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[Designation of Document] SPECIFICATION

[Title of the Invention] Active Matrix Type Liquid
Crystal Display Device

[Claims]

5 [Claim 1] A liquid crystal display device
comprising:

a pair of insulating substrate disposed opposite
each other;

10 a pair of orientation films formed over the
insulating substrates;

a liquid crystal composition held between the
pair of orientation films;

15 pixel electrodes and counter electrodes to apply
a lateral electric field almost parallel to surfaces
of the substrates; and

a pair of polarizers holding the pair of
substrates therebetween;

20 wherein an initial orientation angle β_1 between
an in-plane direction of the lateral electric field
and an initial orientation direction on one
orientation film side and an initial orientation angle
 β_2 between the in-plane direction of the lateral
electric field and an initial orientation direction on
the other orientation film side are in the
25 relationship of $\beta_1 \neq -\beta_2$;

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wherein an angle between the in-plane direction of the lateral electric field and a polarizing axis of one of the polarizers is almost zero.

[Claim 2] A liquid crystal display device
5 comprising:

a pair of insulating substrate disposed opposite each other;

a pair of orientation films formed over the insulating substrates;

10 a liquid crystal composition held between the pair of orientation films;

pixel electrodes and counter electrodes to apply a lateral electric field almost parallel to surfaces of the substrates; and

15 a pair of polarizers holding the pair of substrates therebetween;

wherein the liquid crystal composition has a positive dielectric anisotropy;

wherein an initial orientation angle β_1 between
20 an in-plane direction of the lateral electric field and an initial orientation direction on one orientation film side and an initial orientation angle β_2 between the in-plane direction of the lateral electric field and an initial orientation direction on
25 the other orientation film side have opposite signs



and are in the relationship of $|\beta_1 + \beta_2| \leq 20$ degrees;

wherein an angle between the in-plane direction of the lateral electric field and a polarizing axis of one of the polarizers is almost zero.

[Claim 3] A liquid crystal display device according to claim 2, wherein $35 \text{ degrees} \leq |\beta_1| < 90 \text{ degrees}$ and $35 \text{ degrees} \leq |\beta_2| < 90 \text{ degrees}$ hold.

[Claim 4] A liquid crystal display device according to claim 1, 2 or 3, wherein optical compensation liquid crystal cells are arranged on the upper side or the lower side of the pair of the opposing substrates

[Claim 5] A liquid crystal display device according to claim 4, wherein in the optical optical compensation liquid crystal cells, an initial orientation angle β_3 between an in-plane direction of the lateral electric field and an initial orientation direction on one orientation film side and an initial orientation angle β_4 between the in-plane direction of the lateral electric field and an initial orientation direction on the other orientation film side have the relationship, with respect to β_1 and β_2 , of $|\beta_3 - \beta_4| \approx |\beta_1 - \beta_2|$, and the angle β_3 is almost perpendicular to the angle β_2 .



[Claim 6] A liquid crystal display device according to claim 5, wherein a product of a refractive index anisotropy of the liquid crystal composition in the optical compensation liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$)' and a product of a refractive index anisotropy of a liquid crystal composition in a drive liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is in the relationship of

10
$$0.4 \cdot (\Delta n \cdot d) \leq (\Delta n \cdot d)' \leq 0.6 \cdot (\Delta n \cdot d)$$

[Claim 7] A liquid crystal display device according to claim 6, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the in-plane electric field are in the relationship of

$$90 \text{ degrees} \leq |\phi_1 - \phi_2| \leq 120 \text{ degrees}$$

[Claim 8] A liquid crystal display device according to claim 6, wherein the angle β_1 and the angle β_2 are in the relationship of

$$90 \text{ degrees} \leq |\beta_1 - \beta_2| \leq 115 \text{ degrees}$$

[Claim 9] A liquid crystal display device according to claim 6, wherein a product of a refractive index anisotropy of the liquid crystal



composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

$$(\Delta n \cdot d) \geq 750 \text{ nm}$$

[Claim 10] A liquid crystal display device
5 according to claim 5, wherein a product of a refractive index anisotropy of the liquid crystal composition in the optical compensation liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$)' and a product of a refractive index anisotropy of
10 a liquid crystal composition in a drive liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is in the relationship of

$$(\Delta n \cdot d) = (\Delta n \cdot d)'$$

[Claim 11] A liquid crystal display device
15 according to claim 10, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the lateral
20 electric field are in the relationship of

$$|\phi_1 - \phi_2| = 90 \text{ degrees}$$

[Claim 12] A liquid crystal display device
according to claim 10, wherein the angle β_1 and the angle β_2 are in the relationship of

25 $70 \text{ degrees} \leq |\beta_1 - \beta_2| \leq 160 \text{ degrees}$



[Claim 13] A liquid crystal display device according to claim 10, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

$$(\Delta n \cdot d) \geq 750 \text{ nm}$$

[Claim 14] A liquid crystal display device according to claim 1, 2 or 3, wherein optical compensation phase films are arranged on the upper side, lower side or both sides of the pair of substrates.

[Claim 15] A liquid crystal display device according to claim 14, wherein the optical compensation phase films hold a cholesteric liquid crystal therebetween.

[Claim 16] A liquid crystal display device according to claim 14, wherein two or more of the optical compensation phase films are provided, with at least one film arranged between one of the substrates and the polarizer and at least one film arranged between the other substrate and the polarizer.

[Claim 17] A liquid crystal display device according to claim 16, wherein an angle γ_1 between one phase lagging axis of the optical compensation phase films and an in-plane direction of a lateral electric



field, and an angle γ_2 between the other phase lagging axis and the in-plane direction of the lateral electric field are

$$\gamma_1 = \beta_1/2 \text{ and } \gamma_2 = \beta_2/2$$

5 [Claim 18] A liquid crystal display device according to claim 17, wherein the sum of products $(\Delta n \cdot d)_n$ of a refractive index anisotropy and a thickness of a liquid crystal composition in the optical compensation phase films, and a product $(\Delta n \cdot$
10 $d)$ of a refractive index anisotropy and a thickness of a liquid crystal composition of drive liquid crystal cells are in the relationship of

$$0.4 \cdot (\Delta n \cdot d) \leq \sum_{i=1}^n (\Delta n \cdot d)_i \leq 0.6 \cdot (\Delta n \cdot d)$$

[Claim 19] A liquid crystal display device
15 according to claim 18, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the lateral
20 electric field are in the relationship of

$$90 \text{ degrees} \leq |\phi_1 - \phi_2| \leq 120 \text{ degrees}$$

[Claim 20] A liquid crystal display device according to claim 18, wherein the angle β_1 and the angle β_2 are in the relationship of



90 degrees $\leq |\beta_1 - \beta_2| \leq 115$ degrees

[Claim 21] A liquid crystal display device according to claim 18, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

$$(\Delta n \cdot d) \geq 750 \text{ nm}$$

[Claim 22] A liquid crystal display device according to claim 17, wherein the sum of products ($\Delta n \cdot d$)_n of a refractive index anisotropy and a thickness of a liquid crystal composition in the optical compensation phase films, and a product ($\Delta n \cdot d$) of a refractive index anisotropy and a thickness of a liquid crystal composition of drive liquid crystal cells are in the relationship of

$$\sum_{i=1}^n (\Delta n \cdot d)_i = (\Delta n \cdot d)$$

[Claim 23] A liquid crystal display device according to claim 22, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the lateral electric field are in the relationship of

$$|\phi_1 - \phi_2| = 90 \text{ degrees}$$



[Claim 24] A liquid crystal display device according to claim 22, wherein the angle β_1 and the angle β_2 are in the relationship of

$$70 \text{ degrees} \leq |\beta_1 - \beta_2| \leq 160 \text{ degrees}$$

5 [Claim 25] A liquid crystal display device according to claim 22, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

10 $(\Delta n \cdot d) \geq 750 \text{ nm}$

[Claim 26] A liquid crystal display device according to claim 14, wherein two or more of the optical compensation phase films are provided, with at least two films arranged between one of the substrates and the polarizer.

[Claim 27] A liquid crystal display device comprising:

a pair of insulating substrate disposed opposite each other;

20 a pair of orientation films formed over the insulating substrates;

a liquid crystal composition held between the pair of orientation films;

pixel electrodes and counter electrodes to apply
25 a lateral electric field almost parallel to surfaces



of the substrates; and

a pair of polarizers holding the pair of substrates therebetween;

wherein the liquid crystal composition has a
5 negative dielectric anisotropy;

wherein an initial orientation angle β_1 between
an in-plane direction of the lateral electric field
and an initial orientation direction on one
orientation film side and an initial orientation angle
10 β_2 between the in-plane direction of the lateral
electric field and an initial orientation direction on
the other orientation film side have opposite signs
and are in the relationship of

0 degree $< |\beta_1| \leq 55$ degrees and 0 degree $< |\beta_2|$
15 ≤ 55 degrees;

wherein an angle between the in-plane direction
of the lateral electric field and a polarizing axis of
one of the polarizers is almost zero.

[Claim 28]. A liquid crystal display device
20 according to claim 27, wherein an angle ϕ_1 between a
polarizing axis of one of the polarizers and the in-
plane direction of the lateral electric field and an
angle ϕ_2 between a polarizing axis of the other
polarizer and the in-plane direction of the lateral
25 electric field are in the relationship of



90 degrees $\leq |\phi_1 - \phi_2| \leq$ 120 degrees

[Claim 29] A liquid crystal display device according to claim 27, wherein the angle β_1 and the angle β_2 are in the relationship of

5 20 degrees $\leq |\beta_1 - \beta_2| \leq$ 50 degrees

[Claim 30] A liquid crystal display device according to claim 27, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

$(\Delta n \cdot d) \geq 750$ nm

[Claim 31] A liquid crystal display device according to claim 27, further comprising a pair of opposing insulating substrates, a pair of orientation films formed on the substrates to orientate a liquid crystal composition, and optical compensation liquid crystal cells holding the liquid crystal composition between the pair of orientation films.

[Claim 32] A liquid crystal display device according to claim 27, further comprising optical compensation phase films.

[Detailed Description of the Invention]

[0001]

[Technical Field to Which the Invention Belongs]

25 The present invention relates to a liquid crystal



display device and more particularly to an active matrix type liquid crystal display device using thin-film transistors.

[0002]

5 [Prior Art]

Active matrix type liquid crystal display devices using active devices represented by thin-film transistors (TFTs) are beginning to find wide uses as display terminals for office automation equipment
10 thanks to their features of small thickness and light weight and high display quality, compared to that of CRT. The display methods of the liquid crystal display device can be classified largely into two categories. In one method, a liquid crystal is held
15 between two substrates having transparent electrodes and the liquid crystal is activated by a voltage applied to the transparent electrodes to modulate light that has passed through the transparent electrodes and entered the liquid crystal to display
20 an image. Most of the liquid crystal display products currently in use adopt this method. In another method, the liquid crystal is activated by an electric field virtually parallel to a substrate surface between two electrodes formed on the substrate to
25 modulate the light entering the liquid crystal from a



gap between the two electrodes (hereinafter referred to as a lateral field method). This has an advantage of significantly wide viewing angle and is a prospective technique in connection with the active
5 matrix type liquid crystal display device. The features of the latter method are described mainly in Published Japanese Translation of PCT Patent Application from another state No. 505247/1993, Japanese Patent Publication No. 21907/1988 and
10 Japanese Patent Laid-Open No. 160878/1994.

[0003]

[Problems to be solved by the Invention]

The active matrix type liquid crystal display device described in the above patent application in
15 connection with the lateral field method (also called an in-plane switching method), however, has a response speed of about 100 ms at the fastest, far from the requirement of less than 40-20 ms for the display of dynamic images. This type of liquid crystal display
20 device has the drawback that when a dynamic image is displayed, its residual image is produced making the dynamic image look like a comet with a tail.

[0004]

An object of this invention is to provide an
25 active matrix type liquid crystal display device which

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has a wide viewing angle, compared to that of a CRT
and a response fast enough to display a dynamic image.

[0005]

The known lateral field method has the following
5 two types of configuration.

[0006]

The response time is defined as the sum of a rise
time at voltage application and a fall time at voltage
turn-off and will be detailed in the following.

10 [0007]

The first configuration has the liquid crystal
molecules in a liquid crystal layer initially
orientated in the same direction as the electric field
application direction on the interface of the liquid
15 crystal layer on the upper substrate side and, on the
interface on the lower substrate side, orientated
about 90 degrees from the electric field application
direction so that the liquid crystal molecules are
twisted about 90 degrees when the voltage is turned
20 off.

[0008]

The liquid crystal molecules in this state are
turned about 90 degrees in the electric field
application direction at the interface on the lower
25 substrate side by the electric field almost parallel



to the substrate surface generated by two electrodes (referred to as a lateral field) to eliminate their optical rotary power and thereby change their transmittance to display an image.

5 [0009]

This configuration, however, needs to rotate the liquid crystal molecules near the interface with the lower substrate by as much as about 90 degrees and therefore the drive voltage may easily become
10 extremely high, higher than 10 V. As for the response speed of this configuration, although the rise time can be made faster to some extent, the fall time takes on at least 40 ms because the liquid crystal molecules must turn back through 90 degrees. This response is
15 not fast enough for displaying a dynamic image.

[0010]

In the second configuration the liquid crystal molecules in the liquid crystal layer at the interfaces with the upper and lower substrate are
20 initially orientated almost in the same direction so that they are homogeneously orientated without any twist when the voltage is turned off. The liquid crystal molecules in this state are wholly rotated about 45 degrees in the electric field direction by
25 the lateral field (when the molecules have a positive



dielectric anisotropy. When they have a negative dielectric anisotropy, they are rotated in a direction perpendicular to the electric field) to change the birefringent index of the liquid crystal layer at that
5 time and therefore the transmittance to display an image.

[0011]

The second configuration can reduce the drive voltage to about 5 V, lower than that of the first
10 configuration, which is in a practical range except for a rapidly changing, specific dynamic pictures.

[0012]

In the second configuration, the response speed depends greatly on the thickness of the liquid crystal
15 layer between the upper and lower substrates and is faster as the liquid crystal layer thickness becomes smaller. When the gap between the substrates is made too narrow, the gap uniformity becomes difficult to maintain, with an increased chance of display
20 variations occurring. There is another problem that the process of injecting the liquid crystal is slow, taking a too long time. Considering these factors, the liquid crystal layer has a practical thickness limit of about 4 μm . The response speed therefore has
25 been some 60 ms at the fastest.



[0013]

Examples of the first configuration are described
in G. Baur et al, JAPAN DISPLAY 1992, PP.547-550, or
by R. A. Soref, Journal of Applied Physics, Vol. 45,
5 No. 12, December 1974, PP. 5466-5468, or by R. A.
Soref, Proceedings of the IEEE, December 1974, PP.
1710-1711.

[0014]

An example of the second configuration is found
10 in ASIA DISPLAY 1995, PP. 577-580 by M. Ohe et al.

[0015]

[Means to Solve the Problems]

A typical configuration of this invention is the
one in which the liquid crystal molecules in the
15 liquid crystal layer are initially orientated about 45
degrees from the voltage application direction at the
interface with the upper substrate and, at the
interface with the lower substrate, orientated about -
45 degrees from the voltage application direction so
20 that the liquid crystal molecules are twisted by some
90 degrees when the voltage is turned off.

[0016]

For easy understanding, the initial orientation
angle is defined as positive for a counterclockwise
25 rotation with respect to the in-plane direction of the



lateral field and ranges from -90 degrees to 90 degrees.

[0017]

To display an image, the liquid crystal molecules
5 in this state are rotated by the lateral field about -
45 degrees in the electric field direction at the
interface with the upper substrate and, at the
interface with the lower substrate, rotated about 45
degrees in the electric field direction to eliminate
10 their birefringence and thereby change their
transmittance, forming an image.

[0018]

In this configuration, the liquid crystal
molecules near the interfaces with the upper and lower
15 substrates need only to be turned about 45 degrees
respectively in opposite directions, which can be
realized by a lower voltage than that of the first
configuration. Further, because this configuration
comprises the two liquid crystal layers stacked
20 together, each twisted by 45 degrees about the center
of the liquid crystal layer in opposite directions,
this configuration is identical to the one in which
the gap between the substrates is reduced to about
one-half. That is, the liquid crystal molecules in
25 two stacked layers, because their activation force is



associated with the elastic relation among the liquid crystal molecules in each layer, are identical to the one having virtually one-half the liquid crystal layer thickness in terms of activation of the molecules.

5 [0019]

In the case of the first configuration, like the second configuration the response speed becomes faster as the liquid crystal layer thickness decreases, i.e., the response speed is approximately inversely
10 proportional to the square of the liquid crystal layer thickness. Further, because the liquid crystal layer of this embodiment rotates only 45 degrees, compared to 90 degrees in the first configuration, the response is about two times faster than that of the first
15 configuration. In theory, the configuration of this invention can achieve a response speed up to about eight times that of the first embodiment.

[0020]

Assuming that the fall time in the first
20 embodiment is about 45 ms, the configuration of this invention can theoretically realize a fall time of about 6 ms. Measurements show that this configuration achieved a response speed of about 20 ms.

[0021]

25 In this configuration, no reduction in the



response speed has resulted which has been observed in the conventional configurations during a half-tone display, and almost constant, fast response speed was obtained at any applied voltage.

5 [0022]

[Embodiments of the Invention]

This invention and further objects and features of this invention will become apparent from the following description with reference to the
10 accompanying drawings.

[0023]

(Embodiment 1)

<<Active Matrix Liquid Crystal Display Device>>

An embodiment of an active matrix type color
15 liquid crystal display device to which this invention is applied will be described in the following. In the drawings, parts having identical functions are denoted by like reference numbers and their descriptions will not be repeated.

20 [0024]

<<Planar Configuration of a Matrix Portion (Pixel Portion)>>

Figure 1 is a plan view showing one pixel and its peripheral portion in an active matrix type color
25 liquid crystal display device.

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[0025]

As shown in Figure 1, each pixel is arranged inside an intersection area (an area enclosed by four signal lines) enclosed by a scanning signal line (gate electrode line or horizontal signal line) GL, a counter voltage line (counter electrode wiring) CL, two adjoining video signal lines (drain signal line or vertical signal line) DL. Each pixel includes a thin-film transistor TFT, a storage capacitor Cstg, a pixel electrode PX and a counter electrode CT. Two or more sets of the scanning signal line GL and the counter voltage line CL extending in the lateral direction are arranged in the vertical direction in the figure. A plurality of the video signal lines DL extending in the vertical direction are arranged in the lateral direction. The pixel electrode PX is connected to the thin-film transistor TFT, and the counter electrode CT is formed integrally with the counter voltage line CL.

[0026]

Two pixels adjoining each other vertically along the video signal lines DL, when they are folded along the line A of Figure 1, overlap with each other in their planar configurations. This is to allow the counter voltage line CL to be shared by the two vertically adjoining pixels along the video signal



lines DL and thereby increase the width of the counter voltage line CL to reduce its resistance, allowing a sufficient counter voltage to be supplied to each counter electrode CT of the laterally aligned pixels
5 from an external circuit.

[0027]

The pixel electrode PX and the counter electrode CT oppose each other to form an electric field between them to control an optical state of the liquid crystal
10 LC and therefore image display. The pixel electrode PX and the counter electrode CT are formed like comb teeth, each forming a narrow electrode extending vertically to the paper.

[0028]

15 In each pixel, the number of counter electrodes CT (the number of comb teeth) O and the number of pixel electrodes PX (the number of comb teeth) P have the relation of $O=P+1$ (in this embodiment, $O=3$, $P=2$). This relationship is held to arrange the counter
20 electrodes CT and the pixel electrodes PX alternately and to ensure that the counter electrodes CT are close to the video signal lines DL. This arrangement is for shielding the video signal lines DL from electric lines of force by means of the counter electrodes CT
25 to prevent the electric field between the counter

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electrode CT and the pixel electrode PX from being influenced by the electric field from the video signal lines DL. The counter electrode CT has a stable potential because it is supplied at all times by the external circuit through the counter voltage line CL described later. Hence, the potential of the counter electrode CT shows almost no variation even if it is close to the video signal lines DL. This arrangement sets the pixel electrode PX geometrically remote from the video signal lines DL, resulting in a significant reduction in a parasitic capacitance between the pixel electrode PX and the video signal lines DL and suppressing variations of a pixel electrode potential V_s caused by the video signal voltage. It is therefore possible to minimize crosstalks (image quality degradations called vertical smear) that occur in the vertical direction.

[0029]

The widths of the pixel electrode PX and the counter electrode CT are each set at 6 μm . This value is chosen because these widths need to be set larger than the thickness of the liquid crystal layer described later, 5.0 μm , to allow a sufficient electric field to be applied to the whole liquid crystal layer in the direction of its thickness and



also need to be set as narrow as possible to increase the aperture ratio. To prevent line disconnection, the width of the video signal lines DL is set to 8 μm , slightly wider than the pixel electrode PX and the counter electrode CT. Here, the width of the video signal lines DL is set less than two times the width of the adjoining counter electrode CT. Alternatively, when the width of the video signal lines DL is already determined from the productivity or yield, the width of the counter electrode CT adjoining the video signal lines DL is set more than one-half the width of the video signal lines DL. This is to cause the electric lines of force generated by the video signal lines DL to be absorbed by the counter electrodes CT on both sides. To absorb electric lines of force generated by an electrode of a certain width requires another electrode of an equal or greater width. Because the electric lines of force generated by a part of one-half the width of the video signal line DL (4 μm each) need to be absorbed by the counter electrode CT on one side, the width of the counter electrodes CT adjoining the video signal lines DL is set more than one-half the width of the video signal lines DL. This prevents crosstalks, particularly vertical ones, caused by the effects of the signal electrode.



[0030]

The width of the scanning signal line GL is determined so as to satisfy the resistance value at which a sufficient scanning voltage is allied to a gate electrode GT of a pixel on the terminal side (on the opposite side of a scan signal terminal GTM described later). The width of the counter voltage line CL is also set to meet the resistance value at which a sufficient counter voltage is applied to the counter electrode CT of a pixel on the terminal side (on the opposite side of a common bus line CB described later).

[0031]

The distance between the pixel electrode PX and the counter electrode CT is changed according to the liquid crystal material for the reason described below. Since the electric field strength that realizes the maximum transmittance differs among liquid crystal materials, the electrode-to-electrode distance is set according to the liquid crystal material so that the maximum transmittance can be obtained within the range of the maximum amplitude of the electrode voltage determined by the withstand voltage of the signal electrode drive circuit (a driver on the electrode side). Using a liquid crystal



material described later, the electrode interval is 16
μm.

[0032]

While this embodiment arranges all the electrodes
5 on the TFT substrate side, some electrodes,
particularly the counter electrode CT and the counter
voltage line CL, may be placed on the counter
substrate side. This arrangement also falls in the
scope of this invention.

10 [0033]

There is no particular limitation on the
direction of the counter electrode CT. While in this
embodiment the counter electrode CT is arranged in the
same direction as the gate signal line GL, it may be
15 laid in the same direction as the drain signal line DL
or arranged in the form of matrix. All these
arrangements fall in the scope of this invention.

[0034]

<<Cross-Sectional Configuration of the Matrix Portion
20 (Pixel Portion)>>

Figure 2 shows a cross section taken along the
line 3-3 of Figure 1. Figure 3 shows a cross section
of a thin-film transistor TFT taken along the line 4-4
of Figure 1. Figure 4 shows a cross section of a
25 storage capacitor Cstg taken along the line 5-5 of

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Figure 1. As shown in Figure 2 to 4, there are a lower transparent glass substrate SUB1 and an upper transparent glass substrate SUB2 with the liquid crystal layer LC interposed between. On the lower transparent glass substrate SUB1 are formed a thin-film transistor TFT, a storage capacitor Cstg and other electrodes. On the upper transparent glass substrate SUB2 are formed a color filter FIL and a black matrix pattern BM for light shielding.

10 [0035]

On the inner side (liquid crystal LC side) of each of the transparent glass substrates SUB1, SUB2, alignment or orientation films ORI1, ORI2 are formed that control the initial orientation of the liquid crystal. On the outer side of each of the transparent glass substrates SUB1, SUB2 are placed polarizers whose polarizing axes are crossed perpendicularly (crossed-Nicols arrangement).

[0036]

20 <<TFT Substrate>>

First, the configuration of the lower transparent glass substrate SUB1 (TFT substrate) will be described in detail.

[0037]

25 <<Thin-Film Transistor TFT>>



The thin-film transistor TFT operates in such a way that its channel resistance between the source and the drain decreases when a positive bias is applied to the gate electrode GT and, when the bias is set to
5 zero, increases.

[0038]

As shown in Figure 3, the thin-film transistor TFT has an i-type (intrinsic, meaning no conductivity type determining impurities are introduced)
10 semiconductor layer AS comprising a gate electrode GT, a gate insulating film GI and an i-type amorphous silicon (Si), a pair of source electrodes SD1 and a pair of drain electrodes SD2. The source and the drain are determined essentially by the bias polarity
15 between them, and in the circuit of this liquid crystal display device the bias polarity is reversed during operation and thus it should be understood that the source and the drain switch to each other during the operation. In the following description, however,
20 one of them is fixedly as a source and the other a drain for convenience.

[0039]

<<Gate Electrode GT>>

The gate electrode GT is formed continuously with
25 the scanning signal line GL so that a part of the

scanning signal line GL forms the gate electrode GT.
The gate electrode GT is a part extending beyond an
active region of the thin-film transistor TFT and is
formed slightly larger than the i-type semiconductor
5 layer AS so as to completely cover it (when viewed
from below). In addition to the function of a gate
electrode, the gate electrode GT serves to protect the
i-type semiconductor layer AS from external light and
backlight. In this example, the gate electrode GT is
10 formed of a single layer of a conductive film g1. The
conductive film g1 may be an aluminum (Al) film formed
by sputtering. Over the conductive film g1 is formed
an anodic oxide film AOF of aluminum.

[0040]

15 <<Scanning Signal Line GL>>

The scanning signal line GL is formed of the
conductive film g1. The conductive film g1 of this
scanning signal line GL is made by the same
manufacture process as the conductive film g1 of the
20 gate electrode GT and formed integrally with it.
Through the scanning signal line GL a gate voltage Vg
is supplied from an external circuit to the gate
electrode GT. The anodic oxide film AOF of aluminum
is also formed over the scanning signal line GL. The
25 part of the scanning signal line GL that crosses the

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video signal lines DL is formed narrow to reduce the probability of short-circuit with the video signal lines DL and is bifurcated so as to be cut by laser trimming even when a short-circuit occurs.

5 [0041]

<<Counter Electrode CT>>

The counter electrode CT is formed of a conductive film g1 that is in the same layer as the gate electrode GT and the scanning signal line GL.

10 The aluminum anodic oxide film AOF is formed over the counter electrode CT, too. The counter electrode CT is applied with a counter voltage Vcom. In this embodiment, the counter voltage Vcom is set at a potential which is, by the field-through voltage ΔV_s

15 lower than an intermediate DC potential between a minimum level drive voltage V_{dmin} and a maximum level drive voltage V_{dmax} applied to the video signal lines DL, the field-through voltage ΔV_s being generated when the thin-film transistor TFT is turned off. When

20 it is necessary to reduce the power supply voltage of the integrated circuit used in the signal electrode drive circuit by half, an AC voltage needs to be applied.

[0042]

25 <<Counter Voltage Line CL>>



The counter voltage line CL is formed of a conductive film g1. The conductive film g1 of the counter voltage line CL is deposited in the same manufacturing process for the conductive film g1 of the gate electrode GT, the scanning signal line GL and the counter electrode CT, and is formed integrally with the counter electrode CT. Through this counter voltage line CL the counter voltage Vcom is supplied from the external circuit to the counter electrode CT.

The aluminum anodic oxide film AOF is also formed over the counter voltage line CL. The part of the counter voltage line CL that crosses the video signal lines DL is, like the scanning signal line GL, formed narrow to reduce the probability of short-circuit with the video signal lines DL and is bifurcated so as to be cut by laser trimming even when a short-circuit occurs.

[0043]

<<Insulating Film GI>>

In the thin-film transistor TFT, the insulating film GI is used as a gate insulating film to apply an electric field to the semiconductor layer AS as well as the gate electrode GT. The insulating film GI is formed over the gate electrode GT and the scanning signal line GL. The insulating film GI may be a silicon nitride film deposited to a thickness of 1200-



2700 angstrom (A) (in this embodiment, about 2400 A) by, for instance, a plasma chemical vapor deposition. The gate insulating film GI is formed so as to enclose the whole matrix area AR, with its peripheral portion removed to expose external connection terminals DTM, GTM. The insulating film GI serves also as electric insulation between the scanning signal line GL or counter voltage line CL and the video signal lines DL.

[0044]

10 <<i-type Semiconductor Layer AS>>

The i-type semiconductor layer AS is made of amorphous silicon and deposited to a thickness of 200-2200 A (in this embodiment, about 2000 A). A layer d0 is an N(+) amorphous silicon semiconductor layer doped with phosphorus (P) for ohmic contact, and is left only where there is an i-type semiconductor layer AS below and a conductive layer d1 (d2) above.

[0045]

The i-type semiconductor layer AS is also provided between the scanning signal line GL or counter voltage line CL and the video signal lines DL at their intersections (crossover portions). The i-type semiconductor layer AS at the crossover portions reduces the possibility of short-circuit between the scanning signal line GL or counter voltage line CL and



the video signal lines DL.

[0046]

<<Source Electrode SD1, Drain Electrode SD2>>

The source electrode SD1 and the drain electrode
5 SD2 are each formed of a conductive film d1 in contact
with the N(+) semiconductor layer d0 and a conductive
film d2 formed over the first conductive film d1.

[0047]

The conductive film d1 is made of chromium (Cr)
10 by sputtering to a thickness of 500-1000 A (in this
embodiment, about 600 A). The Cr film has an
increased stress when formed to a greater thickness
and therefore its thickness is limited to about 2000 A
at most. The Cr film is used (as a so-called barrier
15 layer) to ensure a satisfactory adhesion with the N(+) semiconductor layer d0 and to prevent aluminum of the
conductive film d2 from diffusing into the N(+) semiconductor layer d0. In addition to a Cr film, the
conductive film d1 may be a high melting point metal
20 (Mo, Ti, Ta, W) film or a high melting point silicide
(MoSi_2 , TiSi_2 , TaSi_2 , WSi_2) film.

[0048]

The conductive film d2 is formed by sputtering
aluminum to a thickness of 3000-5000 A (in this
25 embodiment, about 4000 A). The aluminum film has



smaller stresses than the Cr film and can be formed to a greater thickness, thus reducing the resistances of the source electrodes SD1, drain electrodes SD2 and video signal lines DL. Improving the step coverage, and ensuring the extension over the steps formed due to the formation of the gate electrode GT and i-type semiconductor layer AS.

[0049]

The conductive film d1 and conductive film d2 are patterned with the same mask pattern and then, by using the same mask or by using the conductive film d1 and conductive film d2 as masks, the N(+) semiconductor layer d0 is removed. That is, the N(+) semiconductor layer d0 remaining on the i-type semiconductor layer AS is removed in a self-alignment manner in the portions other than the conductive film d1 and conductive film d2. At this time, because the N(+) semiconductor layer d0 is etched away to its full thickness, the i-type semiconductor layer AS is also etched slightly at the surface. The degree of the etching can be controlled by the etching time.

[0050]

<<Video Signal Lines DL>>

The video signal lines DL are formed of a source electrode SD1, a second conductive film in the same



layer as the source electrode SD1, and a third
conductive film d3. The video signal lines DL are
formed integrally with the drain electrode SD2.

[0051]

5 <<Pixel Electrode PX>>

The pixel electrode PX is formed of a source
electrode SD1, a second conductive film in the same
layer as the source electrode SD1, and a third
conductive film d3. The pixel electrode PX are formed
10 integrally with the source electrode SD1.

[0052]

<<Storage Capacitor Cstg>>

At its end opposite to the end connected to the
thin-film transistor TFT, the pixel electrode PX is so
15 formed as to overlap with the counter voltage line CL.
This overlapping, as can be seen from Figure 4, forms
a storage capacitor (a capacitive device) Cstg having
the pixel electrode PX as one electrode PL2 and the
counter voltage line CL as another electrode PL1. The
20 dielectric film of the storage capacitor Cstg is
formed of the insulating film GI used as a gate
insulating film of the thin-film transistor TFT and
the anodic oxide film AOF.

[0053]

25 As shown in the plan view of Figure 1, the



storage capacitor Cstg is formed in a region where the width of the conductive film g1 of the counter voltage line CL is enlarged.

[0054]

5 <<Passivation Layer PSV1>>

Over the thin-film transistor TFT is formed a passivation layer PSV1, which has a primary function of protecting the thin-film transistor TFT against moisture and is made of a highly transparent and
10 moisture-resistant material. The passivation layer PSV1 may be formed of a silicon oxide layer or silicon nitride layer deposited by a plasma CVD device to a thickness of about 1 μ m.

[0055]

15 The passivation layer PSV1 is formed to enclose the entire matrix area AR with its peripheral portion removed to expose the external connection terminals DTM, GTM. As to the thickness of the passivation layer PSV1 and the gate insulating film GI, the former
20 is made thick for the protection effect and the latter is made thin considering the mutual conductance gm of a transistor. Hence, the passivation layer PSV1 with a high protecting capability is formed larger than the gate insulating film GI to protect as wide an area as
25 possible at the peripheral portion as well.



[0056]

<<Color Filter Substrate>>

Next, referring back to Figure 1 and 2, the configuration of the upper transparent glass substrate
5 SUB2 (color filter substrate) will be described in detail.

<<Light Shielding Film BM>>

On the upper transparent glass substrate SUB2 is formed a light shielding film BM (generally called a
10 black matrix) that prevents transmitted light passing through unwanted gaps (other than the gaps between the pixel electrode PX and the counter electrode CT) from going toward the display surface and degrading the contrast. The light shielding film BM also serves to
15 prevent external light or backlight from entering the i-type semiconductor layer AS. That is, the i-type semiconductor layer AS of the thin-film transistor TFT is sandwiched by the upper and lower light shielding films BM and the slightly large gate electrode GT, and
20 thus protected against external natural light and backlight.

[0057]

A closed polygonal contour line of the light shielding film BM shown in Figure 1 represents an
25 aperture inside of which the light shielding film BM

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is not formed. This contour line pattern is just one example. The boundary line in the vertical direction of the figure is determined according to the precision of alignment between the upper and lower substrates.

5 When the alignment precision is better than the width of the counter electrode CT adjoining the video signal lines DL, setting the contour line within the width of the counter electrode allows the aperture to be enlarged.

10 [0058]

The light shielding film BM is made of a film that has a light shielding capability and a high insulating capability not to influence the electric field between the pixel electrode PX and the counter
15 electrode CT. In this embodiment the light shielding film BM is made of a resist material mixed with black pigment and formed to a thickness of about 1.2 μm .

[0059]

The light shielding film BM is formed as a grid
20 around each pixel to define an effective display area of each pixel. Thus, the contour of each pixel is made clear by the light shielding film BM. That is, the light shielding film BM has two functions, one as a black matrix and one as a light shielding means for
25 the i-type semiconductor layer AS.



[0060]

The light shielding film BM is also formed at the peripheral portion like a frame and its pattern is continuous with the pattern of the matrix area of Figure 1 having a plurality of dotlike openings. The light shielding film BM at the peripheral portion extends to the outside of the seal portion SL to prevent light such as reflected light produced in the apparatus equipped with the liquid display device, such as a personal computer from entering the matrix area. The light shielding film BM is kept about 0.3-1.0 mm inside from the edge of the substrate SUB2, avoiding the cut area of the substrate SUB2.

[0061]

15 <<Color Filter FIL>>

The color filter FIL comprises alternated red, green and blue stripe filters formed at portions facing the pixels. The color filter FIL overlaps the edge portion of the light shielding film BM.

20 [0062]

The color filter FIL can be formed as follows. First, on the surface of the upper transparent glass substrate SUB2 a dyeing base made of such a material as acrylic resin is formed and then removed in areas other than the red filter forming area by

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photolithography. Then, the dyeing base is colored with a red dye and fixed to form a red filter R. This is followed by the similar process to form a green filter G and a blue filter B.

5 [0063]

<<Overcoating Film OC>>

The overcoating film OC is provided to prevent leakage of the dye of the color filter FIL into the liquid crystal LC and to planarize stepped portions
10 formed by the color filter FIL and the light shielding film BM. The overcoating film OC may be made of a transparent resin material such as acrylic resin or epoxy resin.

[0064]

15 <<Liquid Crystal Layer and Polarizer>>

Next, the liquid crystal layer, orientation film and polarizer, the features of this invention, will be described.

[0065]

20 <<Liquid Crystal Layer>>

The liquid crystal material is a nematic liquid crystal with a positive dielectric anisotropy $\Delta\epsilon$ of 10.2 and a refractive index anisotropy Δn of 0.084 (589 nm at 20°C). The liquid crystal layer has a
25 thickness of 5.0 μm and a retardation $\Delta n \cdot d$ of 0.42



μm. With this retardation $\Delta n \cdot d$, it is possible to obtain the maximum contrast for the initial orientation angle and polarizer arrangement described later. That is, in Embodiment 1, the retardation $\Delta n \cdot d$ is so determined as to produce a display of 0-th order birefringence (first minimum) mode.

[0066]

The thickness of the liquid crystal layer is controlled by polymer beads.

10 [0067]

To realize the initial orientation state in which the liquid crystal is twisted by about 90 degrees, in this embodiment, about 0.1% of chiral material twisted a clockwise is added to the liquid crystal from the upper substrate SUB2 to the lower substrate SUB1.

[0068]

The liquid crystal material LC is not particularly limited. It is noted, however, that the larger the dielectric anisotropy $\Delta\epsilon$ and the smaller the elastic constant K_2 associated with twisting, the lower the drive voltage can be.

[0069]

When the liquid crystal layer is thick, the time taken to inject the liquid crystal can be reduced and variation in the gap between the substrates also can

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be reduced. To improve the response speed, the thickness is 8 μm or less; desirably, to obtain the response speed of around 30 ms the liquid crystal layer thickness should preferably be 5 μm or less.

5 [0070]

<<Orientation Film>>

The orientation film is made of polyimide. The orientation film ORI1 on the lower substrate side is rubbed in a rubbing direction RDR1 and the orientation
10 film ORI2 on the upper substrate side is rubbed in a rubbing direction RDR2.

[0071]

The initial orientation angle is defined to be positive for a counterclockwise rotation with respect
15 to the in-plane direction of the lateral electric field and to range from -90 degrees to 90 degrees. That is, either in the rubbing direction RDR or in the opposite direction, the initial orientation direction is in the range from -90 degrees to 90 degrees with
20 respect to the in-plane direction of the lateral electric field.

[0072]

In this embodiment, the initial orientation angle β_1 between the rubbing direction RDR1 and the applied
25 electric field direction EDR on the orientation film



ORI1 side is set at -45 degrees. The initial orientation angle β_2 between the rubbing direction RDR2 and the applied electric field direction EDR on the orientation film ORI2 side is set at 45 degrees.

5 The initial orientation angles of the upper and lower are twisted $\theta=90$ degrees. Figure 16 shows this state.

[0073]

In this embodiment, it is important to set β_1 and β_2 so that they may fall in the range from -90 degrees to -35 degrees and in the range from 35 degrees to 90 degrees, or preferably set at -45 degrees and 45 degrees respectively.

10

[0074]

It is possible to switch the signs of β_1 and β_2 .

15 In that case, the twist direction is reversed.

[0075]

In the rubbing directions RDR1, RDR2 shown in Figure 16, the orientation of the tilt angle of liquid crystal molecules in the liquid crystal layer at the upper and lower substrate interface is in the "splay" state that the liquid crystal molecules produce an effect of compensating for optical characteristics to provide a wide viewing angle characteristic.

20

[0076]

25 The response speed of this invention can also be



increased by setting the initial orientation angles β_1 , β_2 so that the tilt angle of the liquid crystal molecules in the liquid crystal layer is in the "parallel" state. In that case, the rubbing direction RDR1 is, for example, -45 degrees (β_1 is -45 degrees) with respect to the in-plane direction of the lateral electric field and the rubbing direction RDR2 is -135 degrees (β_2 is 45 degrees) with respect to the in-plane direction of the lateral electric field. In other words, it is also possible to set the rubbing direction RDR2 in the opposite direction.

[0077]

<<Polarizer>>

A polarizer of Nitto Denko make, G1220DU, is used, and the polarizing axis MAX1 of the polarizer POL1 on the lower substrate side is aligned with the direction of electric field EDR. To describe in more detail, the angle ϕ_1 between the polarizing axis MAX1 of the polarizer POL1 and the applied electric field direction EDR is set to 0 degree. The polarizing axis MAX2 of the upper polarizer POL2 is set perpendicular to the polarizing axis MAX1 of the lower polarizer POL1. That is, the angle ϕ_2 between the polarizing axis MAX2 of the upper polarizer POL2 and the applied electric field direction EDR is set to 90 degrees.



[0078]

Therefore, the angle between the polarizing axis MAX1 and the polarizing axis MAX2, $\phi = |\phi_2 - \phi_1|$, is set to 90 degrees. Figure 16 shows this relationship.

5 With this arrangement, as the applied voltage between the pixel electrode PX and the counter electrode CT is increased, the optical axes of the liquid crystal molecules are reorientated toward the polarizing axis MAX1, gradually reducing birefringence until the

10 transmittance progressively decreases down to black. In this way a normally open characteristic is produced.

[0079]

Further, the polarizing axis MAX2 of the upper

15 polarizer POL2 and the polarizing axis MAX1 of the lower polarizer POL1 can be exchanged to produce the identical characteristic. That is, the following setting may be made, $\phi_1 = 90$ degrees and $\phi_2 = 0$ degrees.

20 [0080]

<<Configuration of Periphery of Matrix>>

Figure 5 is a plan view showing an essential peripheral portion around the matrix (AR) of the display panel PNL including the upper and lower glass

25 substrates SUB1, SUB2. Figure 6 shows on the left a



cross section of an external connection terminal GTM region to which the scanning circuit is to be connected, and on the right a cross section of a seal portion with no external connection terminals.

5 [0081]

In the manufacture of this panel, if the panel size is small, a plurality of devices are fabricated simultaneously from a single glass substrate and then divided into individual panels for improved
10 throughput. If the panel size is large, a standard size glass substrate is commonly used to fabricate any type kind of device in order to share the manufacturing facility and then cut to an appropriate size for each kind of device. In either case, after
15 being subjected to a predetermined sequence of processes, the glass substrate is cut. Figure 5 and 6 represent the latter case. Both of these figures show the state of the upper and lower substrates SUB1, SUB2 after being cut., LN denoting the edge of the
20 substrates before cutting. In either case, where there are external connection terminal groups Tg, Td and terminals COT (subscript omitted) (upper and left sides in the figure), the size of the upper substrate SUB2 in a finished state is limited to the inside of
25 the lower substrate SUB1 to expose these terminals.

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The terminal groups Tg, Td including the scanning circuit connection terminals GTM, the signal electrode circuit connection terminals DTM, and their lead out wiring portion are named in groups of terminals grouped for each tape carrier package TCP (Figure 13, 14) mounted with an integrated circuit chip CHI. The leadout wiring from the matrix portion of each terminal group to the external connection terminal portion are inclined as they approach the ends. This is to match the terminals DTM, GTM of the display panel PNL to the arrangement pitch of the packages TCP and the connection terminal pitch in each package TCP. The counter electrode terminal COT is a terminal to apply the counter voltage from the external circuit to the counter electrode CT. The counter voltage lines CL of the matrix portion are led out to the opposite side of the scanning circuit terminals GTM (to the right side in the figure) are grouped together with a common bus line CB and connected to the counter electrode terminal COT.

[0082]

Between the transparent glass substrates SUB1, SUB2 a seal pattern SL is formed along their edges except for a liquid crystal injection port INJ so that the liquid crystal LC can be sealed. The sealing



material may be made of epoxy resin.

[0083]

The orientation films ORI1, ORI2 are formed inside the seal pattern SL. The polarizers POL1, POL2 are formed on the outer surfaces of the lower transparent glass substrate SUB1 and the upper transparent glass substrate SUB2, respectively. The liquid crystal LC is sealed in a space enclosed by the lower orientation film ORI1 and upper orientation film ORI2, both setting the orientation of the liquid crystal molecules, and by the seal pattern SL. The lower orientation film ORI1 is formed over the passivation layer PSV1 on the lower transparent glass substrate SUB1 side.

15 [0084]

This liquid crystal display device is assembled by stacking a variety of layers on the lower transparent glass substrate SUB1 and on the upper transparent glass substrate SUB2, separately; forming the seal pattern SL on the upper transparent glass substrate SUB2 side; stacking the lower transparent glass substrate SUB1 and the upper transparent glass substrate SUB2; injecting the liquid crystal LC from the injection port INJ of the seal material SL; sealing the injection port INJ with epoxy resin or the



like; and cutting the upper and lower substrates.

[0085]

<<Gate Terminal Portion>>

Figure 7 shows the connection structure the
5 scanning signal line GL of the display matrix to its
external connection terminal GTM. Figure 7(A) is a
plan view and Figure 7(B) is a cross section taken
along the line B-B of (A). The figure corresponds to
the lower part of the connection structure and the
10 inclined wiring is shown by straight lines for
convenience.

[0086]

AO denotes a boundary line of a photoresist
direct drawing, i.e., a photoresist pattern for
15 selective anodic oxidation. This photoresist is
removed after anodic oxidation and thus the pattern AO
shown in Figure 7 does not remain in the completed
product. But because the oxide film AOF is
selectively formed over the gate line GL as shown in
20 the cross section, its trace remains. In the plan
view, the left side of the photoresist boundary line
AO is an area that is covered with a resist and not
subjected to anodic oxidation while the right side is
exposed from the resist for anodic oxidation. On the
25 anodically-oxidized aluminum layer g1 is formed an



oxide, Al_2O_3 film AOF, reducing the volume of the underlying conductive portion. The anodic oxidation, of course, is performed under properly controlled conditions including time and voltage so that the
5 underlying conductive portion may remain.

[0087]

In the figure, the aluminum layer g1 is shown by a hatched portion for easy recognition, and the region that is not subjected to anodic oxidation is patterned
10 in the form of comb teeth, for the following reason. When the width of the aluminum layer is wide, whiskers are formed on the surface. Hence, the aluminum layer is divided into a plurality of parallel narrow lines to prevent the formation of whiskers while at the same
15 time minimizing the probability of line breakage and the reduction of conductivity.

[0088]

The gate terminal GTM comprises the aluminum layer g1 and a transparent conductive layer g2 that
20 protects the surface of g1 and improves the reliability of connection with tape carrier packages. The transparent conductive layer g2 is a transparent conductive indium-tin-oxide film (ITO: NESA film) formed by sputtering to a thickness of 100-2000 Å (in
25 this embodiment, about 1400 Å). Conductive layers d1,

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d2 are formed over the aluminum layer g1 and its side. The conductive layer d1 is a Cr layer that has good connectability with both the aluminum layer and the transparent conductive layer g2 to reduce connection resistance and thereby to compensate for defective connection between the aluminum layer and the transparent conductive layer g2. The conductive layer d2 remains there because it is formed by the same mask used for the conductive layer d1.

10 [0089]

In the plan view, the gate insulating film GI is formed on the right side of its boundary line and the passivation layer PSV1 is also formed on the right side of its boundary line. Hence, the terminal portion GTM located at the left end is exposed for electrical contact with external circuits. Although the figure shows only one pair of gate line GL and gate terminal, the actual device has a plurality of such pairs arranged parallelly in a vertical direction to form terminal groups Tg (Figure 5). The left end of the gate terminal is extended beyond the cutting area of the substrate and short-circuited by a wiring Shg (not shown) during the process of manufacture. Such a shorting line SHg is used for supplying electricity during the anodic oxidation and for



preventing electrostatic breakdown during the rubbing of the orientation film ORI1 in the process of manufacture.

[0090]

5 <<Drain Terminal DTM>>

Figure 8 shows the connection structure from the video signal line DL to its external connection terminal DTM. Figure 8(A) is a plan view and Figure 8(B) is a cross section taken along the line B-B of
10 Figure 8(A). Figure 8 corresponds to the upper right area of Figure 5 although the direction of the figure is changed for convenience. The right-hand end area of Figure 8 corresponds to the upper end portion of the substrate SUB1.

15 [0091]

TSTd designates a testing pad, which is formed wider than its line portion so that a probe or the like can be brought into contact with it, although it is not connected with external circuits. Similarly,
20 the drain terminal DTM, too, is formed wider than its line portion for connection with external circuits. The external connection drain terminals DTM are arranged in the vertical direction, forming the terminal groups Td (subscript omitted) as shown in
25 Figure 5 and extending beyond the cutting line of the

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substrate SUB1. The drain terminals DTM are all short-circuited by the wiring SHd (not shown) to prevent electrostatic breakdown during the manufacturing process. The testing pad TSTd is formed
5 at every other video signal line DL as shown in Figure 8.

[0092]

The drain connection terminal DTM is formed of a single transparent conductive layer g2 and is
10 connected to the video signal lines DL at portions where the gate insulating film GI is removed. The semiconductor layer AS formed over the end of the gate insulating film GI is to etch the edge of the gate insulating film GI in a tapered shape. The
15 passivation layer PSV1 is of course removed from the terminal DTM for connection with the external circuits.

[0093]

The leadout wire from the matrix portion to the
20 drain terminal portion DTM has its layers d1, d2-which are at the same level of the video signal lines DL-extending to an intermediate portion of the passivation layer PSV1 and connected with the transparent conductive layer g2 inside the passivation
25 layer PSV1. This arrangement is intended to protect

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the aluminum layer d2, vulnerable to galvanic corrosion, with the passivation layer PSV1 and the seal pattern SL.

[0094]

5 <<Counter Electrode Terminal CTM>>

Figure 9 shows the connection structure from the counter voltage line CL to its external connection terminal CTM. Figure 9(A) is a plan view and Figure 9(B) is a cross section taken along the line B-B of
10 (A). The figure corresponds to the upper left area of Figure 5.

[0095]

The counter voltage lines CL are grouped with the common bus line CB and led out to the counter
15 electrode terminal CTM. The common bus line CB comprises a conductive layer g1, and other conductive layers d1, d2 stacked on the first layer g1. This arrangement is designed to reduce the resistance of the common bus line CB and thereby supply a sufficient
20 counter voltage from the external circuit to each counter voltage line CL. This structure is characterized by the ability to reduce the resistance of the common bus line without imposing any additional burden on the conductive layer. The conductive layer
25 g1 of the common bus line CB is not subjected to



anodic conversion, in order that it is electrically connected to the conductive layers d1, d2. It is also exposed from the gate insulating film GI.

[0096]

5 The counter electrode terminal CTM has the transparent conductive layer g2 stacked over the conductive layer g1. The conductive layer g1 is covered with the transparent conductive layer g2, which has good corrosion resistance, to protect the
10 surface of the conductive layer g1 against galvanic corrosion.

[0097]

<<Equivalent Circuit of Whole Display Device>>

 An equivalent circuit of the display matrix
15 portion and its peripheral circuit are shown in Figure 10. The figure, though it is a circuit diagram, is drawn in compliance with actual geometric arrangement. AR represents a matrix array in which a plurality of pixels are arranged in two dimensional array.

20 [0098]

 In the figure, X represents the video signal lines DL, with subscripts G, B and R representing green, blue and red pixels. Y means scanning signal lines GL, with subscripts 1, 2, 3, ..., end indicating
25 the order of scan timing.

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[0099]

The scanning signal lines Y (the subscripts are omitted) are connected to a scanning circuit V and the video signal lines X (the subscripts are omitted) are
5 connected to a video signal driving circuit H.

[0100]

A circuit SUP includes a power supply circuit for producing step-down power supply voltages from one power source and a circuit for converting information
10 for CRT from a host computer (higher order computer) into information for a TFT liquid crystal display.

[0101]

<<Driving Method>>

Figure 11 shows drive signal waveforms for the
15 liquid crystal display device of this invention. The counter voltage is transformed into alternating rectangular waves having binary values, V_{ch} and V_{cl} , and in synchronism with the alternating waves a nonselection voltage for the scanning signals $V_g(i-1)$, $V_g(i)$ is changed between two values, V_{hl} and
20 V_{gl} , in each scanning period. The amplitude of the counter voltage and the amplitude of the nonselection voltage are set equal. The video signal voltage is obtained by subtracting half the counter voltage from
25 the voltage to be applied to the liquid crystal layer.



[0102]

The counter voltage may be a DC voltage but transforming it into the AC voltage makes it possible to reduce the maximum amplitude of the video signal voltage, allowing the use of a video signal driving
5 circuit (signal side driver) with a lower dielectric strength.

[0103]

<<Function of Storage Capacitor Cstg>>

10 The storage capacitor Cstg is provided for holding the video information written in a pixel for a long period (after the thin-film transistor TFT is turned off). In the system of this invention where an electric field is applied in a direction parallel to
15 the substrate surface, unlike the system where the electric field is applied perpendicularly to the substrate surface, because there is almost no capacitance (generally called a liquid capacitance) produced by the pixel electrode and the counter
20 electrode, the storage capacitor Cstg cannot hold the video information in the pixel. Thus, in the system where the electric field is applied parallel to the substrate surface, the storage capacitor Cstg is an essential constitutional element.

25 [0104]



The storage capacitor Cstg, when the thin-film transistor TFT is switched, also works to reduce the effect of the gate potential change ΔV_g on the pixel electrode potential V_s . This is expressed by the following equation.

[0105]

$$\Delta V_s = \{C_{gs} / (C_{gs} + C_{stg} + C_{pix})\} \times \Delta V_g$$

Here, C_{gs} is a parasitic capacitance produced between the gate electrode GT and the source electrode SD1 of the thin-film transistor TFT, C_{pix} is a capacitance produced between the pixel electrode PX and the counter electrode CT, and ΔV_s is a voltage generally called a feed-through voltage, a change in the pixel electrode potential caused by ΔV_g . This change ΔV_s is a cause of a DC component applied to the liquid crystal LC and can be reduced by increasing the storage capacitor Cstg. Reduced DC components applied to the liquid crystal LC improve the service life of the liquid crystal LC, mitigating so-called image persistence, a phenomenon in which a previous image remains when the liquid crystal screen is switched to another image.

[0106]

As described above, since the gate electrode GT is so formed large as to cover the entire i-type



semiconductor layer AS, the overlapping area with the source electrode SD1 and the drain electrode SD2 correspondingly increase, which in turn increases the parasitic capacitance Cgs, making the pixel electrode potential Vs more susceptible to the influences of the gate (scanning) signal Vg. The provision of the storage capacitor Cstg, however, can eliminate this demerit.

[0107]

10 The method of driving is not limited to the above and other active matrix driving methods may be employed. These methods all fall in the scope of this invention.

[0108]

15 <<Display Panel PNL and Driving Circuit Substrate PCB1>>

Figure 12 is a plan view showing the display panel PNL of Figure 5 connected with the video signal driving circuit H and the scanning circuit V.

20 [0109]

CHI represents drive IC chips to drive the display panel PNL (five shown at the bottom are drive IC chips on the scanning circuit side; ten shown to the left are drive chips on the video signal driving circuit side). TCP denotes tape carrier packages mounted with

25



the drive IC chips CHI by the tape automated bonding (TAB) as described later referring to Figure 13 and 14. A printed circuit board PCB1 is mounted with the TCPs and capacitors and is divided in two, one for the video signal driving circuit and the other for the scan signal driving circuit. FGP denotes a frame ground pad to which are soldered springlike pieces formed by cutting a shield case SHD. A flat cable FC electrically connects the lower-side printed circuit board PCB1 and the left printed circuit board PCB1. The flat cable FC may, as shown, be formed by sandwiching a plurality of lead wires (of phosphor bronze plated with Sn) between a striped polyethylene layer and a polyvinyl alcohol layer.

[00110]

<<Connection Structure of TCP>>

Figure 13 shows a cross-sectional structure of the tape carrier package TCP where the IC chips CHI comprising the scan signal driving circuit V and the video signal driving circuit H is mounted on the flexible printed circuit boards. Figure 14 is a cross section showing an essential part of the liquid crystal display panel connected to the scan signal terminal GTM.

[0111]

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In the figure, TTB denotes an input terminal/wiring portion of the IC circuit CHI. TTM represents an output terminal/wiring portion of the IC circuit CHI. These are made, for instance, of Cu and their inner ends (generally called inner leads) are connected with bonding pads PAD of the IC circuit CHI by the facedown bonding. The outer ends (generally called outer leads) of the terminals TTB, TTM correspond to the input and output, respectively, of the semiconductor IC circuit chip CHI and are connected to the CRT/TFT conversion circuit/power supply circuit SUP by soldering and to the liquid crystal display panel PNL through the anisotropic conductive film ACF. The package TCP is connected to the panel so that the package end covers the edge of the passivation layer PSV1 that exposes the connection terminal GTM on the panel PNL side. Hence, the outer connection terminal GTM (DTM) is covered with at least one of the passivation layer PSV1 and the package TCP, so that its resistance against galvanic corrosion is enhanced.

[0112]

BF1 denotes a base film made, for example, of polyimide. SRS is a solder resist film as a mask to prevent solder from flowing to unwanted areas during



the soldering process. The gap between the upper and lower glass substrates on the outer side of the seal pattern SL is, after cleaning, protected with epoxy resin EPX or the like. Furthermore, silicone resin
5 SIL is placed between the package TCP and the upper substrate SUB2 for double protection.

[0113]

<<Printed Circuit Board PCB2>>

The printed circuit board PCB2 is mounted with
10 electronic parts such as ICs, capacitors and resistors. The printed circuit board PCB2 is mounted with a circuit SUP that includes a power supply circuit for producing step-down supply voltages from a single power source and a circuit for converting CRT
15 information from a host computer (higher order computer) into TFT liquid crystal display device information. CJ represents a connector portion for a connector (not shown) that is connected with an external circuit.

20 [0114]

The printed circuit board PCB1 and the printed circuit board PCB2 are electrically connected with a flat cable FC.

[0115]

25 <<Overall Configuration of the Liquid Crystal Display



Module>>

Figure 15 is an exploded perspective view of constitutional parts of a liquid crystal display module MDL.

5 [0016]

SHD represents a framelike shield case (metal frame) made of a metal plate; LCW a window for the liquid crystal display; PNL a liquid crystal display panel; SPB a diffuser; LCB a light conductor; RM a reflector; BL a backlight fluorescent tube; and LCA a backlight case. These are stacked together in a vertical relationship shown in the figure to form a module MDL.

[0117]

15 The module MDL is secured together with claws and hooks provided to the shield case SHD.

[0118]

The backlight case LCA is so shaped as to accommodate the backlight fluorescent tube BL, diffuser SPB, light conductor LCB and reflector RM. The light from the backlight fluorescent tube BL arranged at the side of the light conductor LCB is diffused by the light conductor LCB, reflector RM and diffuser SPB to produce uniform light at the display surface and directed to the liquid crystal display

20

25



panel PNL.

[0119]

The backlight fluorescent tube BL is connected with an inverter circuit board PCB3 which is a power
5 source of the backlight.

[0120]

<<Characteristic of Liquid Crystal Display Device of Embodiment 1>>

Figure 17 and 18 show the principle of driving
10 the liquid crystal of Embodiment 1.

[0121]

The working principle will be explained for a case where the dielectric anisotropy $\Delta\epsilon$ of the liquid crystal is positive.

15 [0122]

When no voltage is applied, the liquid crystal molecules in the liquid crystal layer are in the initial state where they are twisted 90 degrees clockwise from the upper substrate SUB2 to the lower
20 substrate SUB1, as shown in Figure 17(a). When the voltage is applied, the part of the twisted liquid crystal molecules in the direction of thickness of the liquid crystal layer decreases as shown in Figure 17(b), only molecules in the region close to the
25 interfaces with the upper remain twisted and lower



substrates and a major part of the liquid crystal molecules is oriented homogeneously in the voltage application direction.

[0123]

5 When the voltage is not applied in the configuration of the liquid crystal layer and the arrangement of polarizing axis of polarizer of Figure 16, a high transmittance state (white display) can be obtained by the birefringence effect of the liquid
10 crystal. Further, during voltage application because the homogeneously oriented liquid crystal molecules are aligned with the polarizing axis of one polarizer, the birefringence does not occur at that portion, causing the virtual retardation of the liquid crystal
15 layer to come close to zero, and producing no birefringence effect.

[0124]

 When the voltage is applied, however, the liquid crystal layers near the interfaces actually remain
20 twisted, so that retardation does not become zero. In this embodiment, the thickness of the liquid crystal layer of the twisted molecules can be reduced infinitely, making it possible to assume that almost all molecules can be homogeneously oriented. Because
25 the polarizers are cross-Nicols-arranged



(perpendicularly to each other), light cannot pass through, producing a black display if there is no birefringence.

[0125]

5 Based on this operating principle, the following display characteristics are obtained.

[0126]

With the configuration of Embodiment 1 the normally open type electro-optical characteristic is
10 obtained that enables white display when no voltage is applied. The transmittance at the time of white display was 4.5%. Further, the contrast ratio of 3 was obtained at the time of black display by applying a drive voltage of 12 V.

15 [0127]

Figure 19 shows an applied voltage-transmittance characteristic of Embodiment 1.

[0128]

In Embodiment 1, increasing the drive voltage
20 causes the transmittance to decrease, thus improving the contrast ratio. Because of the limitation on the withstand voltage of the drive circuit, however, in this embodiment, the maximum drive voltage is 12 V. It should be noted that the present invention also
25 includes cases where higher or lower maximum drive



voltages are used for the driving.

[0129]

The response speed of the liquid crystal display device of Embodiment 1 was 22 ms, of which 8 ms was a
5 rise time and 14 ms a fall time.

[0130]

Figure 20 to 22 show the rise time T_r , the fall time and the response speed.

[0131]

10 The response speed of Embodiment 1 is shorter than 30 ms, enabling display of a dynamic image, and this means that a dynamic image can be displayed in good condition without any trailing. Figure 20 to 22 show, for comparison, the response speed, of the first
15 case (conventional configuration 1) and the second case (conventional configuration 2) described above.

[0132]

The response speed of this invention is about $1/2$ to $1/4$ that of the conventional configurations,
20 realizing a significant improvement. The conventional configuration 2 had a liquid crystal layer thickness of $4.0\text{ }\mu\text{m}$ when its response speed was measured. Although the conventional configuration 2 has a normally closed (normally black) characteristic that
25 enables white display when applied with a voltage, the



liquid crystal layer thickness was 4.0 μm in order to make the transmittance of the same liquid crystal material for a white display equal to that of the conventional configuration 1 and the Embodiment 1.

5 The conventional configuration 1 and Embodiment 1 were set at 5.0 μm in the liquid crystal layer thickness.

[0133]

What should be particularly noted is that, with the conventional configuration 1 and 2, the response
10 speed varies greatly with the voltage applied to the liquid crystal and that as the liquid crystal applied voltage is reduced, the response speed decreases remarkably. With the configuration of this invention, on the other hand, it is seen that the response speed
15 exhibits almost no dependence on the liquid crystal applied voltage and remains nearly constant.

[0134]

From this characteristic, it is found that this invention produces no trailing image, a drawback that
20 occurs particularly when a dynamic image is displayed in a half-tone mode.

[0135]

The viewing angle characteristic of this invention was more than 140 degrees in the vertical
25 and horizontal directions, which compares favorably



with those of the conventional configuration 1 and 2.
Further, the color tone variation and the gradation
inversion recognized when viewed at a particular
angle, which are the problems of the conventional
5 configuration 2, were mitigated.

[0136]

The color tone variation is a phenomenon that,
assuming the direction of an in-plane component of the
lateral electric field to be 0 degree, the region
10 along the direction of about 45 degrees and 225
degrees, for example, changes its color from white to
yellow (or blue) and the area along the direction of
about -45 degrees and 135 degrees changes to blue (or
yellow). The gradation inversion is a phenomenon
15 that, when viewed at an oblique angle, white changes to
yellow or blue. These phenomena occur because when
white is displayed, a change in retardation due to
inclination of the viewing angle causes the liquid
crystal layer near the upper substrate and the liquid
20 crystal layer near the lower substrate to compensate
for each other.

[0137]

As can be seen from above, this invention
provides the response speed of less than 30 ms, the
25 minimum requirement for displaying a dynamic image.



An additional advantage is a further improvement of the viewing angle, compared to the conventional configuration. Because a material with greater refractive index anisotropy Δn than that of the conventional configuration 2 can be used, a wider range of materials becomes available. Further, because the thickness of the liquid crystal layer can be set larger, the gap between the substrates is more easily made uniform, improving the uniform distribution of brightness. The thicker liquid crystal layer contributes to a shorter liquid crystal injection time.

[0138]

The cross-sectional structure of the thin-film transistor TFT and the electrode arrangement shown in Embodiment 1 are just one example and it is possible to use another TFT structure and electrode arrangement (including one in which the counter electrodes are placed on the color filter substrate) in this invention.

[0139]

(Embodiment 2 to Embodiment 5)

Embodiment 2 to Embodiment 5 are examples configuration with normally open display characteristics and optical compensation cells. They



are similar in configuration to Embodiment 1 except for the following.

[0140]

A cross-sectional structure of Embodiment 2 to
5 Embodiment 5 is shown in Figure 23.

[0141]

The structure includes drive liquid crystal cells having drive electrodes CT, PX and thin-film transistors TFT, and optical compensation liquid
10 crystal cells with no electrodes.

[0142]

Embodiment 2 has a configuration such that only the optical compensation liquid crystal cells added to Embodiment 1.

15 [0143]

Embodiment 3 has a configuration similar to that of Embodiment 2 with an increased refractive index anisotropy Δn of the liquid crystal material of the drive liquid crystal cells.

20 [0144]

Embodiment 4 has a configuration similar to that of Embodiment 2 with the polarizing axis of the polarizer optimized.

[0145]

25 Embodiment 5 has a configuration in which the



initial twist angle θ of the drive liquid crystal cells is optimized.

[0146]

<<Drive Liquid Crystal Cell>>

5 The initial twist angle θ , initial orientation angles β_1 , β_2 , thickness of the liquid crystal layer, dielectric anisotropy $\Delta\epsilon$ of the liquid crystal material, and refractive index anisotropy Δn , all of Embodiment 2 to Embodiment 5, are shown in Table 1.

10 [0147]

<<Optical compensation Liquid Crystal Cell>>

 The optical compensation liquid crystal cells comprise, as shown in Figure 23, a lower substrate SUB3, an upper substrate SUB4, a liquid crystal
15 composition CLC held between these substrates, an orientation film ORI3 on the lower substrate SUB3 side, and an orientation film ORI4 on the upper substrate SUB4 side.

[0148]

20 <<Optical compensation Liquid Crystal Layer>>

 Figure 24 shows the rubbing direction of the drive liquid crystal cells, the initial orientation angle and the polarizing axis of polarizer, and the rubbing direction of the optical compensation liquid
25 crystal layer (orientation direction near the



orientation film).

[0149]

The orientation film ORI3 is rubbed in the RDR3 direction, and the orientation film ORI4 is rubbed in the RDR4 direction. β_3 is the initial orientation angle between the rubbing direction RDR3 and the applied electric field direction EDR of the drive liquid crystal cell, and β_4 is the initial orientation angle between the rubbing direction RDR4 and the applied electric field direction EDR of the drive liquid crystal cell.

[0150]

Let the product of Δn of the liquid crystal layer of the optical compensation liquid crystal cell and the thickness d of the liquid crystal layer be referred to as retardation $(\Delta n \cdot d)'$. The twist angle θ_2 is a twist angle of the optical compensation liquid crystal layer.

[0151]

The retardation $(\Delta n \cdot d)'$ of the optical compensation liquid crystal layer, the twist angle θ_2 , and the initial orientation angles β_3 , β_4 are shown in Table 1.

[0152]

Here, the relationship among β_1 , β_2 , β_3 and β_4



is $|\beta_3 - \beta_4| \approx |\beta_1 - \beta_2|$, and β_3 crosses β_2 nearly perpendicularly.

[0153]

For the optical compensation liquid crystal cells
5 of this invention films holding cholesteric liquid crystal therebetween which have an optical characteristic identical to that of the optical compensation cells of Embodiment 2 to 5 may be used.

[0154]

10 <<Polarizer>>

The arrangement of the polarizing axis of the polarizer used in Embodiment 2 to 5 is shown in Table 1.

[0155]

15 The direction of the polarizing axis of the polarizer POL1 on the backlight input side is denoted by PDR and the direction of the polarizing axis of the polarizer POL2 on the output side is denoted by ADR.

[0156]

20 <<Characteristics of Embodiment 2 to Embodiment 5>>

The principle of driving the liquid crystal in Embodiment 2 to 5 is shown in Figure 25.

[0157]

To achieve a higher contrast ratio with a lower
25 voltage than in Embodiment 1, the liquid crystal



molecules are oriented in a state shown in Figure 25(b) by applying a voltage to enable black display. That is, the liquid crystal cells of Embodiment 2 to 5 have their liquid crystal molecules near the interface strongly twisted and the liquid crystal molecules in the central portion weakly twisted. The phrase "weakly twisted" means a state that the ratio, twist angle/layer thickness, is small and the phrase "strongly twisted" means a state that the ratio twist angle/layer thickness, is large. Thus, by arranging the optical compensation liquid crystal layer and polarizers in such a way as to compensate for this orientation, it is possible to realize a high contrast ratio with a low voltage.

15 [0158]

The following characteristics of the liquid crystal display device with this configuration are obtained.

[0159]

20 In Embodiment 2 to 5, the response speed characteristic obtained is equivalent to that of Embodiment 1.

[0160]

The relation between the drive voltage V_{lc} and the transmittance T is shown in Figure 26.

25



[0161]

It is seen that the contrast ratio, the drive voltage and the maximum transmittance are improved progressively roughly in order of the embodiment numbers. In Embodiment 5 in particular, the contrast ratio of 100 or higher and the maximum transmittance (absolute transmittance of the panel during a white display) of 4.1% are obtained for the drive voltage of 7 V.

10 [0162]

Figure 27 shows the relation between the retardation of drive cell, the contrast ratio, and the maximum transmittance.

[0163]

15 Figure 27 shows that the optimum retardation needs to be 750 nm or higher to produce a sufficient transmittance, preferably 1250 nm or higher that produces a sufficient contrast ratio.

[0164]

20 Figure 28 shows the relation between the contrast ratios of the liquid crystal display device of Embodiment 2 to 5 and the polarizer arrangement $\phi = |\phi_1 - \phi_2|$.

[0165]

25 It is seen from Figure 28 that, to produce a



sufficient contrast ratio, the optimal relation $\phi=|\phi_1-\phi_2|$ of the polarizing axis of the polarizer needs to be 90 degrees to 120 degrees, preferably 95 degrees to 115 degrees. Figure 29 shows the relation between the
5 initial twist angle of the drive liquid crystal cells, the contrast ratio and the maximum transmittance. Here the twist angle of the optical compensation cell is set to $\theta_2=0$.

[0166]

10 It is found from Figure 29 that the initial twist angle is preferably set in a range between 90 degrees and 115 degrees to realize a sufficient contrast ratio and the maximum transmittance at the same time. The retardation $(\Delta n \cdot d)'$ of the optical compensation
15 liquid crystal layer is preferably set in a range between $0.4 \cdot (\Delta n \cdot d)$ and $0.6 \cdot (\Delta n \cdot d)$, and setting the retardation at around $(\Delta n \cdot d)'=0.52 \cdot (\Delta n \cdot d)$ in particular assures optimization.

[0167]

20 (Embodiment 6 to Embodiment 8)

The configurations of Embodiment 6 to 8 are examples of normally closed configuration with the optical compensation cells and similar to those of Embodiment 2 to 5, except for the following.

25 [0168]



The cross-sectional structures of Embodiment 6 to 8 are similar to those of Embodiment 2 to 5 and shown in Figure 23.

[0169]

5 Embodiment 6 to 8 have drive liquid crystal cells with drive electrodes CT, PX and thin-film transistors TFT, and optical compensation liquid crystal cells without electrodes.

[0170]

10 Embodiment 6, unlike Embodiment 2, matches the retardation $(\Delta n \cdot d)'$ of the optical compensation liquid crystal cell with the retardation $(\Delta n \cdot d)$ of the drive cell.

[0171]

15 Embodiment 7 has a configuration in which the refractive index anisotropy Δn of the liquid crystal material of the drive liquid crystal cell is set large and the retardation $(\Delta n \cdot d)'$ of the optical compensation liquid crystal cell is matched with the
20 retardation $(\Delta n \cdot d)$ of the drive cell.

[0172]

Embodiment 8 has a configuration in which the initial twist angle θ of Embodiment 7 is changed.

[0173]

25 <<Drive Liquid Crystal Cell>>

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The initial twist angle θ , initial orientation angles β_1 , β_2 , thickness of the liquid crystal layer, and $\Delta\epsilon$ and Δn of the liquid crystal material, all used in Embodiment 6 to 8, are shown in Table 2.

5 [0174]

<<Optical compensation Liquid Crystal Cell>>

The retardation $(\Delta n \cdot d)'$, twist angle θ_2 , and the initial orientation angles β_3 , β_4 of the optical compensation liquid crystal layer used in Embodiment 6
10 to 8 are shown in Table 2. Definitions of these parameters are the same as those of Embodiment 2 to 5.

[0175]

The relation among β_1 , β_2 , β_3 and β_4 is $|\beta_3 - \beta_4| \approx |\beta_1 - \beta_2|$, with β_3 crossing β_2 virtually at right
15 angles.

[0176]

The optical compensation liquid crystal cells may use films holding cholesteric liquid crystal therebetween which have an optical characteristic
20 identical to that of the optical compensation cells of the previous embodiments.

[0177]

<<Polarizer>>

The arrangement of the polarizing axis of the
25 polarizer used in Embodiment 6 to 8 is shown in Table



2.

[0178]

<<Characteristics of Embodiment 6 to Embodiment 8>>

The principle of liquid crystal driving is
5 similar to that of Embodiment 2 to 5 and is shown in
Figure 25. Unlike Embodiment 2 to 5, Embodiment 6 to
8 also have the retardation $(\Delta n \cdot d)'$ of the optical
compensation liquid crystal cell matched with the
retardation $(\Delta n \cdot d)$ of the drive liquid crystal cell.
10 Hence, a normally closed characteristic that the
transmittance increases with the voltage applied to
the liquid crystal is obtained.

[0179]

Figure 30 shows the relation between the drive
15 voltage V_{lc} and the transmittance T Embodiment 6 to 8.

[0180]

Embodiment 6 to 8 enables a black display (low
transmission state) when no voltage is applied. When
no voltage is applied, the liquid crystal molecules
20 are oriented in an ideally twisted state making the
optical compensation by the optical compensation cell
easy. Hence, an ideal black level, i.e., the
transmittance infinitely close to zero, can be
achieved. It is therefore possible to widen the
25 margin for variations in the manufacturing process,

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particularly the variations of the gap between substrates, allowing the stable manufacture of high-contrast products.

[0181]

5 Embodiment 7 enabled a contrast ratio of 100 or higher and a maximum transmittance (absolute transmittance of the panel during white display) of 4.5% for a drive voltage of 7 V. The response speed characteristics in Embodiment 6 and 7 are comparable
10 to those of Embodiment 1.

[0182]

As to the relation among the retardation, contrast ratio and maximum transmittance of the drive cells, comparison between Embodiment 6 and Embodiment
15 7 shows that the maximum transmittance is improved in Embodiment 7 over Embodiment 6. Therefore, it is desired that the optimum retardation be set higher than 750 nm as in Embodiment 2 to 5.

[0183]

20 The polarizer arrangement $\phi = |\phi_1 - \phi_2|$ is preferably set close to 90 degrees.

[0184]

Further, as in Embodiment 8, by increasing the initial twist angle to more than 90 degrees it is
25 possible to change a liquid crystal applied voltage at

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which the transmittance starts to increase, i.e., a threshold voltage. Hence, the voltage amplitude contributing to the display and ranging from the threshold voltage to a voltage for the maximum transmittance can be reduced. This in turn reduces the signal output range of the video signal driving circuit. In other words, the video signal driving circuit, particularly the signal driver, can be reduced in circuit size. In Embodiment 8, the response speed is slightly slower, that is, the rise time is 12 ms, the fall time is 20 ms and the response time of 32 ms. The initial twist angle therefore contributes to changing the drive voltage that brings about the maximum transmittance, and it is preferably set in a range from 70 degrees to 160 degrees.

[0185]

(Embodiment 9 to Embodiment 13)

Embodiment 9 to 13 have a normally open configuration with a uniaxial phase film and is similar to the configuration of Embodiment 1, except for the following.

[0186]

A cross-sectional structure of Embodiment 9 to 13 is shown in Figure 31. In these embodiments, uniaxial phase films FILM1 and FILM2 are arranged on the outer

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sides of the substrates SUB1, SUB2 so as to hold them therebetween.

[0187]

Embodiment 9 has the configuration such that the
5 uniaxial phase film FILM1 and FILM2 is added to Embodiment 1.

[0188]

Embodiment 10 has the configuration such that the
lagging axis of the phase film of Embodiment 9 is
10 changed.

[0189]

Embodiment 11 has the configuration such that the
retardation of the phase films of Embodiment 10 is
differentiated between the upper and lower films.

15 [0190]

Embodiment 12 has the configuration such that the
refractive index anisotropy Δn of the liquid crystal
material of Embodiment 11 is increased.

[0191]

20 Embodiment 13 has a structure where the initial
twist angle of Embodiment 12 is changed.

[0192]

<<Uniaxial Phase film>>

The lagging axes γ_1 , γ_2 of the uniaxial phase
25 films and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$ used in



Embodiment 9 to 13 are shown in Table 3. γ_1 represents an angle between the lagging axis LDR1 of the lower phase film FILM1 and the direction of electric field EDR and γ_2 represents an angle between the lagging axis LDR2 of the upper phase film FILM2 and the direction of electric field EDR. Both of these angles are defined as positive for a counterclockwise rotation with respect to the direction of electric field EDR.

10 [0193]

$(\Delta n \cdot d)_1$ represents the retardation of the lower phase film and $(\Delta n \cdot d)_2$ represents the retardation of the upper phase film. Figure 32 shows their angular relation.

15 [0194]

<<Liquid Crystal Layer>>

The retardation $\Delta n \cdot d$ of the optical compensation liquid crystal layer, the initial twist angle θ , and the initial orientation angles β_1 , β_2 used in Embodiment 9 to 13 are shown in Table 3. Figure 32 shows their angular relation.

[0195]

<<Polarizer>>

The polarizing axes of the polarizers used in Embodiment 9 to 13 are shown in Table 3. Figure 32



shows their angular relation.

[0196]

<<Characteristics of Embodiment 9 to Embodiment 13>>

The principle of driving the liquid crystal used
5 in Embodiment 9 to 13 is identical with that of
Embodiment 2 to 5.

[0197]

To realize a higher contrast ratio with a lower
voltage than those of Embodiment 1, Embodiment 9 to 13
10 orientate the liquid crystal in a state shown in
Figure 25(b), enabling black display.

[0198]

At a low voltage, the liquid crystal cells in
Embodiment 9 to 13 assume a transitional state that
15 the liquid crystal molecules near the interface are
strongly twisted while those in the central portion
are weakly twisted. Thus, by arranging the phase
films and the polarizers in such a way as to
compensate for this orientation state, it is possible
20 to achieve a high contrast ratio with a low voltage.

[0199]

Embodiment 9 to 13 have response speed
characteristics comparable to those of Embodiment 1.

[0200]

25 Figure 33 shows the relation between the drive

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voltage V_{lc} and the transmittance T . It is seen that the contrast ratio and the maximum transmittance are improved progressively roughly in order of the embodiment number. In Embodiment 13 in particular,
5 the contrast ratio of 100 or higher and the maximum transmittance (the absolute transmittance of the panel during white display) of 4.4% are obtained for the drive voltage of 7 V.

[0201]

10 As shown in Figure 33, there is no characteristic change between Embodiment 9 and Embodiment 10. This suggests that the lagging axis angles γ_1 , γ_2 of phase plates and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$ of the phase plate do not change their characteristics if γ_1
15 $\cdot (\Delta n \cdot d)_1$ and $\gamma_2 \cdot (\Delta n \cdot d)_2$ are constant even when their values are changed.

[0202]

The relations, explained in conjunction with Embodiment 2 to 5, the relation between the
20 retardation of the drive cells, contrast ratio and maximum transmittance shown in Figure 27, the relation between the polarizing axes of polarizers ϕ , contrast ratio and maximum transmittance shown in Figure 28, and the relation between the initial twist angle of
25 the drive cells, contrast ratio and maximum



transmittance shown in Figure 29, are also obtained in Embodiment 9 to 13. It is noted, however, that the relation $(\Delta n \cdot d)$ between the retardation of the drive cells and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$ of phase shifters is so set that the relation $(\Delta n \cdot d)_1 + (\Delta n \cdot d)_2 = 0.52 \cdot (\Delta n \cdot d)$ is met when $\gamma_1 = -22.5$ degrees and $\gamma_2 = 22.5$ degrees.

[0203]

Thus, the optimum retardation needs to be set higher than 750 nm for a sufficient transmittance, preferably more than 1250 nm to obtain a sufficient contrast ratio.

[0204]

To obtain a sufficient contrast ratio, the relation $\phi = |\phi_1 - \phi_2|$ of optimum polarizing axes of the polarizers needs to be set in a range of between 90 degrees and 120 degrees, preferably between 95 degrees and 115 degrees.

[0205]

Further, the initial twist angle should preferably be set in a range between 90 degrees and 115 degrees to achieve a satisfactory contrast ratio and a white display transmittance at the same time.

[0206]

The retardations of the phase films $(\Delta n \cdot d)_1 +$



($\Delta n \cdot d$)² should preferably be set in the range from
0.4 · ($\Delta n \cdot d$) to 0.6 · ($\Delta n \cdot d$) to exhibit the
characteristics shown in Figure 27 to 29. Setting
them close to ($\Delta n \cdot d$)¹ + ($\Delta n \cdot d$)² = 0.52 · ($\Delta n \cdot d$)
5 results in characteristic optimization.

[0207]

As shown in Embodiment 10 to 12, better
optimization is achieved by setting ($\Delta n \cdot d$)² > ($\Delta n \cdot$
d)¹ or setting | γ_2 | > | γ_1 | for the lagging axis
10 angles. More specifically, when | γ_1 | = | γ_2 |, it is
desired that the retardation be set close to ($\Delta n \cdot d$)²
= 1.5 · ($\Delta n \cdot d$)¹. Therefore, the preferable setting is
($\Delta n \cdot d$)¹ < ($\Delta n \cdot d$)² < 2 · ($\Delta n \cdot d$)¹ or | γ_1 | < | γ_2 | < 2 ·
| γ_1 |.

15 [0208]

A cross-sectional structure, in which two phase
films FILM1, FILM2 are arranged on the upper side
only, is shown in Figure 35. Other arrangements can
also bring about characteristics similar to those of
20 these embodiments and they are within the scope of
this invention.

[0209]

(Embodiment 14 to Embodiment 16)

Embodiment 14 to 16 have a normally closed
25 configuration with uniaxial phase films which is



similar to that of Embodiment 9 to 13, except for the following.

[0210]

The cross-sectional configuration of Embodiment
5 14 to 16 is shown in Figure 31 and is similar to that of Embodiment 9 to 13.

[0211]

As in Embodiment 9 to 13, the uniaxial phase films FILM1, FILM2 are arranged on the outer sides of
10 the substrates SUB1, SUB2 so as to hold them therebetween.

[0212]

Unlike Embodiment 9, Embodiment 14 has a configuration that matches the sum of retardations
15 $(\Delta n \cdot d)_1 + (\Delta n \cdot d)_2$ of the uniaxial phase films to the retardation $(\Delta n \cdot d)$ of the drive cell.

[0213]

Embodiment 15 has a configuration in which, under the retardation condition of Embodiment 14, the
20 dielectric anisotropy Δn of the liquid crystal material of the drive liquid crystal cells is increased.

[0214]

Embodiment 16 is an example where the initial
25 twist angle θ of Embodiment 15 is changed.

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[0215]

<<Uniaxial Phase Film>>

The lagging axes γ_1 , γ_2 of the uniaxial phase films and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$, both
5 used in Embodiment 14 to 16, are shown in Table 4. γ_1 represents the angle between the lagging axis LDR1 of the lower phase film FILM1 and the direction of electric field EDR, γ_2 represents the angle between the lagging axis LDR2 of the upper phase film FILM2
10 and the direction of electric field EDR, $(\Delta n \cdot d)_1$ is the retardation of the lower phase film, and $(\Delta n \cdot d)_2$ is the retardation of the upper phase film. Figure 32 shows their angular relationship.

[0216]

15 <<Liquid Crystal Layer>>

The retardation $\Delta n \cdot d$, initial twist angle θ and initial orientation angles β_1 , β_2 for the liquid crystal layer of the drive cells used in Embodiment 14 to 16 are shown in Table 4. Figure 32 shows their
20 angular relationship.

[0217]

<<Polarizer>>

The polarizing axes of the polarizers used in Embodiment 14 to 16 are shown in Table 4. Their
25 angular relation is shown in Figure 32.



[0218]

<<Characteristics of Embodiment 14 to 16>>

The principle of driving the liquid crystal is shown in Figure 25 and is similar to that used in
5 Embodiment 9 to 13. Unlike Embodiment 9 to 13, Embodiment 14 to 16 matches the sum of the retardations $(\Delta n \cdot d)_1 + (\Delta n \cdot d)_2$ of the uniaxial phase films to the retardation $(\Delta n \cdot d)$ of the drive liquid crystal cell so as to realize a normally closed
10 characteristic, in which the transmittance increases with the voltage applied to the liquid crystal.

[0219]

Figure 34 shows the relation between the drive voltage V_{lc} and the transmittance T for Embodiment 14
15 to 16.

[0220]

Embodiment 14 to 16 enable a black display (low transmittance state) when no voltage is applied.

[0221]

20 When no voltage is applied, the liquid crystal molecules are oriented in an ideally twisted state making the optical compensation by the uniaxial phase films easy. Hence, an ideal black level, i.e., the transmittance infinitely close to zero, can be
25 achieved. It is therefore possible to widen the



margin for variations in the manufacturing process, particularly the variation of the gap between substrates, allowing the stable manufacture of high-contrast products.

5 [0222]

Embodiment 15 and 16 enable a contrast ratio of 100 or higher and a maximum transmittance (absolute transmittance of the panel during white display) of 4.5% for a drive voltage of 7 V. The response speed characteristics in Embodiment 14 and 15 are comparable to those of Embodiment 1.

[0223]

As to the relation among the retardation, the contrast ratio and the maximum transmittance of the drive cells, comparison between Embodiment 14 and Embodiment 15 shows that the maximum transmittance is improved in Embodiment 15 over Embodiment 14. Therefore, it is desired that the optimum retardation be set higher than 750 nm as in Embodiment 9 to 13.

20 [0224]

The polarizer arrangement $\phi = |\phi_1 - \phi_2|$ is preferably set close to 90 degrees.

[0225]

Further, as in Embodiment 16, by increasing the initial twist angle to more than 90 degrees it is

25



possible to change a liquid crystal applied voltage at which the transmittance starts to increase, i.e., a threshold voltage. Hence, the voltage amplitude contributing to the display and ranging from the threshold voltage to a voltage for the maximum transmittance can be reduced. This in turn reduces the signal output range of the video signal driving circuit. In other words, the video signal driving circuit, particularly the signal driver used in it, can be reduced in circuit size.

[0226]

The response speed has slightly deteriorated. Embodiment 16 has a rise time of 12 ms, a fall time of 20 ms and a response time of 32 ms. These suggest that the initial twist angle contributes to changing the drive voltage that leads to the maximum transmittance, and it is preferably set in a range between 70 degrees and 160 degrees.

[0227]

A cross-sectional structure, in which two phase films FILM1, FILM2 are arranged on the upper side only, is shown in Figure 35. Other arrangements can also achieve characteristics similar to those of these embodiments and they are within the scope of this invention.

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[0228]

(Embodiment 17 to Embodiment 20)

Embodiment 17 to 20 are examples of a configuration using a liquid crystal material with a negative dielectric anisotropy ($\Delta\epsilon < 0$). This configuration is similar to that of Embodiment 1 except for the following.

[0229]

Embodiment 17 has a configuration where a liquid crystal material with a negative dielectric anisotropy ($\Delta\epsilon < 0$) is used in Embodiment 1.

[0230]

Embodiment 18 has a configuration of Embodiment 17 with the polarizing axes of the polarizers optimized.

[0231]

Embodiment 19 has a configuration of Embodiment 18 with the initial twist angle θ optimized.

[0232]

Embodiment 20 has a configuration of Embodiment 19 with the retardation $\Delta n \cdot d$ and the polarizing axes of the polarizers optimized.

[0233]

<<Drive Liquid Crystal Cell>>

The initial twist angle θ , initial orientation



angles β_1 , β_2 , thickness of the liquid crystal layer and Δn of the liquid crystal material used in Embodiment 17 to 20 are shown in Table 5.

[0234]

5 <<Polarizer>>

The arrangements of the polarizing axes of the polarizers used in Embodiment 17 to 20 are shown in Table 5.

[0235]

10 <<Characteristics of Embodiment 17 to Embodiment 20>>

The principle of liquid crystal driving is shown in Figure 36.

[0236]

In the liquid crystal with a negative dielectric anisotropy, the major axes of liquid crystal molecules are reoriented in a direction perpendicular to the electric field application direction. Thus, with no voltage applied, the molecules assume a state that they are weakly twisted counterclockwise from the substrate SUB2 to the substrate SUB1, as shown in Figure 36(a). When a voltage is applied, the molecules near the central part of the liquid crystal layer change to a strongly clockwise-twisted state, with the molecules in the upper and lower layers near the interfaces twisted counterclockwise.

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[0237]

By optimizing the polarizer positions in the weakly twisted state set up when no voltage is applied, a desirable black level (low transmittance state) can be obtained, and thus the display panel exhibits a normally closed characteristic that the transmittance increases with the liquid crystal application voltage.

[0238]

10 The relation between the drive voltage V_{lc} and the transmittance T in embodiment 17 to 20 is shown in Figure 37.

[0239]

In Embodiment 17 to 20, black display (low transmittance state) is enabled when no voltage is applied. When no voltage is applied, the liquid crystal molecules are oriented in an ideally twisted state making the optimization by the polarizer arrangement easy. Hence, an ideal black level, i.e., the transmittance infinitely close to zero, can be realized. It is therefore possible to widen the margin for variations in the manufacturing process, particularly the variation of the gap between substrates, allowing the stable manufacture of high-contrast products.

15
20
25



[0240]

Embodiment 20 has a contrast ratio of 100 or higher and a maximum transmittance (an absolute transmittance of the panel during white display) of 4.3% for a drive voltage of 8 V. The response speed characteristics of Embodiment 19 and 20 are slightly slower than those of Embodiment 1, that is the rise time is 20 ms, the fall time is 16 ms and the response time is 36 ms.

10 [0241]

As to the relation among the retardation, contrast ratio and maximum transmittance of the drive cells, comparison between Embodiment 14 and Embodiment 15 shows that the maximum transmittance is improved in Embodiment 20 over Embodiment 19. Therefore, it is desired that the optimum retardation be set higher than 750 nm as in Embodiment 2 to 5.

[0242]

The polarizer arrangement $\phi = |\phi_1 - \phi_2|$ is preferably set close to 90 degrees.

[0243]

In Embodiment 17 and 18, the response speed is slightly slower, that is, the rise time is 40 ms, the fall time is 20 ms and the response time is 60 ms. Further, by increasing the initial twist angle, it is

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possible to make a significant improvement on the response speed, particularly at the leading edge. That is, the greater the initial twist angle is, the faster the response speed is.

5 [0244]

Comparison of Embodiment 18 and Embodiment 19 shows that as the initial twist angle is increased, the resulting contrast ratio after optimizing the polarizer arrangement deteriorates.

10 [0245]

Thus, there is a trade-off relationship between the response speed and the contrast ratio. To achieve a good balance between these characteristics, the initial twist angle is preferably set in a range
15 between 20 and 50 degrees.

[0246]

As to the arrangement of the polarizers, comparison between Embodiment 17 and Embodiment 18 indicates that the contrast ratio and the maximum
20 transmittance can be improved by optimizing the polarizers from 90 degrees.

[0247]

In Embodiment 17 to 20 it is also possible to enhance the contrast ratio, lower the applied voltage
25 or produce a normally open characteristic by using the



optical compensation liquid crystal layer and the phase films, as in Embodiment 2 to 16. The methods for achieving these objectives are also within the scope of this invention.

5 [0248]

(Embodiment 21)

The configuration of Embodiment 21 is similar to that of Embodiment 1 except for the following.

[0249]

10 <<Orientation Film>>

The initial orientation angle β_1 between the rubbing direction of the lower substrate RDR1 and the direction of electric field EDR is set to -50 degrees and the initial orientation angle β_2 between the
15 rubbing direction of the upper substrate RDR2 and the direction of electric field EDR is set to 40 degrees so that the upper and lower substrates are twisted 90 degrees.

[0250]

20 When the liquid crystal drive electrodes (both pixel electrode PX and counter electrode CT) are formed on the lower substrate, the electric field parallel to the substrate surface (lateral electric field) is strong near the lower substrate and
25 progressively weaker toward the upper substrate.



Hence, the liquid crystal molecules near the lower substrate are more easily rotatable than those close to the upper substrate. The voltage required to reorientate most of the liquid crystal molecules in the liquid crystal layer in the direction of the electric field EDR in Embodiment 21 can be lower than that of Embodiment 1. Embodiment 1 requires a voltage of about 12 V to enable black display while Embodiment 21 needs only about 10 V to realize the same black level as Embodiment 1.

[0251]

While in this embodiment β_1 and β_2 are set at -50 degrees and 40 degrees, respectively, they may be set at 50 degrees and -40 degrees to produce the same effect. The essential configuration of Embodiment 21 is that, when the liquid crystal drive electrodes are arranged only on the lower substrate, the condition $|\beta_1| > |\beta_2|$ needs to be met; and that when the liquid crystal drive electrodes are arranged only on the upper substrate, the condition $|\beta_1| < |\beta_2|$ needs to be satisfied.

[0252]

The configuration of Embodiment 21 is applicable not only to Embodiment 1 but to Embodiment 2 to 20, and these configurations are within the scope of this



invention.

[0253]

[Advantage of the Invention]

As described above, this invention provides an
5 active matrix type liquid crystal display device that
realizes as wide a viewing angle as a CRT and a
response speed fast enough to display a dynamic image.

[Brief Description of the Drawings]

[Figure 1] An essential part plan view showing one
10 pixel and its peripheral area in the liquid crystal
display portion of the active matrix type color liquid
crystal display device of this invention.

[Figure 2] A cross section of the pixel taken along
the line 3-3 of Figure 1.

15 [Figure 3] A cross section of the thin-film
transistor TFT taken along the line 4-4 of Figure 1.

[Figure 4] A cross section of the storage capacitor
Cstg taken along the line 5-5 of Figure 1.

[Figure 5] A plan view showing the configuration of a
20 peripheral portion around the matrix in the display
panel.

[Figure 6] A cross section showing the scanning
signal terminal on the left side and the panel edge
portion with no external connection terminal on the
25 right side.



[Figure 7] A plan view and a cross-sectional view showing the connecting portion of the gate terminal GTM and the gate line GL.

[Figure 8] A plan view and a cross-sectional view
5 showing the connecting portion of the drain terminal and the video signal line DL.

[Figure 9] A plan view and a cross-sectional view showing the connecting portion of the common electrode terminal CTM, the common bus line CB and the common
10 voltage line CL.

[Figure 10] A circuit diagram showing the matrix area and its peripheral portion in the active matrix type color liquid crystal display device of this invention.

[Figure 11] A waveform diagram showing drive signals
15 of the active matrix type color liquid crystal display device of this invention.

[Figure 12] A top plan view showing the liquid crystal display panel equipped with the peripheral drive circuits.

20 [Figure 13] A cross-sectional view of the tape carrier package TCP having the flexible printed circuit board mounted with the IC chips CHI forming the drive circuit.

[Figure 14] An essential part cross section showing
25 the tape carrier package TCP connected to the scan



signal terminal GTM of the liquid crystal display panel PNL.

[Figure 15] An exploded perspective view of the liquid crystal display module.

- 5 [Figure 16] A schematic diagram showing the relation between the direction of applied electric field, the rubbing direction, the initial orientation angle, and the polarizing axes of the polarizers.

[Figure 17] A schematic diagram showing the action of
10 the liquid crystal of Embodiment 1 as seen from a direction perpendicular to the substrate surface.

[Figure 18] A schematic diagram showing the action of the liquid crystal of Embodiment 1 as seen from a cross-sectional direction.

- 15 [Figure 19] A graph showing the relation between the liquid crystal applied voltage and the transmittance in Embodiment 1.

[Figure 20] A graph showing the relation between the liquid crystal applied voltage and the rise time in
20 Embodiment 1.

[Figure 21] A graph showing the relation between the liquid crystal applied voltage and the fall time in Embodiment 1.

[Figure 22] A graph showing the relation between the
25 liquid crystal applied voltage and the overall



response time in Embodiment 1.

[Figure 23] A cross section of the pixel taken along the line 3-3 of Figure 1 in Embodiment 2 to 8.

[Figure 24] A schematic diagram showing the relation
5 between the direction of applied electric field, the rubbing direction of the drive liquid crystal cells and optical compensation liquid crystal cells, the initial orientation angle, and the polarizing axes of the polarizers in Embodiments 2 to 8.

10 [Figure 25] A schematic diagram showing the action of the liquid crystal as seen from a direction of cross section in Embodiment 2 to 8.

[Figure 26] A graph showing the relation between the liquid crystal applied voltage and the transmittance
15 in Embodiment 2 to 5.

[Figure 27] A graph showing the relation between the retardation, contrast ratio and white display transmittance of the liquid crystal cells in Embodiment 2 to 5.

20 [Figure 28] A graph showing the relation between the polarizing axis arrangement of polarizers and the contrast ratio in Embodiment 2 to 5.

[Figure 29] A graph showing the relation between the initial twist angle, contrast ratio and white display
25 transmittance of the liquid crystal cells in



Embodiment 2 to 5.

[Figure 30] A graph showing the relation between the liquid crystal applied voltage and the transmittance in Embodiment 6 to 8.

5 [Figure 31] A cross section of the pixel taken along the line 3-3 of Figure 1 in Embodiment 9 to 13.

[Figure 32] A schematic diagram showing the relation between the direction of applied electric field, the rubbing direction of liquid crystal cells, the initial
10 orientation angle, the polarizing axes of polarizers, and the lagging axis of phase shifter in Embodiment 9 to 13.

[Figure 33] A graph showing the relation between the direction of applied electric field and the
15 transmittance in Embodiment 9 to 13.

[Figure 34] A graph showing the relation between the direction of applied electric field and the transmittance in Embodiment 14 to 16.

[Figure 35] A cross section of the pixel taken along
20 the line 3-3 of Figure 1 in the arrangement where the two phase plates are both placed on the top.

[Figure 36] A schematic diagram showing the action of the liquid crystal as seen from a direction of the cross section in Embodiment 17 to 20.

25 [Figure 37] A graph showing the relation between the



direction of applied electric field and the transmittance in Embodiment 17 to 20.

[Description of Reference Numerals]

SUB...Transparent glass substrate, GL...Scanning signal
5 line, DL...Video signal line, CL...Counter voltage
line, PX...Pixel electrode, CT...Counter electrode,
GI...Insulating film, GT...Gate electrode, AS...i-type
semiconductor layer, SD...Source electrode or drain
electrode, PSV...Passivation layer, BM...Light
10 shielding film, LC...Liquid crystal, TFT...Thin-film
transistor, g, d...Conductive film, Cstg...Storage
capacitor, AOF...Anodic oxidized film, AO...Anodic
oxidized mask, GTM...Gate terminal, DTM...Drain
terminal, CB...Common bus line, DTM...Common electrode
15 terminal, SHD...Shield case, PNL...Liquid crystal
display panel, SPB...Light diffuser, LCB...Light
conductor, BL...Backlight fluorescent tube,
LCA...Backlight case, RM...Reflector, $\beta 1$...Initial
orientation angle between the initial orientation
20 direction of the drive cell on the orientation film
ORI1 side and the in-plane direction of lateral
electric field EDR, $\beta 2$...Initial orientation angle
between the initial orientation direction of the drive
cell on the orientation film ORI2 side and the in-
25 plane direction of lateral electric field EDR,



$\beta 3$...Initial orientation angle between the initial orientation direction of the optical compensation cell on the orientation film ORI3 side and the in-plane direction of lateral electric field EDR, $\beta 4$...Initial orientation angle between the initial orientation direction of the optical compensation cell on the orientation film ORI4 side and the in-plane direction of lateral electric field EDR, $\gamma 1$...Angle between the lagging axis of the optical compensation phase film FILM1 and the in-plane direction of lateral electric field EDR, $\gamma 2$...Angle between the lagging axis of the optical compensation phase film FILM2 and the in-plane direction of lateral electric field EDR, RDR...Rubbing direction of the orientation film (Subscripts are omitted).

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[Designation of Document] Abstract

[Abstract]

[Problem] To provide an active matrix type liquid crystal display device in which the image display is controlled by an electric field parallel to the substrate surface, and which is capable of realizing a wide viewing angle comparable to that of a CRT and a response speed fast enough to display a dynamic image.

[Means for Solving the Problem] A liquid crystal display device which comprises a pair of insulating substrate so disposed as to face each other; a pair of orientation films formed over the insulating substrates; a liquid crystal composition held between the pair of orientation films; and pixel electrodes and counter electrodes to apply a lateral electric field almost parallel to surfaces of the substrates; wherein an initial orientation direction on one orientation film side and an initial orientation direction on the other orientation film side are line-symmetric with respect to the direction of the lateral electric field.

[Effect] The liquid crystal display device of lateral electric field type has a fast response speed that allows display of a dynamic image.

[Selected figure] Figure 1



FIG.1

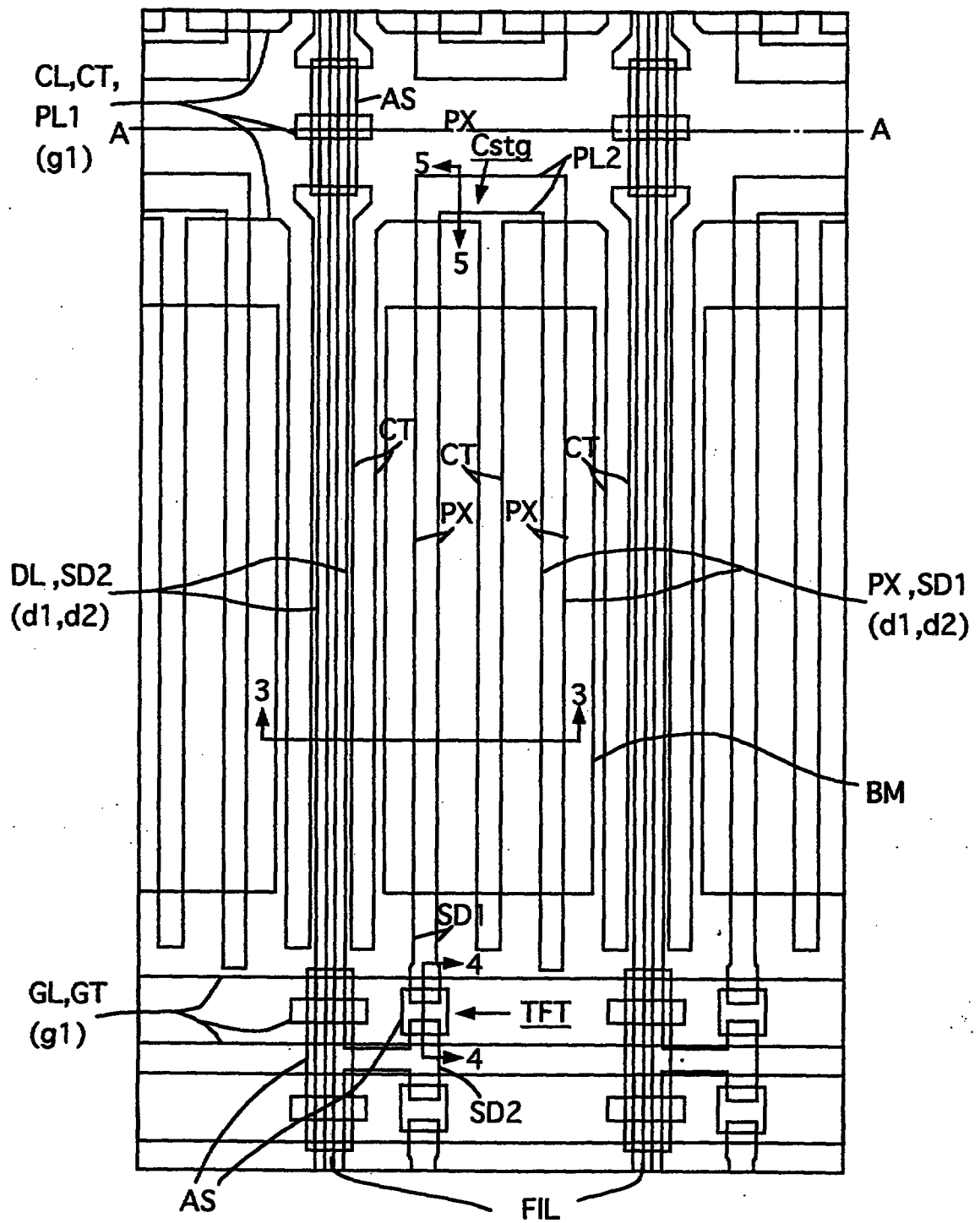
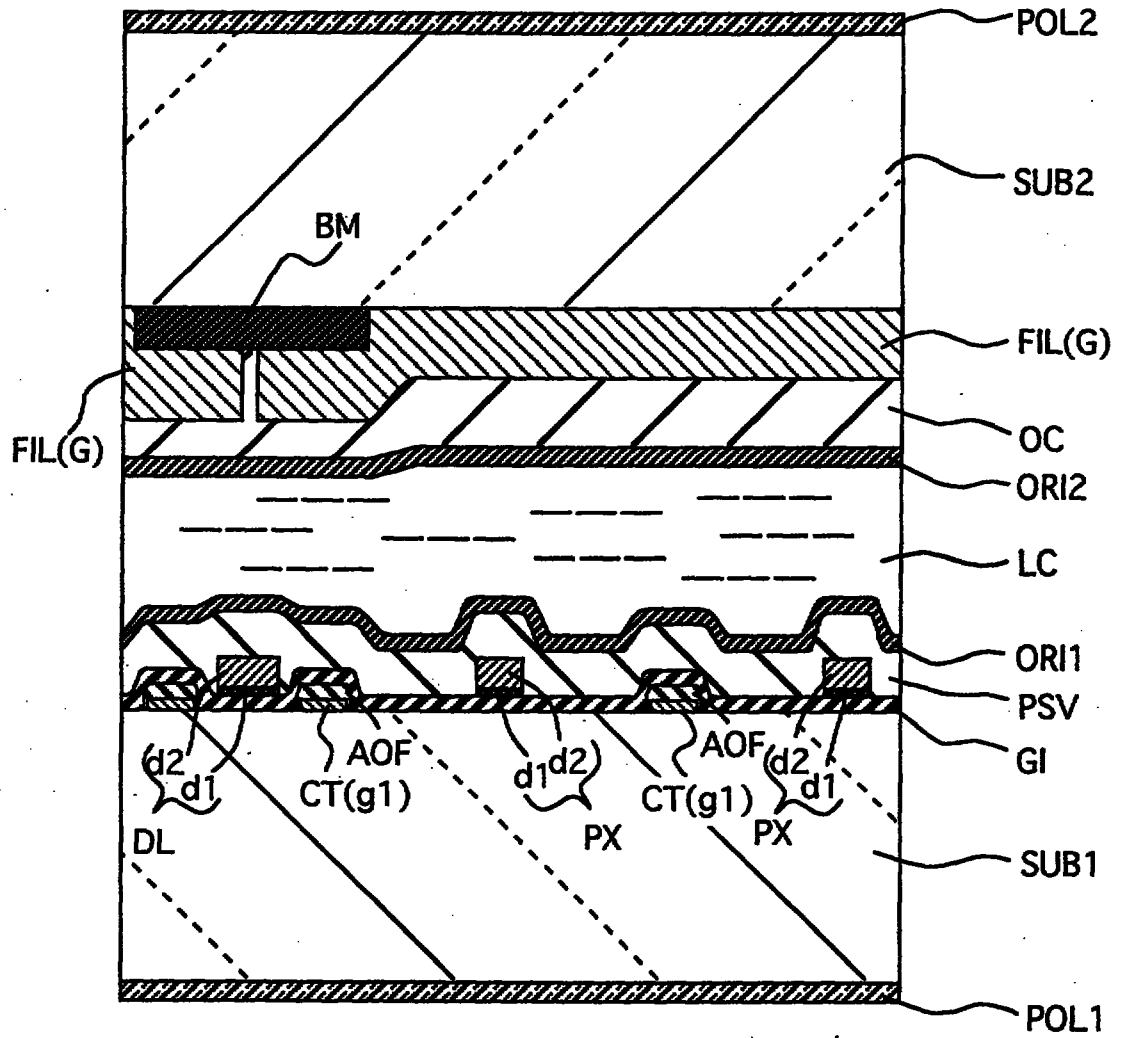


FIG.2



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FIG.3

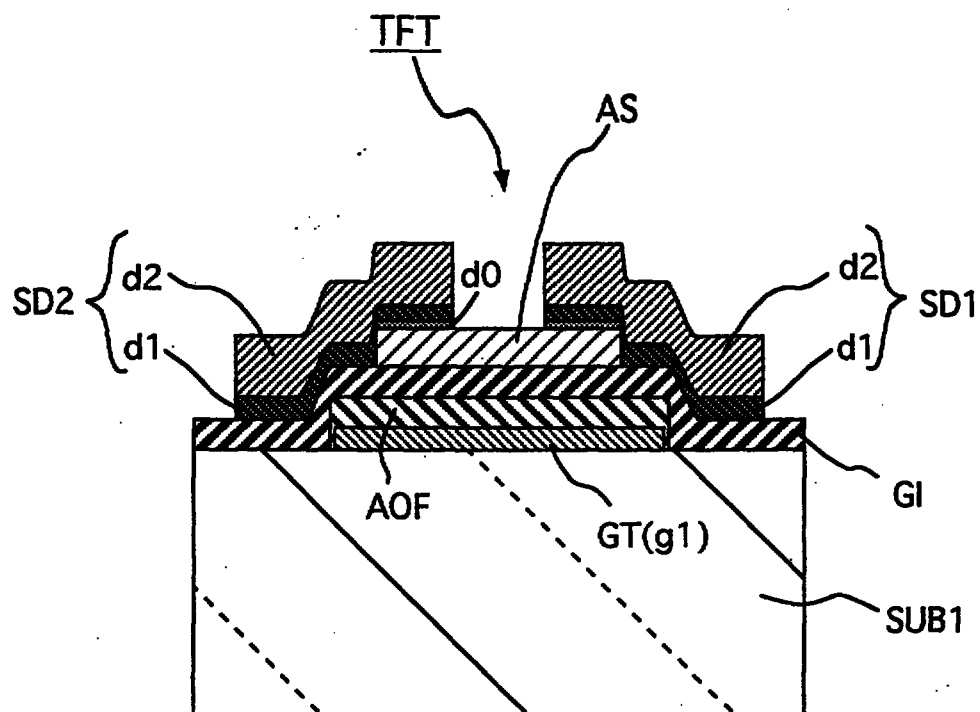
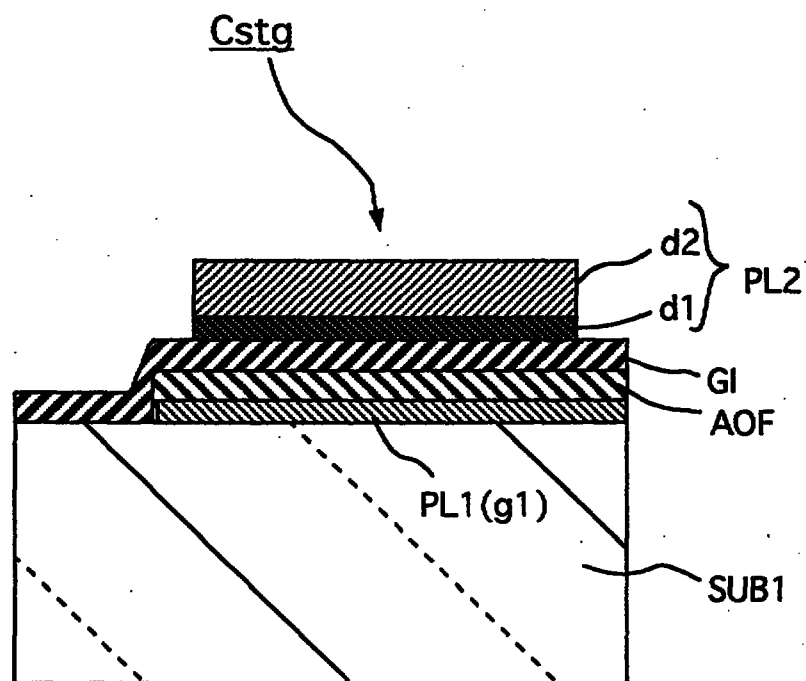


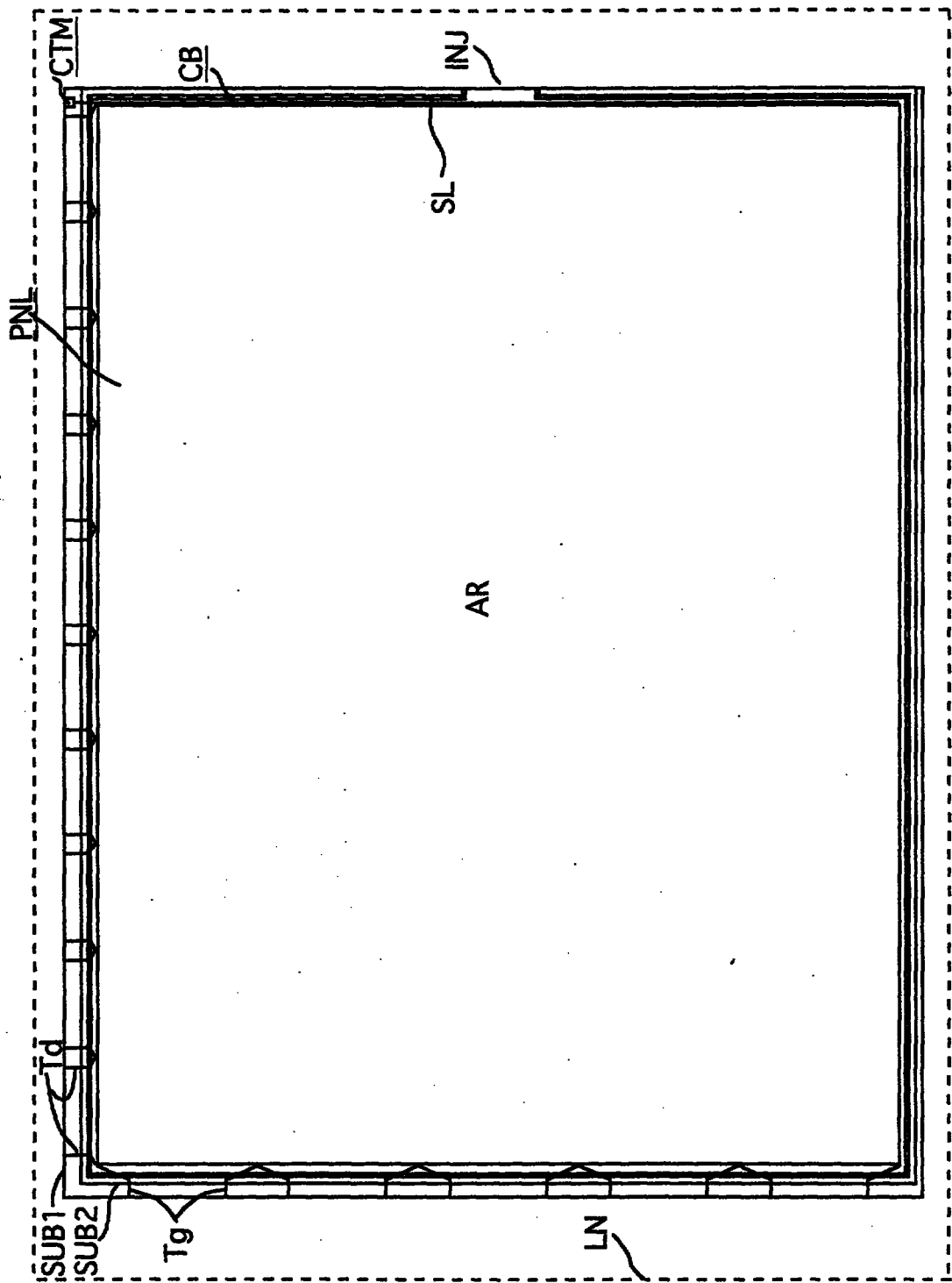
FIG.4



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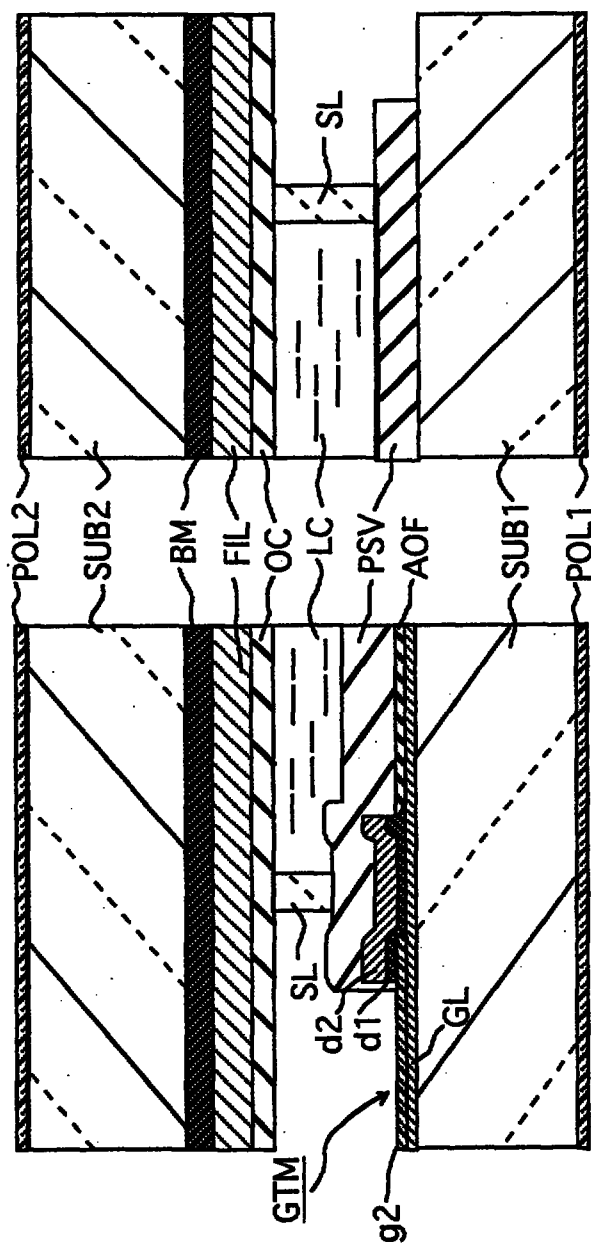
FIG.5



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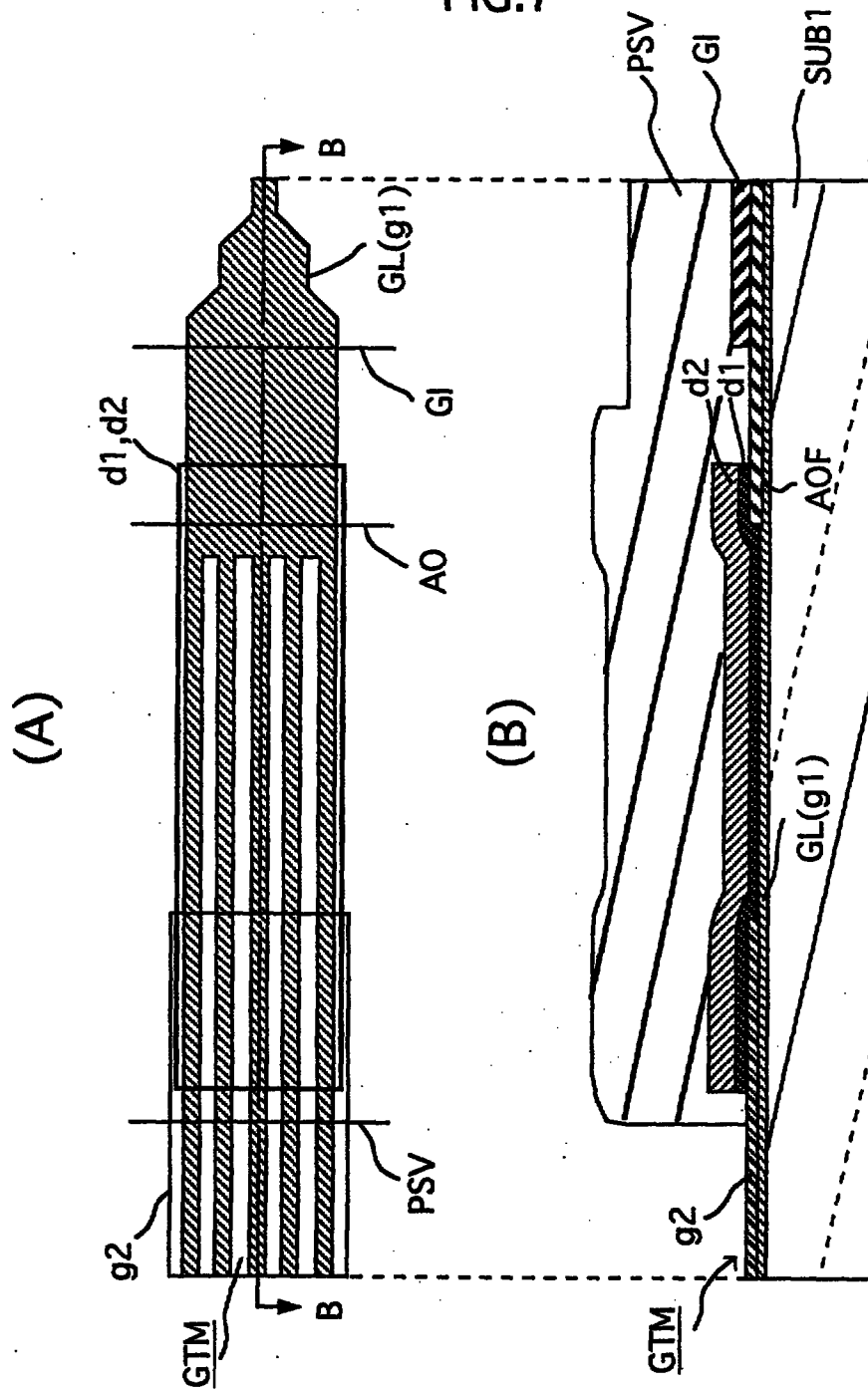
FIG.6



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FIG. 7



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FIG.8

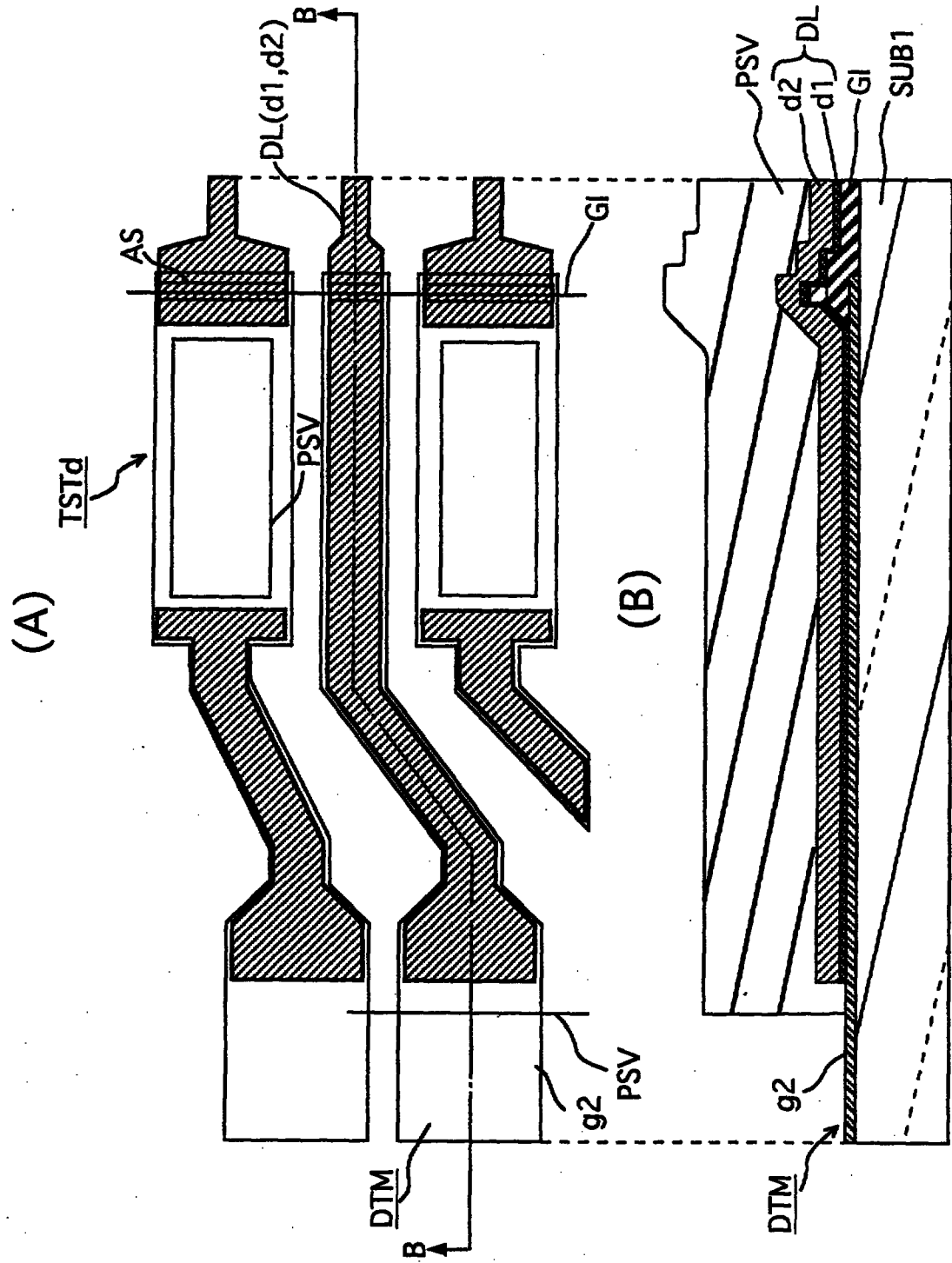
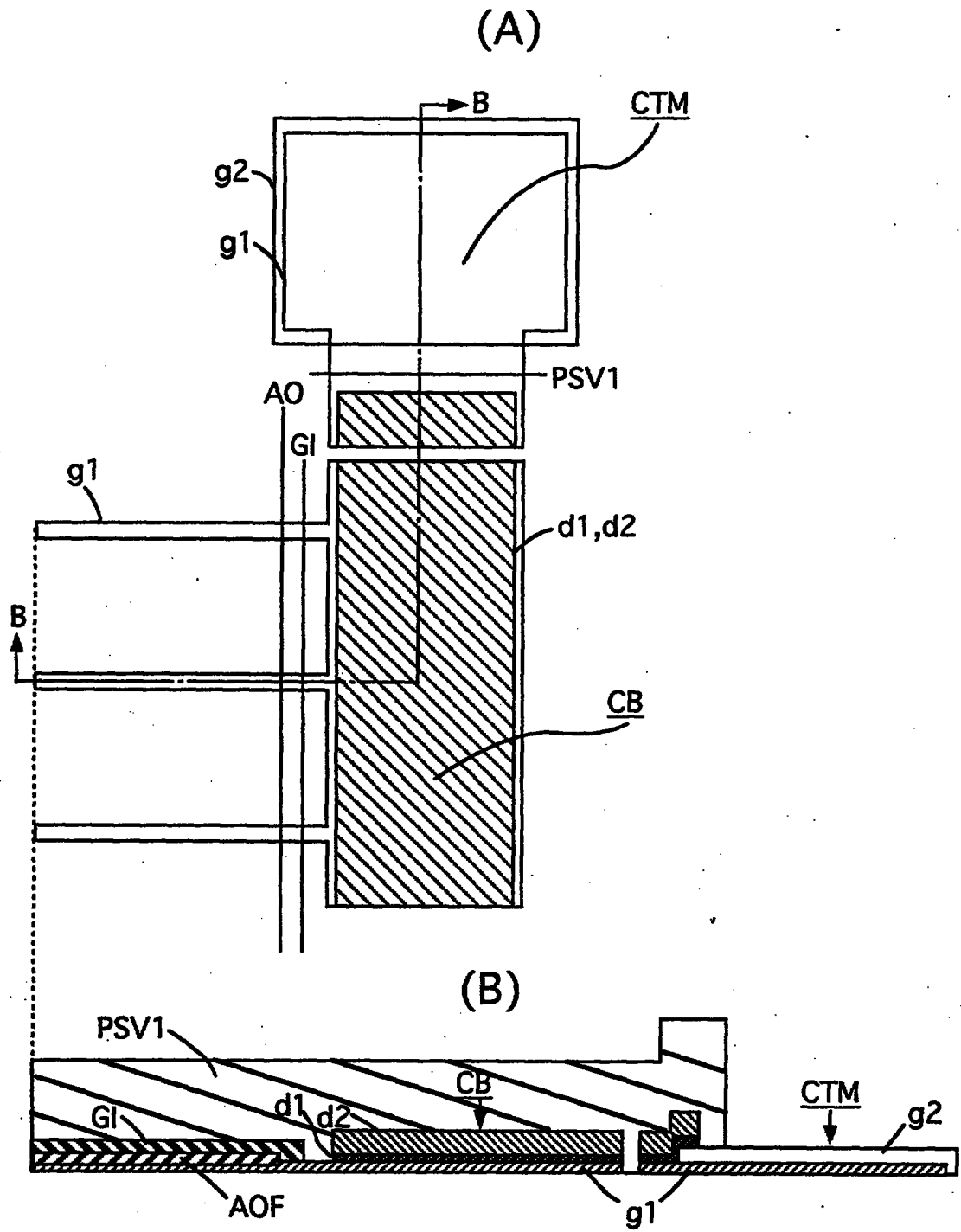


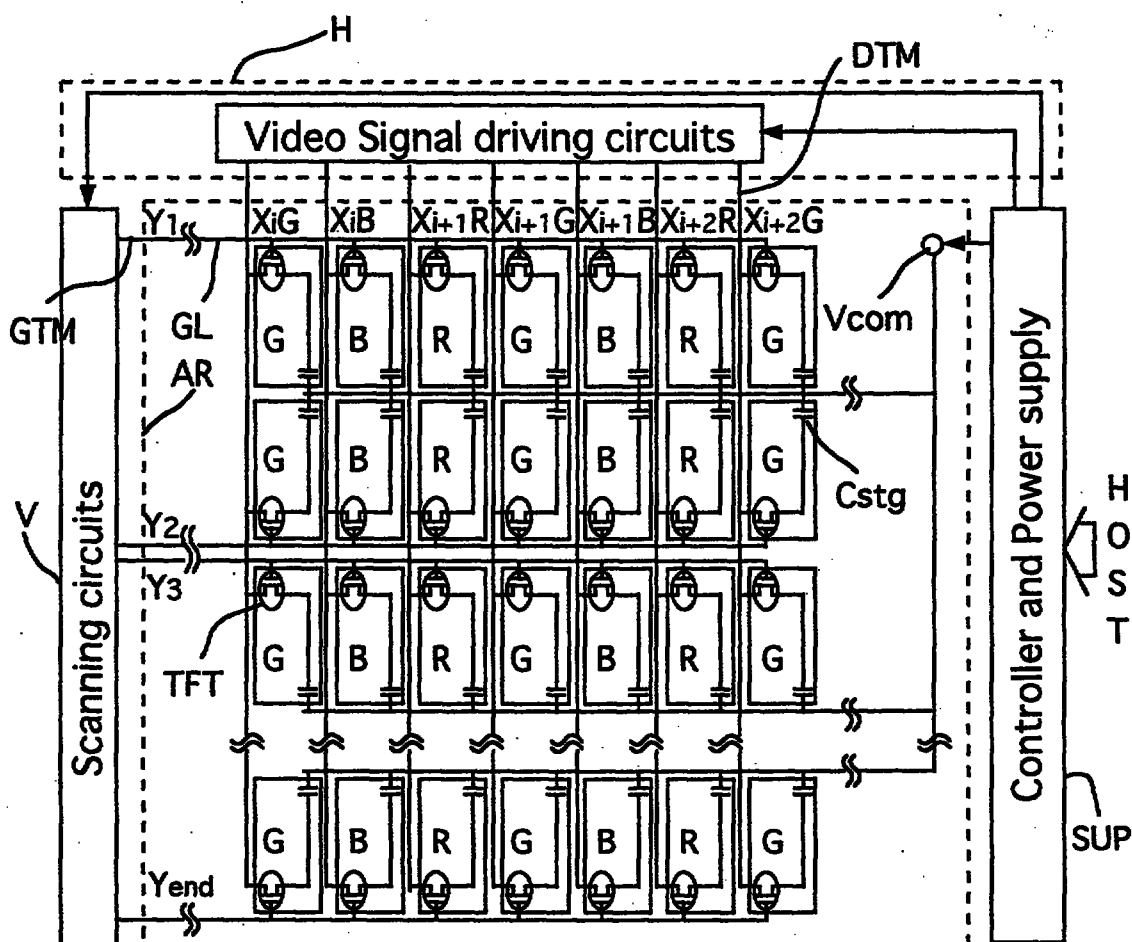
FIG. 9



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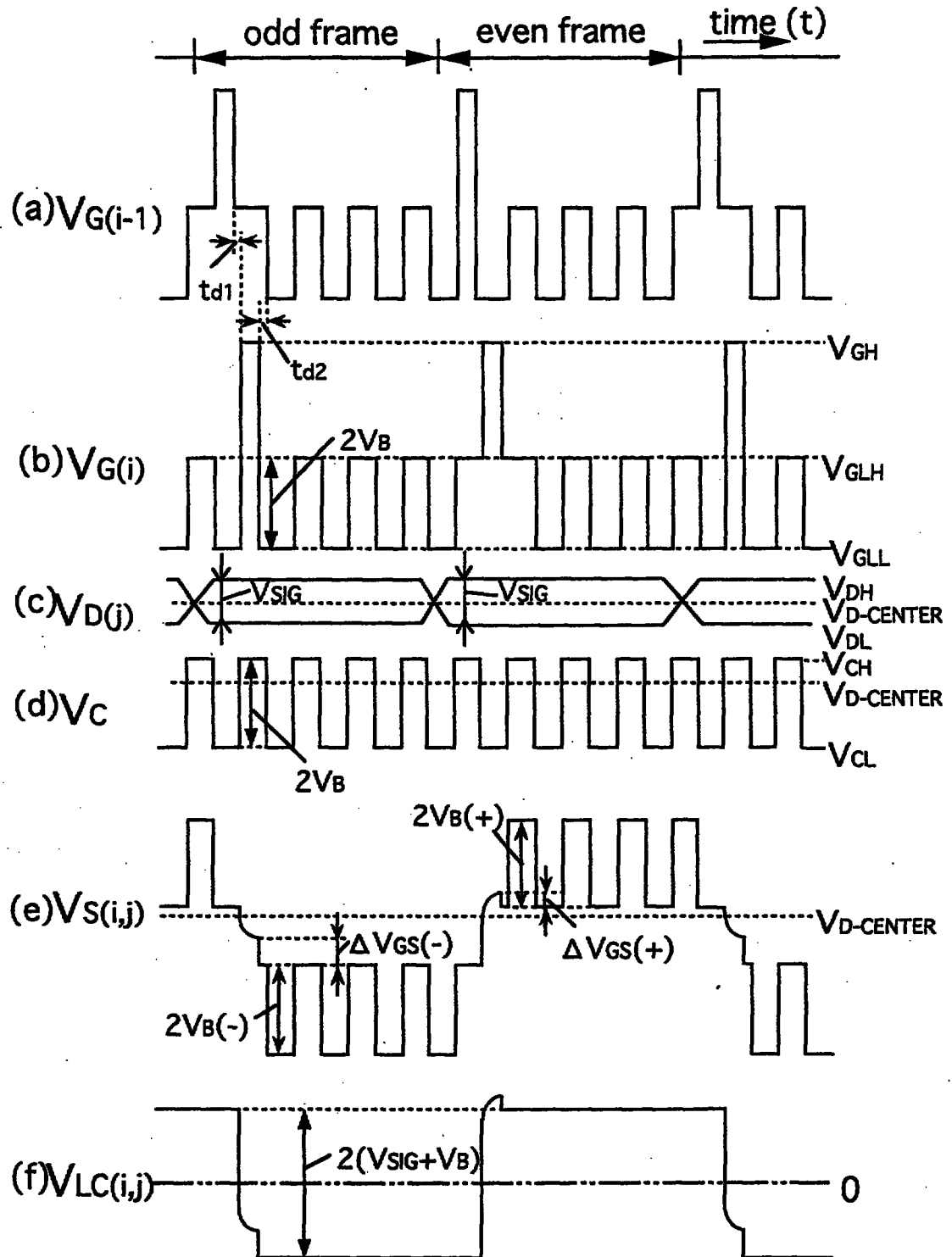
FIG.10



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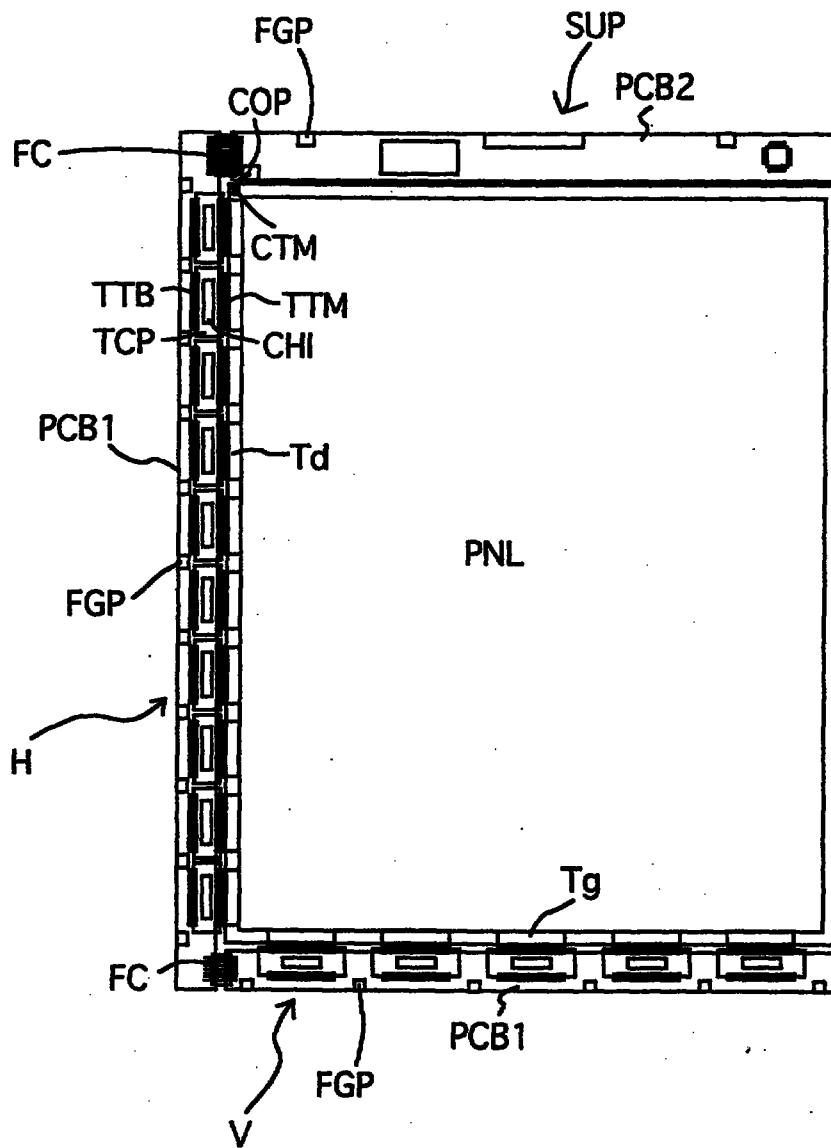
FIG. 11



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FIG.12



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FIG.13

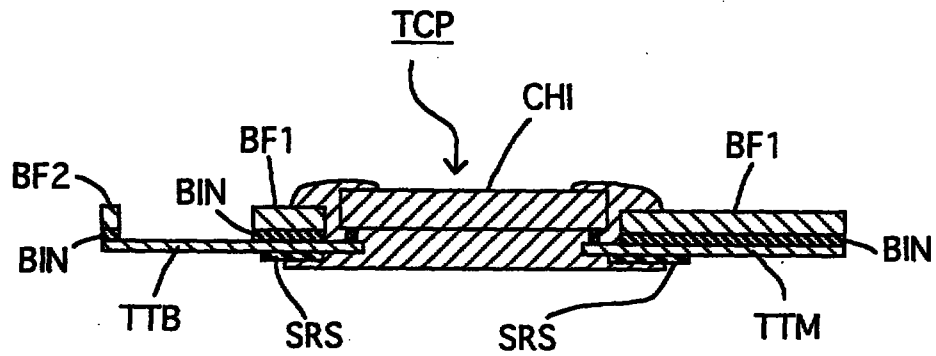
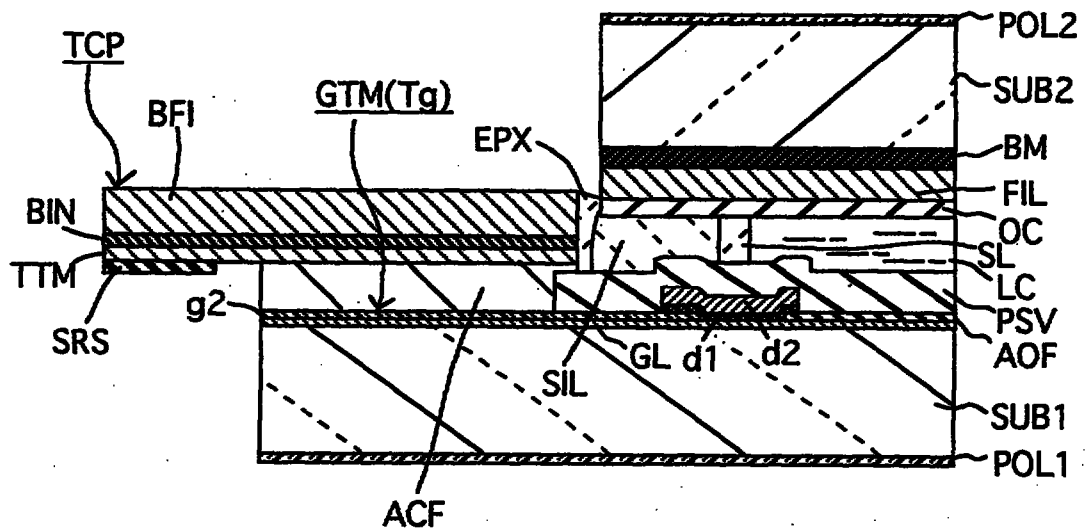


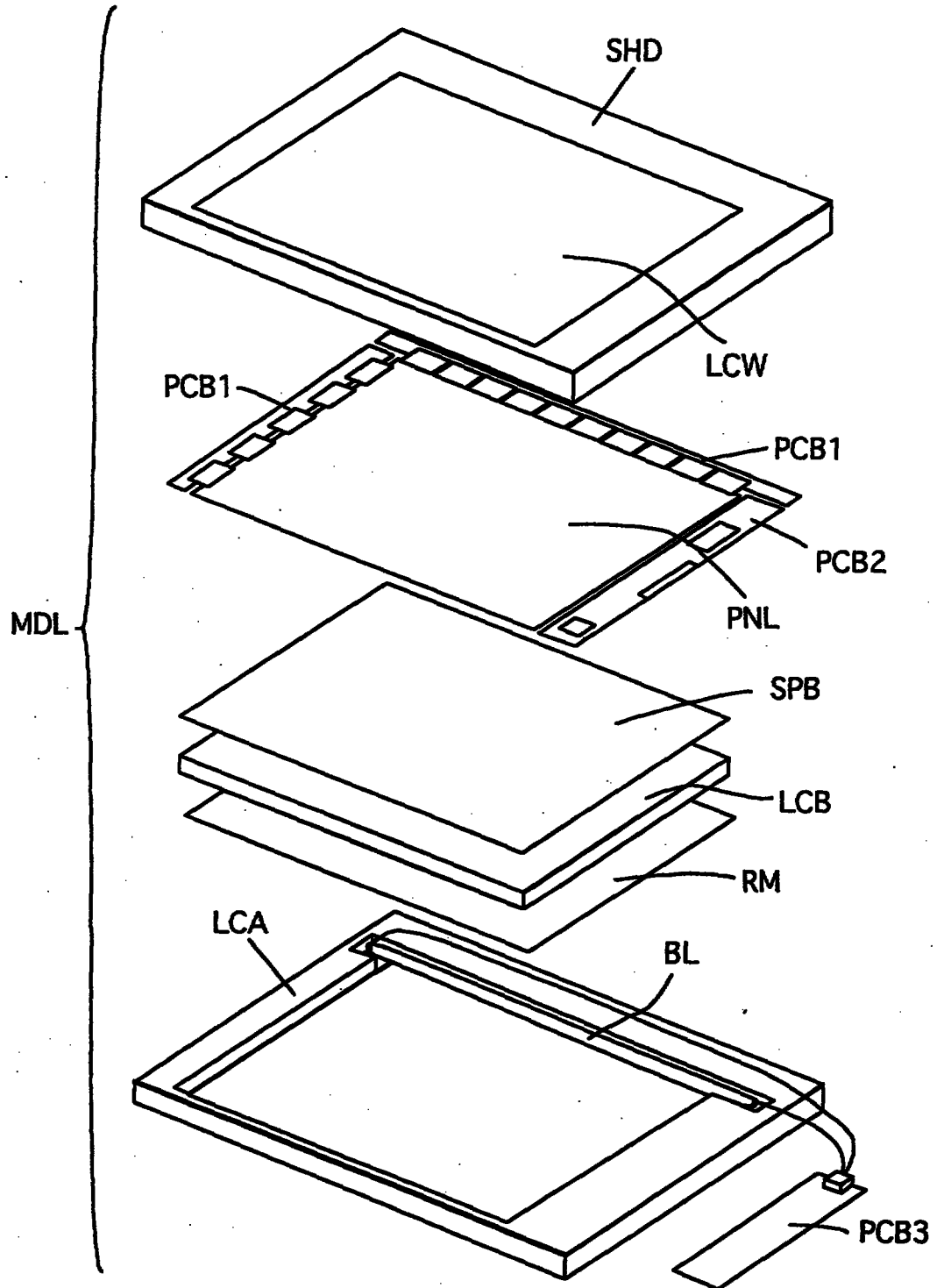
FIG.14



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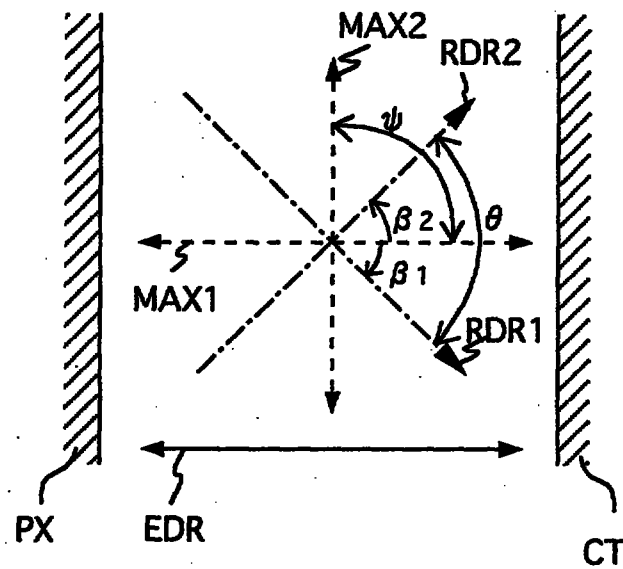
FIG.15



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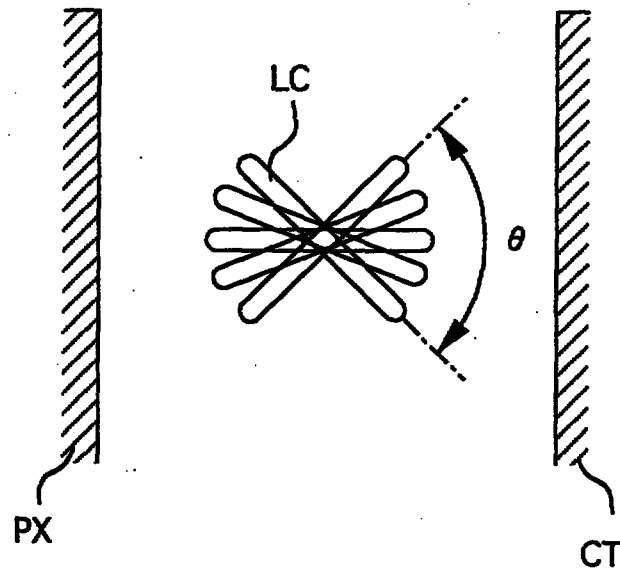
FIG.16



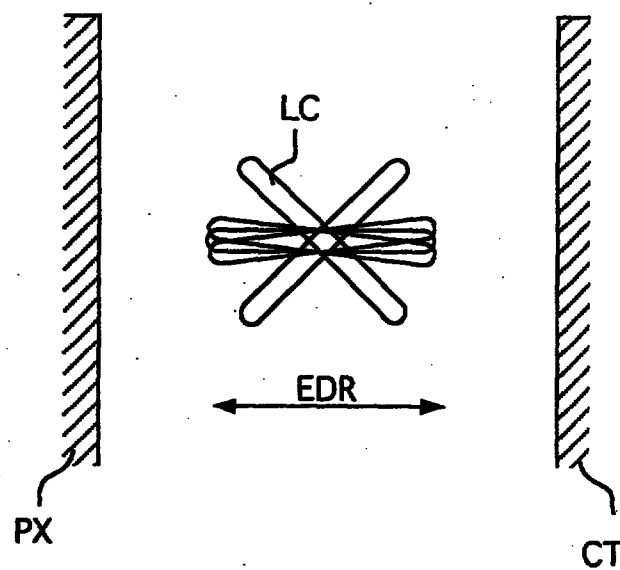
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FIG.17



(a) State of voltage OFF (High penetration rate)

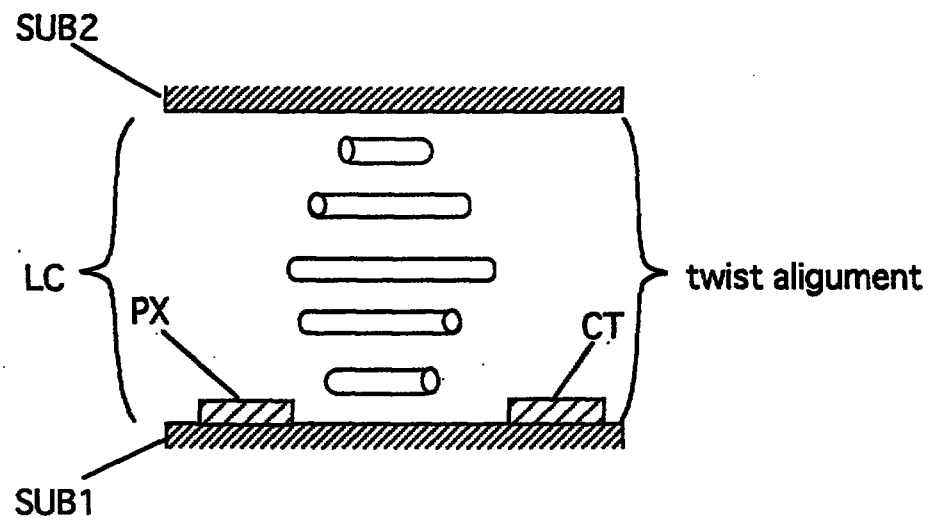


(b) State of voltage ON (Low penetration rate)

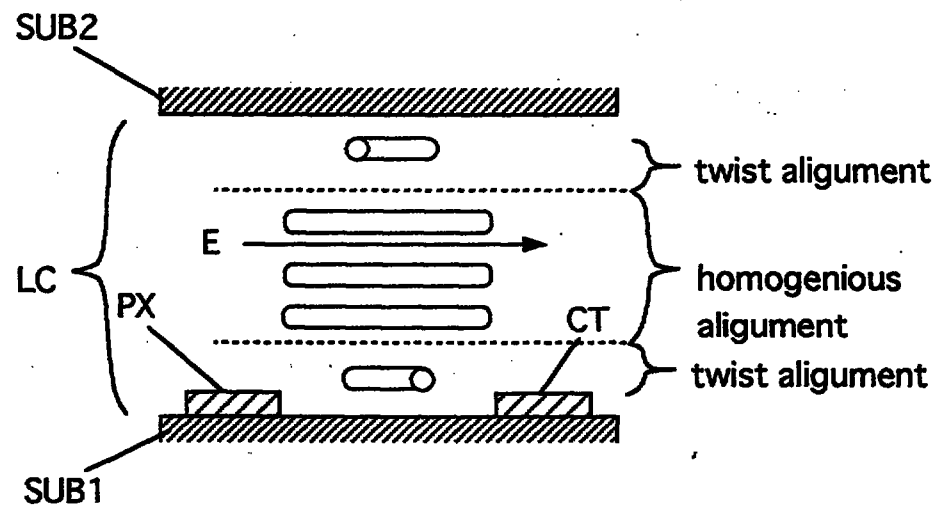
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FIG.18



(a) State of voltage OFF (High penetration rate)



(b) State of voltage ON (Low penetration rate)

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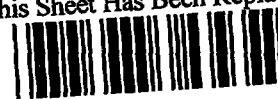


FIG.19

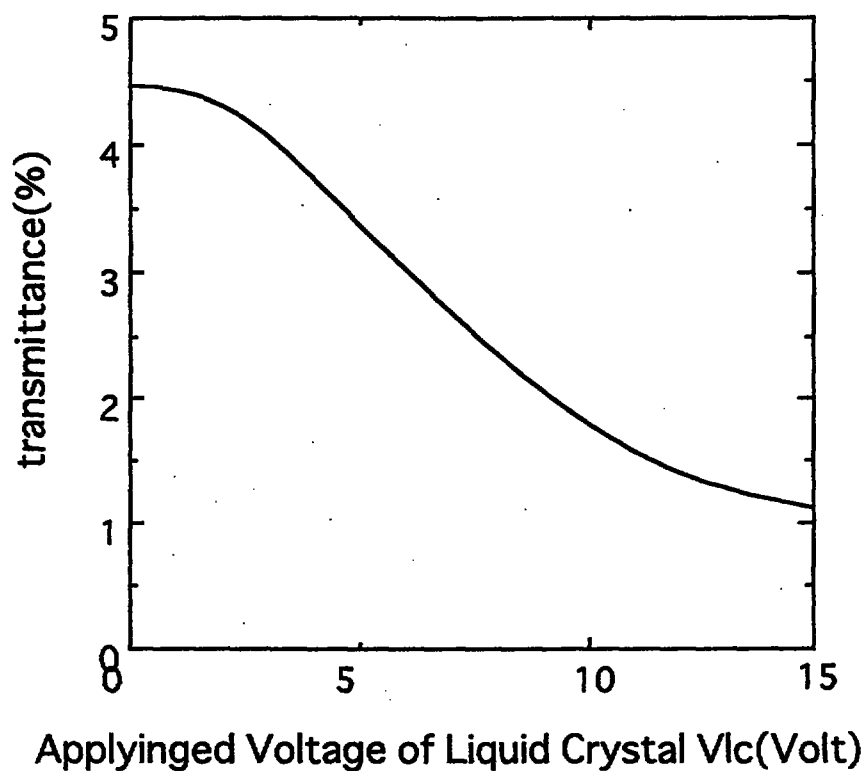


FIG.20

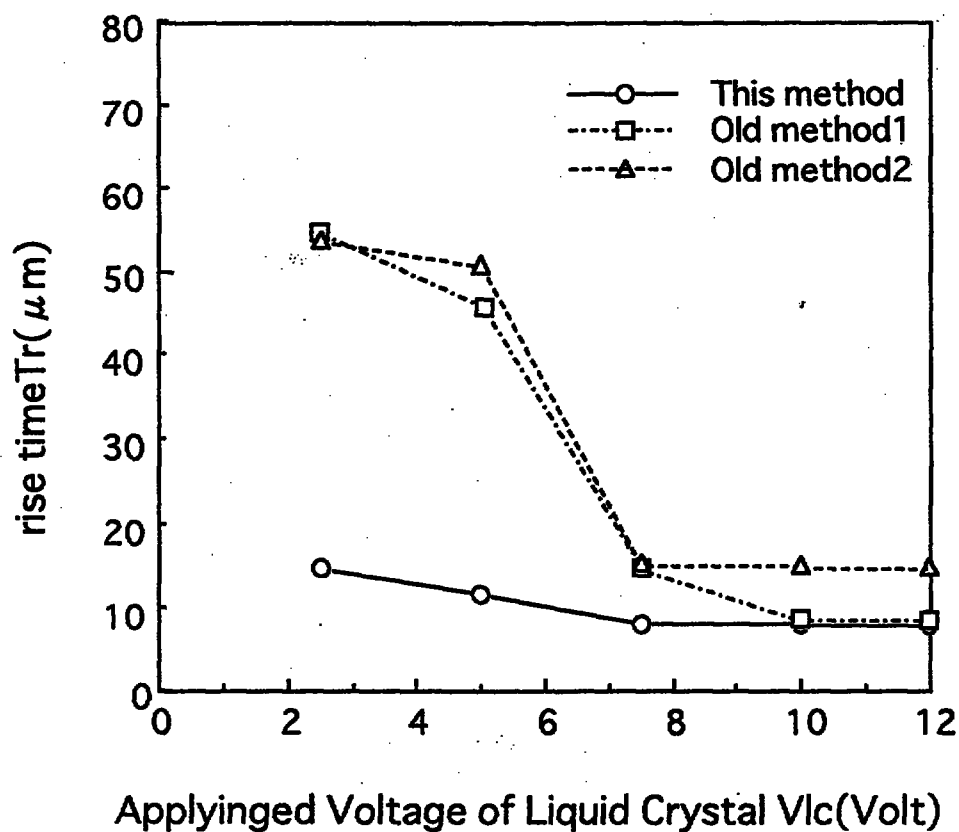




FIG.21

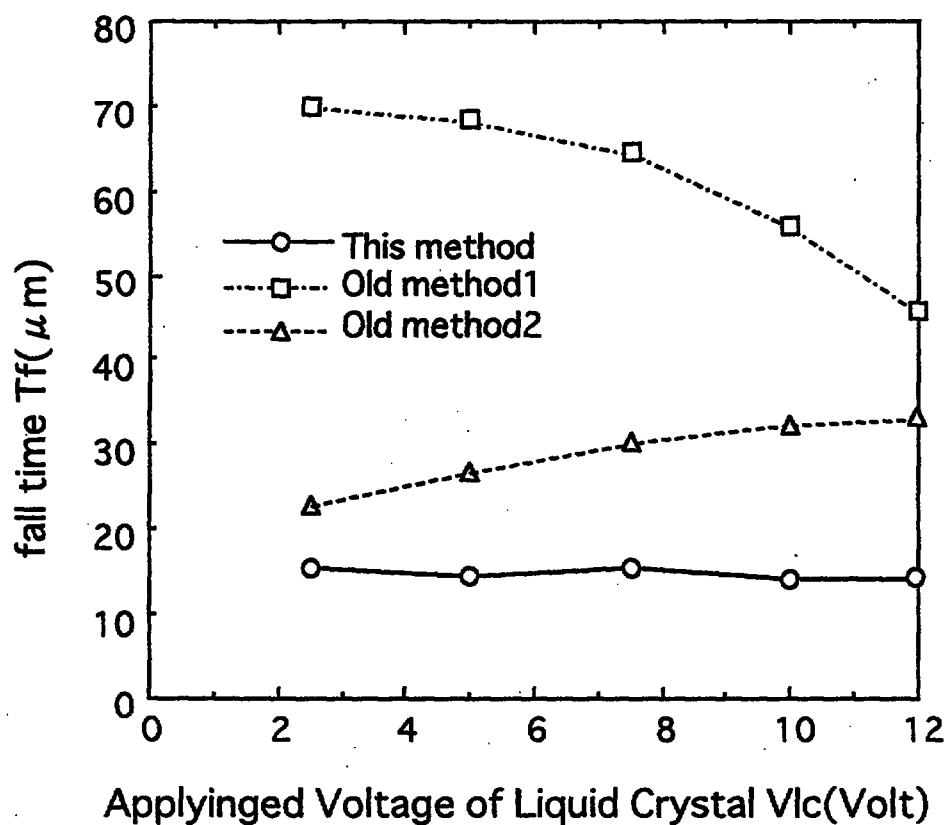


FIG.22

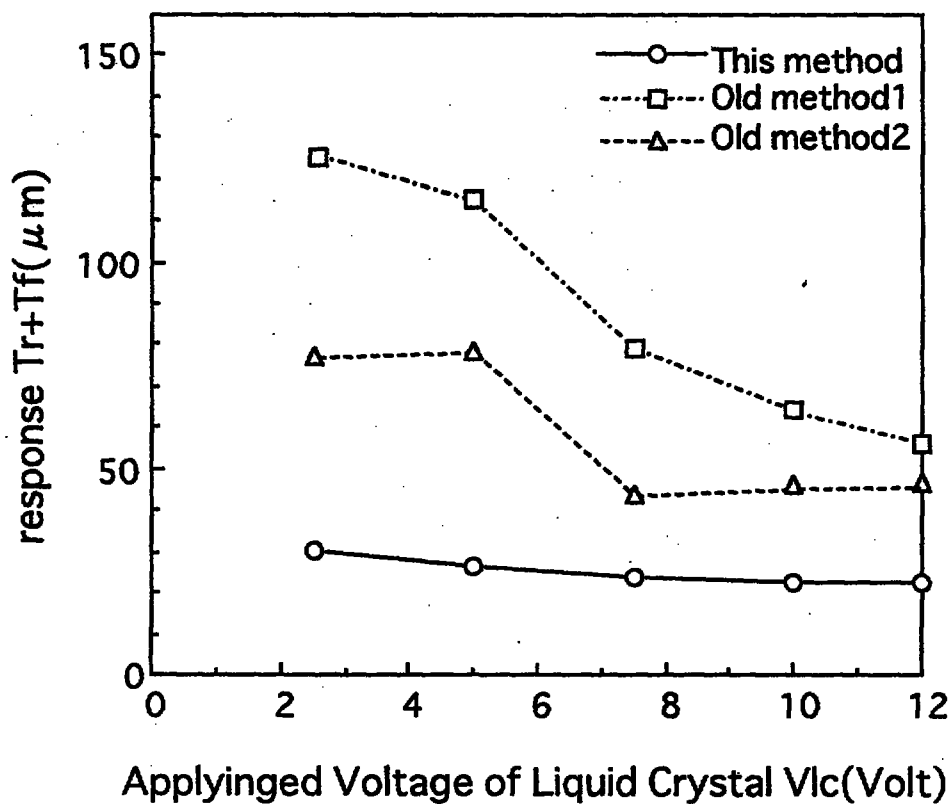
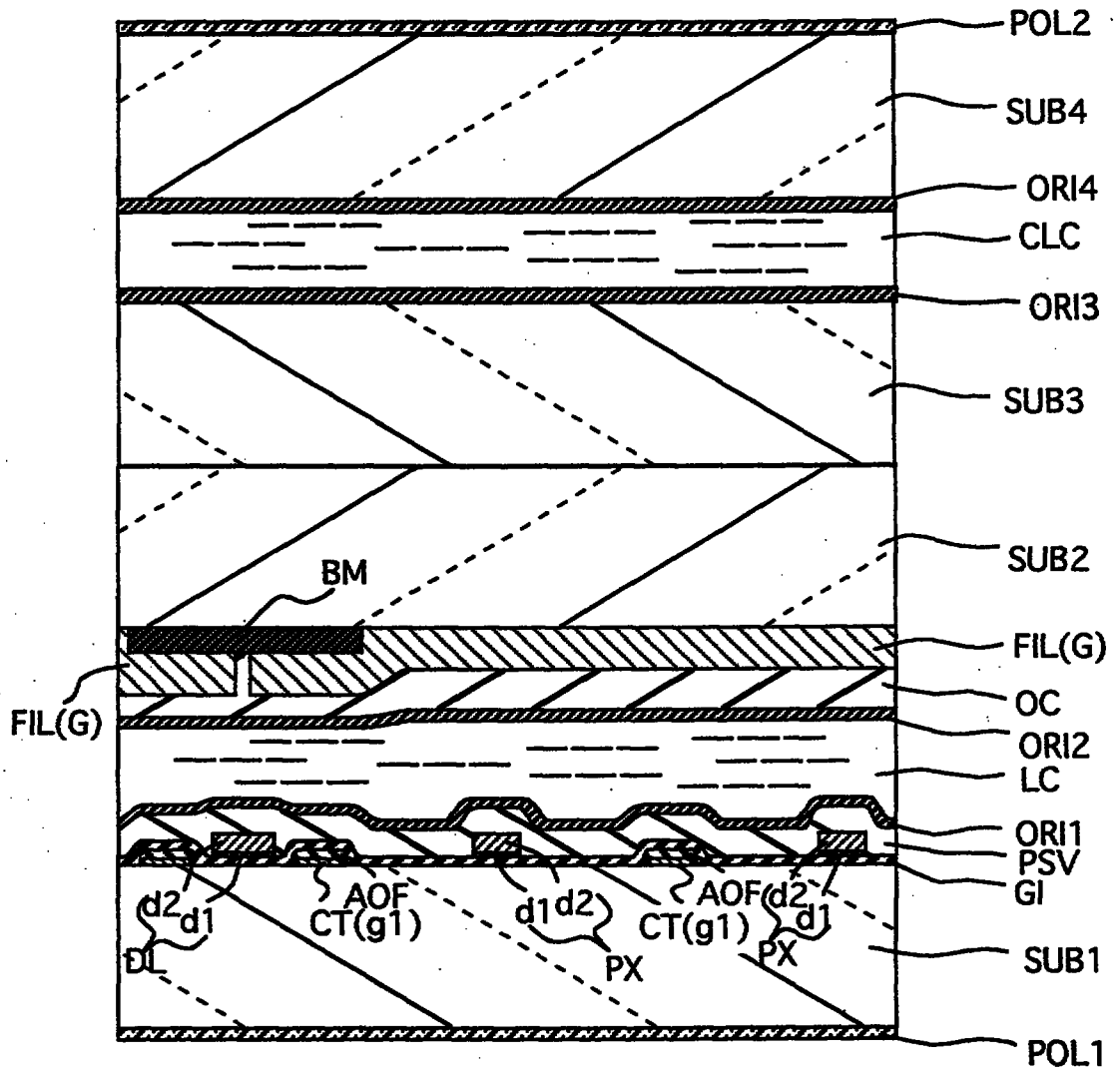


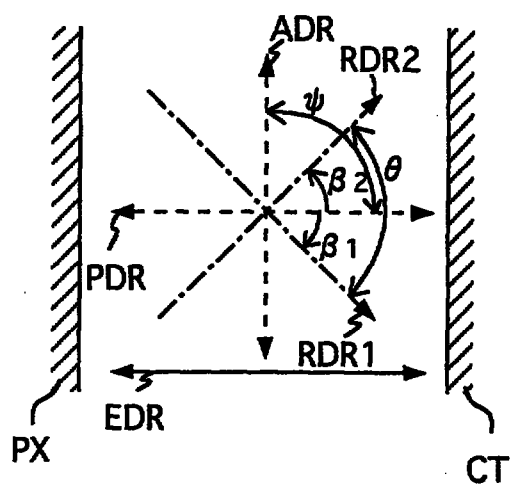
FIG.23



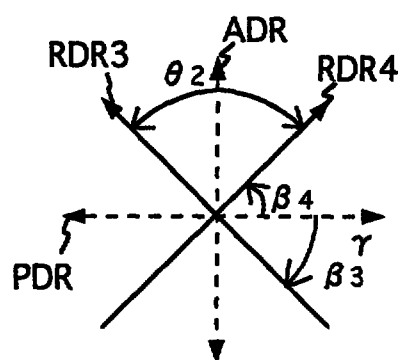
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FIG.24



(a) Liquid Crystal cell for drive

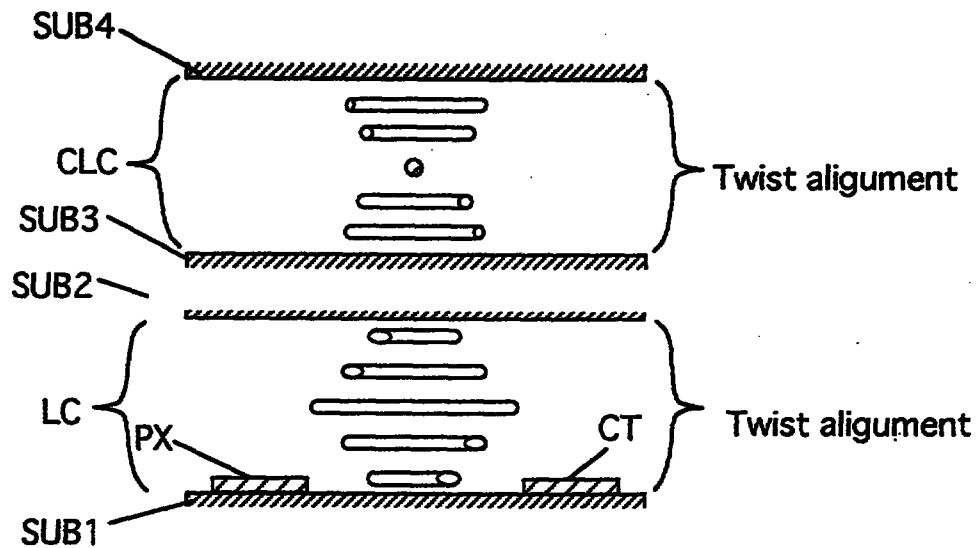


(b) Liquid Crystal cell for amend

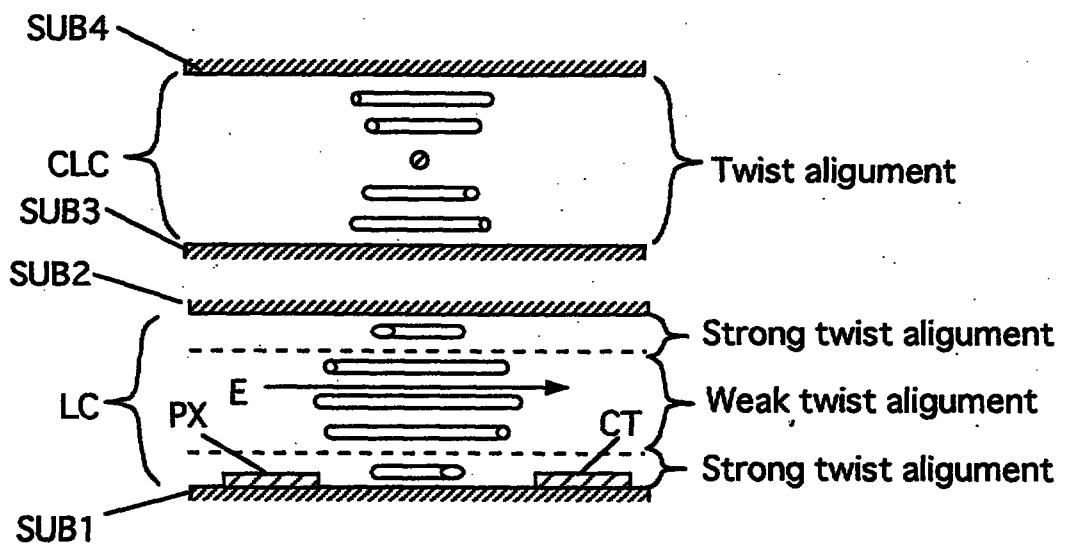
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FIG.25



(a) State of voltage OFF (High penetration rete)



(b) State of voltage ON (Low penetration rete)

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FIG.26

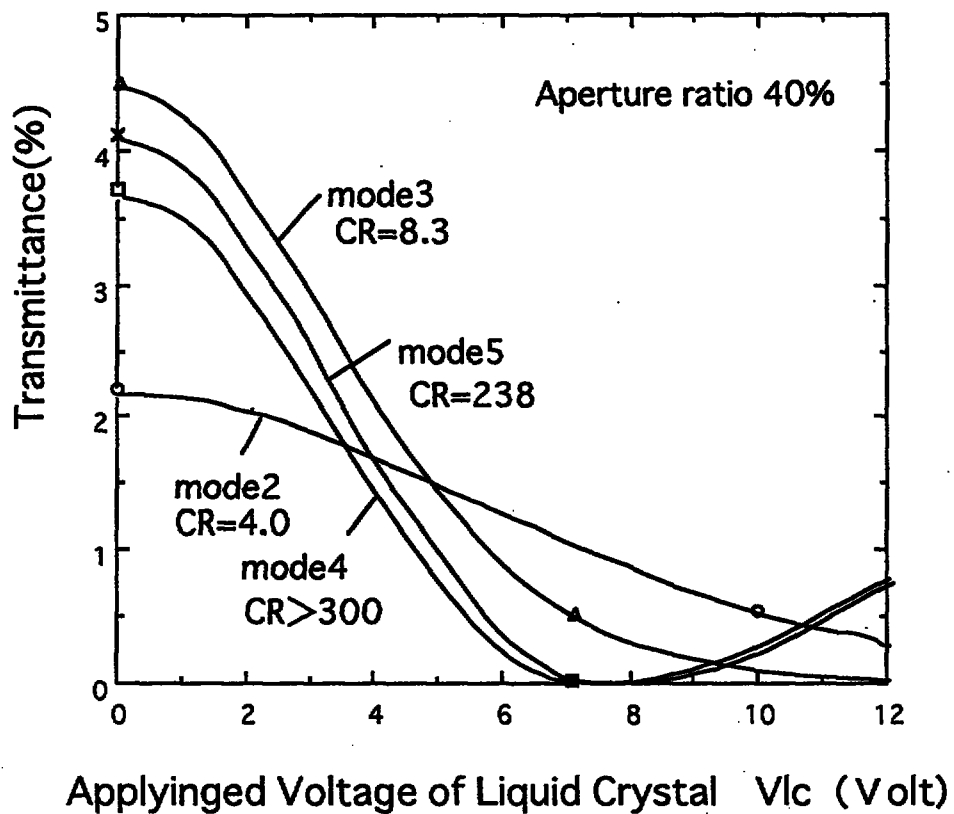


FIG.27

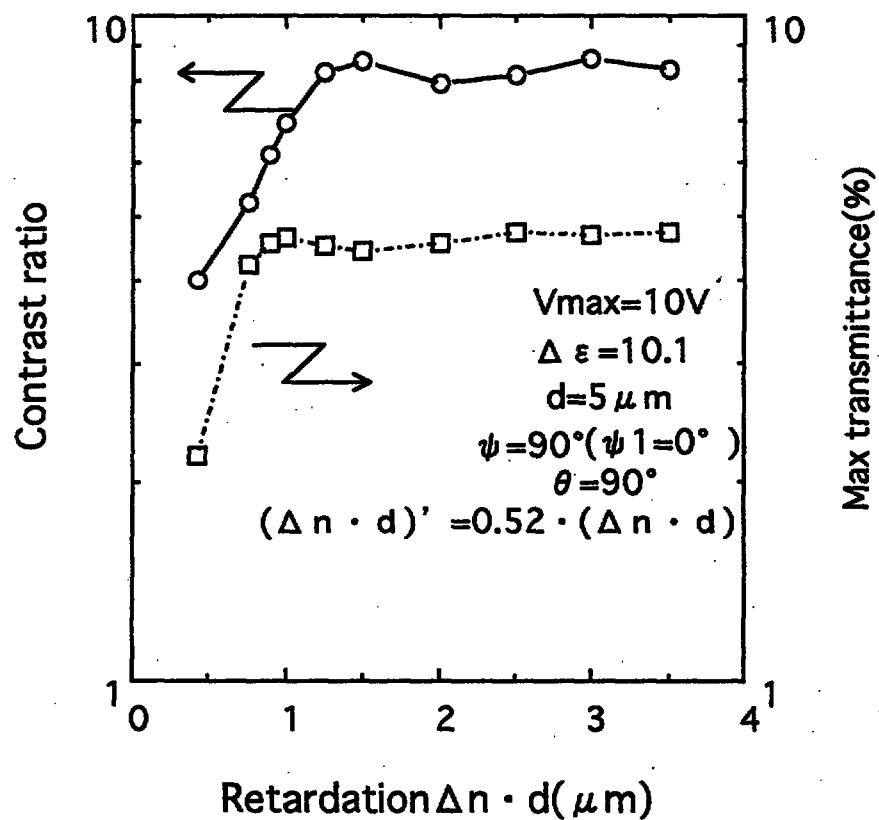




FIG.28

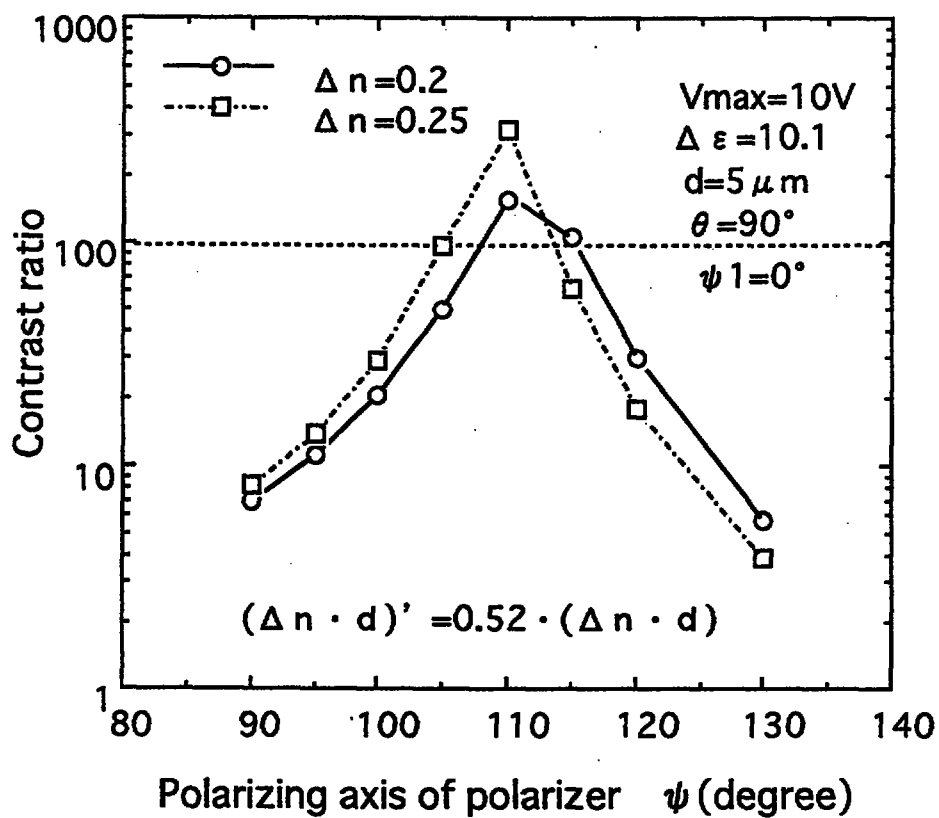


FIG.29

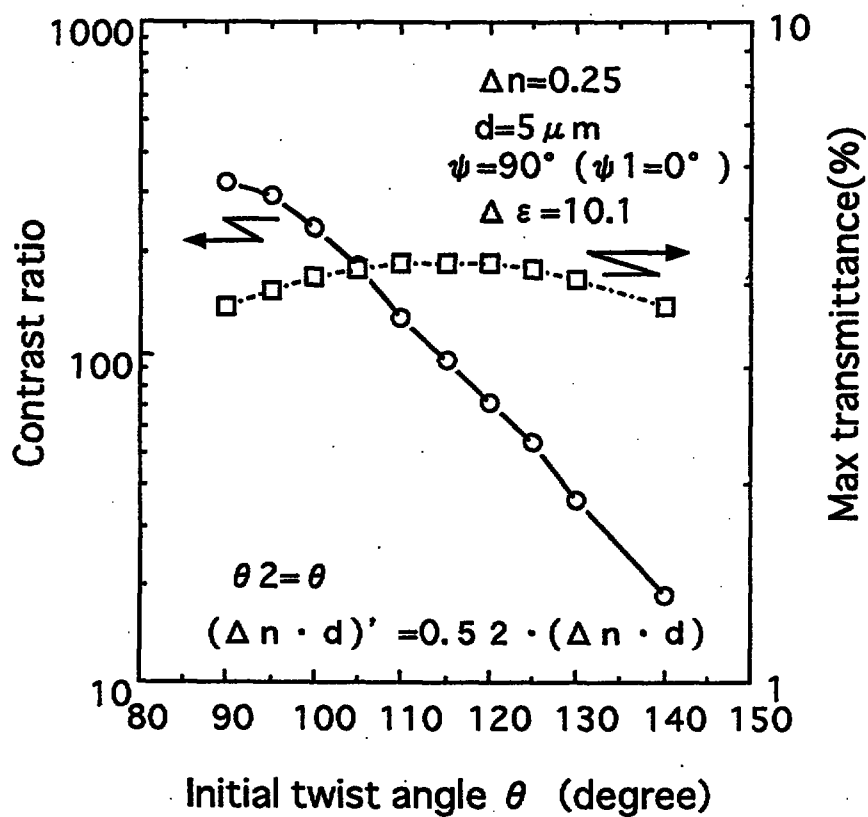
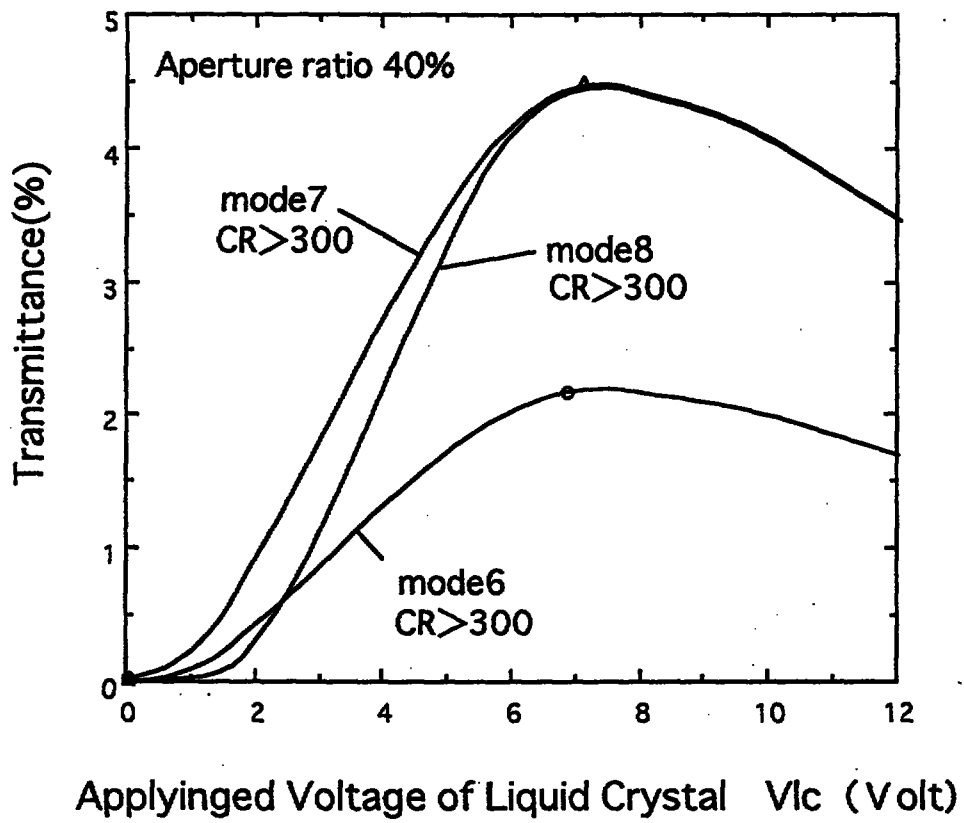


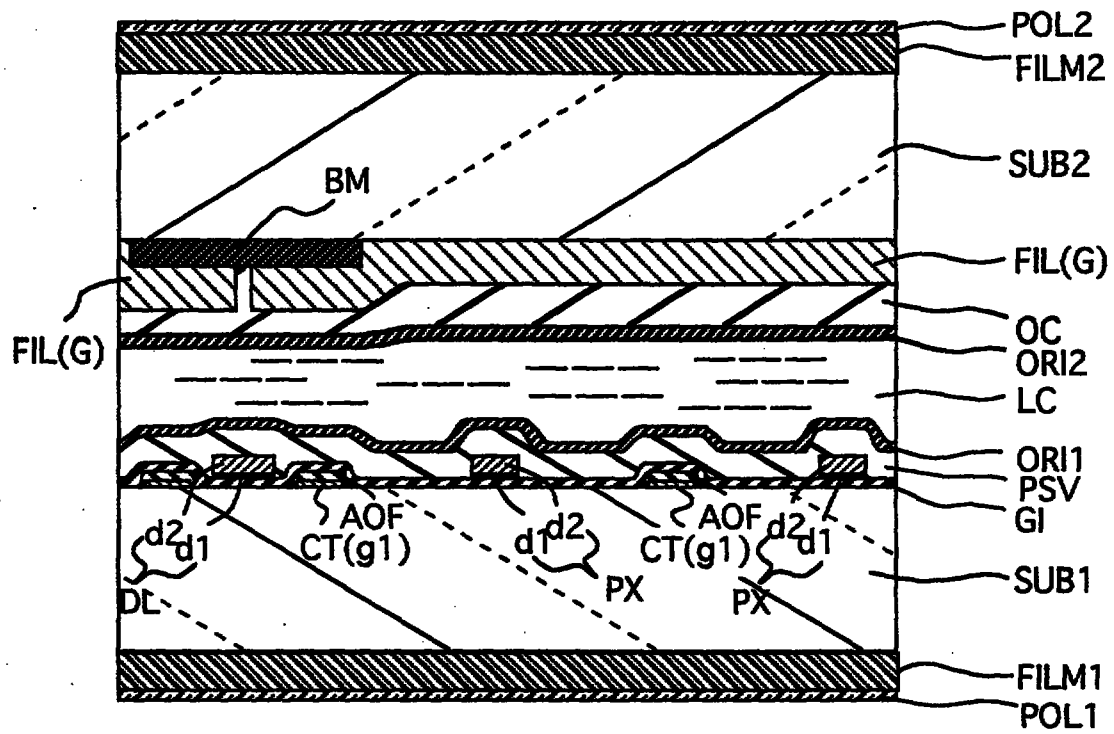
FIG.30



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FIG.31



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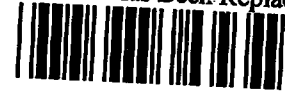


FIG.32

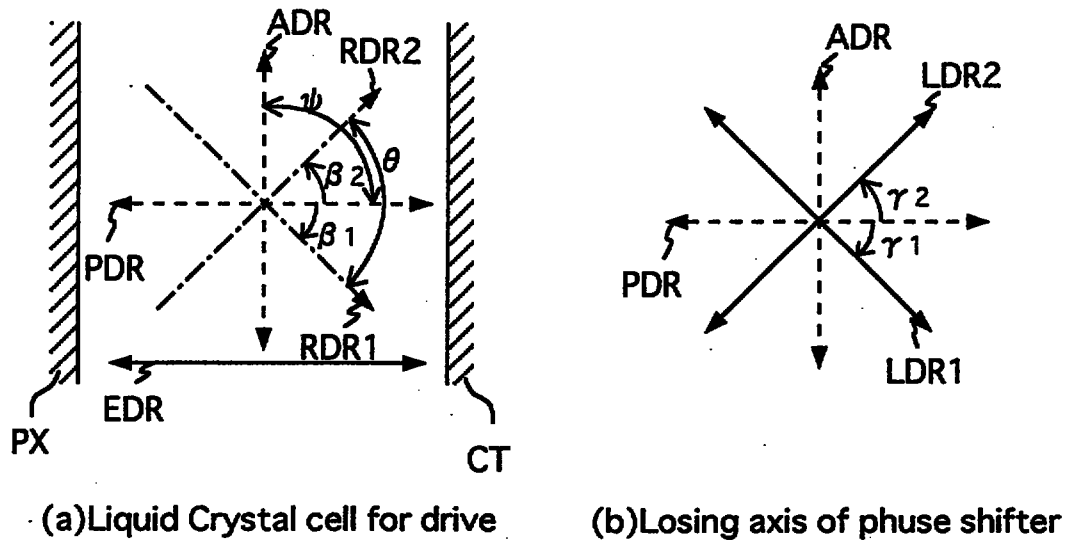


FIG.33

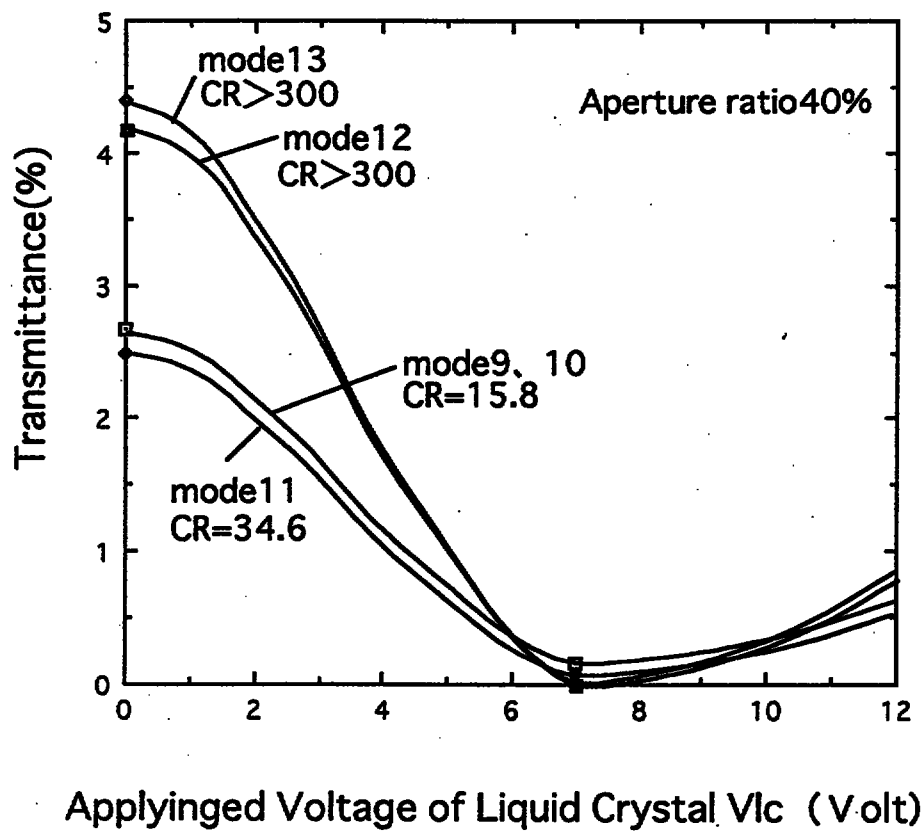




FIG.34

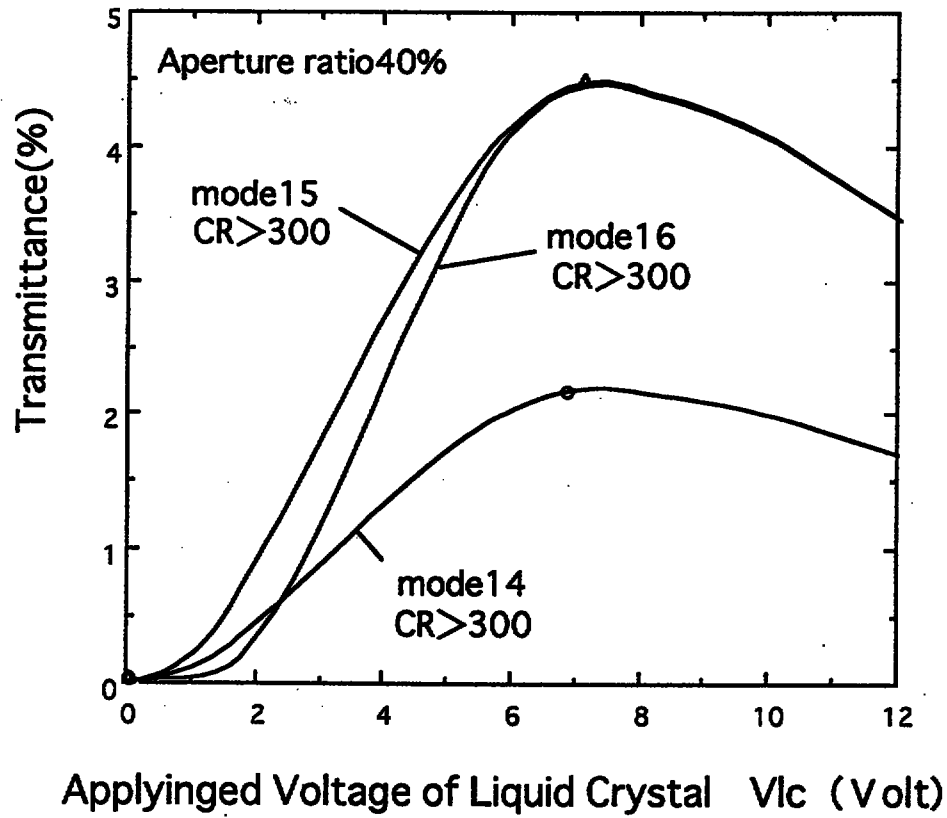


FIG.35

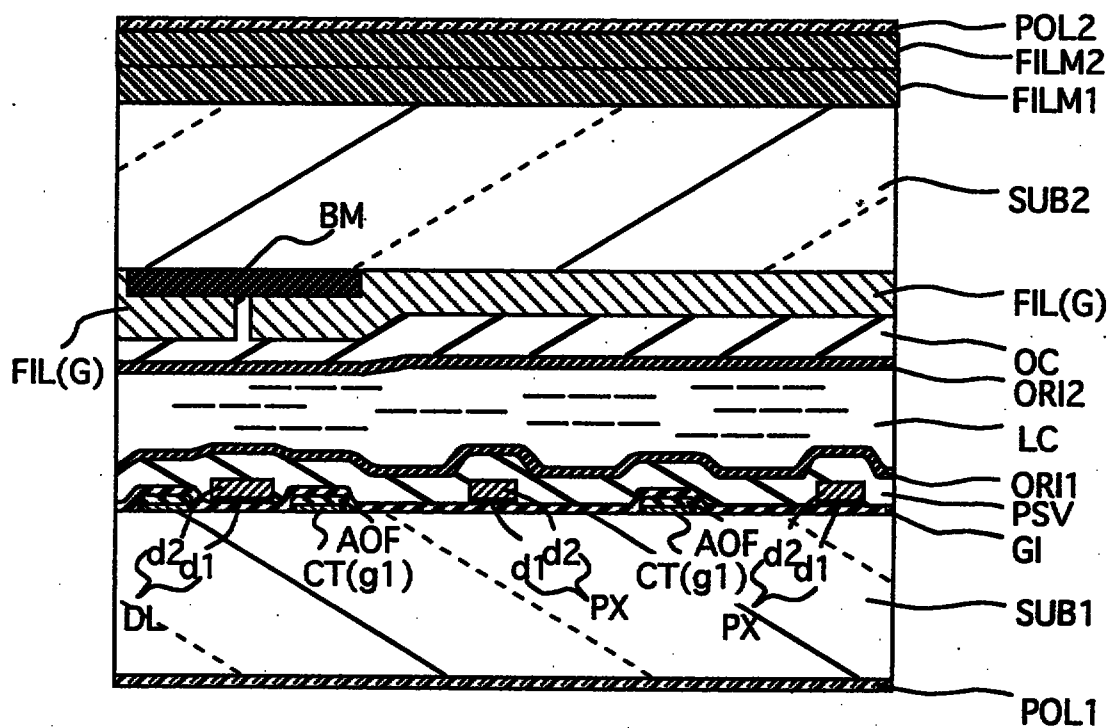
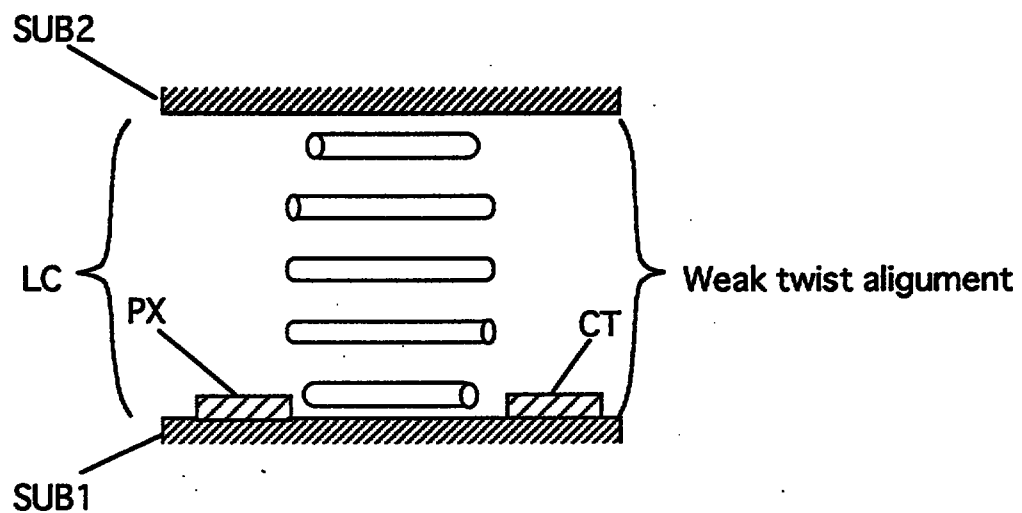
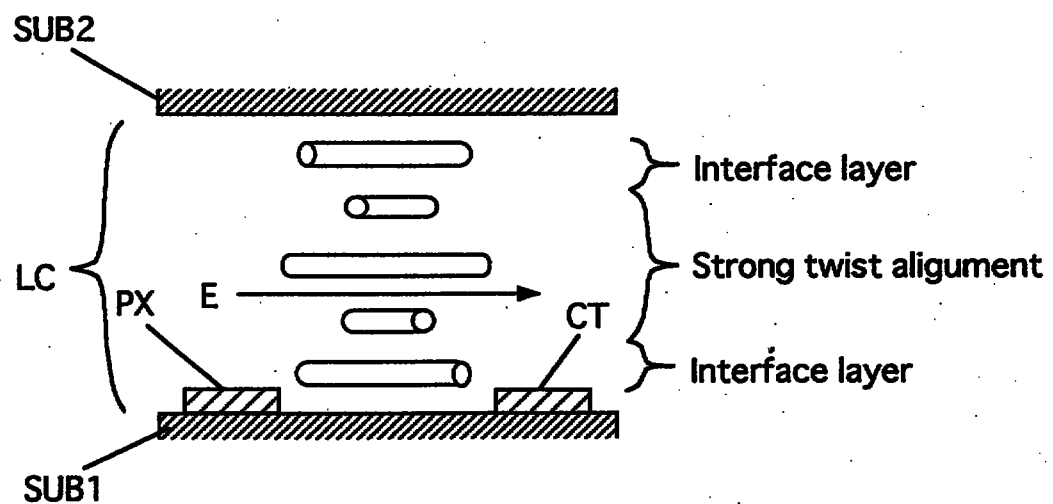




FIG.36

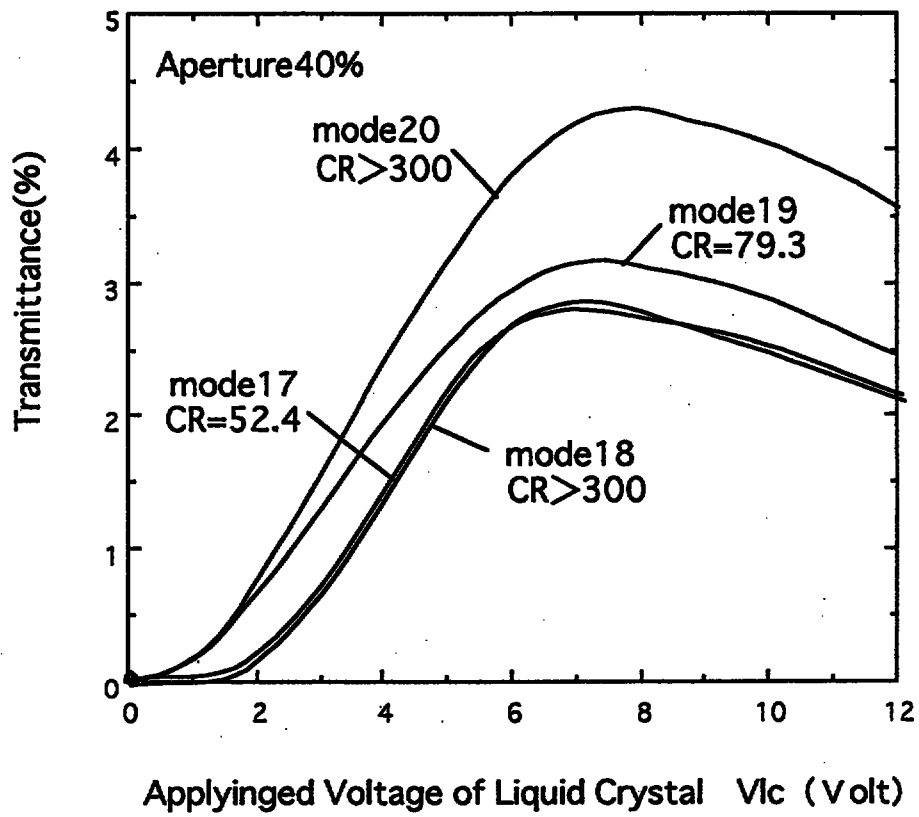


(a) State of voltage OFF (Low Penetration rate)



(b) State of voltage ON (High Penetration rate)

FIG.37



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REPLACEMENT SHEETS SG
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ACTIVE MATRIX TYPE LIQUID CRYSTAL DISPLAY DEVICE

[Detailed Description of the Invention]

[0001]

[Technical Field to Which the Invention Belongs]

The present invention relates to a liquid crystal display device and more particularly to an active matrix type liquid crystal display device using thin-film transistors.

[0002]

5 [Prior Art]

Active matrix type liquid crystal display devices using active devices represented by thin-film transistors (TFTs) are beginning to find wide uses as display terminals for office automation equipment thanks to their features of small thickness and light weight and high display quality, compared to that of CRT. The display methods of the liquid crystal display device can be classified largely into two categories. In one method, a liquid crystal is held between two substrates having transparent electrodes and the liquid crystal is activated by a voltage applied to the transparent electrodes to modulate light that has passed through the transparent electrodes and entered the liquid crystal to display an image. Most of the liquid crystal display products currently in use adopt this method. In another method, the liquid crystal is activated by an electric field virtually parallel to a substrate surface between two electrodes formed on the substrate to modulate the light entering the liquid crystal from a

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gap between the two electrodes (hereinafter referred to as a lateral field method). This has an advantage of significantly wide viewing angle and is a prospective technique in connection with the active matrix type liquid crystal display device. The features of the latter method are described mainly in Published Japanese Translation of PCT Patent Application from another state No. 505247/1993, Japanese Patent Publication No. 21907/1988 and Japanese Patent Laid-Open No. 160878/1994.

[0003]

[Problems to be solved by the Invention]

The active matrix type liquid crystal display device described in the above patent application in connection with the lateral field method (also called an in-plane switching method), however, has a response speed of about 100 ms at the fastest, far from the requirement of less than 40-20 ms for the display of dynamic images. This type of liquid crystal display device has the drawback that when a dynamic image is displayed, its residual image is produced making the dynamic image look like a comet with a tail.

[0004]

An object of this invention is to provide an active matrix type liquid crystal display device which

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has a wide viewing angle, compared to that of a CRT and a response fast enough to display a dynamic image.

[0005]

The known lateral field method has the following
5 two types of configuration.

[0006]

The response time is defined as the sum of a rise time at voltage application and a fall time at voltage turn-off and will be detailed in the following.

10 [0007]

The first configuration has the liquid crystal molecules in a liquid crystal layer initially orientated in the same direction as the electric field application direction on the interface of the liquid
15 crystal layer on the upper substrate side and, on the interface on the lower substrate side, orientated about 90 degrees from the electric field application direction so that the liquid crystal molecules are twisted about 90 degrees when the voltage is turned
20 off.

[0008]

The liquid crystal molecules in this state are turned about 90 degrees in the electric field application direction at the interface on the lower
25 substrate side by the electric field almost parallel

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to the substrate surface generated by two electrodes (referred to as a lateral field) to eliminate their optical rotary power and thereby change their transmittance to display an image.

5 [0009]

 This configuration, however, needs to rotate the liquid crystal molecules near the interface with the lower substrate by as much as about 90 degrees and therefore the drive voltage may easily become
10 extremely high, higher than 10 V. As for the response speed of this configuration, although the rise time can be made faster to some extent, the fall time takes on at least 40 ms because the liquid crystal molecules must turn back through 90 degrees. This response is
15 not fast enough for displaying a dynamic image.

 [0010]

 In the second configuration the liquid crystal molecules in the liquid crystal layer at the interfaces with the upper and lower substrate are
20 initially orientated almost in the same direction so that they are homogeneously orientated without any twist when the voltage is turned off. The liquid crystal molecules in this state are wholly rotated about 45 degrees in the electric field direction by
25 the lateral field (when the molecules have a positive

dielectric anisotropy. When they have a negative dielectric anisotropy, they are rotated in a direction perpendicular to the electric field) to change the birefringent index of the liquid crystal layer at that time and therefore the transmittance to display an image.

[0011]

The second configuration can reduce the drive voltage to about 5 V, lower than that of the first configuration, which is in a practical range except for a rapidly changing, specific dynamic pictures.

[0012]

In the second configuration, the response speed depends greatly on the thickness of the liquid crystal layer between the upper and lower substrates and is faster as the liquid crystal layer thickness becomes smaller. When the gap between the substrates is made too narrow, the gap uniformity becomes difficult to maintain, with an increased chance of display variations occurring. There is another problem that the process of injecting the liquid crystal is slow, taking a too long time. Considering these factors, the liquid crystal layer has a practical thickness limit of about 4 μm . The response speed therefore has been some 60 ms at the fastest.

[0013]

Examples of the first configuration are described
in G. Baur et al, JAPAN DISPLAY 1992, PP.547-550, or
by R. A. Soref, Journal of Applied Physics, Vol. 45,
5 No. 12, December 1974, PP. 5466-5468, or by R. A.
Soref, Proceedings of the IEEE, December 1974, PP.
1710-1711.

[0014]

An example of the second configuration is found
10 in ASIA DISPLAY 1995, PP. 577-580 by M. Ohe et al.

[0015]

[Means to Solve the Problems]

A typical configuration of this invention is the
one in which the liquid crystal molecules in the
15 liquid crystal layer are initially orientated about 45
degrees from the voltage application direction at the
interface with the upper substrate and, at the
interface with the lower substrate, orientated about -
45 degrees from the voltage application direction so
20 that the liquid crystal molecules are twisted by some
90 degrees when the voltage is turned off.

[0016]

For easy understanding, the initial orientation
angle is defined as positive for a counterclockwise
25 rotation with respect to the in-plane direction of the

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lateral field and ranges from -90 degrees to 90 degrees.

[0017]

To display an image, the liquid crystal molecules
5 in this state are rotated by the lateral field about -
45 degrees in the electric field direction at the
interface with the upper substrate and, at the
interface with the lower substrate, rotated about 45
degrees in the electric field direction to eliminate
10 their birefringence and thereby change their
transmittance, forming an image.

[0018]

In this configuration, the liquid crystal
molecules near the interfaces with the upper and lower
15 substrates need only to be turned about 45 degrees
respectively in opposite directions, which can be
realized by a lower voltage than that of the first
configuration. Further, because this configuration
comprises the two liquid crystal layers stacked
20 together, each twisted by 45 degrees about the center
of the liquid crystal layer in opposite directions,
this configuration is identical to the one in which
the gap between the substrates is reduced to about
one-half. That is, the liquid crystal molecules in
25 two stacked layers, because their activation force is

associated with the elastic relation among the liquid crystal molecules in each layer, are identical to the one having virtually one-half the liquid crystal layer thickness in terms of activation of the molecules.

5 [0019]

In the case of the first configuration, like the second configuration the response speed becomes faster as the liquid crystal layer thickness decreases, i.e., the response speed is approximately inversely
10 proportional to the square of the liquid crystal layer thickness. Further, because the liquid crystal layer of this embodiment rotates only 45 degrees, compared to 90 degrees in the first configuration, the response is about two times faster than that of the first
15 configuration. In theory, the configuration of this invention can achieve a response speed up to about eight times that of the first embodiment.

[0020]

Assuming that the fall time in the first
20 embodiment is about 45 ms, the configuration of this invention can theoretically realize a fall time of about 6 ms. Measurements show that this configuration achieved a response speed of about 20 ms.

[0021]

25 In this configuration, no reduction in the

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response speed has resulted which has been observed in the conventional configurations during a half-tone display, and almost constant, fast response speed was obtained at any applied voltage.

5 [0022]

[Embodiments of the Invention]

This invention and further objects and features of this invention will become apparent from the following description with reference to the
10 accompanying drawings.

[0023]

(Embodiment 1)

<<Active Matrix Liquid Crystal Display Device>>

An embodiment of an active matrix type color
15 liquid crystal display device to which this invention is applied will be described in the following. In the drawings, parts having identical functions are denoted by like reference numbers and their descriptions will not be repeated.

20 [0024]

<<Planar Configuration of a Matrix Portion (Pixel Portion)>>

Figure 1 is a plan view showing one pixel and its peripheral portion in an active matrix type color
25 liquid crystal display device.

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[0025]

As shown in Figure 1, each pixel is arranged inside an intersection area (an area enclosed by four signal lines) enclosed by a scanning signal line (gate electrode line or horizontal signal line) GL, a counter voltage line (counter electrode wiring) CL, two adjoining video signal lines (drain signal line or vertical signal line) DL. Each pixel includes a thin-film transistor TFT, a storage capacitor Cstg, a pixel electrode PX and a counter electrode CT. Two or more sets of the scanning signal line GL and the counter voltage line CL extending in the lateral direction are arranged in the vertical direction in the figure. A plurality of the video signal lines DL extending in the vertical direction are arranged in the lateral direction. The pixel electrode PX is connected to the thin-film transistor TFT, and the counter electrode CT is formed integrally with the counter voltage line CL.

[0026]

Two pixels adjoining each other vertically along the video signal lines DL, when they are folded along the line A of Figure 1, overlap with each other in their planar configurations. This is to allow the counter voltage line CL to be shared by the two vertically adjoining pixels along the video signal

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lines DL and thereby increase the width of the counter voltage line CL to reduce its resistance, allowing a sufficient counter voltage to be supplied to each counter electrode CT of the laterally aligned pixels
5 from an external circuit.

[0027]

The pixel electrode PX and the counter electrode CT oppose each other to form an electric field between them to control an optical state of the liquid crystal
10 LC and therefore image display. The pixel electrode PX and the counter electrode CT are formed like comb teeth, each forming a narrow electrode extending vertically to the paper.

[0028]

15 In each pixel, the number of counter electrodes CT (the number of comb teeth) O and the number of pixel electrodes PX (the number of comb teeth) P have the relation of $O=P+1$ (in this embodiment, $O=3$, $P=2$). This relationship is held to arrange the counter
20 electrodes CT and the pixel electrodes PX alternately and to ensure that the counter electrodes CT are close to the video signal lines DL. This arrangement is for shielding the video signal lines DL from electric lines of force by means of the counter electrodes CT
25 to prevent the electric field between the counter

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electrode CT and the pixel electrode PX from being influenced by the electric field from the video signal lines DL. The counter electrode CT has a stable potential because it is supplied at all times by the external circuit through the counter voltage line CL described later. Hence, the potential of the counter electrode CT shows almost no variation even if it is close to the video signal lines DL. This arrangement sets the pixel electrode PX geometrically remote from the video signal lines DL, resulting in a significant reduction in a parasitic capacitance between the pixel electrode PX and the video signal lines DL and suppressing variations of a pixel electrode potential V_s caused by the video signal voltage. It is therefore possible to minimize crosstalks (image quality degradations called vertical smear) that occur in the vertical direction.

[0029]

The widths of the pixel electrode PX and the counter electrode CT are each set at 6 μm . This value is chosen because these widths need to be set larger than the thickness of the liquid crystal layer described later, 5.0 μm , to allow a sufficient electric field to be applied to the whole liquid crystal layer in the direction of its thickness and

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also need to be set as narrow as possible to increase the aperture ratio. To prevent line disconnection, the width of the video signal lines DL is set to 8 μm , slightly wider than the pixel electrode PX and the counter electrode CT. Here, the width of the video signal lines DL is set less than two times the width of the adjoining counter electrode CT. Alternatively, when the width of the video signal lines DL is already determined from the productivity or yield, the width of the counter electrode CT adjoining the video signal lines DL is set more than one-half the width of the video signal lines DL. This is to cause the electric lines of force generated by the video signal lines DL to be absorbed by the counter electrodes CT on both sides. To absorb electric lines of force generated by an electrode of a certain width requires another electrode of an equal or greater width. Because the electric lines of force generated by a part of one-half the width of the video signal line DL (4 μm each) need to be absorbed by the counter electrode CT on one side, the width of the counter electrodes CT adjoining the video signal lines DL is set more than one-half the width of the video signal lines DL. This prevents crosstalks, particularly vertical ones, caused by the effects of the signal electrode.

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[0030]

The width of the scanning signal line GL is determined so as to satisfy the resistance value at which a sufficient scanning voltage is allied to a
5 gate electrode GT of a pixel on the terminal side (on the opposite side of a scan signal terminal GTM described later). The width of the counter voltage line CL is also set to meet the resistance value at which a sufficient counter voltage is applied to the
10 counter electrode CT of a pixel on the terminal side (on the opposite side of a common bus line CB described later).

[0031]

The distance between the pixel electrode PX and
15 the counter electrode CT is changed according to the liquid crystal material for the reason described below. Since the electric field strength that realizes the maximum transmittance differs among liquid crystal materials, the electrode-to-electrode
20 distance is set according to the liquid crystal material so that the maximum transmittance can be obtained within the range of the maximum amplitude of the electrode voltage determined by the withstand voltage of the signal electrode drive circuit (a
25 driver on the electrode side). Using a liquid crystal

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material described later, the electrode interval is 16 μm .

[0032]

While this embodiment arranges all the electrodes
5 on the TFT substrate side, some electrodes,
particularly the counter electrode CT and the counter
voltage line CL, may be placed on the counter
substrate side. This arrangement also falls in the
scope of this invention.

10 [0033]

There is no particular limitation on the
direction of the counter electrode CT. While in this
embodiment the counter electrode CT is arranged in the
same direction as the gate signal line GL, it may be
15 laid in the same direction as the drain signal line DL
or arranged in the form of matrix. All these
arrangements fall in the scope of this invention.

[0034]

<<Cross-Sectional Configuration of the Matrix Portion
20 (Pixel Portion)>>

Figure 2 shows a cross section taken along the
line 3-3 of Figure 1. Figure 3 shows a cross section
of a thin-film transistor TFT taken along the line 4-4
of Figure 1. Figure 4 shows a cross section of a
25 storage capacitor Cstg taken along the line 5-5 of

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Figure 1. As shown in Figure 2 to 4, there are a lower transparent glass substrate SUB1 and an upper transparent glass substrate SUB2 with the liquid crystal layer LC interposed between. On the lower transparent glass substrate SUB1 are formed a thin-film transistor TFT, a storage capacitor Cstg and other electrodes. On the upper transparent glass substrate SUB2 are formed a color filter FIL and a black matrix pattern BM for light shielding.

10 [0035]

On the inner side (liquid crystal LC side) of each of the transparent glass substrates SUB1, SUB2, alignment or orientation films ORI1, ORI2 are formed that control the initial orientation of the liquid crystal. On the outer side of each of the transparent glass substrates SUB1, SUB2 are placed polarizers whose polarizing axes are crossed perpendicularly (crossed-Nicols arrangement).

[0036]

20 <<TFT Substrate>>

First, the configuration of the lower transparent glass substrate SUB1 (TFT substrate) will be described in detail.

[0037]

25 <<Thin-Film Transistor TFT>>

The thin-film transistor TFT operates in such a way that its channel resistance between the source and the drain decreases when a positive bias is applied to the gate electrode GT and, when the bias is set to
5 zero, increases.

[0038]

As shown in Figure 3, the thin-film transistor TFT has an i-type (intrinsic, meaning no conductivity type determining impurities are introduced)
10 semiconductor layer AS comprising a gate electrode GT, a gate insulating film GI and an i-type amorphous silicon (Si), a pair of source electrodes SD1 and a pair of drain electrodes SD2. The source and the drain are determined essentially by the bias polarity
15 between them, and in the circuit of this liquid crystal display device the bias polarity is reversed during operation and thus it should be understood that the source and the drain switch to each other during the operation. In the following description, however,
20 one of them is fixedly as a source and the other a drain for convenience.

[0039]

<<Gate Electrode GT>>

The gate electrode GT is formed continuously with
25 the scanning signal line GL so that a part of the

scanning signal line GL forms the gate electrode GT.
The gate electrode GT is a part extending beyond an
active region of the thin-film transistor TFT and is
formed slightly larger than the i-type semiconductor
5 layer AS so as to completely cover it (when viewed
from below). In addition to the function of a gate
electrode, the gate electrode GT serves to protect the
i-type semiconductor layer AS from external light and
backlight. In this example, the gate electrode GT is
10 formed of a single layer of a conductive film g1. The
conductive film g1 may be an aluminum (Al) film formed
by sputtering. Over the conductive film g1 is formed
an anodic oxide film AOF of aluminum.

[0040]

15 <<Scanning Signal Line GL>>

The scanning signal line GL is formed of the
conductive film g1. The conductive film g1 of this
scanning signal line GL is made by the same
manufacture process as the conductive film g1 of the
20 gate electrode GT and formed integrally with it.
Through the scanning signal line GL a gate voltage Vg
is supplied from an external circuit to the gate
electrode GT. The anodic oxide film AOF of aluminum
is also formed over the scanning signal line GL. The
25 part of the scanning signal line GL that crosses the

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video signal lines DL is formed narrow to reduce the probability of short-circuit with the video signal lines DL and is bifurcated so as to be cut by laser trimming even when a short-circuit occurs.

5 [0041]

<<Counter Electrode CT>>

The counter electrode CT is formed of a conductive film g1 that is in the same layer as the gate electrode GT and the scanning signal line GL.

10 The aluminum anodic oxide film AOF is formed over the counter electrode CT, too. The counter electrode CT is applied with a counter voltage Vcom. In this embodiment, the counter voltage Vcom is set at a potential which is, by the field-through voltage ΔV_s

15 lower than an intermediate DC potential between a minimum level drive voltage Vdmin and a maximum level drive voltage Vdmax applied to the video signal lines DL, the field-through voltage ΔV_s being generated when the thin-film transistor TFT is turned off. When

20 it is necessary to reduce the power supply voltage of the integrated circuit used in the signal electrode drive circuit by half, an AC voltage needs to be applied.

[0042]

25 <<Counter Voltage Line CL>>

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The counter voltage line CL is formed of a conductive film g1. The conductive film g1 of the counter voltage line CL is deposited in the same manufacturing process for the conductive film g1 of the gate electrode GT, the scanning signal line GL and the counter electrode CT, and is formed integrally with the counter electrode CT. Through this counter voltage line CL the counter voltage Vcom is supplied from the external circuit to the counter electrode CT.

The aluminum anodic oxide film AOF is also formed over the counter voltage line CL. The part of the counter voltage line CL that crosses the video signal lines DL is, like the scanning signal line GL, formed narrow to reduce the probability of short-circuit with the video signal lines DL and is bifurcated so as to be cut by laser trimming even when a short-circuit occurs.

[0043]

<<Insulating Film GI>>

In the thin-film transistor TFT, the insulating film GI is used as a gate insulating film to apply an electric field to the semiconductor layer AS as well as the gate electrode GT. The insulating film GI is formed over the gate electrode GT and the scanning signal line GL. The insulating film GI may be a silicon nitride film deposited to a thickness of 1200-

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2700 angstrom (A) (in this embodiment, about 2400 A) by, for instance, a plasma chemical vapor deposition. The gate insulating film GI is formed so as to enclose the whole matrix area AR, with its peripheral portion removed to expose external connection terminals DTM, GTM. The insulating film GI serves also as electric insulation between the scanning signal line GL or counter voltage line CL and the video signal lines DL.

[0044]

10 <<i-type Semiconductor Layer AS>>

The i-type semiconductor layer AS is made of amorphous silicon and deposited to a thickness of 200-2200 A (in this embodiment, about 2000 A). A layer d0 is an N(+) amorphous silicon semiconductor layer doped with phosphorus (P) for ohmic contact, and is left only where there is an i-type semiconductor layer AS below and a conductive layer d1 (d2) above.

[0045]

The i-type semiconductor layer AS is also provided between the scanning signal line GL or counter voltage line CL and the video signal lines DL at their intersections (crossover portions). The i-type semiconductor layer AS at the crossover portions reduces the possibility of short-circuit between the scanning signal line GL or counter voltage line CL and

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the video signal lines DL.

[0046]

<<Source Electrode SD1, Drain Electrode SD2>>

The source electrode SD1 and the drain electrode
5 SD2 are each formed of a conductive film d1 in contact
with the N(+) semiconductor layer d0 and a conductive
film d2 formed over the first conductive film d1.

[0047]

The conductive film d1 is made of chromium (Cr)
10 by sputtering to a thickness of 500-1000 Å (in this
embodiment, about 600 Å). The Cr film has an
increased stress when formed to a greater thickness
and therefore its thickness is limited to about 2000 Å
at most. The Cr film is used (as a so-called barrier
15 layer) to ensure a satisfactory adhesion with the N(+) semiconductor layer d0 and to prevent aluminum of the
conductive film d2 from diffusing into the N(+) semiconductor layer d0. In addition to a Cr film, the
conductive film d1 may be a high melting point metal
20 (Mo, Ti, Ta, W) film or a high melting point silicide
(MoSi₂, TiSi₂, TaSi₂, WSi₂) film.

[0048]

The conductive film d2 is formed by sputtering
aluminum to a thickness of 3000-5000 Å (in this
25 embodiment, about 4000 Å). The aluminum film has

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smaller stresses than the Cr film and can be formed to a greater thickness, thus reducing the resistances of the source electrodes SD1, drain electrodes SD2 and video signal lines DL. Improving the step coverage, and ensuring the extension over the steps formed due to the formation of the gate electrode GT and i-type semiconductor layer AS.

[0049]

The conductive film d1 and conductive film d2 are patterned with the same mask pattern and then, by using the same mask or by using the conductive film d1 and conductive film d2 as masks, the N(+) semiconductor layer d0 is removed. That is, the N(+) semiconductor layer d0 remaining on the i-type semiconductor layer AS is removed in a self-alignment manner in the portions other than the conductive film d1 and conductive film d2. At this time, because the N(+) semiconductor layer d0 is etched away to its full thickness, the i-type semiconductor layer AS is also etched slightly at the surface. The degree of the etching can be controlled by the etching time.

[0050]

<<Video Signal Lines DL>>

The video signal lines DL are formed of a source electrode SD1, a second conductive film in the same

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layer as the source electrode SD1, and a third
conductive film d3. The video signal lines DL are
formed integrally with the drain electrode SD2.

[0051]

5 <<Pixel Electrode PX>>

The pixel electrode PX is formed of a source
electrode SD1, a second conductive film in the same
layer as the source electrode SD1, and a third
conductive film d3. The pixel electrode PX are formed
10 integrally with the source electrode SD1.

[0052]

<<Storage Capacitor Cstg>>

At its end opposite to the end connected to the
thin-film transistor TFT, the pixel electrode PX is so
15 formed as to overlap with the counter voltage line CL.
This overlapping, as can be seen from Figure 4, forms
a storage capacitor (a capacitive device) Cstg having
the pixel electrode PX as one electrode PL2 and the
counter voltage line CL as another electrode PL1. The
20 dielectric film of the storage capacitor Cstg is
formed of the insulating film GI used as a gate
insulating film of the thin-film transistor TFT and
the anodic oxide film AOF.

[0053]

25 As shown in the plan view of Figure 1, the

storage capacitor Cstg is formed in a region where the width of the conductive film g1 of the counter voltage line CL is enlarged.

[0054]

5 <<Passivation Layer PSV1>>

Over the thin-film transistor TFT is formed a passivation layer PSV1, which has a primary function of protecting the thin-film transistor TFT against moisture and is made of a highly transparent and
10 moisture-resistant material. The passivation layer PSV1 may be formed of a silicon oxide layer or silicon nitride layer deposited by a plasma CVD device to a thickness of about 1 μ m.

[0055]

15 The passivation layer PSV1 is formed to enclose the entire matrix area AR with its peripheral portion removed to expose the external connection terminals DTM, GTM. As to the thickness of the passivation layer PSV1 and the gate insulating film GI, the former
20 is made thick for the protection effect and the latter is made thin considering the mutual conductance gm of a transistor. Hence, the passivation layer PSV1 with a high protecting capability is formed larger than the gate insulating film GI to protect as wide an area as
25 possible at the peripheral portion as well.

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[0056]

<<Color Filter Substrate>>

Next, referring back to Figure 1 and 2, the configuration of the upper transparent glass substrate
5 SUB2 (color filter substrate) will be described in detail.

<<Light Shielding Film BM>>

On the upper transparent glass substrate SUB2 is formed a light shielding film BM (generally called a
10 black matrix) that prevents transmitted light passing through unwanted gaps (other than the gaps between the pixel electrode PX and the counter electrode CT) from going toward the display surface and degrading the contrast. The light shielding film BM also serves to
15 prevent external light or backlight from entering the i-type semiconductor layer AS. That is, the i-type semiconductor layer AS of the thin-film transistor TFT is sandwiched by the upper and lower light shielding films BM and the slightly large gate electrode GT, and
20 thus protected against external natural light and backlight.

[0057]

A closed polygonal contour line of the light shielding film BM shown in Figure 1 represents an
25 aperture inside of which the light shielding film BM

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is not formed. This contour line pattern is just one example. The boundary line in the vertical direction of the figure is determined according to the precision of alignment between the upper and lower substrates.

5 When the alignment precision is better than the width of the counter electrode CT adjoining the video signal lines DL, setting the contour line within the width of the counter electrode allows the aperture to be enlarged.

10 [0058]

The light shielding film BM is made of a film that has a light shielding capability and a high insulating capability not to influence the electric field between the pixel electrode PX and the counter
15 electrode CT. In this embodiment the light shielding film BM is made of a resist material mixed with black pigment and formed to a thickness of about 1.2 μm .

[0059]

The light shielding film BM is formed as a grid
20 around each pixel to define an effective display area of each pixel. Thus, the contour of each pixel is made clear by the light shielding film BM. That is, the light shielding film BM has two functions, one as a black matrix and one as a light shielding means for
25 the i-type semiconductor layer AS.

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[0060]

The light shielding film BM is also formed at the peripheral portion like a frame and its pattern is continuous with the pattern of the matrix area of Figure 1 having a plurality of dotlike openings. The light shielding film BM at the peripheral portion extends to the outside of the seal portion SL to prevent light such as reflected light produced in the apparatus equipped with the liquid display device, such as a personal computer from entering the matrix area. The light shielding film BM is kept about 0.3-1.0 mm inside from the edge of the substrate SUB2, avoiding the cut area of the substrate SUB2.

[0061]

15 <<Color Filter FIL>>

The color filter FIL comprises alternated red, green and blue stripe filters formed at portions facing the pixels. The color filter FIL overlaps the edge portion of the light shielding film BM.

20 [0062]

The color filter FIL can be formed as follows. First, on the surface of the upper transparent glass substrate SUB2 a dyeing base made of such a material as acrylic resin is formed and then removed in areas other than the red filter forming area by

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photolithography. Then, the dyeing base is colored with a red dye and fixed to form a red filter R. This is followed by the similar process to form a green filter G and a blue filter B.

5 [0063]

<<Overcoating Film OC>>

The overcoating film OC is provided to prevent leakage of the dye of the color filter FIL into the liquid crystal LC and to planarize stepped portions
10 formed by the color filter FIL and the light shielding film BM. The overcoating film OC may be made of a transparent resin material such as acrylic resin or epoxy resin.

[0064]

15 <<Liquid Crystal Layer and Polarizer>>

Next, the liquid crystal layer, orientation film and polarizer, the features of this invention, will be described.

[0065]

20 <<Liquid Crystal Layer>>

The liquid crystal material is a nematic liquid crystal with a positive dielectric anisotropy $\Delta\epsilon$ of 10.2 and a refractive index anisotropy Δn of 0.084 (589 nm at 20°C). The liquid crystal layer has a
25 thickness of 5.0 μm and a retardation $\Delta n \cdot d$ of 0.42

μm. With this retardation $\Delta n \cdot d$, it is possible to obtain the maximum contrast for the initial orientation angle and polarizer arrangement described later. That is, in Embodiment 1, the retardation $\Delta n \cdot d$ is so determined as to produce a display of 0-th order birefringence (first minimum) mode.

[0066]

The thickness of the liquid crystal layer is controlled by polymer beads.

10 [0067]

To realize the initial orientation state in which the liquid crystal is twisted by about 90 degrees, in this embodiment, about 0.1% of chiral material twisted a clockwise is added to the liquid crystal from the upper substrate SUB2 to the lower substrate SUB1.

[0068]

The liquid crystal material LC is not particularly limited. It is noted, however, that the larger the dielectric anisotropy $\Delta\epsilon$ and the smaller the elastic constant K_2 associated with twisting, the lower the drive voltage can be.

[0069]

When the liquid crystal layer is thick, the time taken to inject the liquid crystal can be reduced and variation in the gap between the substrates also can

be reduced. To improve the response speed, the thickness is 8 μm or less; desirably, to obtain the response speed of around 30 ms the liquid crystal layer thickness should preferably be 5 μm or less.

5 [0070]

<<Orientation Film>>

The orientation film is made of polyimide. The orientation film ORI1 on the lower substrate side is rubbed in a rubbing direction RDR1 and the orientation
10 film ORI2 on the upper substrate side is rubbed in a rubbing direction RDR2.

[0071]

The initial orientation angle is defined to be positive for a counterclockwise rotation with respect
15 to the in-plane direction of the lateral electric field and to range from -90 degrees to 90 degrees. That is, either in the rubbing direction RDR or in the opposite direction, the initial orientation direction is in the range from -90 degrees to 90 degrees with
20 respect to the in-plane direction of the lateral electric field.

[0072]

In this embodiment, the initial orientation angle β_1 between the rubbing direction RDR1 and the applied
25 electric field direction EDR on the orientation film

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ORI1 side is set at -45 degrees. The initial orientation angle $\beta 2$ between the rubbing direction RDR2 and the applied electric field direction EDR on the orientation film ORI2 side is set at 45 degrees.

5 The initial orientation angles of the upper and lower are twisted $\theta=90$ degrees. Figure 16 shows this state.

[0073]

In this embodiment, it is important to set $\beta 1$ and $\beta 2$ so that they may fall in the range from -90 degrees to -35 degrees and in the range from 35 degrees to 90
10 degrees, or preferably set at -45 degrees and 45 degrees respectively.

[0074]

It is possible to switch the signs of $\beta 1$ and $\beta 2$.
15 In that case, the twist direction is reversed.

[0075]

In the rubbing directions RDR1, RDR2 shown in Figure 16, the orientation of the tilt angle of liquid crystal molecules in the liquid crystal layer at the
20 upper and lower substrate interface is in the "splay" state that the liquid crystal molecules produce an effect of compensating for optical characteristics to provide a wide viewing angle characteristic.

[0076]

25 The response speed of this invention can also be

increased by setting the initial orientation angles β_1 , β_2 so that the tilt angle of the liquid crystal molecules in the liquid crystal layer is in the "parallel" state. In that case, the rubbing direction RDR1 is, for example, -45 degrees (β_1 is -45 degrees) with respect to the in-plane direction of the lateral electric field and the rubbing direction RDR2 is -135 degrees (β_2 is 45 degrees) with respect to the in-plane direction of the lateral electric field. In other words, it is also possible to set the rubbing direction RDR2 in the opposite direction.

[0077]

<<Polarizer>>

A polarizer of Nitto Denko make, G1220DU, is used, and the polarizing axis MAX1 of the polarizer POL1 on the lower substrate side is aligned with the direction of electric field EDR. To describe in more detail, the angle ϕ_1 between the polarizing axis MAX1 of the polarizer POL1 and the applied electric field direction EDR is set to 0 degree. The polarizing axis MAX2 of the upper polarizer POL2 is set perpendicular to the polarizing axis MAX1 of the lower polarizer POL1. That is, the angle ϕ_2 between the polarizing axis MAX2 of the upper polarizer POL2 and the applied electric field direction EDR is set to 90 degrees.

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[0078]

Therefore, the angle between the polarizing axis MAX1 and the polarizing axis MAX2, $\phi = |\phi_2 - \phi_1|$, is set to 90 degrees. Figure 16 shows this relationship.

5 With this arrangement, as the applied voltage between the pixel electrode PX and the counter electrode CT is increased, the optical axes of the liquid crystal molecules are reorientated toward the polarizing axis MAX1, gradually reducing birefringence until the

10 transmittance progressively decreases down to black. In this way a normally open characteristic is produced.

[0079]

Further, the polarizing axis MAX2 of the upper

15 polarizer POL2 and the polarizing axis MAX1 of the lower polarizer POL1 can be exchanged to produce the identical characteristic. That is, the following setting may be made, $\phi_1 = 90$ degrees and $\phi_2 = 0$ degrees.

20 [0080]

<<Configuration of Periphery of Matrix>>

Figure 5 is a plan view showing an essential peripheral portion around the matrix (AR) of the display panel PNL including the upper and lower glass

25 substrates SUB1, SUB2. Figure 6 shows on the left a

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cross section of an external connection terminal GTM region to which the scanning circuit is to be connected, and on the right a cross section of a seal portion with no external connection terminals.

5 [0081]

In the manufacture of this panel, if the panel size is small, a plurality of devices are fabricated simultaneously from a single glass substrate and then divided into individual panels for improved
10 throughput. If the panel size is large, a standard size glass substrate is commonly used to fabricate any type kind of device in order to share the manufacturing facility and then cut to an appropriate size for each kind of device. In either case, after
15 being subjected to a predetermined sequence of processes, the glass substrate is cut. Figure 5 and 6 represent the latter case. Both of these figures show the state of the upper and lower substrates SUB1, SUB2 after being cut., LN denoting the edge of the
20 substrates before cutting. In either case, where there are external connection terminal groups Tg, Td and terminals COT (subscript omitted) (upper and left sides in the figure), the size of the upper substrate SUB2 in a finished state is limited to the inside of
25 the lower substrate SUB1 to expose these terminals.

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The terminal groups Tg, Td including the scanning circuit connection terminals GTM, the signal electrode circuit connection terminals DTM, and their lead out wiring portion are named in groups of terminals grouped for each tape carrier package TCP (Figure 13, 14) mounted with an integrated circuit chip CHI. The leadout wiring from the matrix portion of each terminal group to the external connection terminal portion are inclined as they approach the ends. This is to match the terminals DTM, GTM of the display panel PNL to the arrangement pitch of the packages TCP and the connection terminal pitch in each package TCP. The counter electrode terminal COT is a terminal to apply the counter voltage from the external circuit to the counter electrode CT. The counter voltage lines CL of the matrix portion are led out to the opposite side of the scanning circuit terminals GTM (to the right side in the figure) are grouped together with a common bus line CB and connected to the counter electrode terminal COT.

[0082]

Between the transparent glass substrates SUB1, SUB2 a seal pattern SL is formed along their edges except for a liquid crystal injection port INJ so that the liquid crystal LC can be sealed. The sealing

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material may be made of epoxy resin.

[0083]

The orientation films ORI1, ORI2 are formed inside the seal pattern SL. The polarizers POL1, POL2
5 are formed on the outer surfaces of the lower transparent glass substrate SUB1 and the upper transparent glass substrate SUB2, respectively. The liquid crystal LC is sealed in a space enclosed by the lower orientation film ORI1 and upper orientation film
10 ORI2, both setting the orientation of the liquid crystal molecules, and by the seal pattern SL. The lower orientation film ORI1 is formed over the passivation layer PSV1 on the lower transparent glass substrate SUB1 side.

15 [0084]

This liquid crystal display device is assembled by stacking a variety of layers on the lower transparent glass substrate SUB1 and on the upper transparent glass substrate SUB2, separately; forming
20 the seal pattern SL on the upper transparent glass substrate SUB2 side; stacking the lower transparent glass substrate SUB1 and the upper transparent glass substrate SUB2; injecting the liquid crystal LC from the injection port INJ of the seal material SL;
25 sealing the injection port INJ with epoxy resin or the

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like; and cutting the upper and lower substrates.

[0085]

<<Gate Terminal Portion>>

Figure 7 shows the connection structure the
5 scanning signal line GL of the display matrix to its
external connection terminal GTM. Figure 7(A) is a
plan view and Figure 7(B) is a cross section taken
along the line B-B of (A). The figure corresponds to
the lower part of the connection structure and the
10 inclined wiring is shown by straight lines for
convenience.

[0086]

AO denotes a boundary line of a photoresist
direct drawing, i.e., a photoresist pattern for
15 selective anodic oxidation. This photoresist is
removed after anodic oxidation and thus the pattern AO
shown in Figure 7 does not remain in the completed
product. But because the oxide film AOF is
selectively formed over the gate line GL as shown in
20 the cross section, its trace remains. In the plan
view, the left side of the photoresist boundary line
AO is an area that is covered with a resist and not
subjected to anodic oxidation while the right side is
exposed from the resist for anodic oxidation. On the
25 anodically-oxidized aluminum layer gl is formed an

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oxide, Al_2O_3 film AOF, reducing the volume of the underlying conductive portion. The anodic oxidation, of course, is performed under properly controlled conditions including time and voltage so that the
5 underlying conductive portion may remain.

[0087]

In the figure, the aluminum layer g1 is shown by a hatched portion for easy recognition, and the region that is not subjected to anodic oxidation is patterned
10 in the form of comb teeth, for the following reason. When the width of the aluminum layer is wide, whiskers are formed on the surface. Hence, the aluminum layer is divided into a plurality of parallel narrow lines to prevent the formation of whiskers while at the same
15 time minimizing the probability of line breakage and the reduction of conductivity.

[0088]

The gate terminal GTM comprises the aluminum layer g1 and a transparent conductive layer g2 that
20 protects the surface of g1 and improves the reliability of connection with tape carrier packages. The transparent conductive layer g2 is a transparent conductive indium-tin-oxide film (ITO: NESA film) formed by sputtering to a thickness of 100-2000 Å (in
25 this embodiment, about 1400 Å). Conductive layers d1,

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d2 are formed over the aluminum layer g1 and its side. The conductive layer d1 is a Cr layer that has good connectability with both the aluminum layer and the transparent conductive layer g2 to reduce connection resistance and thereby to compensate for detective connection between the aluminum layer and the transparent conductive layer g2. The conductive layer d2 remains there because it is formed by the same mask used for the conductive layer d1.

10 [0089]

In the plan view, the gate insulating film GI is formed on the right side of its boundary line and the passivation layer PSV1 is also formed on the right side of its boundary line. Hence, the terminal portion GTM located at the left end is exposed for electrical contact with external circuits. Although the figure shows only one pair of gate line GL and gate terminal, the actual device has a plurality of such pairs arranged parallelly in a vertical direction to form terminal groups Tg (Figure 5). The left end of the gate terminal is extended beyond the cutting area of the substrate and short-circuited by a wiring Shg (not shown) during the process of manufacture. Such a shorting line SHg is used for supplying electricity during the anodic oxidation and for

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preventing electrostatic breakdown during the rubbing of the orientation film ORI1 in the process of manufacture.

[0090]

5 <<Drain Terminal DTM>>

Figure 8 shows the connection structure from the video signal line DL to its external connection terminal DTM. Figure 8(A) is a plan view and Figure 8(B) is a cross section taken along the line B-B of Figure 8(A). Figure 8 corresponds to the upper right area of Figure 5 although the direction of the figure is changed for convenience. The right-hand end area of Figure 8 corresponds to the upper end portion of the substrate SUB1.

15 [0091]

TSTd designates a testing pad, which is formed wider than its line portion so that a probe or the like can be brought into contact with it, although it is not connected with external circuits. Similarly, the drain terminal DTM, too, is formed wider than its line portion for connection with external circuits. The external connection drain terminals DTM are arranged in the vertical direction, forming the terminal groups Td (subscript omitted) as shown in Figure 5 and extending beyond the cutting line of the

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substrate SUB1. The drain terminals DTM are all short-circuited by the wiring SHd (not shown) to prevent electrostatic breakdown during the manufacturing process. The testing pad TSTd is formed
5 at every other video signal line DL as shown in Figure 8.

[0092]

The drain connection terminal DTM is formed of a single transparent conductive layer g2 and is
10 connected to the video signal lines DL at portions where the gate insulating film GI is removed. The semiconductor layer AS formed over the end of the gate insulating film GI is to etch the edge of the gate insulating film GI in a tapered shape. The
15 passivation layer PSV1 is of course removed from the terminal DTM for connection with the external circuits.

[0093]

The leadout wire from the matrix portion to the
20 drain terminal portion DTM has its layers d1, d2-which are at the same level of the video signal lines DL-extending to an intermediate portion of the passivation layer PSV1 and connected with the transparent conductive layer g2 inside the passivation
25 layer PSV1. This arrangement is intended to protect

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the aluminum layer d2, vulnerable to galvanic corrosion, with the passivation layer PSV1 and the seal pattern SL.

[0094]

5 <<Counter Electrode Terminal CTM>>

Figure 9 shows the connection structure from the counter voltage line CL to its external connection terminal CTM. Figure 9(A) is a plan view and Figure 9(B) is a cross section taken along the line B-B of
10 (A). The figure corresponds to the upper left area of Figure 5.

[0095]

The counter voltage lines CL are grouped with the common bus line CB and led out to the counter
15 electrode terminal CTM. The common bus line CB comprises a conductive layer g1, and other conductive layers d1, d2 stacked on the first layer g1. This arrangement is designed to reduce the resistance of the common bus line CB and thereby supply a sufficient
20 counter voltage from the external circuit to each counter voltage line CL. This structure is characterized by the ability to reduce the resistance of the common bus line without imposing any additional burden on the conductive layer. The conductive layer
25 g1 of the common bus line CB is not subjected to

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anodic conversion, in order that it is electrically connected to the conductive layers d1, d2. It is also exposed from the gate insulating film GI.

[0096]

5 The counter electrode terminal CTM has the transparent conductive layer g2 stacked over the conductive layer g1. The conductive layer g1 is covered with the transparent conductive layer g2, which has good corrosion resistance, to protect the
10 surface of the conductive layer g1 against galvanic corrosion.

[0097]

<<Equivalent Circuit of Whole Display Device>>

 An equivalent circuit of the display matrix
15 portion and its peripheral circuit are shown in Figure 10. The figure, though it is a circuit diagram, is drawn in compliance with actual geometric arrangement. AR represents a matrix array in which a plurality of pixels are arranged in two dimensional array.

20 [0098]

 In the figure, X represents the video signal lines DL, with subscripts G, B and R representing green, blue and red pixels. Y means scanning signal lines GL, with subscripts 1, 2, 3, ..., end indicating
25 the order of scan timing.

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[0099]

The scanning signal lines Y (the subscripts are omitted) are connected to a scanning circuit V and the video signal lines X (the subscripts are omitted) are
5 connected to a video signal driving circuit H.

[0100]

A circuit SUP includes a power supply circuit for producing step-down power supply voltages from one power source and a circuit for converting information
10 for CRT from a host computer (higher order computer) into information for a TFT liquid crystal display.

[0101]

<<Driving Method>>

Figure 11 shows drive signal waveforms for the
15 liquid crystal display device of this invention. The counter voltage is transformed into alternating rectangular waves having binary values, V_{ch} and V_{cl} , and in synchronism with the alternating waves a nonselection voltage for the scanning signals V_g ($i=1$), $V_g(i)$ is changed between two values, V_{hlh} and V_{gll} , in each scanning period. The amplitude of the counter voltage and the amplitude of the nonselection voltage are set equal. The video signal voltage is
20 obtained by subtracting half the counter voltage from
25 the voltage to be applied to the liquid crystal layer.

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[0102]

The counter voltage may be a DC voltage but transforming it into the AC voltage makes it possible to reduce the maximum amplitude of the video signal voltage, allowing the use of a video signal driving circuit (signal side driver) with a lower dielectric strength.

[0103]

<<Function of Storage Capacitor Cstg>>

10 The storage capacitor Cstg is provided for holding the video information written in a pixel for a long period (after the thin-film transistor TFT is turned off). In the system of this invention where an electric field is applied in a direction parallel to
15 the substrate surface, unlike the system where the electric field is applied perpendicularly to the substrate surface, because there is almost no capacitance (generally called a liquid capacitance) produced by the pixel electrode and the counter
20 electrode, the storage capacitor Cstg cannot hold the video information in the pixel. Thus, in the system where the electric field is applied parallel to the substrate surface, the storage capacitor Cstg is an essential constitutional element.

25 [0104]

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The storage capacitor Cstg, when the thin-film transistor TFT is switched, also works to reduce the effect of the gate potential change ΔV_g on the pixel electrode potential V_s . This is expressed by the following equation.

[0105]

$$\Delta V_s = \{C_{gs} / (C_{gs} + C_{stg} + C_{pix})\} \times \Delta V_g$$

Here, C_{gs} is a parasitic capacitance produced between the gate electrode GT and the source electrode SD1 of the thin-film transistor TFT, C_{pix} is a capacitance produced between the pixel electrode PX and the counter electrode CT, and ΔV_s is a voltage generally called a feed-through voltage, a change in the pixel electrode potential caused by ΔV_g . This change ΔV_s is a cause of a DC component applied to the liquid crystal LC and can be reduced by increasing the storage capacitor Cstg. Reduced DC components applied to the liquid crystal LC improve the service life of the liquid crystal LC, mitigating so-called image persistence, a phenomenon in which a previous image remains when the liquid crystal screen is switched to another image.

[0106]

As described above, since the gate electrode GT is so formed large as to cover the entire i-type

semiconductor layer AS, the overlapping area with the source electrode SD1 and the drain electrode SD2 correspondingly increase, which in turn increases the parasitic capacitance Cgs, making the pixel electrode potential Vs more susceptible to the influences of the gate (scanning) signal Vg. The provision of the storage capacitor Cstg, however, can eliminate this demerit.

[0107]

10 The method of driving is not limited to the above and other active matrix driving methods may be employed. These methods all fall in the scope of this invention.

[0108]

15 <<Display Panel PNL and Driving Circuit Substrate PCB1>>

Figure 12 is a plan view showing the display panel PNL of Figure 5 connected with the video signal driving circuit H and the scanning circuit V.

20 [0109]

CHI represents drive IC chips to drive the display panel PNL (five shown at the bottom are drive IC chips on the scanning circuit side; ten shown to the left are drive chips on the video signal driving circuit side). TCP denotes tape carrier packages mounted with

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the drive IC chips CHI by the tape automated bonding (TAB) as described later referring to Figure 13 and 14. A printed circuit board PCB1 is mounted with the TCPs and capacitors and is divided in two, one for the
5 video signal driving circuit and the other for the scan signal driving circuit. FGP denotes a frame ground pad to which are soldered springlike pieces formed by cutting a shield case SHD. A flat cable FC electrically connects the lower-side printed circuit
10 board PCB1 and the left printed circuit board PCB1. The flat cable FC may, as shown, be formed by sandwiching a plurality of lead wires (of phosphor bronze plated with Sn) between a striped polyethylene layer and a polyvinyl alcohol layer.

15 [00110]

<<Connection Structure of TCP>>

Figure 13 shows a cross-sectional structure of the tape carrier package TCP where the IC chips CHI comprising the scan signal driving circuit V and the
20 video signal driving circuit H is mounted on the flexible printed circuit boards. Figure 14 is a cross section showing an essential part of the liquid crystal display panel connected to the scan signal terminal GTM.

25 [0111]

In the figure, TTB denotes an input terminal/wiring portion of the IC circuit CHI. TTM represents an output terminal/wiring portion of the IC circuit CHI. These are made, for instance, of Cu and their inner ends (generally called inner leads) are connected with bonding pads PAD of the IC circuit CHI by the facedown bonding. The outer ends (generally called outer leads) of the terminals TTB, TTM correspond to the input and output, respectively, of the semiconductor IC circuit chip CHI and are connected to the CRT/TFT conversion circuit/power supply circuit SUP by soldering and to the liquid crystal display panel PNL through the anisotropic conductive film ACF. The package TCP is connected to the panel so that the package end covers the edge of the passivation layer PSV1 that exposes the connection terminal GTM on the panel PNL side. Hence, the outer connection terminal GTM (DTM) is covered with at least one of the passivation layer PSV1 and the package TCP, so that its resistance against galvanic corrosion is enhanced.

[0112]

BF1 denotes a base film made, for example, of polyimide. SRS is a solder resist film as a mask to prevent solder from flowing to unwanted areas during

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the soldering process. The gap between the upper and lower glass substrates on the outer side of the seal pattern SL is, after cleaning, protected with epoxy resin EPX or the like. Furthermore, silicone resin
5 SIL is placed between the package TCP and the upper substrate SUB2 for double protection.

[0113]

<<Printed Circuit Board PCB2>>

The printed circuit board PCB2 is mounted with
10 electronic parts such as ICs, capacitors and resistors. The printed circuit board PCB2 is mounted with a circuit SUP that includes a power supply circuit for producing step-down supply voltages from a single power source and a circuit for converting CRT
15 information from a host computer (higher order computer) into TFT liquid crystal display device information. CJ represents a connector portion for a connector (not shown) that is connected with an external circuit.

20 [0114]

The printed circuit board PCB1 and the printed circuit board PCB2 are electrically connected with a flat cable FC.

[0115]

25 <<Overall Configuration of the Liquid Crystal Display

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Module>>

Figure 15 is an exploded perspective view of constitutional parts of a liquid crystal display module MDL.

5 [0016]

SHD represents a framelike shield case (metal frame) made of a metal plate; LCW a window for the liquid crystal display; PNL a liquid crystal display panel; SPB a diffuser; LCB a light conductor; RM a reflector; BL a backlight fluorescent tube; and LCA a backlight case. These are stacked together in a vertical relationship shown in the figure to form a module MDL.

[0117]

15 The module MDL is secured together with claws and hooks provided to the shield case SHD.

[0118]

The backlight case LCA is so shaped as to accommodate the backlight fluorescent tube BL, diffuser SPB, light conductor LCB and reflector RM. The light from the backlight fluorescent tube BL arranged at the side of the light conductor LCB is diffused by the light conductor LCB, reflector RM and diffuser SPB to produce uniform light at the display surface and directed to the liquid crystal display

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panel PNL.

[0119]

The backlight fluorescent tube BL is connected with an inverter circuit board PCB3 which is a power
5 source of the backlight.

[0120]

<<Characteristic of Liquid Crystal Display Device of Embodiment 1>>

Figure 17 and 18 show the principle of driving
10 the liquid crystal of Embodiment 1.

[0121]

The working principle will be explained for a case where the dielectric anisotropy $\Delta\epsilon$ of the liquid crystal is positive.

15 [0122]

When no voltage is applied, the liquid crystal molecules in the liquid crystal layer are in the initial state where they are twisted 90 degrees clockwise from the upper substrate SUB2 to the lower
20 substrate SUB1, as shown in Figure 17(a). When the voltage is applied, the part of the twisted liquid crystal molecules in the direction of thickness of the liquid crystal layer decreases as shown in Figure 17(b), only molecules in the region close to the
25 interfaces with the upper remain twisted and lower

substrates and a major part of the liquid crystal molecules is oriented homogeneously in the voltage application direction.

[0123]

5 When the voltage is not applied in the configuration of the liquid crystal layer and the arrangement of polarizing axis of polarizer of Figure 16, a high transmittance state (white display) can be obtained by the birefringence effect of the liquid
10 crystal. Further, during voltage application because the homogeneously oriented liquid crystal molecules are aligned with the polarizing axis of one polarizer, the birefringence does not occur at that portion, causing the virtual retardation of the liquid crystal
15 layer to come close to zero, and producing no birefringence effect.

[0124]

When the voltage is applied, however, the liquid crystal layers near the interfaces actually remain
20 twisted, so that retardation does not become zero. In this embodiment, the thickness of the liquid crystal layer of the twisted molecules can be reduced infinitely, making it possible to assume that almost all molecules can be homogeneously oriented. Because
25 the polarizers are cross-Nicols-arranged

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(perpendicularly to each other), light cannot pass through, producing a black display if there is no birefringence.

[0125]

5 Based on this operating principle, the following display characteristics are obtained.

[0126]

With the configuration of Embodiment 1 the normally open type electro-optical characteristic is
10 obtained that enables white display when no voltage is applied. The transmittance at the time of white display was 4.5%. Further, the contrast ratio of 3 was obtained at the time of black display by applying a drive voltage of 12 V.

15 [0127]

Figure 19 shows an applied voltage-transmittance characteristic of Embodiment 1.

[0128]

In Embodiment 1, increasing the drive voltage
20 causes the transmittance to decrease, thus improving the contrast ratio. Because of the limitation on the withstand voltage of the drive circuit, however, in this embodiment, the maximum drive voltage is 12 V. It should be noted that the present invention also
25 includes cases where higher or lower maximum drive

voltages are used for the driving.

[0129]

The response speed of the liquid crystal display device of Embodiment 1 was 22 ms, of which 8 ms was a
5 rise time and 14 ms a fall time.

[0130]

Figure 20 to 22 show the rise time T_r , the fall time and the response speed.

[0131]

10 The response speed of Embodiment 1 is shorter than 30 ms, enabling display of a dynamic image, and this means that a dynamic image can be displayed in good condition without any trailing. Figure 20 to 22 show, for comparison, the response speed, of the first
15 case (conventional configuration 1) and the second case (conventional configuration 2) described above.

[0132]

The response speed of this invention is about 1/2 to 1/4 that of the conventional configurations,
20 realizing a significant improvement. The conventional configuration 2 had a liquid crystal layer thickness of 4.0 μm when its response speed was measured. Although the conventional configuration 2 has a normally closed (normally black) characteristic that
25 enables white display when applied with a voltage, the

liquid crystal layer thickness was 4.0 μm in order to make the transmittance of the same liquid crystal material for a white display equal to that of the conventional configuration 1 and the Embodiment 1.

5 The conventional configuration 1 and Embodiment 1 were set at 5.0 μm in the liquid crystal layer thickness.

[0133]

What should be particularly noted is that, with the conventional configuration 1 and 2, the response
10 speed varies greatly with the voltage applied to the liquid crystal and that as the liquid crystal applied voltage is reduced, the response speed decreases remarkably. With the configuration of this invention, on the other hand, it is seen that the response speed
15 exhibits almost no dependence on the liquid crystal applied voltage and remains nearly constant.

[0134]

From this characteristic, it is found that this invention produces no trailing image, a drawback that
20 occurs particularly when a dynamic image is displayed in a half-tone mode.

[0135]

The viewing angle characteristic of this invention was more than 140 degrees in the vertical
25 and horizontal directions, which compares favorably

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with those of the conventional configuration 1 and 2.
Further, the color tone variation and the gradation
inversion recognized when viewed at a particular
angle, which are the problems of the conventional
5 configuration 2, were mitigated.

[0136]

The color tone variation is a phenomenon that,
assuming the direction of an in-plane component of the
lateral electric field to be 0 degree, the region
10 along the direction of about 45 degrees and 225
degrees, for example, changes its color from white to
yellow (or blue) and the area along the direction of
about -45 degrees and 135 degrees changes to blue (or
yellow). The gradation inversion is a phenomenon
15 that, when viewed at an oblique angle, white changes to
yellow or blue. These phenomena occur because when
white is displayed, a change in retardation due to
inclination of the viewing angle causes the liquid
crystal layer near the upper substrate and the liquid
20 crystal layer near the lower substrate to compensate
for each other.

[0137]

As can be seen from above, this invention
provides the response speed of less than 30 ms, the
25 minimum requirement for displaying a dynamic image.

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An additional advantage is a further improvement of the viewing angle, compared to the conventional configuration. Because a material with greater refractive index anisotropy Δn than that of the conventional configuration 2 can be used, a wider
5 range of materials becomes available. Further, because the thickness of the liquid crystal layer can be set larger, the gap between the substrates is more easily made uniform, improving the uniform
10 distribution of brightness. The thicker liquid crystal layer contributes to a shorter liquid crystal injection time.

[0138]

The cross-sectional structure of the thin-film transistor TFT and the electrode arrangement shown in
15 Embodiment 1 are just one example and it is possible to use another TFT structure and electrode arrangement (including one in which the counter electrodes are placed on the color filter substrate) in this
20 invention.

[0139]

(Embodiment 2 to Embodiment 5)

Embodiment 2 to Embodiment 5 are examples configuration with normally open display
25 characteristics and optical compensation cells. They

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are similar in configuration to Embodiment 1 except for the following.

[0140]

A cross-sectional structure of Embodiment 2 to
5 Embodiment 5 is shown in Figure 23.

[0141]

The structure includes drive liquid crystal cells having drive electrodes CT, PX and thin-film transistors TFT, and optical compensation liquid
10 crystal cells with no electrodes.

[0142]

Embodiment 2 has a configuration such that only the optical compensation liquid crystal cells added to Embodiment 1.

15 [0143]

Embodiment 3 has a configuration similar to that of Embodiment 2 with an increased refractive index anisotropy Δn of the liquid crystal material of the drive liquid crystal cells.

20 [0144]

Embodiment 4 has a configuration similar to that of Embodiment 2 with the polarizing axis of the polarizer optimized.

[0145]

25 Embodiment 5 has a configuration in which the

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initial twist angle θ of the drive liquid crystal cells is optimized.

[0146]

<<Drive Liquid Crystal Cell>>

5 The initial twist angle θ , initial orientation angles β_1 , β_2 , thickness of the liquid crystal layer, dielectric anisotropy $\Delta\epsilon$ of the liquid crystal material, and refractive index anisotropy Δn , all of Embodiment 2 to Embodiment 5, are shown in Table 1.

10 [0147]

<<Optical compensation Liquid Crystal Cell>>

 The optical compensation liquid crystal cells comprise, as shown in Figure 23, a lower substrate SUB3, an upper substrate SUB4, a liquid crystal
15 composition CLC held between these substrates, an orientation film ORI3 on the lower substrate SUB3 side, and an orientation film ORI4 on the upper substrate SUB4 side.

[0148]

20 <<Optical compensation Liquid Crystal Layer>>

 Figure 24 shows the rubbing direction of the drive liquid crystal cells, the initial orientation angle and the polarizing axis of polarizer, and the rubbing direction of the optical compensation liquid
25 crystal layer (orientation direction near the

orientation film).

[0149]

The orientation film ORI3 is rubbed in the RDR3 direction, and the orientation film ORI4 is rubbed in the RDR4 direction. β_3 is the initial orientation angle between the rubbing direction RDR3 and the applied electric field direction EDR of the drive liquid crystal cell, and β_4 is the initial orientation angle between the rubbing direction RDR4 and the applied electric field direction EDR of the drive liquid crystal cell.

[0150]

Let the product of Δn of the liquid crystal layer of the optical compensation liquid crystal cell and the thickness d of the liquid crystal layer be referred to as retardation $(\Delta n \cdot d)'$. The twist angle θ_2 is a twist angle of the optical compensation liquid crystal layer.

[0151]

The retardation $(\Delta n \cdot d)'$ of the optical compensation liquid crystal layer, the twist angle θ_2 , and the initial orientation angles β_3 , β_4 are shown in Table 1.

[0152]

Here, the relationship among β_1 , β_2 , β_3 and β_4

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is $|\beta_3 - B_4| \approx |\beta_1 - B_2|$, and β_3 crosses β_2 nearly perpendicularly.

[0153]

For the optical compensation liquid crystal cells
5 of this invention films holding cholesteric liquid crystal therebetween which have an optical characteristic identical to that of the optical compensation cells of Embodiment 2 to 5 may be used.

[0154]

10 <<Polarizer>>

The arrangement of the polarizing axis of the polarizer used in Embodiment 2 to 5 is shown in Table 1.

[0155]

15 The direction of the polarizing axis of the polarizer POL1 on the backlight input side is denoted by PDR and the direction of the polarizing axis of the polarizer POL2 on the output side is denoted by ADR.

[0156]

20 <<Characteristics of Embodiment 2 to Embodiment 5>>

The principle of driving the liquid crystal in Embodiment 2 to 5 is shown in Figure 25.

[0157]

To achieve a higher contrast ratio with a lower
25 voltage than in Embodiment 1, the liquid crystal

molecules are oriented in a state shown in Figure 25(b) by applying a voltage to enable black display. That is, the liquid crystal cells of Embodiment 2 to 5 have their liquid crystal molecules near the interface strongly twisted and the liquid crystal molecules in the central portion weakly twisted. The phrase "weakly twisted" means a state that the ratio, twist angle/layer thickness, is small and the phrase "strongly twisted" means a state that the ratio twist angle/layer thickness, is large. Thus, by arranging the optical compensation liquid crystal layer and polarizers in such a way as to compensate for this orientation, it is possible to realize a high contrast ratio with a low voltage.

15 [0158]

The following characteristics of the liquid crystal display device with this configuration are obtained.

[0159]

20 In Embodiment 2 to 5, the response speed characteristic obtained is equivalent to that of Embodiment 1.

[0160]

The relation between the drive voltage V_{lc} and the transmittance T is shown in Figure 26.

[0161]

It is seen that the contrast ratio, the drive voltage and the maximum transmittance are improved progressively roughly in order of the embodiment numbers. In Embodiment 5 in particular, the contrast ratio of 100 or higher and the maximum transmittance (absolute transmittance of the panel during a white display) of 4.1% are obtained for the drive voltage of 7 V.

10 [0162]

Figure 27 shows the relation between the retardation of drive cell, the contrast ratio, and the maximum transmittance.

[0163]

15 Figure 27 shows that the optimum retardation needs to be 750 nm or higher to produce a sufficient transmittance, preferably 1250 nm or higher that produces a sufficient contrast ratio.

[0164]

20 Figure 28 shows the relation between the contrast ratios of the liquid crystal display device of Embodiment 2 to 5 and the polarizer arrangement $\phi = |\phi_1 - \phi_2|$.

[0165]

25 It is seen from Figure 28 that, to produce a

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sufficient contrast ratio, the optimal relation $\phi = |\phi_1 - \phi_2|$ of the polarizing axis of the polarizer needs to be 90 degrees to 120 degrees, preferably 95 degrees to 115 degrees. Figure 29 shows the relation between the
5 initial twist angle of the drive liquid crystal cells, the contrast ratio and the maximum transmittance. Here the twist angle of the optical compensation cell is set to $\theta_2 = \theta$.

[0166]

10 It is found from Figure 29 that the initial twist angle is preferably set in a range between 90 degrees and 115 degrees to realize a sufficient contrast ratio and the maximum transmittance at the same time. The retardation $(\Delta n \cdot d)'$ of the optical compensation
15 liquid crystal layer is preferably set in a range between $0.4 \cdot (\Delta n \cdot d)$ and $0.6 \cdot (\Delta n \cdot d)$, and setting the retardation at around $(\Delta n \cdot d)' = 0.52 \cdot (\Delta n \cdot d)$ in particular assures optimization.

[0167]

20 (Embodiment 6 to Embodiment 8)

The configurations of Embodiment 6 to 8 are examples of normally closed configuration with the optical compensation cells and similar to those of Embodiment 2 to 5, except for the following.

25 [0168]

The cross-sectional structures of Embodiment 6 to 8 are similar to those of Embodiment 2 to 5 and shown in Figure 23.

[0169]

- 5 Embodiment 6 to 8 have drive liquid crystal cells with drive electrodes CT, PX and thin-film transistors TFT, and optical compensation liquid crystal cells without electrodes.

[0170]

- 10 Embodiment 6, unlike Embodiment 2, matches the retardation $(\Delta n \cdot d)'$ of the optical compensation liquid crystal cell with the retardation $(\Delta n \cdot d)$ of the drive cell.

[0171]

- 15 Embodiment 7 has a configuration in which the refractive index anisotropy Δn of the liquid crystal material of the drive liquid crystal cell is set large and the retardation $(\Delta n \cdot d)'$ of the optical compensation liquid crystal cell is matched with the
20 retardation $(\Delta n \cdot d)$ of the drive cell.

[0172]

Embodiment 8 has a configuration in which the initial twist angle θ of Embodiment 7 is changed.

[0173]

- 25 <<Drive Liquid Crystal Cell>>

The initial twist angle θ , initial orientation angles β_1 , β_2 , thickness of the liquid crystal layer, and $\Delta\epsilon$ and Δn of the liquid crystal material, all used in Embodiment 6 to 8, are shown in Table 2.

5 [0174]

<<Optical compensation Liquid Crystal Cell>>

The retardation $(\Delta n \cdot d)'$, twist angle θ_2 , and the initial orientation angles β_3 , β_4 of the optical compensation liquid crystal layer used in Embodiment 6
10 to 8 are shown in Table 2. Definitions of these parameters are the same as those of Embodiment 2 to 5.

[0175]

The relation among β_1 , β_2 , β_3 and β_4 is $|\beta_3 - \beta_4| \approx |\beta_1 - \beta_2|$, with β_3 crossing β_2 virtually at right
15 angles.

[0176]

The optical compensation liquid crystal cells may use films holding cholesteric liquid crystal therebetween which have an optical characteristic
20 identical to that of the optical compensation cells of the previous embodiments.

[0177]

<<Polarizer>>

The arrangement of the polarizing axis of the
25 polarizer used in Embodiment 6 to 8 is shown in Table

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2.

[0178]

<<Characteristics of Embodiment 6 to Embodiment 8>>

The principle of liquid crystal driving is
5 similar to that of Embodiment 2 to 5 and is shown in
Figure 25. Unlike Embodiment 2 to 5, Embodiment 6 to
8 also have the retardation $(\Delta n \cdot d)'$ of the optical
compensation liquid crystal cell matched with the
retardation $(\Delta n \cdot d)$ of the drive liquid crystal cell.
10 Hence, a normally closed characteristic that the
transmittance increases with the voltage applied to
the liquid crystal is obtained.

[0179]

Figure 30 shows the relation between the drive
15 voltage V_{lc} and the transmittance T Embodiment 6 to 8.

[0180]

Embodiment 6 to 8 enables a black display (low
transmission state) when no voltage is applied. When
no voltage is applied, the liquid crystal molecules
20 are oriented in an ideally twisted state making the
optical compensation by the optical compensation cell
easy. Hence, an ideal black level, i.e., the
transmittance infinitely close to zero, can be
achieved. It is therefore possible to widen the
25 margin for variations in the manufacturing process,

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particularly the variations of the gap between substrates, allowing the stable manufacture of high-contrast products.

[0181]

5 Embodiment 7 enabled a contrast ratio of 100 or higher and a maximum transmittance (absolute transmittance of the panel during white display) of 4.5% for a drive voltage of 7 V. The response speed characteristics in Embodiment 6 and 7 are comparable
10 to those of Embodiment 1.

[0182]

As to the relation among the retardation, contrast ratio and maximum transmittance of the drive cells, comparison between Embodiment 6 and Embodiment
15 7 shows that the maximum transmittance is improved in Embodiment 7 over Embodiment 6. Therefore, it is desired that the optimum retardation be set higher than 750 nm as in Embodiment 2 to 5.

[0183]

20 The polarizer arrangement $\phi = |\phi_1 - \phi_2|$ is preferably set close to 90 degrees.

[0184]

Further, as in Embodiment 8, by increasing the initial twist angle to more than 90 degrees it is
25 possible to change a liquid crystal applied voltage at

which the transmittance starts to increase, i.e., a threshold voltage. Hence, the voltage amplitude contributing to the display and ranging from the threshold voltage to a voltage for the maximum transmittance can be reduced. This in turn reduces the signal output range of the video signal driving circuit. In other words, the video signal driving circuit, particularly the signal driver, can be reduced in circuit size. In Embodiment 8, the response speed is slightly slower, that is, the rise time is 12 ms, the fall time is 20 ms and the response time of 32 ms. The initial twist angle therefore contributes to changing the drive voltage that brings about the maximum transmittance, and it is preferably set in a range from 70 degrees to 160 degrees.

[0185]

(Embodiment 9 to Embodiment 13)

Embodiment 9 to 13 have a normally open configuration with a uniaxial phase film and is similar to the configuration of Embodiment 1, except for the following.

[0186]

A cross-sectional structure of Embodiment 9 to 13 is shown in Figure 31. In these embodiments, uniaxial phase films FILM1 and FILM2 are arranged on the outer

sides of the substrates SUB1, SUB2 so as to hold them therebetween.

[0187]

Embodiment 9 has the configuration such that the
5 uniaxial phase film FILM1 and FILM2 is added to Embodiment 1.

[0188]

Embodiment 10 has the configuration such that the lagging axis of the phase film of Embodiment 9 is
10 changed.

[0189]

Embodiment 11 has the configuration such that the retardation of the phase films of Embodiment 10 is differentiated between the upper and lower films.

15 [0190]

Embodiment 12 has the configuration such that the refractive index anisotropy Δn of the liquid crystal material of Embodiment 11 is increased.

[0191]

20 Embodiment 13 has a structure where the initial twist angle of Embodiment 12 is changed.

[0192]

<<Uniaxial Phase film>>

The lagging axes γ_1 , γ_2 of the uniaxial phase
25 films and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$ used in

Embodiment 9 to 13 are shown in Table 3. γ_1 represents an angle between the lagging axis LDR1 of the lower phase film FILM1 and the direction of electric field EDR and γ_2 represents an angle between the lagging axis LDR2 of the upper phase film FILM2 and the direction of electric field EDR. Both of these angles are defined as positive for a counterclockwise rotation with respect to the direction of electric field EDR.

10 [0193]

$(\Delta n \cdot d)_1$ represents the retardation of the lower phase film and $(\Delta n \cdot d)_2$ represents the retardation of the upper phase film. Figure 32 shows their angular relation.

15 [0194]

<<Liquid Crystal Layer>>

The retardation $\Delta n \cdot d$ of the optical compensation liquid crystal layer, the initial twist angle θ , and the initial orientation angles β_1 , β_2 used in

20 Embodiment 9 to 13 are shown in Table 3. Figure 32 shows their angular relation.

[0195]

<<Polarizer>>

The polarizing axes of the polarizers used in Embodiment 9 to 13 are shown in Table 3. Figure 32

shows their angular relation.

[0196]

<<Characteristics of Embodiment 9 to Embodiment 13>>

The principle of driving the liquid crystal used
5 in Embodiment 9 to 13 is identical with that of
Embodiment 2 to 5.

[0197]

To realize a higher contrast ratio with a lower
voltage than those of Embodiment 1, Embodiment 9 to 13
10 orientate the liquid crystal in a state shown in
Figure 25(b), enabling black display.

[0198]

At a low voltage, the liquid crystal cells in
Embodiment 9 to 13 assume a transitional state that
15 the liquid crystal molecules near the interface are
strongly twisted while those in the central portion
are weakly twisted. Thus, by arranging the phase
films and the polarizers in such a way as to
compensate for this orientation state, it is possible
20 to achieve a high contrast ratio with a low voltage.

[0199]

Embodiment 9 to 13 have response speed
characteristics comparable to those of Embodiment 1.

[0200]

25 Figure 33 shows the relation between the drive

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voltage V_{lc} and the transmittance T . It is seen that the contrast ratio and the maximum transmittance are improved progressively roughly in order of the embodiment number. In Embodiment 13 in particular,
5 the contrast ratio of 100 or higher and the maximum transmittance (the absolute transmittance of the panel during white display) of 4.4% are obtained for the drive voltage of 7 V.

[0201]

10 As shown in Figure 33, there is no characteristic change between Embodiment 9 and Embodiment 10. This suggests that the lagging axis angles γ_1 , γ_2 of phase plates and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$ of the phase plate do not change their characteristics if γ_1
15 $\cdot (\Delta n \cdot d)_1$ and $\gamma_2 \cdot (\Delta n \cdot d)_2$ are constant even when their values are changed.

[0202]

The relations, explained in conjunction with Embodiment 2 to 5, the relation between the
20 retardation of the drive cells, contrast ratio and maximum transmittance shown in Figure 27, the relation between the polarizing axes of polarizers ϕ , contrast ratio and maximum transmittance shown in Figure 28, and the relation between the initial twist angle of
25 the drive cells, contrast ratio and maximum

transmittance shown in Figure 29, are also obtained in Embodiment 9 to 13. It is noted, however, that the relation $(\Delta n \cdot d)$ between the retardation of the drive cells and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$ of phase shifters is so set that the relation $(\Delta n \cdot d)_1 + (\Delta n \cdot d)_2 = 0.52 \cdot (\Delta n \cdot d)$ is met when $\gamma_1 = -22.5$ degrees and $\gamma_2 = 22.5$ degrees.

[0203]

Thus, the optimum retardation needs to be set higher than 750 nm for a sufficient transmittance, preferably more than 1250 nm to obtain a sufficient contrast ratio.

[0204]

To obtain a sufficient contrast ratio, the relation $\phi = |\phi_1 - \phi_2|$ of optimum polarizing axes of the polarizers needs to be set in a range of between 90 degrees and 120 degrees, preferably between 95 degrees and 115 degrees.

[0205]

Further, the initial twist angle should preferably be set in a range between 90 degrees and 115 degrees to achieve a satisfactory contrast ratio and a white display transmittance at the same time.

[0206]

The retardations of the phase films $(\Delta n \cdot d)_1 +$

($\Delta n \cdot d$)² should preferably be set in the range from
0.4 · ($\Delta n \cdot d$) to 0.6 · ($\Delta n \cdot d$) to exhibit the
characteristics shown in Figure 27 to 29. Setting
them close to ($\Delta n \cdot d$)¹ + ($\Delta n \cdot d$)² = 0.52 · ($\Delta n \cdot d$)
5 results in characteristic optimization.

[0207]

As shown in Embodiment 10 to 12, better
optimization is achieved by setting ($\Delta n \cdot d$)² > ($\Delta n \cdot d$)¹
or setting $|\gamma_2| > |\gamma_1|$ for the lagging axis
10 angles. More specifically, when $|\gamma_1| = |\gamma_2|$, it is
desired that the retardation be set close to ($\Delta n \cdot d$)²
= 1.5 · ($\Delta n \cdot d$)¹. Therefore, the preferable setting is
($\Delta n \cdot d$)¹ < ($\Delta n \cdot d$)² < 2 · ($\Delta n \cdot d$)¹ or $|\gamma_1| < |\gamma_2| < 2 \cdot |\gamma_1|$.

15 [0208]

A cross-sectional structure, in which two phase
films FILM1, FILM2 are arranged on the upper side
only, is shown in Figure 35. Other arrangements can
also bring about characteristics similar to those of
20 these embodiments and they are within the scope of
this invention.

[0209]

(Embodiment 14 to Embodiment 16)

Embodiment 14 to 16 have a normally closed
25 configuration with uniaxial phase films which is

similar to that of Embodiment 9 to 13, except for the following.

[0210]

The cross-sectional configuration of Embodiment
5 14 to 16 is shown in Figure 31 and is similar to that
of Embodiment 9 to 13.

[0211]

As in Embodiment 9 to 13, the uniaxial phase
films FILM1, FILM2 are arranged on the outer sides of
10 the substrates SUB1, SUB2 so as to hold them
therebetween.

[0212]

Unlike Embodiment 9, Embodiment 14 has a
configuration that matches the sum of retardations
15 $(\Delta n \cdot d)_1 + (\Delta n \cdot d)_2$ of the uniaxial phase films to
the retardation $(\Delta n \cdot d)$ of the drive cell.

[0213]

Embodiment 15 has a configuration in which, under
the retardation condition of Embodiment 14, the
20 dielectric anisotropy Δn of the liquid crystal
material of the drive liquid crystal cells is
increased.

[0214]

Embodiment 16 is an example where the initial
25 twist angle θ of Embodiment 15 is changed.

[0215]

<<Uniaxial Phase Film>>

The lagging axes γ_1 , γ_2 of the uniaxial phase films and the retardations $(\Delta n \cdot d)_1$, $(\Delta n \cdot d)_2$, both
5 used in Embodiment 14 to 16, are shown in Table 4. γ_1 represents the angle between the lagging axis LDR1 of the lower phase film FILM1 and the direction of electric field EDR, γ_2 represents the angle between the lagging axis LDR2 of the upper phase film FILM2
10 and the direction of electric field EDR, $(\Delta n \cdot d)_1$ is the retardation of the lower phase film, and $(\Delta n \cdot d)_2$ is the retardation of the upper phase film. Figure 32 shows their angular relationship.

[0216]

15 <<Liquid Crystal Layer>>

The retardation $\Delta n \cdot d$, initial twist angle θ and initial orientation angles β_1 , β_2 for the liquid crystal layer of the drive cells used in Embodiment 14 to 16 are shown in Table 4. Figure 32 shows their
20 angular relationship.

[0217]

<<Polarizer>>

The polarizing axes of the polarizers used in Embodiment 14 to 16 are shown in Table 4. Their
25 angular relation is shown in Figure 32.

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[0218]

<<Characteristics of Embodiment 14 to 16>>

The principle of driving the liquid crystal is shown in Figure 25 and is similar to that used in Embodiment 9 to 13. Unlike Embodiment 9 to 13, Embodiment 14 to 16 matches the sum of the retardations $(\Delta n \cdot d)_1 + (\Delta n \cdot d)_2$ of the uniaxial phase films to the retardation $(\Delta n \cdot d)$ of the drive liquid crystal cell so as to realize a normally closed characteristic, in which the transmittance increases with the voltage applied to the liquid crystal.

[0219]

Figure 34 shows the relation between the drive voltage V_{lc} and the transmittance T for Embodiment 14 to 16.

[0220]

Embodiment 14 to 16 enable a black display (low transmittance state) when no voltage is applied.

[0221]

When no voltage is applied, the liquid crystal molecules are oriented in an ideally twisted state making the optical compensation by the uniaxial phase films easy. Hence, an ideal black level, i.e., the transmittance infinitely close to zero, can be achieved. It is therefore possible to widen the

margin for variations in the manufacturing process, particularly the variation of the gap between substrates, allowing the stable manufacture of high-contrast products.

5 [0222]

Embodiment 15 and 16 enable a contrast ratio of 100 or higher and a maximum transmittance (absolute transmittance of the panel during white display) of 4.5% for a drive voltage of 7 V. The response speed
10 characteristics in Embodiment 14 and 15 are comparable to those of Embodiment 1.

[0223]

As to the relation among the retardation, the contrast ratio and the maximum transmittance of the
15 drive cells, comparison between Embodiment 14 and Embodiment 15 shows that the maximum transmittance is improved in Embodiment 15 over Embodiment 14. Therefore, it is desired that the optimum retardation be set higher than 750 nm as in Embodiment 9 to 13.

20 [0224]

The polarizer arrangement $\phi = |\phi_1 - \phi_2|$ is preferably set close to 90 degrees.

[0225]

Further, as in Embodiment 16, by increasing the
25 initial twist angle to more than 90 degrees it is

possible to change a liquid crystal applied voltage at which the transmittance starts to increase, i.e., a threshold voltage. Hence, the voltage amplitude contributing to the display and ranging from the threshold voltage to a voltage for the maximum transmittance can be reduced. This in turn reduces the signal output range of the video signal driving circuit. In other words, the video signal driving circuit, particularly the signal driver used in it, can be reduced in circuit size.

[0226]

The response speed has slightly deteriorated. Embodiment 16 has a rise time of 12 ms, a fall time of 20 ms and a response time of 32 ms. These suggest that the initial twist angle contributes to changing the drive voltage that leads to the maximum transmittance, and it is preferably set in a range between 70 degrees and 160 degrees.

[0227]

A cross-sectional structure, in which two phase films FILM1, FILM2 are arranged on the upper side only, is shown in Figure 35. Other arrangements can also achieve characteristics similar to those of these embodiments and they are within the scope of this invention.

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[0228]

(Embodiment 17 to Embodiment 20)

Embodiment 17 to 20 are examples of a configuration using a liquid crystal material with a negative dielectric anisotropy ($\Delta\epsilon < 0$). This configuration is similar to that of Embodiment 1 except for the following.

[0229]

Embodiment 17 has a configuration where a liquid crystal material with a negative dielectric anisotropy ($\Delta\epsilon < 0$) is used in Embodiment 1.

[0230]

Embodiment 18 has a configuration of Embodiment 17 with the polarizing axes of the polarizers optimized.

[0231]

Embodiment 19 has a configuration of Embodiment 18 with the initial twist angle θ optimized.

[0232]

Embodiment 20 has a configuration of Embodiment 19 with the retardation $\Delta n \cdot d$ and the polarizing axes of the polarizers optimized.

[0233]

<<Drive Liquid Crystal Cell>>

The initial twist angle θ , initial orientation

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angles β_1 , β_2 , thickness of the liquid crystal layer and Δn of the liquid crystal material used in Embodiment 17 to 20 are shown in Table 5.

[0234]

5 <<Polarizer>>

The arrangements of the polarizing axes of the polarizers used in Embodiment 17 to 20 are shown in Table 5.

[0235]

10 <<Characteristics of Embodiment 17 to Embodiment 20>>

The principle of liquid crystal driving is shown in Figure 36.

[0236]

In the liquid crystal with a negative dielectric
15 anisotropy, the major axes of liquid crystal molecules are reoriented in a direction perpendicular to the electric field application direction. Thus, with no voltage applied, the molecules assume a state that they are weakly twisted counterclockwise from the
20 substrate SUB2 to the substrate SUB1, as shown in Figure 36(a). When a voltage is applied, the molecules near the central part of the liquid crystal layer change to a strongly clockwise-twisted state, with the molecules in the upper and lower layers near
25 the interfaces twisted counterclockwise.

[0237]

By optimizing the polarizer positions in the weakly twisted state set up when no voltage is applied, a desirable black level (low transmittance state) can be obtained, and thus the display panel exhibits a normally closed characteristic that the transmittance increases with the liquid crystal application voltage.

[0238]

10 The relation between the drive voltage V_{lc} and the transmittance T in embodiment 17 to 20 is shown in Figure 37.

[0239]

15 In Embodiment 17 to 20, black display (low transmittance state) is enabled when no voltage is applied. When no voltage is applied, the liquid crystal molecules are oriented in an ideally twisted state making the optimization by the polarizer arrangement easy. Hence, an ideal black level, i.e., 20 the transmittance infinitely close to zero, can be realized. It is therefore possible to widen the margin for variations in the manufacturing process, particularly the variation of the gap between substrates, allowing the stable manufacture of high-contrast products.

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[0240]

Embodiment 20 has a contrast ratio of 100 or higher and a maximum transmittance (an absolute transmittance of the panel during white display) of 4.3% for a drive voltage of 8 V. The response speed characteristics of Embodiment 19 and 20 are slightly slower than those of Embodiment 1, that is the rise time is 20 ms, the fall time is 16 ms and the response time is 36 ms.

10 [0241]

As to the relation among the retardation, contrast ratio and maximum transmittance of the drive cells, comparison between Embodiment 14 and Embodiment 15 shows that the maximum transmittance is improved in Embodiment 20 over Embodiment 19. Therefore, it is desired that the optimum retardation be set higher than 750 nm as in Embodiment 2 to 5.

[0242]

The polarizer arrangement $\phi = |\phi_1 - \phi_2|$ is preferably set close to 90 degrees.

[0243]

In Embodiment 17 and 18, the response speed is slightly slower, that is, the rise time is 40 ms, the fall time is 20 ms and the response time is 60 ms. Further, by increasing the initial twist angle, it is

possible to make a significant improvement on the response speed, particularly at the leading edge. That is, the greater the initial twist angle is, the faster the response speed is.

5 [0244]

Comparison of Embodiment 18 and Embodiment 19 shows that as the initial twist angle is increased, the resulting contrast ratio after optimizing the polarizer arrangement deteriorates.

10 [0245]

Thus, there is a trade-off relationship between the response speed and the contrast ratio. To achieve a good balance between these characteristics, the initial twist angle is preferably set in a range
15 between 20 and 50 degrees.

[0246]

As to the arrangement of the polarizers, comparison between Embodiment 17 and Embodiment 18 indicates that the contrast ratio and the maximum
20 transmittance can be improved by optimizing the polarizers from 90 degrees.

[0247]

In Embodiment 17 to 20 it is also possible to enhance the contrast ratio, lower the applied voltage
25 or produce a normally open characteristic by using the

optical compensation liquid crystal layer and the phase films, as in Embodiment 2 to 16. The methods for achieving these objectives are also within the scope of this invention.

5 [0248]
(Embodiment 21)

The configuration of Embodiment 21 is similar to that of Embodiment 1 except for the following.

[0249]

10 <<Orientation Film>>

The initial orientation angle β_1 between the rubbing direction of the lower substrate RDR1 and the direction of electric field EDR is set to -50 degrees and the initial orientation angle β_2 between the
15 rubbing direction of the upper substrate RDR2 and the direction of electric field EDR is set to 40 degrees so that the upper and lower substrates are twisted 90 degrees.

[0250]

20 When the liquid crystal drive electrodes (both pixel electrode PX and counter electrode CT) are formed on the lower substrate, the electric field parallel to the substrate surface (lateral electric field) is strong near the lower substrate and
25 progressively weaker toward the upper substrate.

Hence, the liquid crystal molecules near the lower substrate are more easily rotatable than those close to the upper substrate. The voltage required to reorientate most of the liquid crystal molecules in the liquid crystal layer in the direction of the electric field EDR in Embodiment 21 can be lower than that of Embodiment 1. Embodiment 1 requires a voltage of about 12 V to enable black display while Embodiment 21 needs only about 10 V to realize the same black level as Embodiment 1.

[0251]

While in this embodiment β_1 and β_2 are set at -50 degrees and 40 degrees, respectively, they may be set at 50 degrees and -40 degrees to produce the same effect. The essential configuration of Embodiment 21 is that, when the liquid crystal drive electrodes are arranged only on the lower substrate, the condition $|\beta_1| > |\beta_2|$ needs to be met; and that when the liquid crystal drive electrodes are arranged only on the upper substrate, the condition $|\beta_1| < |\beta_2|$ needs to be satisfied.

[0252]

The configuration of Embodiment 21 is applicable not only to Embodiment 1 but to Embodiment 2 to 20, and these configurations are within the scope of this

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invention.

[0253]

[Advantage of the Invention]

As described above, this invention provides an
5 active matrix type liquid crystal display device that
realizes as wide a viewing angle as a CRT and a
response speed fast enough to display a dynamic image.

[Brief Description of the Drawings]

[Figure 1] An essential part plan view showing one
10 pixel and its peripheral area in the liquid crystal
display portion of the active matrix type color liquid
crystal display device of this invention.

[Figure 2] A cross section of the pixel taken along
the line 3-3 of Figure 1.

15 [Figure 3] A cross section of the thin-film
transistor TFT taken along the line 4-4 of Figure 1.

[Figure 4] A cross section of the storage capacitor
Cstg taken along the line 5-5 of Figure 1.

[Figure 5] A plan view showing the configuration of a
20 peripheral portion around the matrix in the display
panel.

[Figure 6] A cross section showing the scanning
signal terminal on the left side and the panel edge
portion with no external connection terminal on the
25 right side.

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[Figure 7] A plan view and a cross-sectional view showing the connecting portion of the gate terminal GTM and the gate line GL.

[Figure 8] A plan view and a cross-sectional view
5 showing the connecting portion of the drain terminal and the video signal line DL.

[Figure 9] A plan view and a cross-sectional view showing the connecting portion of the common electrode terminal CTM, the common bus line CB and the common
10 voltage line CL.

[Figure 10] A circuit diagram showing the matrix area and its peripheral portion in the active matrix type color liquid crystal display device of this invention.

[Figure 11] A waveform diagram showing drive signals
15 of the active matrix type color liquid crystal display device of this invention.

[Figure 12] A top plan view showing the liquid crystal display panel equipped with the peripheral drive circuits.

20 [Figure 13] A cross-sectional view of the tape carrier package TCP having the flexible printed circuit board mounted with the IC chips CHI forming the drive circuit.

[Figure 14] An essential part cross section showing
25 the tape carrier package TCP connected to the scan

signal terminal GTM of the liquid crystal display panel PNL.

[Figure 15] An exploded perspective view of the liquid crystal display module.

- 5 [Figure 16] A schematic diagram showing the relation between the direction of applied electric field, the rubbing direction, the initial orientation angle, and the polarizing axes of the polarizers.

[Figure 17] A schematic diagram showing the action of
10 the liquid crystal of Embodiment 1 as seen from a direction perpendicular to the substrate surface.

[Figure 18] A schematic diagram showing the action of the liquid crystal of Embodiment 1 as seen from a cross-sectional direction.

- 15 [Figure 19] A graph showing the relation between the liquid crystal applied voltage and the transmittance in Embodiment 1.

[Figure 20] A graph showing the relation between the liquid crystal applied voltage and the rise time in
20 Embodiment 1.

[Figure 21] A graph showing the relation between the liquid crystal applied voltage and the fall time in Embodiment 1.

[Figure 22] A graph showing the relation between the
25 liquid crystal applied voltage and the overall

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response time in Embodiment 1.

[Figure 23] A cross section of the pixel taken along the line 3-3 of Figure 1 in Embodiment 2 to 8.

[Figure 24] A schematic diagram showing the relation
5 between the direction of applied electric field, the rubbing direction of the drive liquid crystal cells and optical compensation liquid crystal cells, the initial orientation angle, and the polarizing axes of the polarizers in Embodiments 2 to 8.

10 [Figure 25] A schematic diagram showing the action of the liquid crystal as seen from a direction of cross section in Embodiment 2 to 8.

[Figure 26] A graph showing the relation between the liquid crystal applied voltage and the transmittance
15 in Embodiment 2 to 5.

[Figure 27] A graph showing the relation between the retardation, contrast ratio and white display transmittance of the liquid crystal cells in Embodiment 2 to 5.

20 [Figure 28] A graph showing the relation between the polarizing axis arrangement of polarizers and the contrast ratio in Embodiment 2 to 5.

[Figure 29] A graph showing the relation between the initial twist angle, contrast ratio and white display
25 transmittance of the liquid crystal cells in

Embodiment 2 to 5.

[Figure 30] A graph showing the relation between the liquid crystal applied voltage and the transmittance in Embodiment 6 to 8.

5 [Figure 31] A cross section of the pixel taken along the line 3-3 of Figure 1 in Embodiment 9 to 13.

[Figure 32] A schematic diagram showing the relation between the direction of applied electric field, the rubbing direction of liquid crystal cells, the initial
10 orientation angle, the polarizing axes of polarizers, and the lagging axis of phase shifter in Embodiment 9 to 13.

[Figure 33] A graph showing the relation between the direction of applied electric field and the
15 transmittance in Embodiment 9 to 13.

[Figure 34] A graph showing the relation between the direction of applied electric field and the transmittance in Embodiment 14 to 16.

[Figure 35] A cross section of the pixel taken along
20 the line 3-3 of Figure 1 in the arrangement where the two phase plates are both placed on the top.

[Figure 36] A schematic diagram showing the action of the liquid crystal as seen from a direction of the cross section in Embodiment 17 to 20.

25 [Figure 37] A graph showing the relation between the

direction of applied electric field and the transmittance in Embodiment 17 to 20.

[Description of Reference Numerals]

SUB...Transparent glass substrate, GL...Scanning signal
5 line, DL...Video signal line, CL...Counter voltage
line, PX...Pixel electrode, CT...Counter electrode,
GI...Insulating film, GT...Gate electrode, AS...i-type
semiconductor layer, SD...Source electrode or drain
electrode, PSV...Passivation layer, BM...Light
10 shielding film, LC...Liquid crystal, TFT...Thin-film
transistor, g, d...Conductive film, Cstg...Storage
capacitor, AOF...Anodic oxidized film, AO...Anodic
oxidized mask, GTM...Gate terminal, DTM...Drain
terminal, CB...Common bus line, DTM...Common electrode
15 terminal, SHD...Shield case, PNL...Liquid crystal
display panel, SPB...Light diffuser, LCB...Light
conductor, BL...Backlight fluorescent tube,
LCA...Backlight case, RM...Reflector, $\beta 1$...Initial
orientation angle between the initial orientation
20 direction of the drive cell on the orientation film
ORI1 side and the in-plane direction of lateral
electric field EDR, $\beta 2$...Initial orientation angle
between the initial orientation direction of the drive
cell on the orientation film ORI2 side and the in-
25 plane direction of lateral electric field EDR,

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$\beta 3$...Initial orientation angle between the initial
orientation direction of the optical compensation cell
on the orientation film ORI3 side and the in-plane
direction of lateral electric field EDR, $\beta 4$...Initial
5 orientation angle between the initial orientation
direction of the optical compensation cell on the
orientation film ORI4 side and the in-plane direction
of lateral electric field EDR, $\gamma 1$...Angle between the
lagging axis of the optical compensation phase film
10 FILM1 and the in-plane direction of lateral electric
field EDR, $\gamma 2$...Angle between the lagging axis of the
optical compensation phase film FILM2 and the in-plane
direction of lateral electric field EDR, RDR...Rubbing
direction of the orientation film (Subscripts are
15 omitted).

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Claims

- 5 Claim 1 A liquid crystal display device
comprising:
 a pair of insulating substrate disposed opposite
each other;
 a pair of orientation films formed over the
10 insulating substrates;
 a liquid crystal composition held between the
pair of orientation films;
 pixel electrodes and counter electrodes to apply
a lateral electric field almost parallel to surfaces
15 of the substrates; and
 a pair of polarizers holding the pair of
substrates therebetween;
 wherein an initial orientation angle β_1 between
an in-plane direction of the lateral electric field
20 and an initial orientation direction on one
orientation film side and an initial orientation angle
 β_2 between the in-plane direction of the lateral
electric field and an initial orientation direction on
the other orientation film side are in the
25 relationship of $\beta_1 \neq -\beta_2$;



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wherein an angle between the in-plane direction of the lateral electric field and a polarizing axis of one of the polarizers is almost zero.

- Claim 2 A liquid crystal display device
- 5 comprising:
- a pair of insulating substrate disposed opposite each other;
 - a pair of orientation films formed over the insulating substrates;
 - 10 a liquid crystal composition held between the pair of orientation films;
 - pixel electrodes and counter electrodes to apply a lateral electric field almost parallel to surfaces of the substrates; and
 - 15 a pair of polarizers holding the pair of substrates therebetween;
- wherein the liquid crystal composition has a positive dielectric anisotropy;
- wherein an initial orientation angle β_1 between
- 20 an in-plane direction of the lateral electric field and an initial orientation direction on one orientation film side and an initial orientation angle β_2 between the in-plane direction of the lateral electric field and an initial orientation direction on
- 25 the other orientation film side have opposite signs



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and are in the relationship of $|\beta_1 + \beta_2| \leq 20$ degrees;

wherein an angle between the in-plane direction of the lateral electric field and a polarizing axis of one of the polarizers is almost zero.

Claim 3 A liquid crystal display device according to claim 2, wherein $35 \text{ degrees} \leq |\beta_1| < 90 \text{ degrees}$ and $35 \text{ degrees} \leq |\beta_2| < 90 \text{ degrees}$ hold.

Claim 4 A liquid crystal display device, according to claim 1, 2 or 3, wherein optical compensation liquid crystal cells are arranged on the upper side or the lower side of the pair of the opposing substrates

Claim 5 A liquid crystal display device according to claim 4, wherein in the optical optical compensation liquid crystal cells, an initial orientation angle β_3 between an in-plane direction of the lateral electric field and an initial orientation direction on one orientation film side and an initial orientation angle β_4 between the in-plane direction of the lateral electric field and an initial orientation direction on the other orientation film side have the relationship, with respect to β_1 and β_2 , of $|\beta_3 - \beta_4| \approx |\beta_1 - \beta_2|$, and the angle β_3 is almost perpendicular to the angle β_2 .

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Claim 6 A liquid crystal display device according to claim 5, wherein a product of a refractive index anisotropy of the liquid crystal composition in the optical compensation liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$)' and a product of a refractive index anisotropy of a liquid crystal composition in a drive liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is in the relationship of

10
$$0.4 \cdot (\Delta n \cdot d) \leq (\Delta n \cdot d)' \leq 0.6 \cdot (\Delta n \cdot d)$$

Claim 7 A liquid crystal display device according to claim 6, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the in-plane electric field are in the relationship of

$$90 \text{ degrees} \leq |\phi_1 - \phi_2| \leq 120 \text{ degrees}$$

Claim 8 A liquid crystal display device according to claim 6, wherein the angle β_1 and the angle β_2 are in the relationship of

$$90 \text{ degrees} \leq |\beta_1 - \beta_2| \leq 115 \text{ degrees}$$

Claim 9 A liquid crystal display device according to claim 6, wherein a product of a refractive index anisotropy of the liquid crystal



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composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

$$(\Delta n \cdot d) \geq 750 \text{ nm}$$

Claim 10 A liquid crystal display device
5 according to claim 5, wherein a product of a refractive index anisotropy of the liquid crystal composition in the optical compensation liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$)' and a product of a refractive index anisotropy of
10 a liquid crystal composition in a drive liquid crystal cell and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is in the relationship of

$$(\Delta n \cdot d) = (\Delta n \cdot d)'$$

Claim 11 A liquid crystal display device
15 according to claim 10, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the lateral
20 electric field are in the relationship of

$$|\phi_1 - \phi_2| = 90 \text{ degrees}$$

Claim 12 A liquid crystal display device
according to claim 10, wherein the angle β_1 and the angle β_2 are in the relationship of
25 $70 \text{ degrees} \leq |\beta_1 - \beta_2| \leq 160 \text{ degrees}$



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Claim 13 A liquid crystal display device
according to claim 10, wherein a product of a
refractive index anisotropy of the liquid crystal
composition and a thickness of the liquid crystal
5 layer ($\Delta n \cdot d$) is

$$(\Delta n \cdot d) \geq 750 \text{ nm}$$

Claim 14 A liquid crystal display device
according to claim 1, 2 or 3, wherein optical
compensation phase films are arranged on the upper
10 side, lower side or both sides of the pair of
substrates.

Claim 15 A liquid crystal display device
according to claim 14, wherein the optical
compensation phase films hold a cholesteric liquid
15 crystal therebetween.

Claim 16 A liquid crystal display device
according to claim 14, wherein two or more of the
optical compensation phase films are provided, with at
least one film arranged between one of the substrates
20 and the polarizer and at least one film arranged
between the other substrate and the polarizer.

Claim 17 A liquid crystal display device
according to claim 16, wherein an angle γ_1 between one
phase lagging axis of the optical compensation phase
25 films and an in-plane direction of a lateral electric



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field, and an angle γ_2 between the other phase lagging axis and the in-plane direction of the lateral electric field are

$$\gamma_1 = \beta_1/2 \text{ and } \gamma_2 = \beta_2/2$$

5 Claim 18 A liquid crystal display device according to claim 17, wherein the sum of products $(\Delta n \cdot d)_n$ of a refractive index anisotropy and a thickness of a liquid crystal composition in the optical compensation phase films, and a product $(\Delta n \cdot$
10 $d)$ of a refractive index anisotropy and a thickness of a liquid crystal composition of drive liquid crystal cells are in the relationship of

$$0.4 \cdot (\Delta n \cdot d) \leq \sum_{i=1}^n (\Delta n \cdot d)_i \leq 0.6 \cdot (\Delta n \cdot d)$$

 Claim 19 A liquid crystal display device
15 according to claim 18, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the lateral
20 electric field are in the relationship of

$$90 \text{ degrees} \leq |\phi_1 - \phi_2| \leq 120 \text{ degrees}$$

 Claim 20 A liquid crystal display device according to claim 18, wherein the angle β_1 and the angle β_2 are in the relationship of

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90 degrees $\leq |\beta_1 - \beta_2| \leq 115$ degrees

Claim 21 A liquid crystal display device according to claim 18, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

$$(\Delta n \cdot d) \geq 750 \text{ nm}$$

Claim 22 A liquid crystal display device according to claim 17, wherein the sum of products ($\Delta n \cdot d$)_n of a refractive index anisotropy and a thickness of a liquid crystal composition in the optical compensation phase films, and a product ($\Delta n \cdot d$) of a refractive index anisotropy and a thickness of a liquid crystal composition of drive liquid crystal cells are in the relationship of

$$\sum_{i=1}^n (\Delta \cdot d)_n = (\Delta n \cdot d)$$

Claim 23 A liquid crystal display device according to claim 22, wherein an angle ϕ_1 between a polarizing axis of one of the polarizers and the in-plane direction of the lateral electric field and an angle ϕ_2 between a polarizing axis of the other polarizer and the in-plane direction of the lateral electric field are in the relationship of

$$|\phi_1 - \phi_2| = 90 \text{ degrees}$$



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Claim 24 A liquid crystal display device according to claim 22, wherein the angle β_1 and the angle β_2 are in the relationship of

$$70 \text{ degrees} \leq |\beta_1 - \beta_2| \leq 160 \text{ degrees}$$

5 Claim 25 A liquid crystal display device according to claim 22, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

10 $(\Delta n \cdot d) \geq 750 \text{ nm}$

Claim 26 A liquid crystal display device according to claim 14, wherein two or more of the optical compensation phase films are provided, with at least two films arranged between one of the substrates and the polarizer.

15 Claim 27 A liquid crystal display device comprising:

a pair of insulating substrate disposed opposite each other;

20 a pair of orientation films formed over the insulating substrates;

a liquid crystal composition held between the pair of orientation films;

25 pixel electrodes and counter electrodes to apply a lateral electric field almost parallel to surfaces



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of the substrates; and

a pair of polarizers holding the pair of
substrates therebetween;

wherein the liquid crystal composition has a
5 negative dielectric anisotropy;

wherein an initial orientation angle β_1 between
an in-plane direction of the lateral electric field
and an initial orientation direction on one
orientation film side and an initial orientation angle
10 β_2 between the in-plane direction of the lateral
electric field and an initial orientation direction on
the other orientation film side have opposite signs
and are in the relationship of

0 degree < $|\beta_1| \leq 55$ degrees and 0 degree < $|\beta_2|$
15 ≤ 55 degrees;

wherein an angle between the in-plane direction
of the lateral electric field and a polarizing axis of
one of the polarizers is almost zero.

Claim 28 A liquid crystal display device
20 according to claim 27, wherein an angle ϕ_1 between a
polarizing axis of one of the polarizers and the in-
plane direction of the lateral electric field and an
angle ϕ_2 between a polarizing axis of the other
polarizer and the in-plane direction of the lateral
25 electric field are in the relationship of



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90 degrees $\leq |\phi_1 - \phi_2| \leq$ 120 degrees

Claim 29 A liquid crystal display device according to claim 27, wherein the angle β_1 and the angle β_2 are in the relationship of

5 20 degrees $\leq |\beta_1 - \beta_2| \leq$ 50 degrees

Claim 30 A liquid crystal display device according to claim 27, wherein a product of a refractive index anisotropy of the liquid crystal composition and a thickness of the liquid crystal layer ($\Delta n \cdot d$) is

($\Delta n \cdot d$) $\geq$ 750 nm

Claim 31 A liquid crystal display device according to claim 27, further comprising a pair of opposing insulating substrates, a pair of orientation films formed on the substrates to orientate a liquid crystal composition, and optical compensation liquid crystal cells holding the liquid crystal composition between the pair of orientation films.

Claim 32 A liquid crystal display device according to claim 27, further comprising optical compensation phase films.



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ACTIVE MATRIX TYPE LIQUID CRYSTAL DISPLAY DEVICE

[Designation of Document] Abstract

[Abstract]

[Problem] To provide an active matrix type liquid crystal display device in which the image display is controlled by an electric field parallel to the substrate surface, and which is capable of realizing a wide viewing angle comparable to that of a CRT and a response speed fast enough to display a dynamic image.

10 [Means for Solving the Problem] A liquid crystal display device which comprises a pair of insulating substrate so disposed as to face each other; a pair of orientation films formed over the insulating substrates; a liquid crystal composition held between
15 the pair of orientation films; and pixel electrodes and counter electrodes to apply a lateral electric field almost parallel to surfaces of the substrates; wherein an initial orientation direction on one orientation film side and an initial orientation
20 direction on the other orientation film side are line-symmetric with respect to the direction of the lateral electric field.

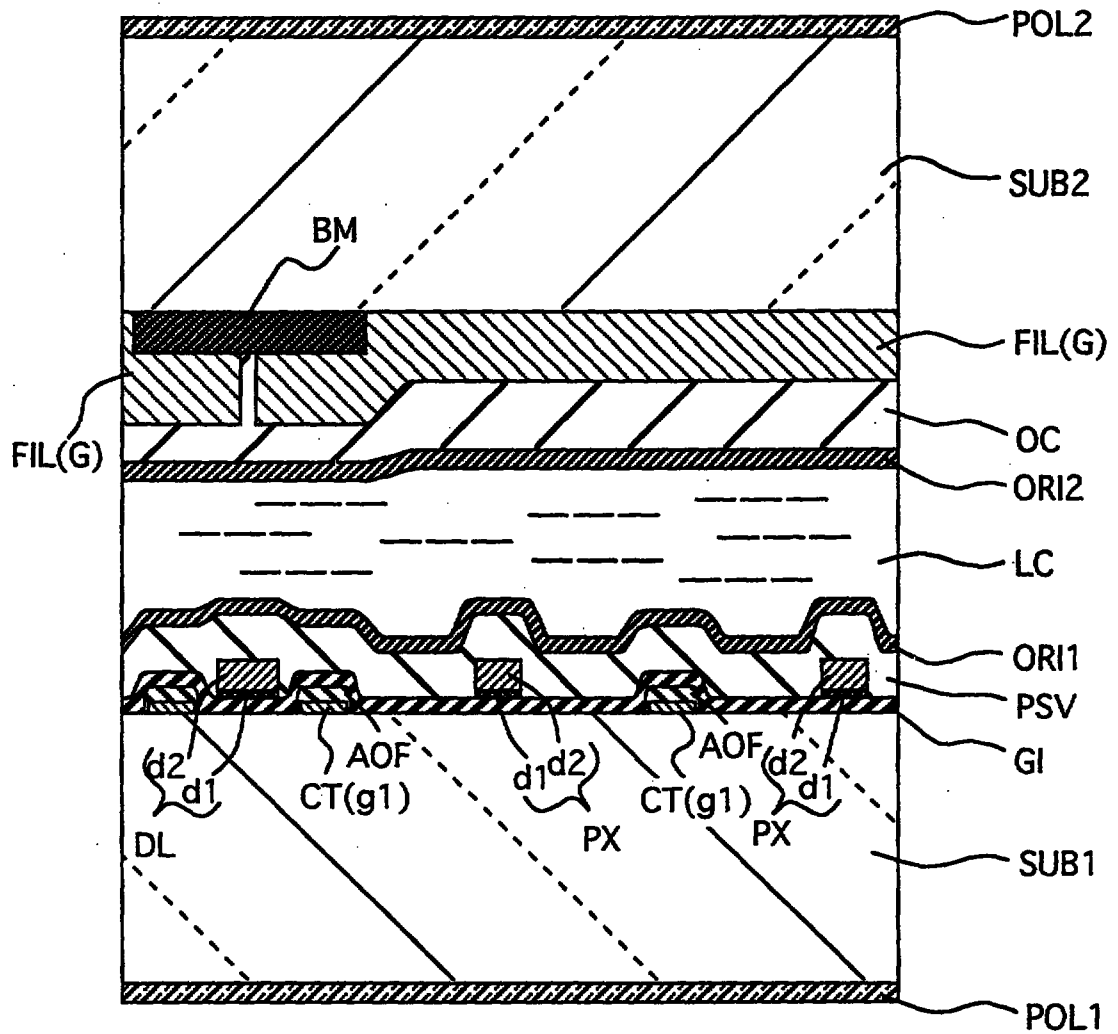
[Effect] The liquid crystal display device of lateral electric field type has a fast response speed
25 that allows display of a dynamic image.

[Selected figure] Figure 1

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FIG.2



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FIG.3

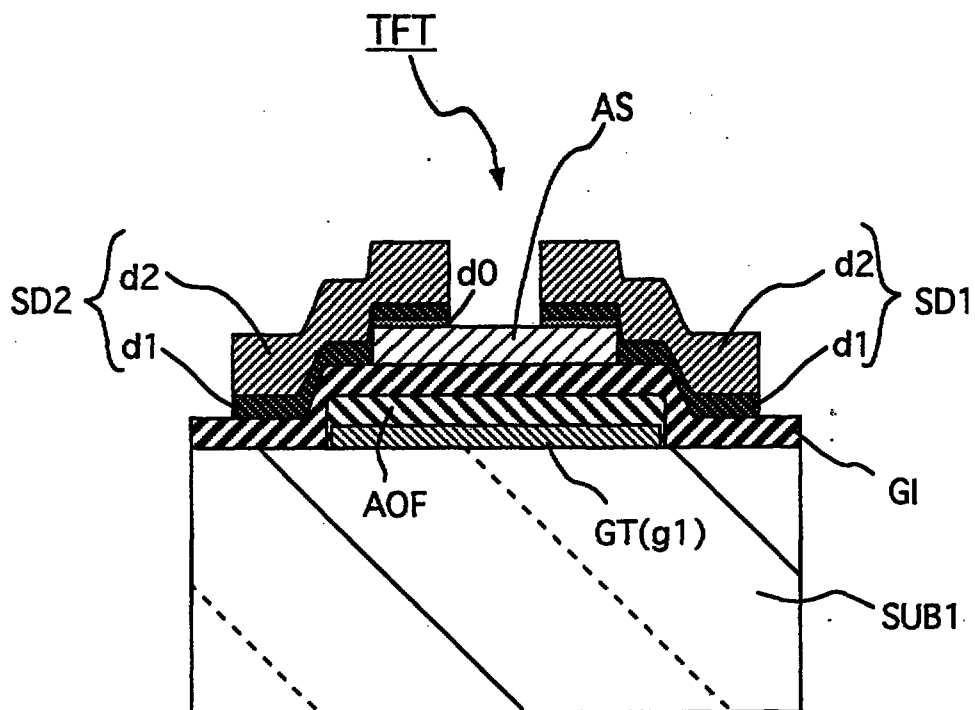
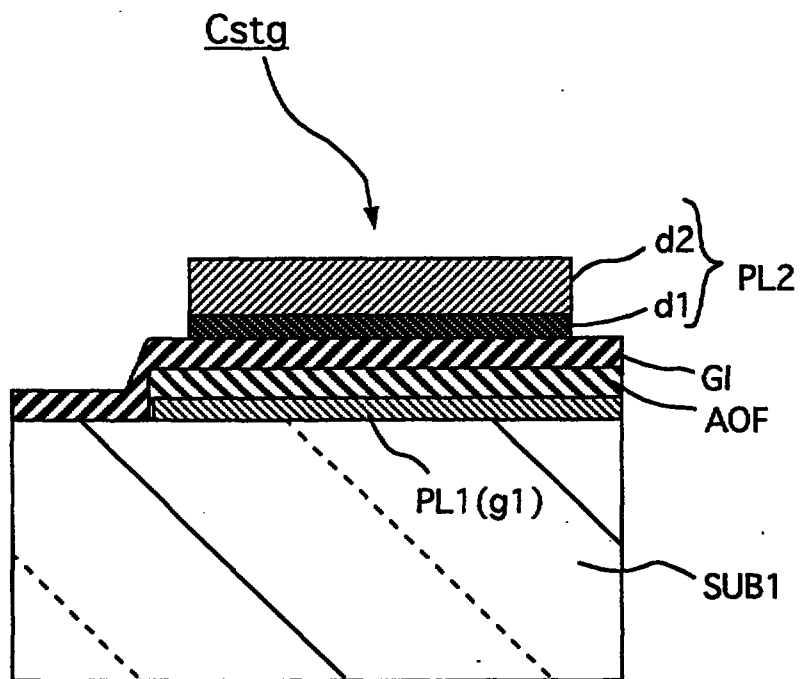


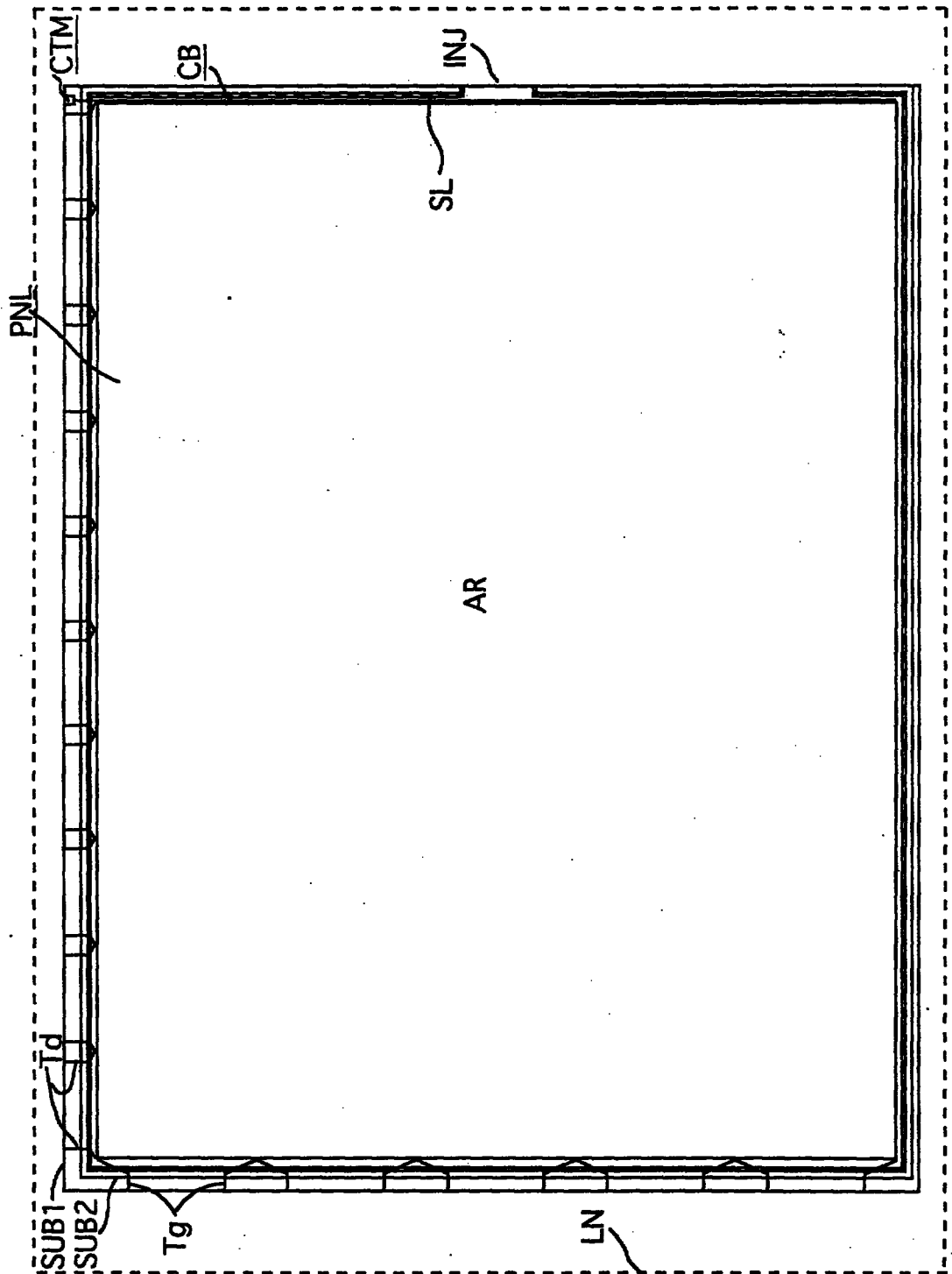
FIG.4



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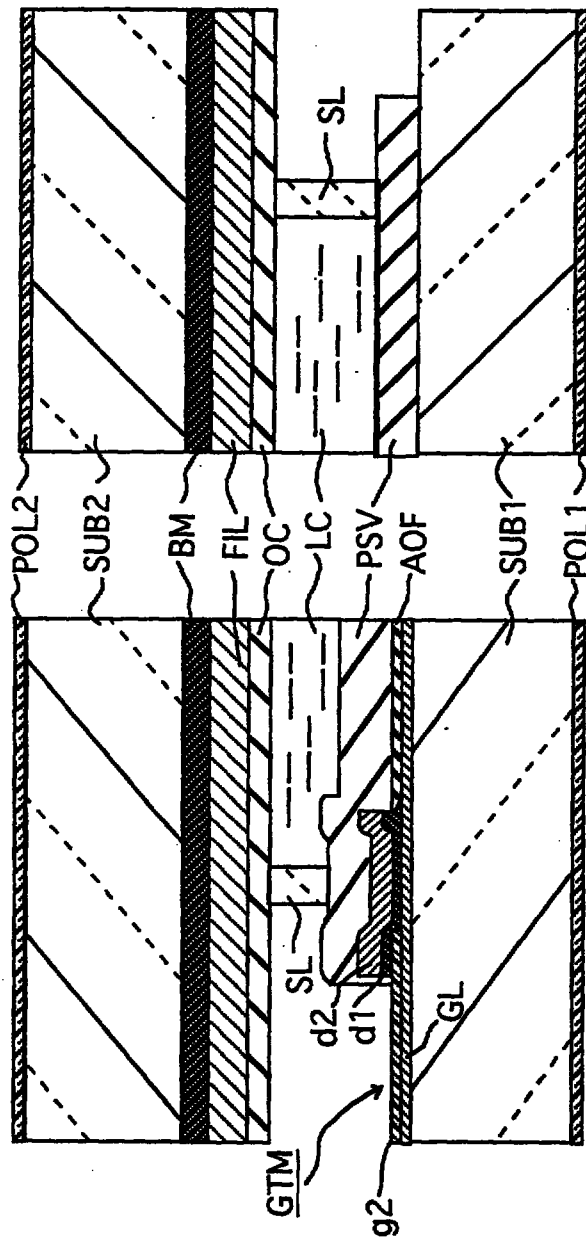
FIG. 5



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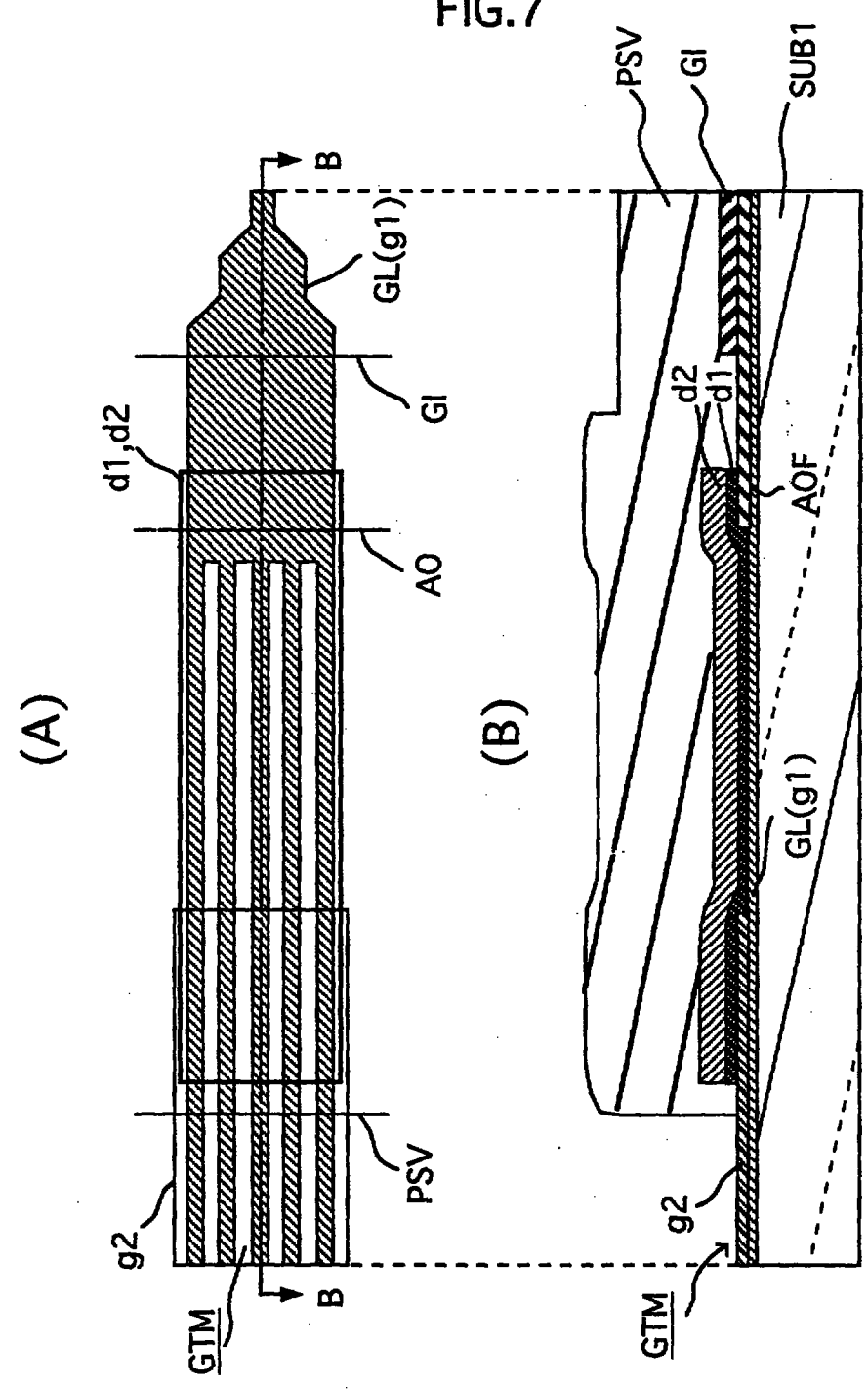
FIG.6



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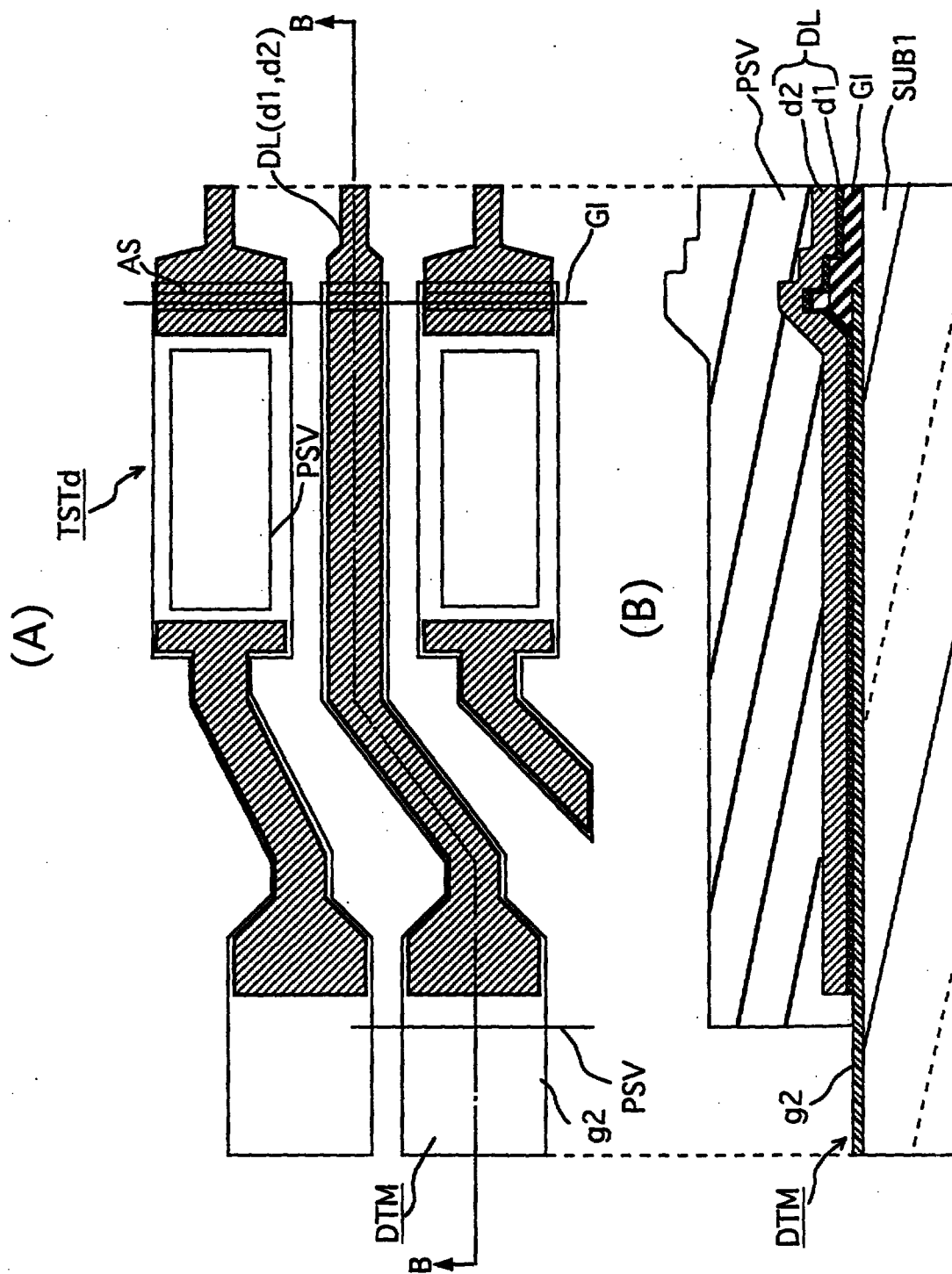
FIG.7



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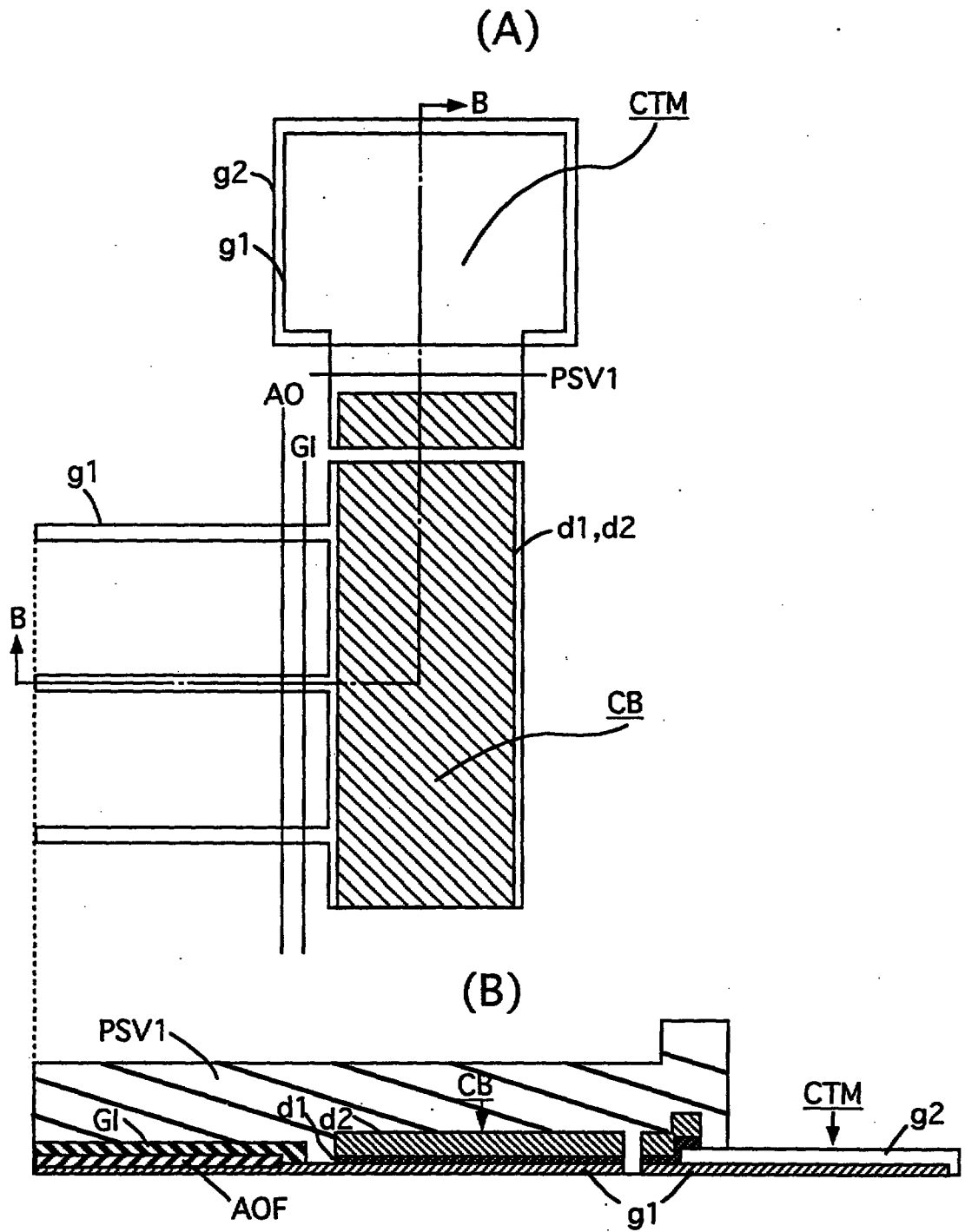
FIG.8



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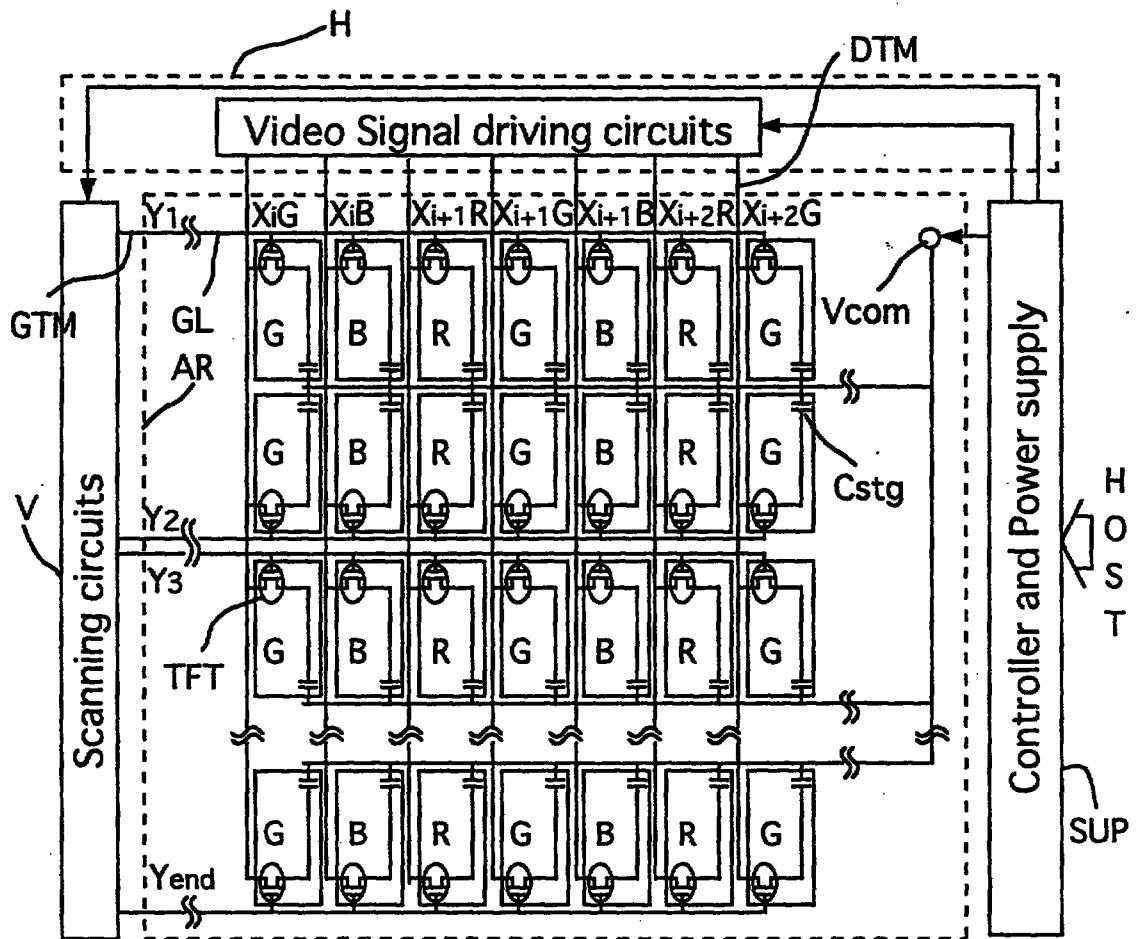
FIG.9



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FIG.10



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FIG. 11

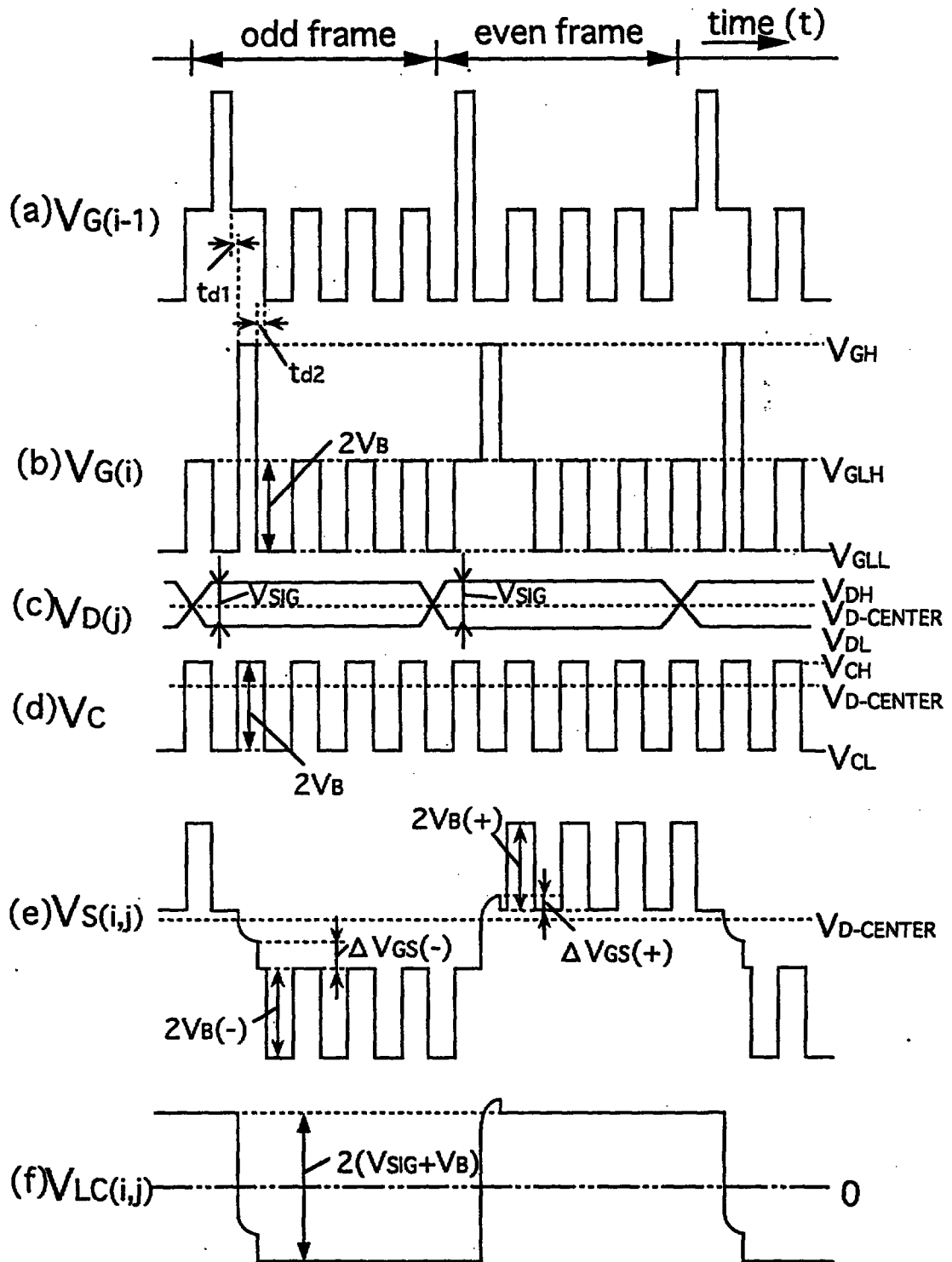
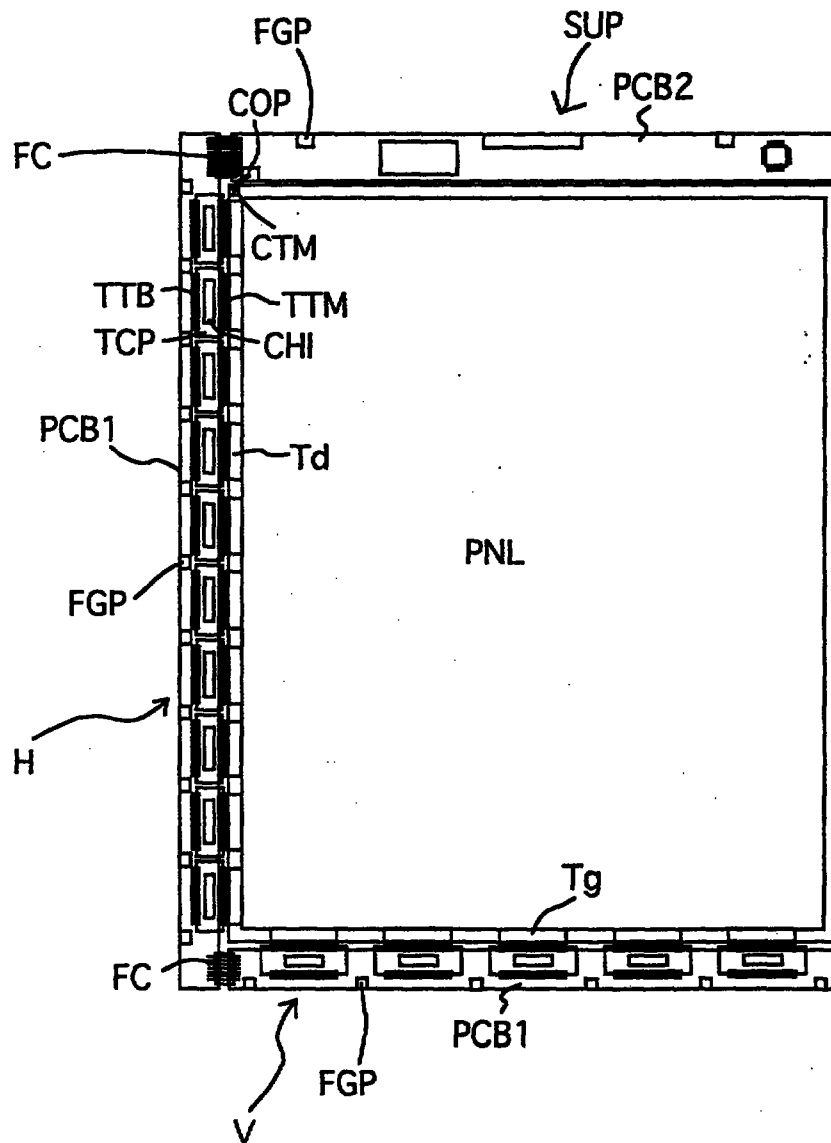


FIG.12



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FIG.13

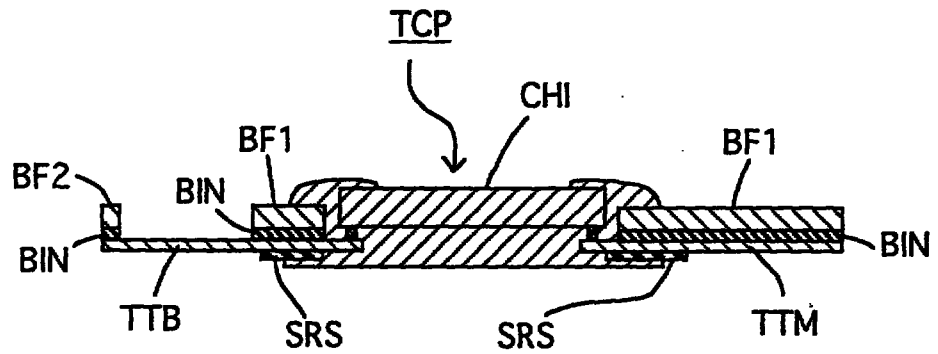
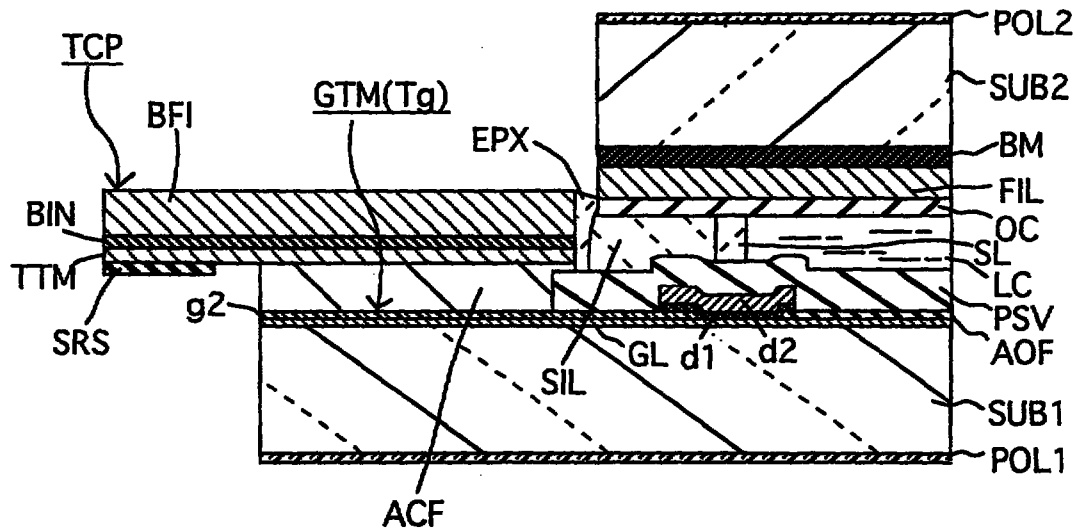


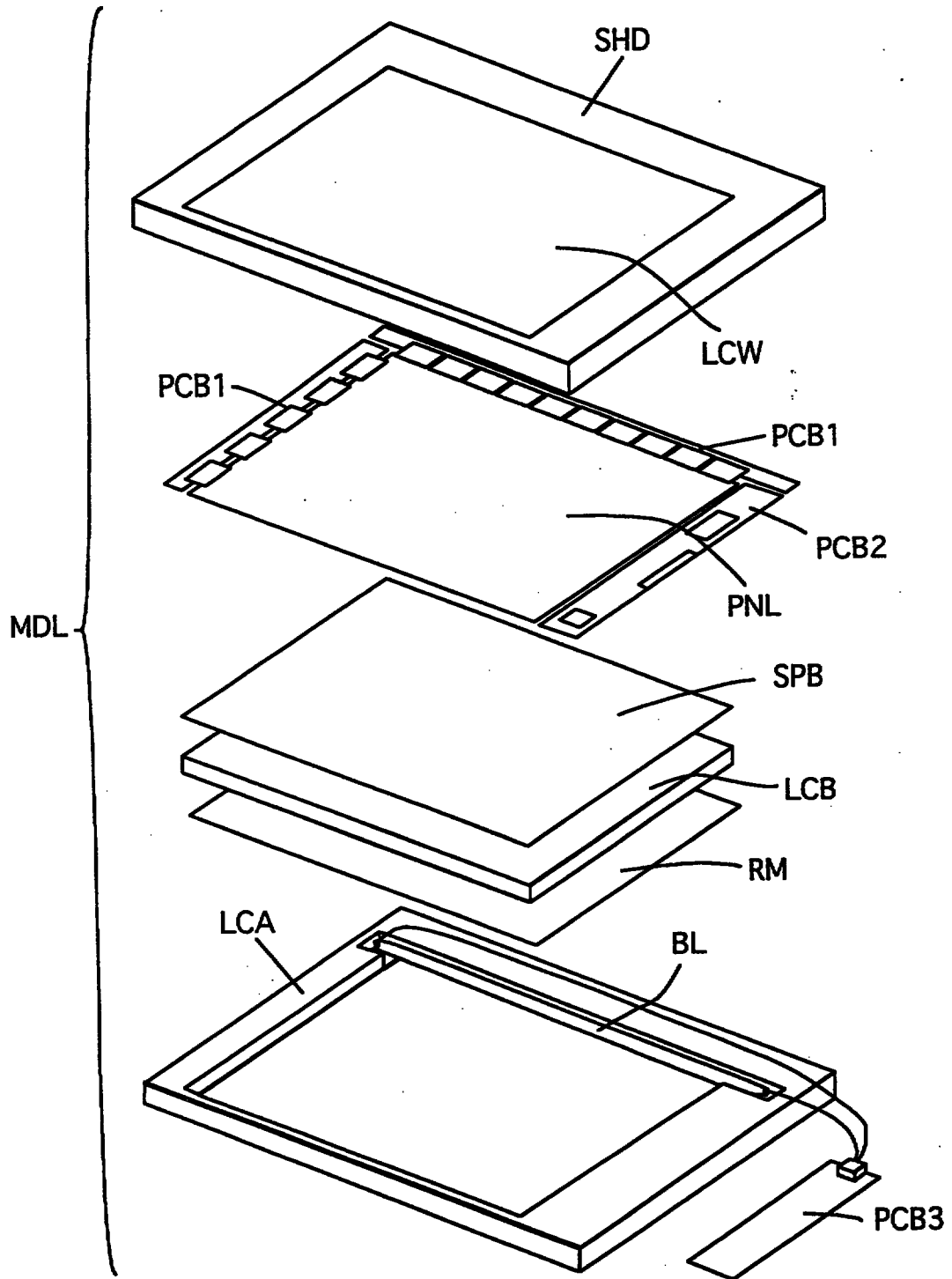
FIG.14



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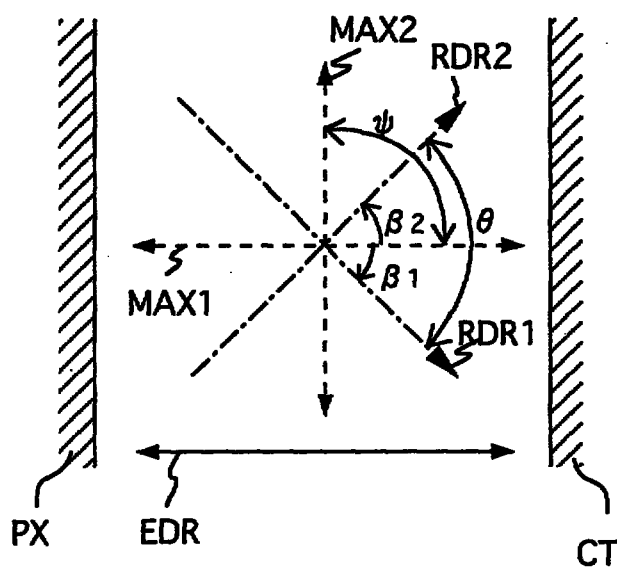
FIG.15



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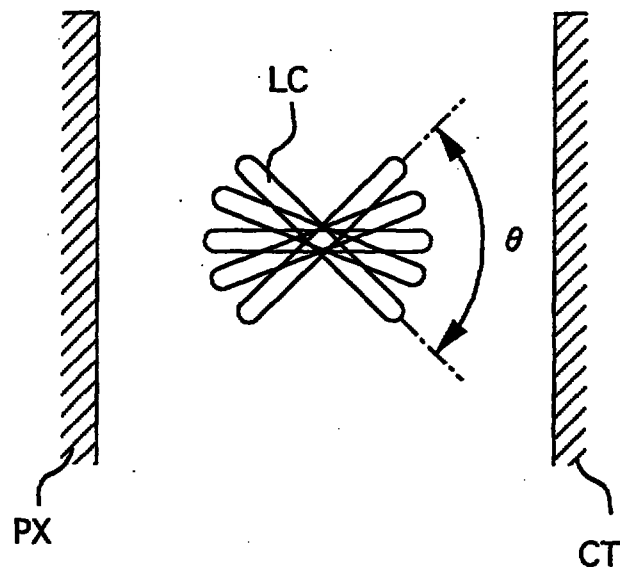
FIG.16



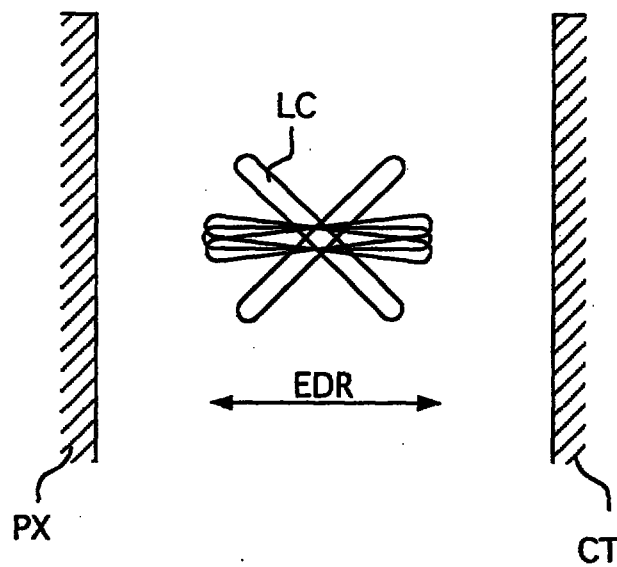
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FIG.17

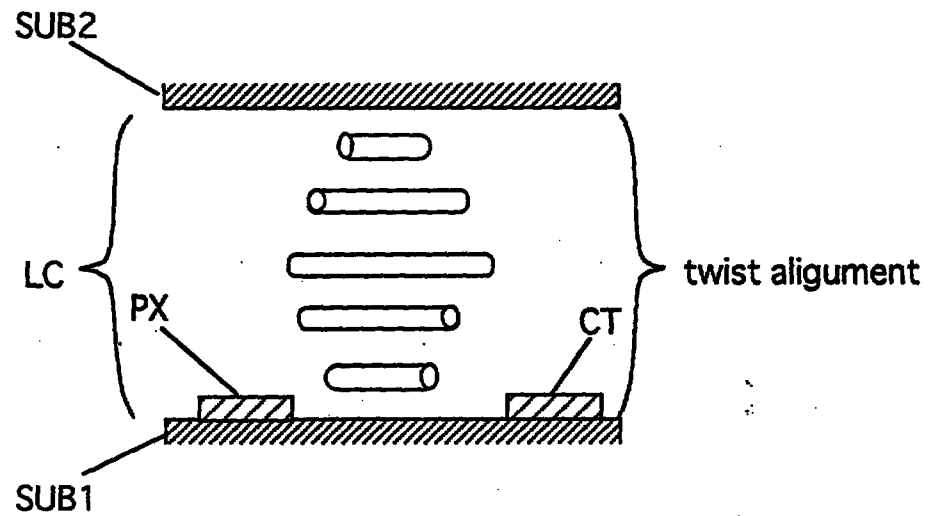


(a) State of voltage OFF (High penetration rate)

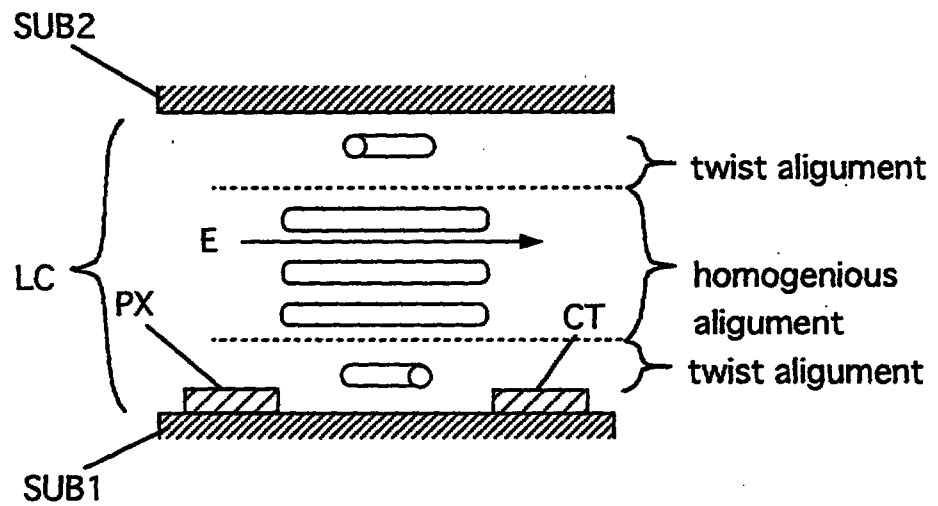


(b) State of voltage ON (Low penetration rate)

FIG.18

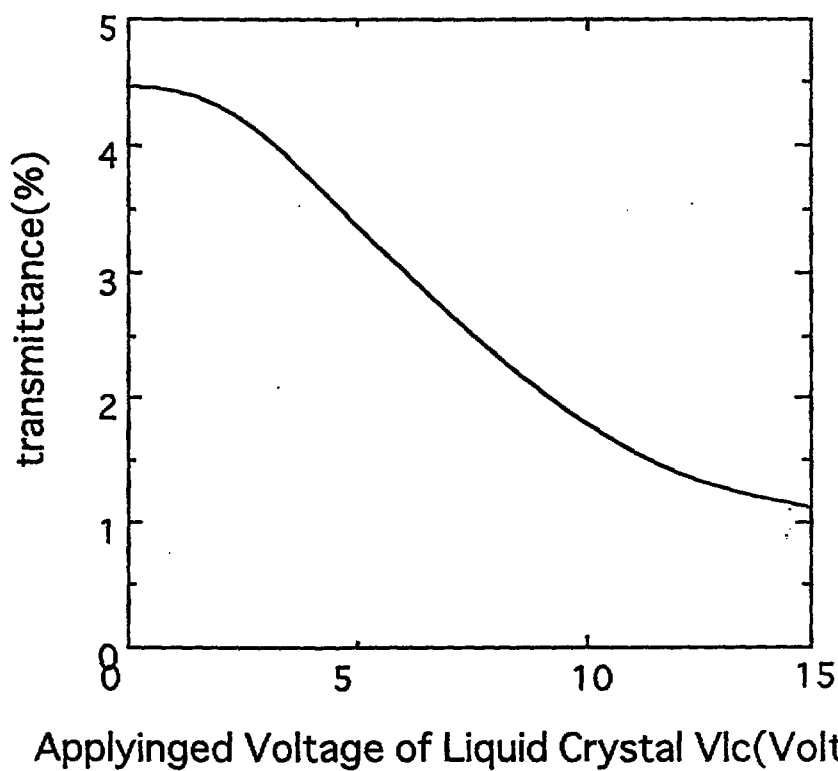


(a) State of voltage OFF (High penetration rete)



(b) State of voltage ON (Low penetration rete)

FIG.19



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FIG.20

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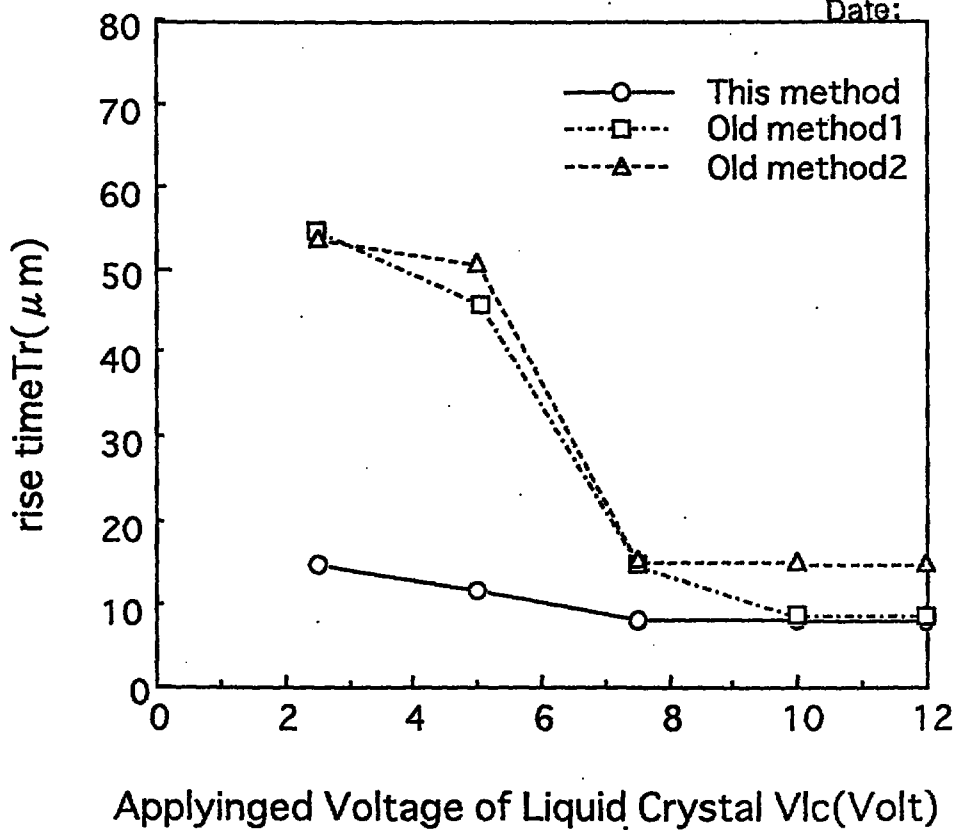
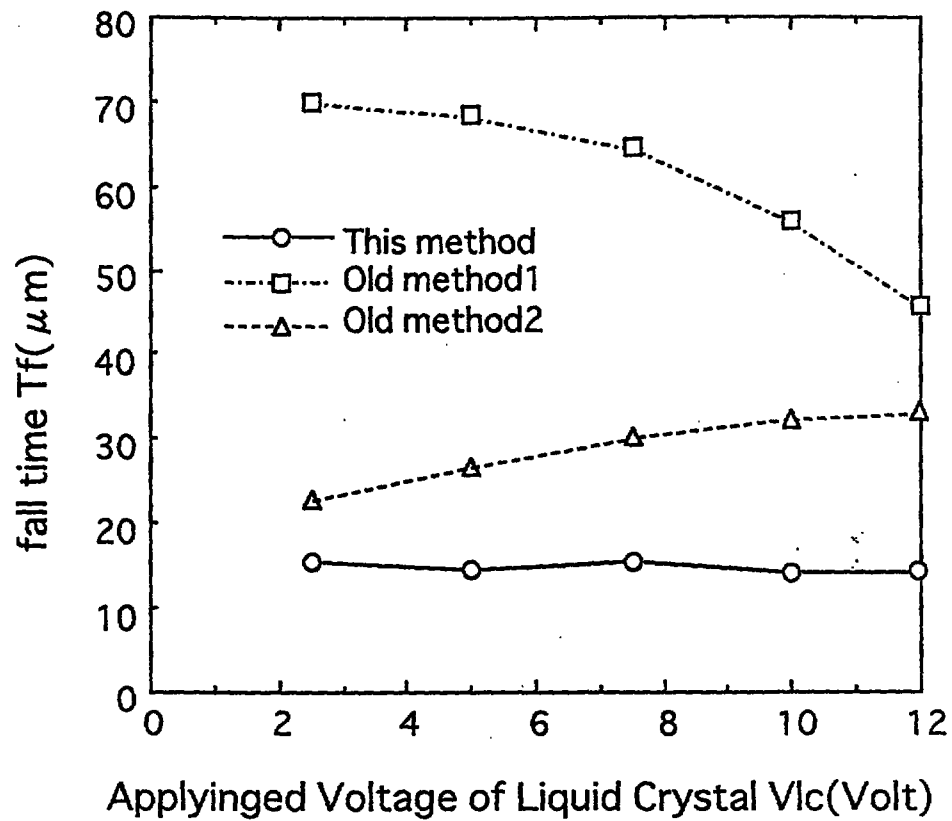
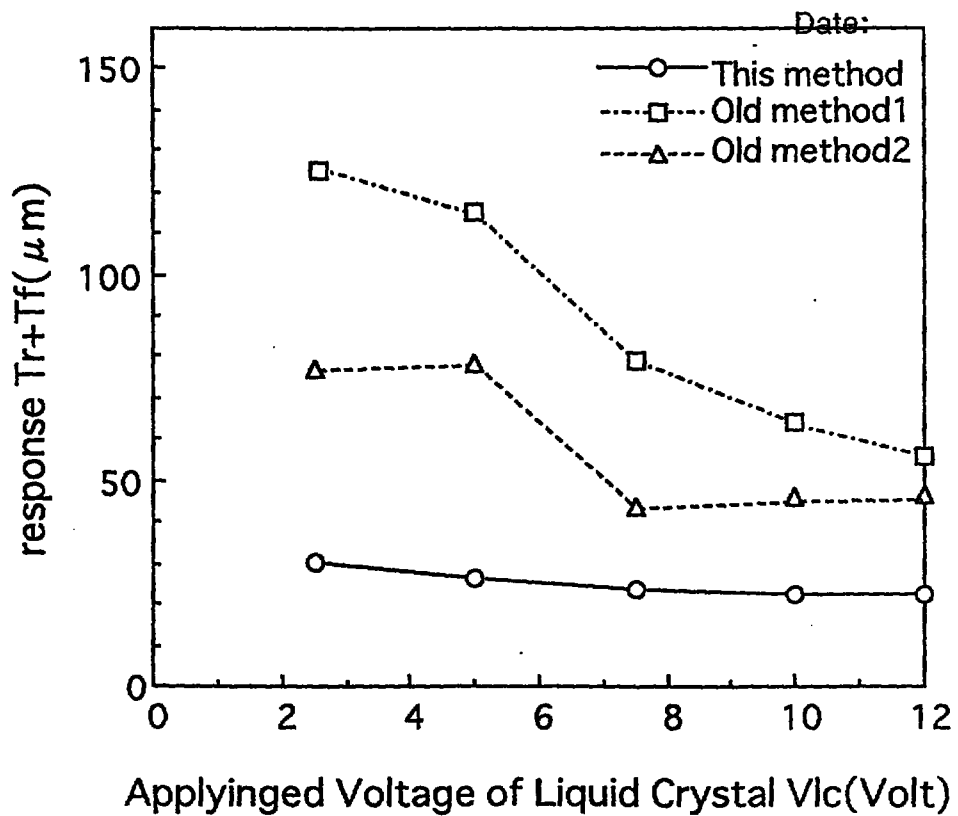


FIG.21



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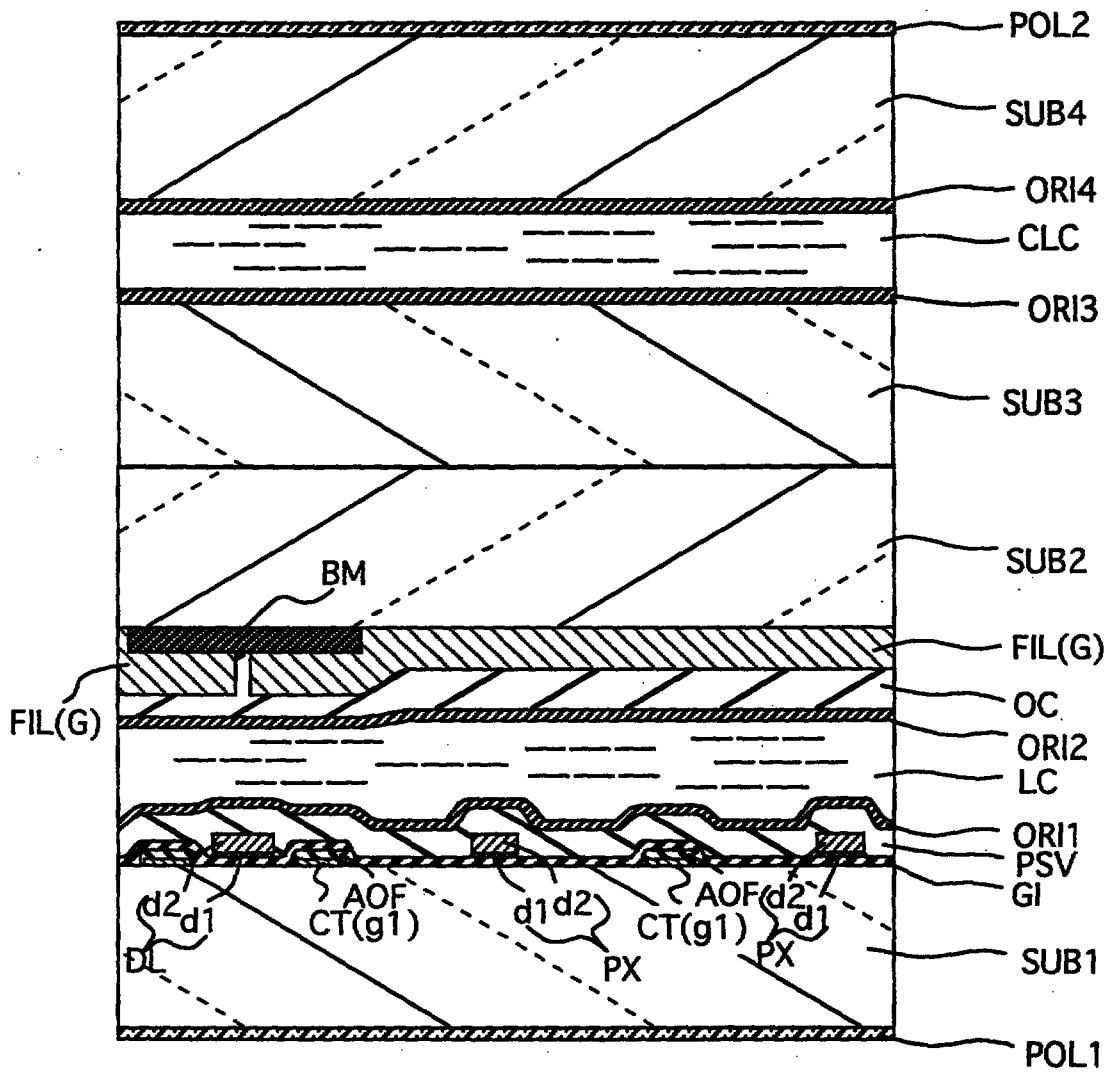
FIG.22



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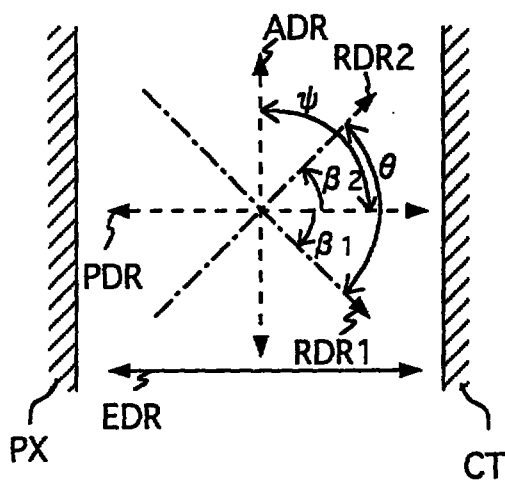
FIG.23



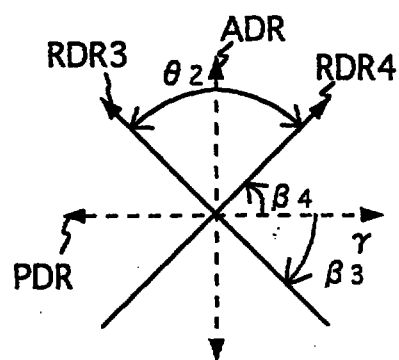
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FIG.24



(a) Liquid Crystal cell for drive

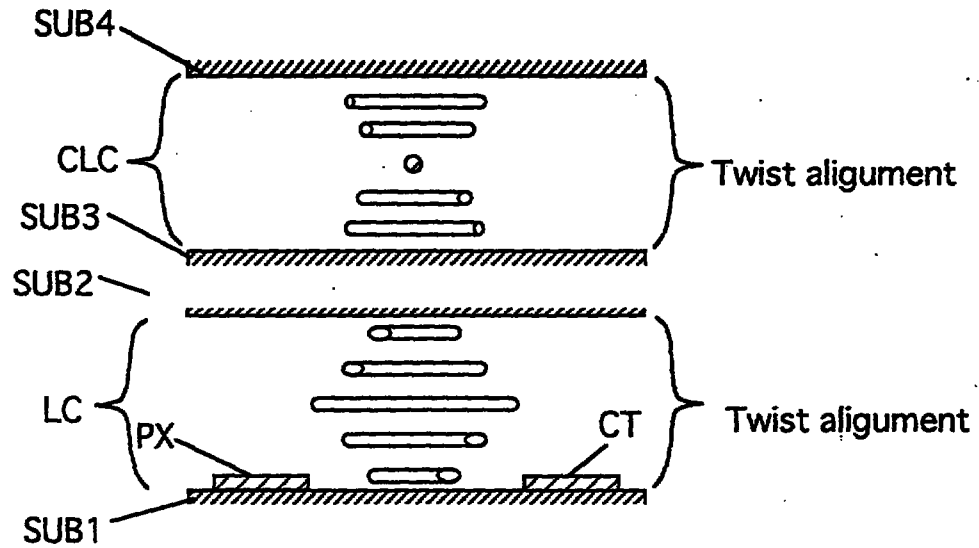


(b) Liquid Crystal cell for amend

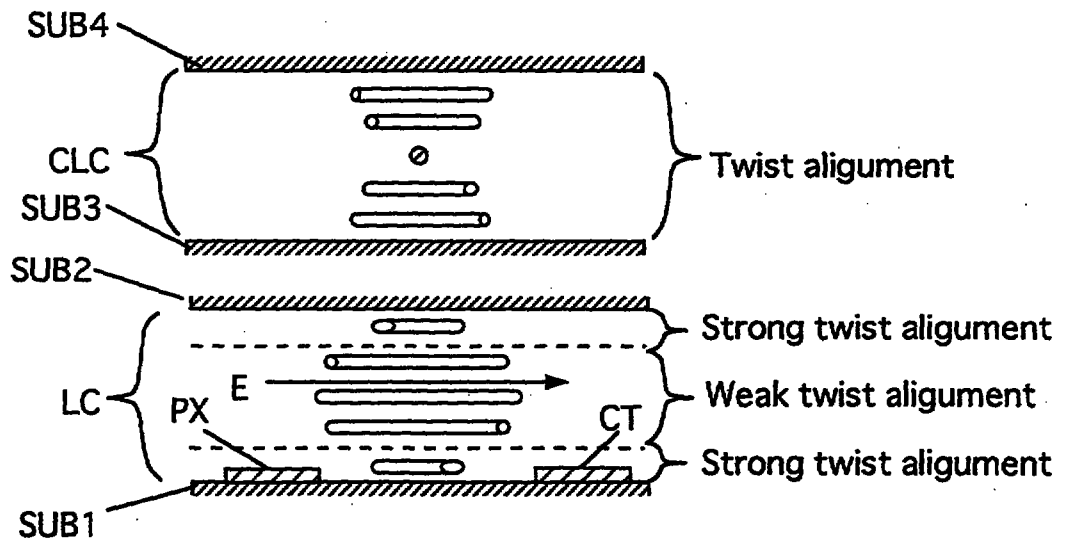
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FIG.25



(a) State of voltage OFF (High penetration rete)



(b) State of voltage ON (Low penetration rete)

FIG.26

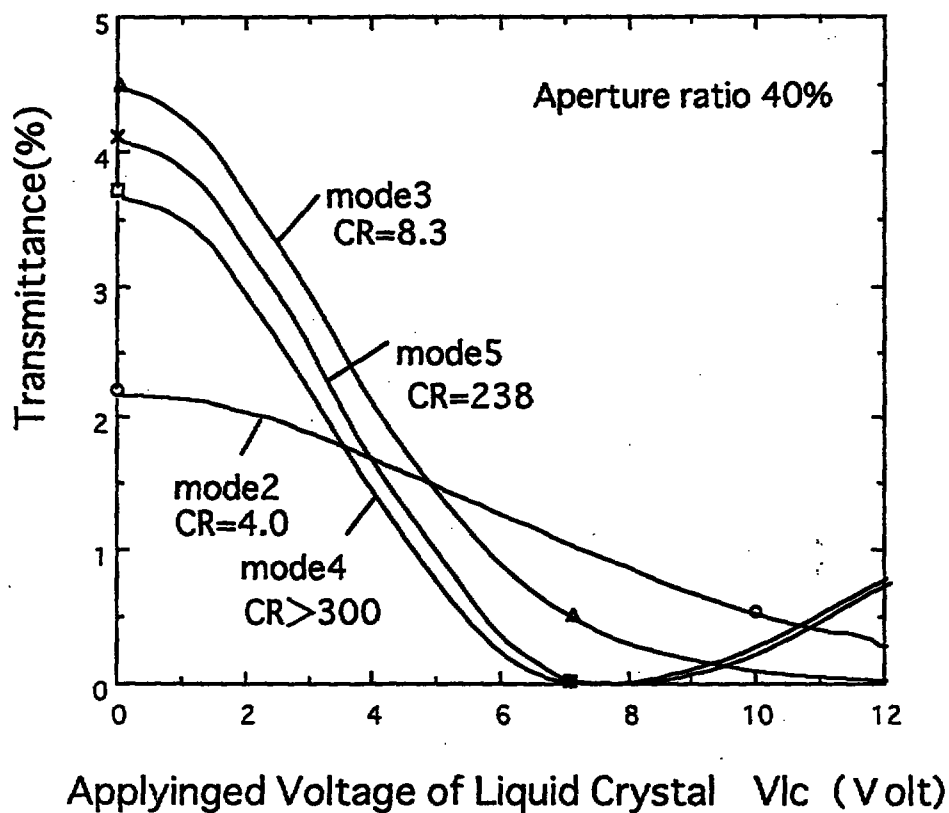
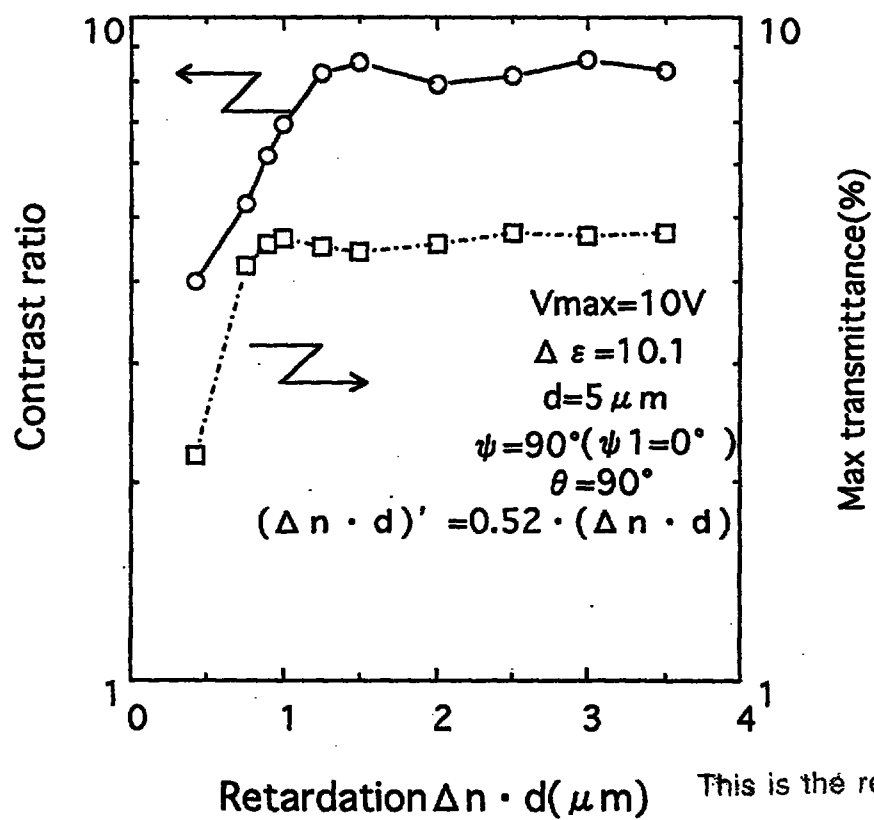


FIG.27



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FIG.28

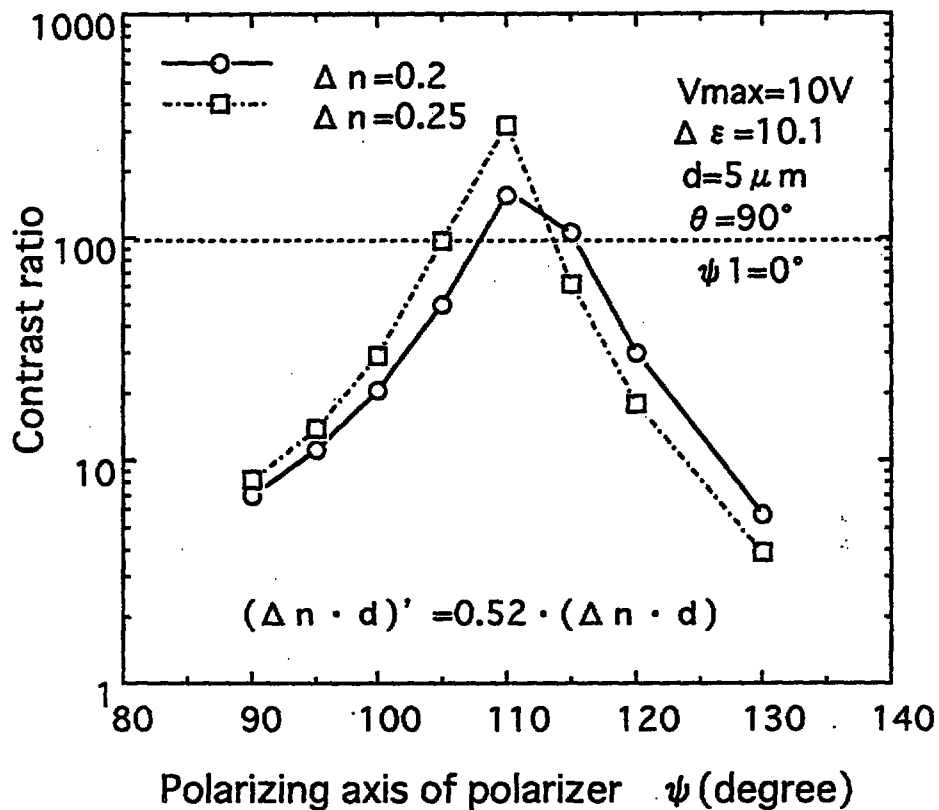
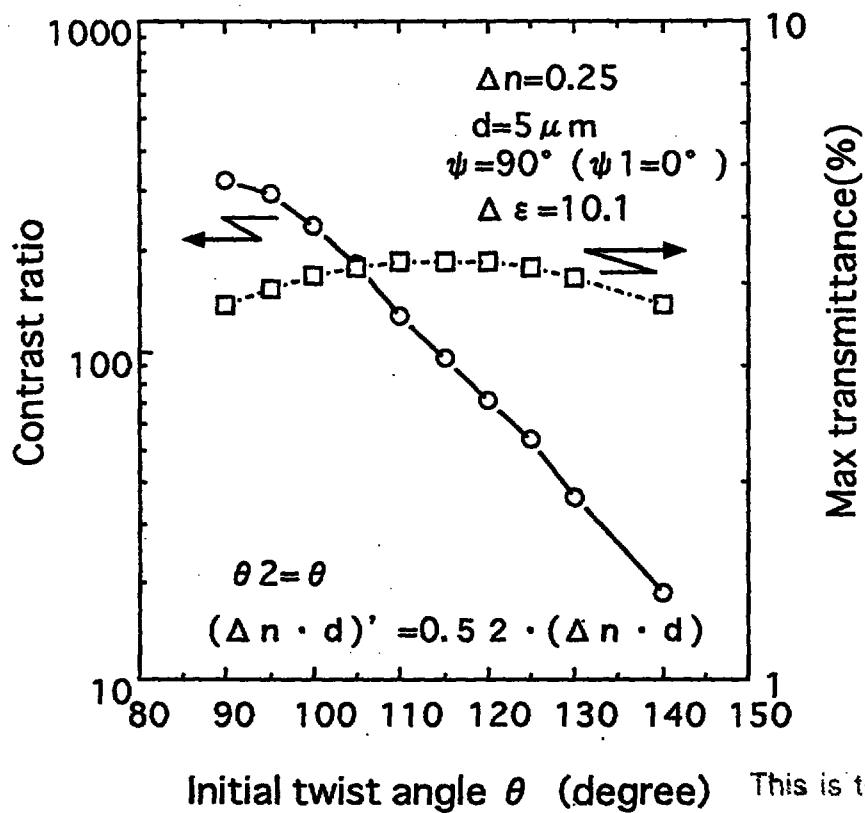


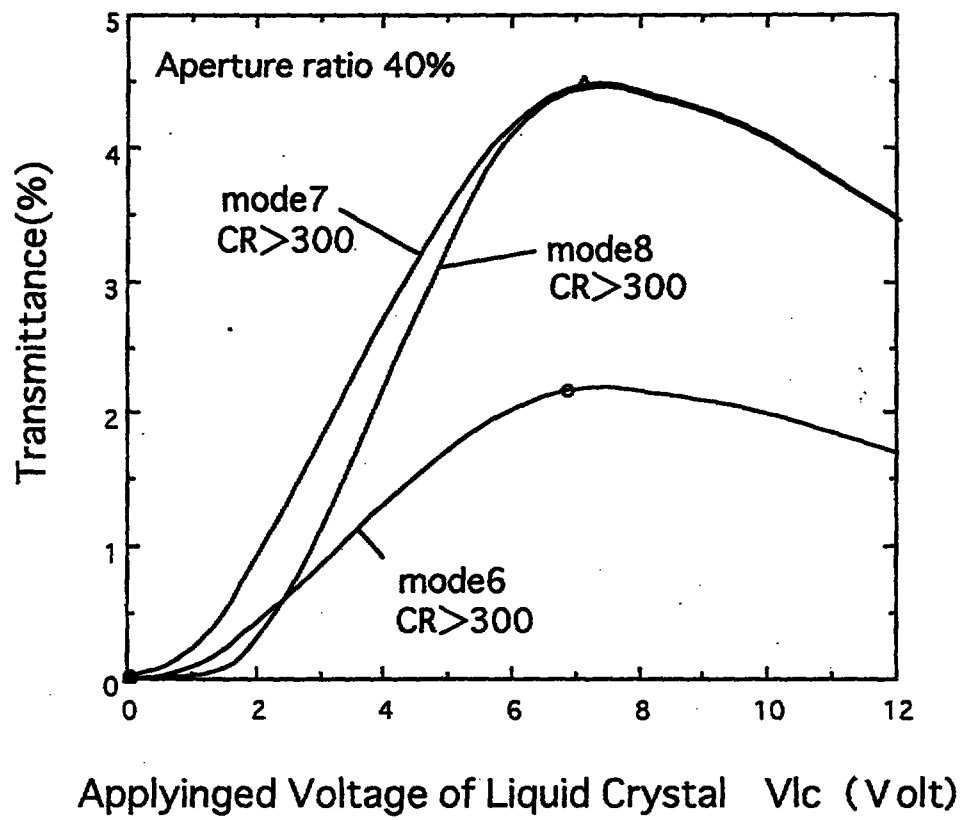
FIG.29



This is the replacement sheet

Date: 13 OCT 1997

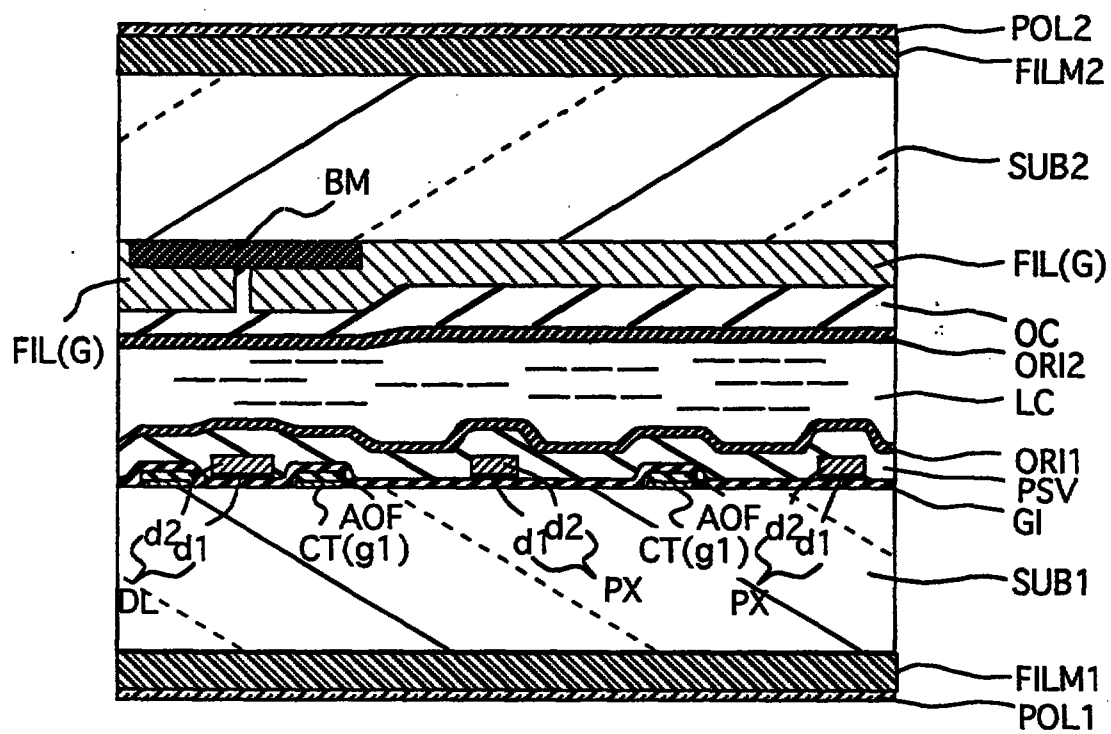
FIG.30



This is the replacement sheet

Date: 13 OCT 1997

FIG.31



This is the replacement sheet

Date: 13 OCT 1997

FIG.32

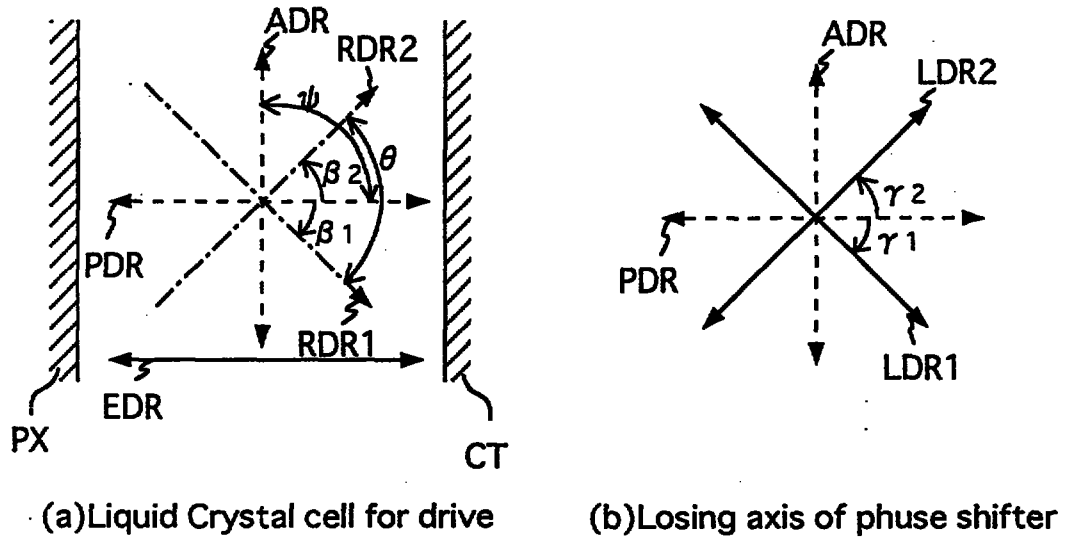


FIG.33

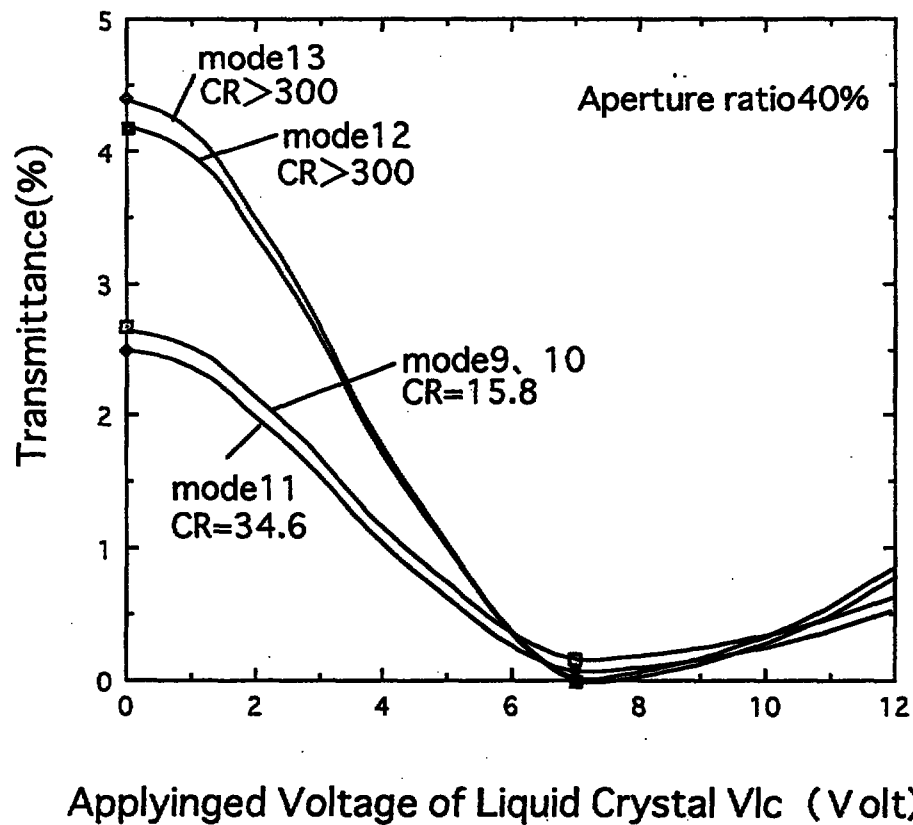


FIG.34

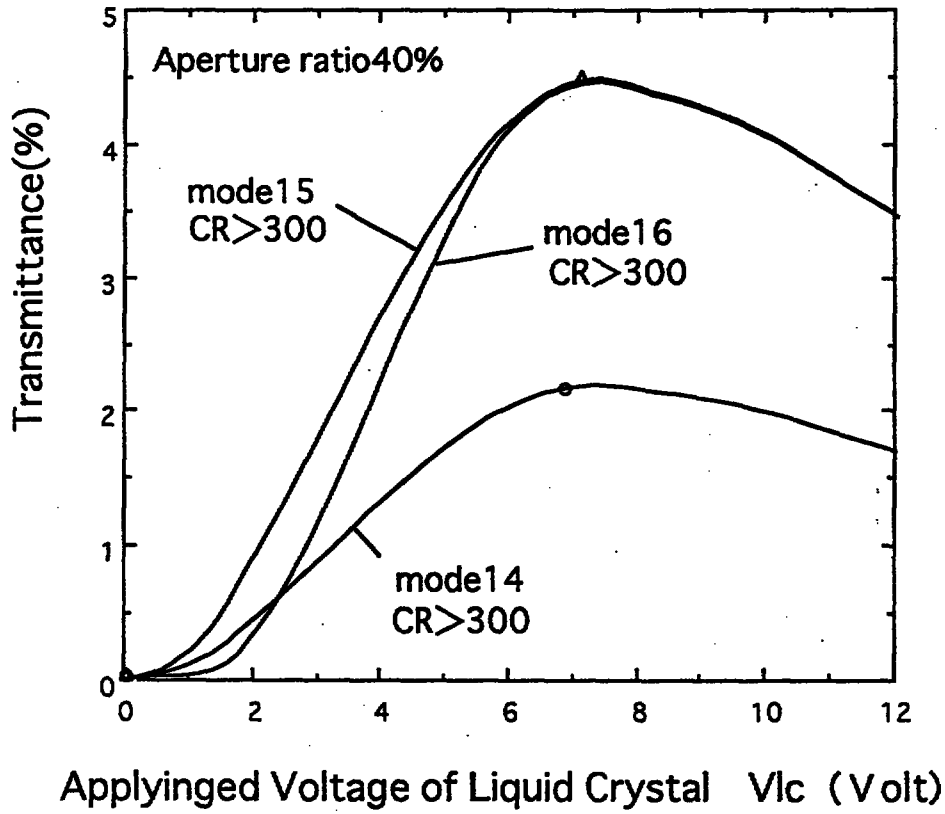
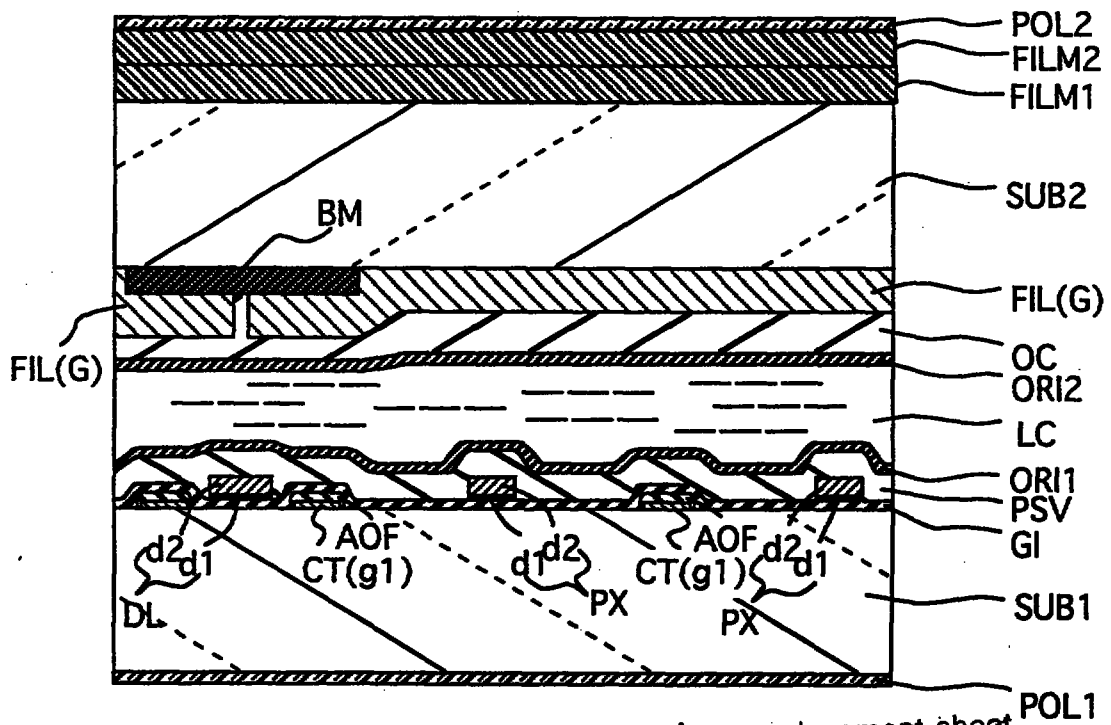


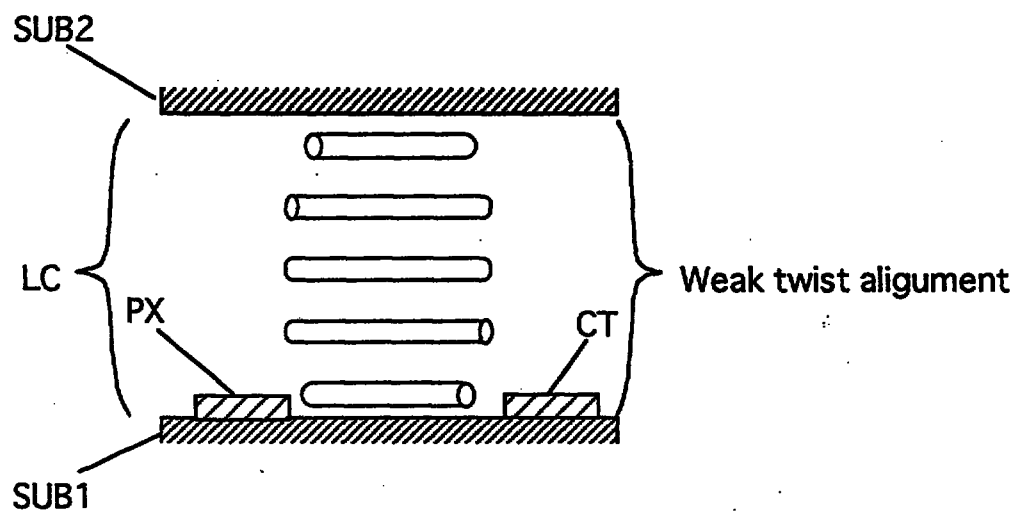
FIG.35



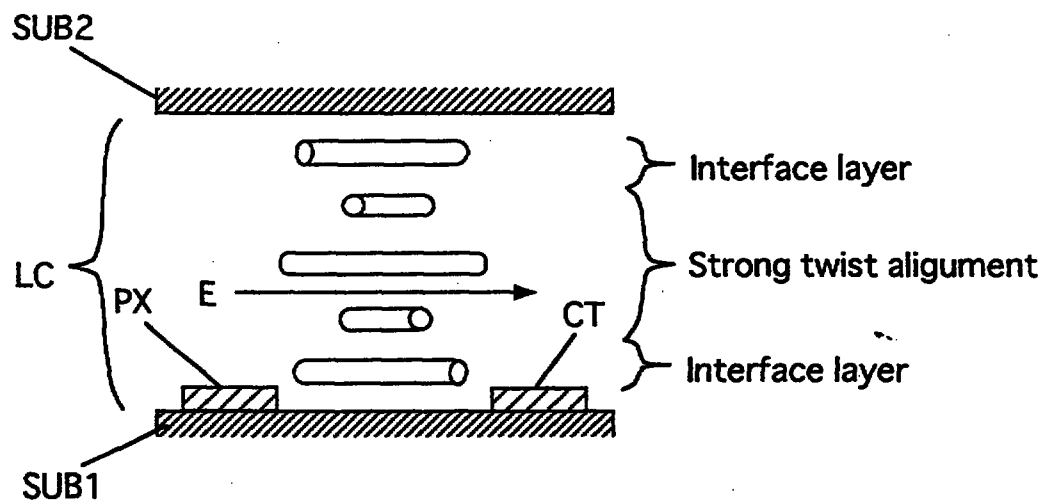
This is the replacement sheet

1 3 OCT 1997

FIG.36

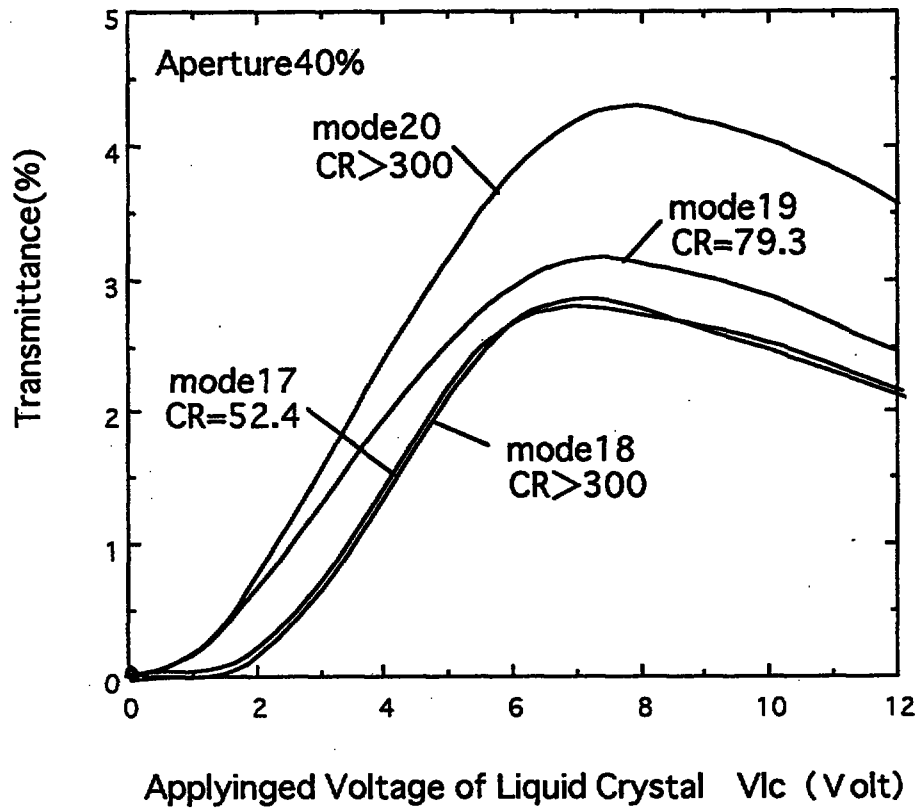


(a) State of voltage OFF (Low Penetration rate)



(b) State of voltage ON (High Penetration rate)

FIG.37



This is the replacement sheet

Date: 13 OCT 1997