors, HRI Backfill, No Haze in ULI

An OLED with an optical extraction film was simulated in the same way as in Example 1, except that the refractive index of the nanovoiced ULI material was set to 1.26 (rather than 1.2), and the refractive index of the backfill material (see for example, layer 416 in FIG. 5b) was chosen to be 1.65 (rather than 1.48) which is representative of a high refractive index curable resin such as a nanozirconia-filled UV curable acrylate resin, such as those described in U.S. Patent 7,547,476 (Jones et al.).

The color non-uniformity and integral gain were determined as in Example 1. The calculated color deviation is given in Table 2. The maximum angular color non-uniformity with and without the optical extraction film was 0.0083 and 0.0242, respectively. The integral gain with the extraction film was 1.55.

TABLE 2

Angle (degrees)	$\Delta u'v'$ OLED with Extraction Film	$\Delta u'v'$ Original OLED
88.5	0.0022	0.0242
85.5	0.0030	0.0219
82.5	0.0053	0.0202
79.5	0.0083	0.0193
76.5	0.0072	0.0189
73.5	0.0072	0.0182
70.5	0.0072	0.0178
67.5	0.0060	0.0174
64.5	0.0059	0.0171
61.5	0.0054	0.0166
58.5	0.0060	0.0158
55.5	0.0058	0.0150
52.5	0.0048	0.0143
49.5	0.0065	0.0134
46.5	0.0058	0.0124
43.5	0.0075	0.0115
40.5	0.0062	0.0102
37.5	0.0067	0.0088
34.5	0.0068	0.0073
31.5	0.0070	0.0061

28.5	0.0055	0.0048
25.5	0.0040	0.0036
22.5	0.0037	0.0027
19.5	0.0020	0.0015
16.5	0.0014	0.0010
13.5	0.0013	0.0005
10.5	0.0008	0.0005
7.5	0.0002	0.0003
4.5	0.0010	0.0006
1.5	0.0000	0.0000

These results are plotted in FIG. 11b, where curve **1120** is the color deviation of the modeled OLED/extraction film combination, and curve **1122** is the color deviation of the OLED with no extraction film.

5

Example 4: 50/60 Bullet-Shaped Extractors, HRI Backfill, Haze in ULI

An OLED with an optical extraction film was simulated in the same way as in Example 3, except that some haze was included in the nanovoiced Ultra Low Index (ULI) layer, the same haze as described in Example 2. The color non-uniformity and integral gain were determined as in

Example 1. The angular color non-uniformity was reduced to 0.007, and the integral gain was improved to 1.57.

10

Example 5: Bullet-Shaped Extractors plus 1-D prism array

An OLED with an extraction film was simulated in the same way as in Example 1, except that a 1-dimensional (that is, linearly extending) prism film was added to the substrate on the side opposite the OLED layer (see for example, surface 412b in FIG. 5b), with the peaks of the prisms facing away from the OLED layer. The pitch of the prism array was 50 μm . The refractive index of the prism material was chosen to be the same as the substrate ($n=1.65$) and all other device

parameters were the same as those in Example 1.

15

20

The calculated color deviation is given in Table 3. The maximum color non-uniformity was 0.0126 and the integrated gain was 1.34. Although the integrated gain is lower than that of Examples 1 and 2, the emitted light was substantially collimated in this example.

TABLE 3

Angle (degrees)	$\Delta u'v'$ OLED with Extraction Film	$\Delta u'v'$ Original OLED
88.5	0.008	0.0242
85.5	0.0105	0.0219
82.5	0.0074	0.0202
79.5	0.0066	0.0193
76.5	0.005	0.0189
73.5	0.0079	0.0182
70.5	0.0067	0.0178
67.5	0.0084	0.0174
64.5	0.01	0.0171
61.5	0.0126	0.0166
58.5	0.0118	0.0158
55.5	0.0122	0.0150
52.5	0.0119	0.0143
49.5	0.0098	0.0134
46.5	0.0111	0.0124
43.5	0.011	0.0115
40.5	0.01	0.0102
37.5	0.009	0.0088
34.5	0.0085	0.0073
31.5	0.0062	0.0061
28.5	0.0048	0.0048
25.5	0.0035	0.0036
22.5	0.0036	0.0027
19.5	0.0029	0.0015
16.5	0.0024	0.0010
13.5	0.0029	0.0005
10.5	0.0023	0.0005
7.5	0.0018	0.0003
4.5	0.0002	0.0006
1.5	0.0000	0.0000

These results are plotted in FIG. 11c, where curve **1130** is the color deviation of the modeled OLED/extraction film combination, and curve **1132** is the color deviation of the OLED with no
5 extraction film.

Example 6: Low haze ULI, Soken PSA backfill

Light extraction films were made with microreplicated nanovoiced material (also referred to as Ultra Low Index or ULI material) as described below. Detailed information about
10 microreplicated ULI and the process for making microreplicated ULI structures can be found in the commonly assigned U.S. patent application (Attorney Docket 66015US005) referenced

elsewhere herein.

Bullet-Shaped Microreplication Tooling

Bullet-shaped microreplication tooling was made for this Example 6 using an excimer laser machining process as described in U.S. Patent 6,285,001 (Fleming et al.). The resulting pattern was translated into a copper roll having an inverted bullet shape where the bullet features were arranged in a closely packed hexagon pattern with 50 μm pitch and the shape of the bullet was substantially as described in Example 1, except that the curved arc that defines the surface of revolution was bounded by angles $\theta_1 = 25$ degrees and $\theta_2 = 65$ degrees. The copper roll was then used as a replication master for a continuous cast and cure process using Accentrim resin (a urethane containing UV curable acrylate resin with a composition of 75% by weight PHOTOMER 6210 available from Cognis and 25% 1,6-hexanedioldiacrylate available from Aldrich Chemical Co., and a photoinitiator, 1% by weight Darocur 1173 from Ciba Specialty Chemicals). The Accentrim resin was cast onto a PET support film (DuPont 618 PET Film, 5 mil thickness) and then cured against a precision cylindrical tool using ultraviolet light.

A-174 Treated Silica Nanoparticles

In a 2 liter three-neck flask, equipped with a condenser and a thermometer, 960 grams of IPA-ST-UP organosilica elongated particles (available from Nissan Chemical Inc., Houston, TX), 19.2 grams of deionized water, and 350 grams of 1-methoxy-2-propanol were mixed under rapid stirring. The elongated particles had a diameter in a range from about 9 nm to about 15 nm and a length in a range of about 40 nm to about 100 nm. The particles were dispersed in a 15.2% wt IPA. Next, 22.8 grams of Silquest A-174 silane (available from GE Advanced Materials, Wilton, CT) was added to the flask. The resulting mixture was stirred for 30 minutes.

The mixture was kept at 81°C for 16 hours. Next, the solution was allowed to cool down to room temperature. Next, about 950 grams of the solvent in the solution were removed using a rotary evaporator under a 40 °C water-bath, resulting in a 41.7 wt% A-174-modified elongated silica clear dispersion in 1-methoxy-2-propanol.

Low Haze, Low Index Formulation (ULI resin)

To an amber glass jar was added 194.1 g of a 41.78 wt% solution of A-174 treated silica nanoparticles IPA-ST-UP in 1-methoxy-2-propanol. To the jar was also added 64.87 g of Sartomer SR 444 and 40.5 g of Sartomer CN 9893 (both available from Sartomer Company, Exton, PA) as a 40% solution in ethyl acetate, 1.458 g of Irgacure 184, 0.48 g of Irgacure 819 (both available from Ciba Specialty Chemicals Company, High Point, NC), and 1.5 g of TEGO® Rad 2250 (available from Evonik Tego Chemie GmbH, Essen, Germany). The contents of the formulation were mixed thoroughly, giving a UV curable ULI resin with 50.5% solids by weight.

Ultra Low Index (ULI) structures

The bullet film from the above-mentioned continuous cast and cure process was taken and treated for release. The release treatment consisted of first an oxygen plasma treatment of the film 500ccm O₂ at 200W for 20 seconds followed by a tetramethylsilane (TMS) plasma treatment, 200ccm TMS at 150W for 90 seconds. This film was then used as the replication master for a continuous cast and cure process to micro-replicate ultra low index (ULI) structures. The ULI resin was 50.5% solids by weight and was replicated on 3 mil thick primed PET film. The resin was cured using an LED curing system running at 35.3V and 5.85 amps. The microreplicated ULI films were postcured using a Fusion Lamp (H-Bulb). The refractive index of the microreplicated ULI layer was measured using a Metricon Model 2010 Prism Coupler (available from Metricon Corporation, Pennington, NJ) and was found to be about 1.25. FIG. 10c shows an optical micrograph of the structured surface **1030** of the ULI replica that was made, where individual bullet-shaped extraction elements **1032** are clearly visible.

Extraction Film

The ULI film was backfilled with Soken 2032 pressure sensitive adhesive (commercially available from Soken Chemical & Engineering Co., Ltd, Japan) by lamination under pressure using a heated roller laminator with rollers at 230 °F. Full filling of the PSA into the ULI bullet template was confirmed by optical microscopy. The film was also interrogated with a laser pointer and a similar refraction pattern was observed as for the bullet film tool that was replicated from the original copper tool.

The optical performance of this light extraction film was evaluated by bonding the backfilled adhesive layer of the extraction film to the substrate side of a Philips Lumiblade OLED test vehicle (available from Philips Lighting U.S., Somerset, NJ). The integral gain was measured as the integrated power ratio of the OLED with the extraction film and the OLED without the extraction film. The maximum angular color non-uniformity with the embedded extraction film showed an improvement relative to the OLED without the embedded extraction film. The integral gain with the embedded extraction film was 1.28.

Example 7: OLED with ULI-based internal extraction film

400nm 1D Structures

The microreplication tool used for this experimental example 7 was a film replicate made by a cast and cure process from a metallic cylindrical tool pattern. The tool used for making the “sawtooth” 1-dimensional structured film tool (linearly extending prisms with a 400 nm pitch) was a modified diamond-turned metallic cylindrical tool pattern that was cut into the copper surface of the tool using a precision diamond turning machine. The resulting copper cylinder with precision

sawtooth cut features (an SEM image of which is shown in FIG. 12) was nickel plated and coated with PA11-4. The plating and coating process of the copper master cylinder is a common practice used to promote release of cured resin during the microreplication process. The film replicate was made using an acrylate resin composition comprising acrylate monomers (75% by weight
5 PHOTOMER 6210 available from Cognis and 25% by weight 1,6-hexanedioldiacrylate available from Aldrich Chemical Co.) and a photoinitiator (1% by weight Darocur 1173, Ciba Specialty Chemicals) that was cast onto a PET support film (5 mil thicknesses) and then cured against the precision cylindrical tool using ultraviolet light.

The surface of the resulting structured film was coated with a silane release agent
10 (tetramethylsilane) using a plasma-enhanced chemical vapor deposition (PECVD) process. The release treatment consisted of an oxygen plasma treatment of the film with 500ccm O₂ at 200W for 20 seconds followed by a tetramethylsilane (TMS) plasma treatment with 200ccm TMS at 150W for 90 seconds. The surface-treated structured film was then used as a tool by wrapping and securing a piece of the film, structured side out, to the surface of a casting roll.

15 Low Haze, Low Index Formulation

A-174 treated IPA-ST-UP silica nanoparticles were prepared as in Example 6. To an amber glass jar was added 131.25 g of a 40wt% solution of A-174 treated silica nanoparticles IPA-ST-UP in 1-methoxy-2-propanol. To the jar was also added 42 g of Sartomer SR 444 and 10.5 g of Sartomer CN 9893 (both available from Sartomer Company, Exton, PA), 0.2875 g of Irgacure
20 184, 0.8 g of Irgacure 819 (both available from Ciba Specialty Chemicals Company, High Point, NC), 1 g of TEGO[®] Rad 2250 (available from Evonik Tego Chemie GmbH, Essen, Germany) and 25.5 grams of ethyl acetate. The contents of the formulation were mixed thoroughly giving a UV curable ULI resin with 50.5% solids by weight.

1D-ULI (Ultra Low Index) structures

The 400nm pitch saw tooth film described above under "400nm 1D Structures" was taken and treated for release. The release treatment consisted of first an oxygen plasma treatment of the film with 500ccm O₂ at 200W for 20 seconds followed by a tetramethylsilane (TMS) plasma
treatment with 200ccm TMS at 150W for 90 seconds. The surface-treated structured film was then used as a tool by wrapping and securing a piece of the film, structured side out, to the surface of a
30 casting roll.

A film microreplication apparatus was employed to create microstructured nanovoiced structures on a continuous film substrate. The apparatus included: a needle die and syringe pump for applying the coating solution; a cylindrical microreplication tool; a rubber nip roll against the tool; a series of UV-LED arrays arranged around the surface of the microreplication tool; and a
35 web handling system to supply, tension, and take up the continuous film. The apparatus was

configured to control a number of coating parameters manually including tool temperature, tool rotation, web speed, rubber nip roll/tool pressure, coating solution flow rate, and UV-LED irradiance. An example process is illustrated in FIG. 2.

The coating solution (see above) was applied to a 3 mil PET film (DuPont Melinex film primed on both sides) adjacent to the nip formed between the tool and the film. The flow rate of the solution was adjusted to about 0.25 ml/min and the web speed was set to 1 ft/min so that a continuous, rolling bank of solution was maintained at the nip.

The UV-LED bank used 8 rows with 16 LEDs (Nichia NCCU001, peak wavelength = 385 nm) per row. The LEDs were configured on 4 circuit boards that were positioned such that the face of each circuit board was mounted at a tangent to the surface of the microreplication tool roll and the distance of the LEDs could be adjusted to distance of between 0.5 and 1.5 inches. The LEDs were driven 16 parallel strings of 8 LEDs in series. The UV-LED bank was controlled by adjusting the device current. For the experiments described herein the current was set to approximately 5.6 amps at 35.4 V with a distance of the LEDs to the microreplication tooling being between 0.5 and 1.0 inches. The irradiance was uncalibrated. The coating solution was cured with the solvent present as the film and tool rotated past the banks of UV LEDs, forming micro-replicated nano-porous structure arrays corresponding to the negative or 3-dimensional inverse or complement of the tool structure.

The structured film separated from the tool and was collected on a take-up roll. The nano-structured coating was further cured (post-process curing) by UV radiation to improve the mechanical characteristics of the coating. The post-process curing was accomplished using a Fusion Systems Model I300P (Gaithersburg MD) fitted with an H-bulb. The UV chamber was nitrogen-inerted to approximately 50 ppm oxygen.

OLED with ULI based internal extraction film

The nanoreplicated ULI layer on PET was backfilled and roughly planarized with a 1000 nm thick layer of silicon nitride by plasma-enhanced chemical vapor deposition (PECVD, Model PlasmaLab™ System100 available from Oxford Instruments, Yatton, UK). The parameters used in the PECVD process are set forth in Table 4.

TABLE 4

Reactant/Condition:	Value:
SiH ₄	400 sccm
NH ₃	20 sccm
N ₂	600 sccm
Pressure	650 mTorr
Temperature	100°C
High frequency (HF) power	20W
Low frequency (LF) power	20W

The refractive index of the silicon nitride layer was measured using a Metricon Model 2010 Prism Coupler (available from Metricon Corporation, Pennington, NJ) and was found to be 1.78. The refractive index contrast (difference in refractive indices) between the ULI and silicon nitride backfill in the nanostructured layer was about 0.5.

OLED fabrication on the planarized substrate began with approximately 110nm-thick ITO deposited onto the silicon nitride backfill-coated 1D structures through a shadow mask to define the anode geometry with a 5x5mm active area. Subsequently, a green organic emitting stack and cathode were deposited to complete the OLED. The OLEDs were fabricated by standard thermal deposition through a set of shadow masks in a vacuum system at base pressure of ca. 10^{-6} Torr.

The following OLED construction was deposited:

HIL(300nm)/HTL(40nm)/EML(30nm,6%)/ETL(20nm)/ LiF(1nm)/Al(200nm), where HIL is a hole-injection layer, HTL is a hole-transport layer, EML is an emissive layer, and ETL is an electron transport layer.

After completion, the OLED was encapsulated by laminating a barrier encapsulation film as described in U.S. Patent 7,018,713 (Padiyath et al.) under inert atmosphere using SAES moisture and oxygen scavenging getters (available from SAES Getters USA, Inc., Colorado Springs, CO) in between the encapsulation film and the OLED cathode.

Samples were tested on an Autronic conoscope (available from Autronic-Melchers GmbH, Karlsruhe, Germany) to measure luminance and angularity. Table 5 shows the results of the measurement of several samples.

TABLE 5

Example	Voltage at 10 mA/cm ²	Axial Lum. (cd/m ²)	Max. Lum. (cd/m ²)	θ at Max Lum.	Φ at Max Lum.	Integrated Intensity (lm/m ²)	Axial Lum. (cd/m ²)	Total Gain	On-axis Gain
Example 7, Sample A	7	6186	6486	8	104	14953	6186	1.56	1.44
Example 7, Sample B	7.1	5866	6092	10	296	13938	5866	1.46	1.37
Example 7, Sample C	7	6156	6313	13	245	14797	6156	1.55	1.43
Example 7, Sample D	7	5943	6214	9	251	14815	5943	1.55	1.38
Example 7, Sample E	7	5693	5845	9	290	13801	5693	1.44	1.33
Example 7, Sample F	7.1	5624	6049	10	285	14293	5624	1.49	1.31
Example 7, Sample G	7.6	5404	5673	14	291	13601	5404	1.66	1.47

Example 7, Sample H	6.5	5153	5321	5	69	12455	5153	1.52	1.41
Example 7, Sample I	7	5088	5291	11	271	12748	5088	1.56	1.39
Example 7, Sample J	6.9	5283	5451	4	28	12621	5283	1.54	1.44
Example 7, Sample K	7.1	5225	5347	2	53	12387	5225	1.51	1.42

The measured values of the total gain and the on-axis gain are summarized in the right-most columns of FIGS. 13a and 13b, respectively, labeled as “Resin B”. The diamond-shaped markings in the figure represent statistical measures of the group of data.

5

Comparative Example 1: OLED with Accentrim-based internal extraction film

A nanoreplicated film was made as described in Example 7, except that a non-nanovoiced Accentrim resin (an urethane containing UV curable acrylate resin with a composition of 75% by weight PHOTOMER 6210 available from Cognis and 25% 1,6-hexanedioldiacrylate available from Aldrich Chemical Co. and a photoinitiator, 1% by weight Darocur 1173 from Ciba Specialty Chemicals) was used instead of the nanovoiced ULI material. The 400 nm pitch sawtooth structured surface was formed in the Accentrim resin, which was then backfilled and roughly planarized with a 1000 nm thick layer of silicon nitride by plasma-enhanced chemical vapor deposition (PECVD, Model PlasmaLab™ System100 available from Oxford Instruments, Yatton, UK). The parameters used in the PECVD process are as described in Example 7.

The refractive index of the silicon nitride layer was measured using a Metricon Model 2010 Prism Coupler (available from Metricon Corporation, Pennington, NJ), and was found to be 1.78. The refractive index of the Accentrim resin was about 1.48. The refractive index contrast between the Accentrim-based nanostructure and silicon nitride backfill in the nanostructured layer was about 0.2.

An OLED was fabricated on the backfilled substrate and encapsulated with a barrier film as described in Example 7. Samples were tested on an Autronic conoscope (available from Autronic-Melchers GmbH, Karlsruhe, Germany) to measure luminance and angularity. Table 6 shows the measurement results of several samples.

25

TABLE 6

Example	Voltage at 10 mA/cm ²	Axial Lum. (cm/m ²)	Max. Lum. (cm/m ²)	θ at Max Lum.	Φ at Max Lum.	Integrated Intensity (lm/m ²)	Axial Lum. (cm/m ²)	Total Gain	On-axis Gain
Comp. Ex. 1, Sample A	10.1	3721	5763	11	110	12299	3721	1.29	0.87
Comp. Ex. 1, Sample B	7.2	3973	6155	11	71	13242	3973	1.38	0.93
Comp. Ex. 1, Sample C	8.5	4265	5921	10	296	12979	4265	1.36	0.99
Comp. Ex. 1, Sample D	6.9	4459	6155	10	296	13588	4459	1.42	1.04
Comp. Ex. 1, Sample E	10.3	4535	5927	14	316	13362	4535	1.4	1.06
Comp. Ex. 1, Sample F	7.1	3290	4264	12	288	9586	3290	1.17	0.9
Comp. Ex. 1, Sample G	6.6	3565	4503	12	276	10268	3565	1.25	0.97

The measured values of the total gain and the on-axis gain of these comparative examples are summarized in the middle columns of FIGS. 13a and 13b, respectively, labeled as “Resin A”.

5 Comparative Example 2: OLED on Glass

A control sample OLED was fabricated on glass for comparison with the 1-D nanostructure samples. The fabrication and encapsulation was as described in Example 7, except that no optical extraction film was used. Samples were tested on an Autronic conoscope (available from Autronic-Melchers GmbH, Karlsruhe, Germany) to measure luminance and angularity.

10 Table 7 shows the results of the measurement results of several samples.

TABLE 7

Example	Voltage at 10 mA/cm ²	Axial Lum. (cm/m ²)	Max. Lum. (cm/m ²)	θ at Max Lum.	Φ at Max Lum.	Integrated Intensity (lm/m ²)	Axial Lum. (cm/m ²)	Total Gain	On-axis Gain
Comp. Ex. 2, Sample A	7.7	4236	4250	2	67	9458	4236	0.99	0.99
Comp. Ex. 2, Sample B	7.8	4311	4324	2	24	9671	4311	1.01	1
Comp. Ex. 2, Sample C	7.8	4309	4334	2	53	9560	4309	1	1
Comp. Ex. 2, Sample D	7.9	4315	4331	2	53	9570	4315	1	1.01
Comp. Ex. 2, Sample E	7	3621	3637	0	271	8010	3621	0.98	0.99
Comp. Ex. 2, Sample F	7.2	3735	3755	2	53	8323	3735	1.02	1.02
Comp. Ex. 2, Sample G	7.2	3690	3708	2	53	8283	3690	1.01	1.01

Comp. Ex. 2, Sample H	7.1	3622	3634	0	271	8115	3622	0.99	0.99
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The measured values of the total gain and the on-axis gain of these comparative examples are summarized in the left-most columns of FIGS. 13a and 13b, respectively, labeled as “glass”.

- 5 Unless otherwise indicated, all numbers expressing quantities, measurement of properties, and so forth used in the specification and claims are to be understood as being modified by the term “about”. Accordingly, unless indicated to the contrary, the numerical parameters set forth in the specification and claims are approximations that can vary depending on the desired properties sought to be obtained by those skilled in the art utilizing the teachings of the present application.
- 10 Not as an attempt to limit the application of the doctrine of equivalents to the scope of the claims, each numerical parameter should at least be construed in light of the number of reported significant digits and by applying ordinary rounding techniques. Notwithstanding that the numerical ranges and parameters setting forth the broad scope of the invention are approximations, to the extent any numerical values are set forth in specific examples described herein, they are
- 15 reported as precisely as reasonably possible. Any numerical value, however, may well contain errors associated with testing or measurement limitations.

- Various modifications and alterations of this invention will be apparent to those skilled in the art without departing from the spirit and scope of this invention, and it should be understood that this invention is not limited to the illustrative embodiments set forth herein. For example, the
- 20 reader should assume that features of one disclosed embodiment can also be applied to all other disclosed embodiments unless otherwise indicated. It should also be understood that all U.S. patents, patent application publications, and other patent and non-patent documents referred to herein are incorporated by reference, to the extent they do not contradict the foregoing disclosure.

CLAIMS

1. An optical extraction film for enhancing light extraction from a self-emissive light source, comprising:

a flexible carrier film; and

a first and second layer carried by the carrier film, the first and second layers defining therebetween a first embedded interface;

wherein the first embedded interface forms a first structured surface of first light extraction elements;

wherein the first layer has a nanovoiced morphology and comprises a polymer binder, the first layer also having a refractive index less than 1.35;

wherein the second layer has a refractive index greater than that of the first layer; and

wherein the first layer is disposed between the carrier film and the second layer.

2. The extraction film of claim 1, wherein the first layer has a refractive index less than 1.3.

3. The extraction film of claim 1, wherein the second layer has a refractive index greater than 1.4.

4. The extraction film of claim 1, wherein a refractive index difference between the first and second layers is at least 0.3, or at least 0.4, or at least 0.5.

5. The extraction film of claim 1, wherein the first light extraction elements are small enough and the second layer is thin enough so that a substantial portion of the extraction elements are disposed within an evanescent zone of the self-emissive light source when the extraction film is combined with the self-emissive light source.

6. The extraction film of claim 1, wherein the first light extraction elements comprise diffractive elements.

7. The extraction film of claim 1, wherein the first light extraction elements have a pitch of less than 1 micrometer.
8. The extraction film of claim 1, wherein the first light extraction elements have a pitch of greater than 1 micrometer.
9. The extraction film of claim 8, wherein the first light extraction elements comprise refractive elements.
10. The extraction film of claim 8, wherein the first light extraction elements have associated therewith a land, and the land has a thickness of less than 50 microns.
11. The extraction film of claim 10, wherein the land thickness is less than 25 microns.
12. The extraction film of claim 1, wherein the second layer comprises a light transmissive viscoelastic material.
13. The extraction film of claim 12, further comprising a release liner covering a major surface of the second layer opposite the first structured surface.
14. The extraction film of claim 1, wherein the extraction film is adapted for application to the self-emissive light source which is fabricated separately from the extraction film.
15. The extraction film of claim 1, wherein the extraction film is adapted as a substrate on which the self-emissive light source can be fabricated.
16. The extraction film of claim 1, wherein the carrier film has physical characteristics making it suitable as a free-standing support film in roll-to-roll processing.

17. The extraction film of claim 1, wherein neither the first layer nor the second layer has physical characteristics making it suitable as a free-standing support film in roll-to-roll processing.

18. An optical extraction film for enhancing light extraction from a self-emissive light source, comprising:

- a flexible carrier film; and

- a first and second layer carried by the carrier film, the first and second layers defining therebetween a first embedded interface;

- a third layer carried by the carrier film, the first and third layers defining therebetween a second embedded interface;

- wherein the first embedded interface forms a first structured surface of first light extraction elements;

- wherein the first layer has a nanovoiced morphology and comprises a polymer binder, the first layer also having a refractive index less than 1.35;

- wherein the second layer has a refractive index greater than that of the first layer; and

- wherein the second embedded interface forms a second structured surface of second light extraction elements.

19. The extraction film of claim 18, wherein the first light extraction elements have a pitch less than 1 micron and the second light extraction elements have a pitch greater than 1 micron.

20. The extraction film of claim 18, wherein a substantial portion of the first light extraction elements are adapted to be disposed within an evanescent zone of the self-emissive light source when the extraction film is combined with the self-emissive light source.

21. The extraction film of claim 18, wherein the second light extraction elements have associated therewith a land, and the land has a thickness of less than 50 microns.

22. The extraction film of claim 21, wherein the land thickness is less than 25 microns.

23. The extraction film of claim 1, wherein the self-emissive light source comprises an OLED.

24. The extraction film of claim 1 in combination with the self-emissive light source, wherein the first and second layers are disposed between the flexible carrier film and the self-emissive light source.

25. A device, comprising:

an OLED; and

an optical extraction film attached to the OLED;

wherein the optical extraction film includes a flexible carrier film and a first and second layer carried by the carrier film, the first and second layers defining therebetween a first embedded interface that forms a first structured surface of first light extraction elements;

wherein the first layer has a nanovoiced morphology and comprises a polymer binder, the first layer also having a refractive index less than 1.35; and

wherein the second layer has a refractive index greater than that of the first layer and is disposed between the first layer and the OLED.

26. The device of claim 25, wherein a high refractive index region is associated with the OLED, the high refractive index region comprising at least one organic light generating layer and at least one transparent electrode layer, and wherein a substantial portion of the first light extraction elements are disposed within an evanescent zone of the high refractive index region.

27. The device of claim 26, wherein the at least one transparent electrode layer is part of the optical extraction film.

28. The device of claim 25, wherein the first light extraction elements comprise refractive elements and have a pitch of greater than 1 micron.

29. The device of claim 28, wherein the first light extraction elements have associated therewith a land, and the land has a thickness of less than 50 microns.

30. The device of claim 28, wherein the land has a thickness of less than 25 microns.