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Choi et al.

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(54) **ORGANIC LIGHT-EMITTING DISPLAY AND METHOD OF MANUFACTURING THE SAME**

(71) Applicant: **Samsung Display Co., Ltd**, Yongin-si, Gyeonggi-do (KR)

(72) Inventors: **Jonghyun Choi**, Yongin-si (KR);
Kinyeng Kang, Yongin-si (KR);
Sunkwang Kim, Yongin-si (KR);
Suyeon Sim, Yongin-si (KR)

(73) Assignee: **Samsung Display Co., Ltd.**, Yongin-si (KR)

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H01L 51/00 (2006.01)
H01L 27/32 (2006.01)

(52) **U.S. Cl.**

CPC **H01L 51/5253** (2013.01); **H01L 27/3258** (2013.01); **H01L 51/0096** (2013.01)

(58) **Field of Classification Search**

None
See application file for complete search history.

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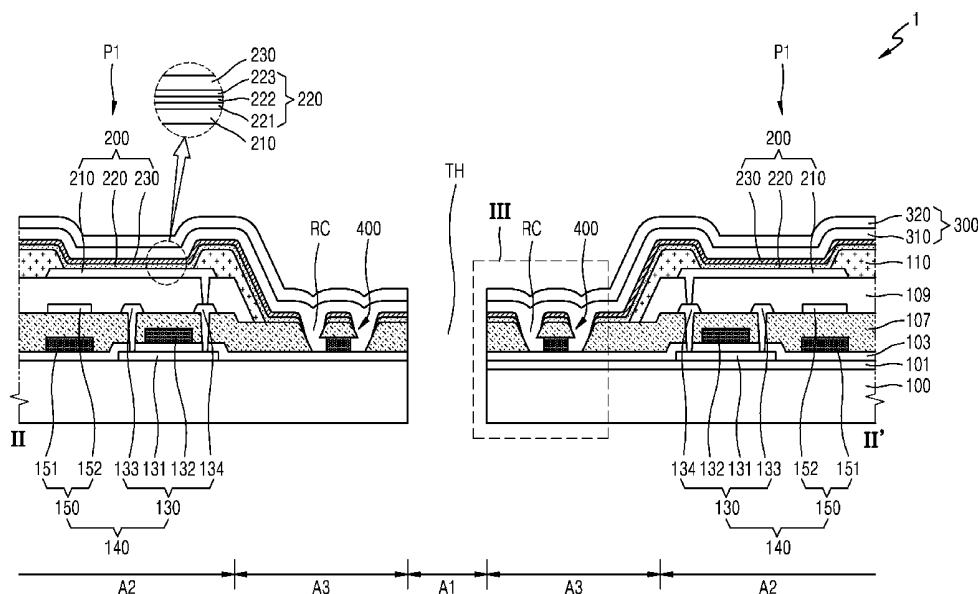
Primary Examiner — Lex Malsawma

(74) *Attorney, Agent, or Firm* — Lewis Roca Rothgerber Christie LLP

(57) **ABSTRACT**

An organic light-emitting display including a substrate, an insulating layer on the substrate, the substrate and the insulating layer having an opening therethrough penetrating, a pixel array on the insulating layer, the pixel array including a plurality of pixels that surround the opening, a first pixel adjacent to the opening from among the plurality of pixels includes a pixel electrode layer, an intermediate layer on the pixel electrode layer, and an opposite electrode layer on the intermediate layer, and a stepped portion on the substrate and adjacent to the opening, the stepped portion having an under-cut step, wherein the intermediate layer including an organic emission layer, and wherein at least one of the intermediate layer and the opposite electrode layer extends toward the opening and is disconnected by the stepped portion.

11 Claims, 32 Drawing Sheets



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FIG. 1

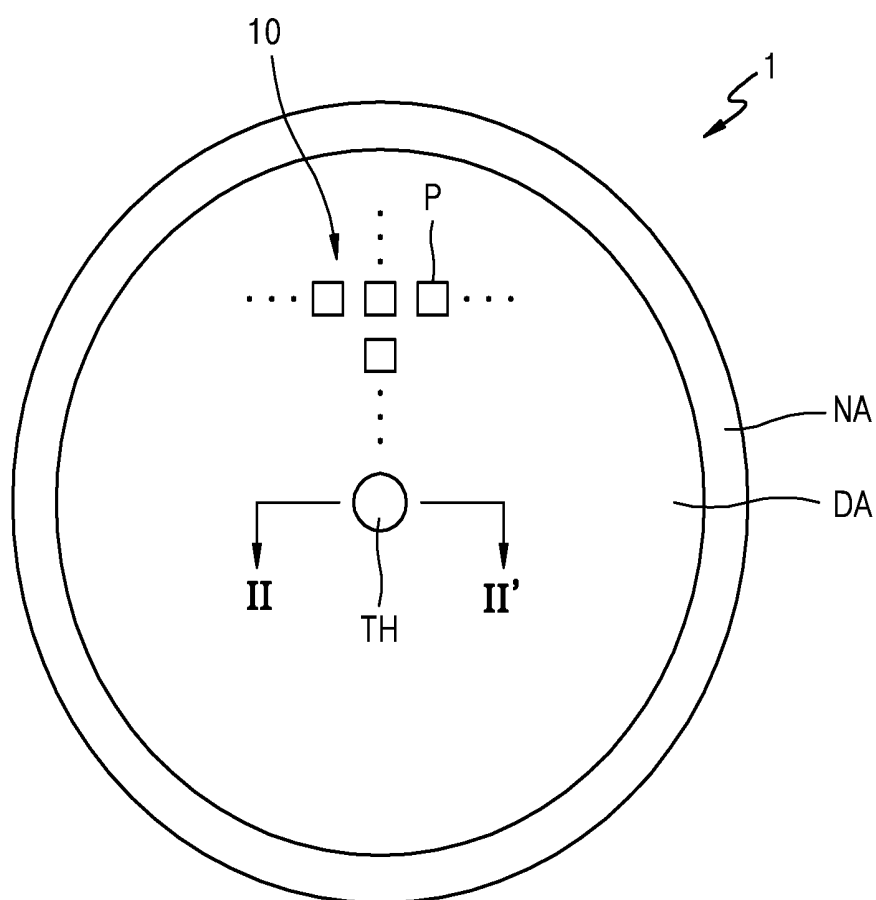


FIG. 2

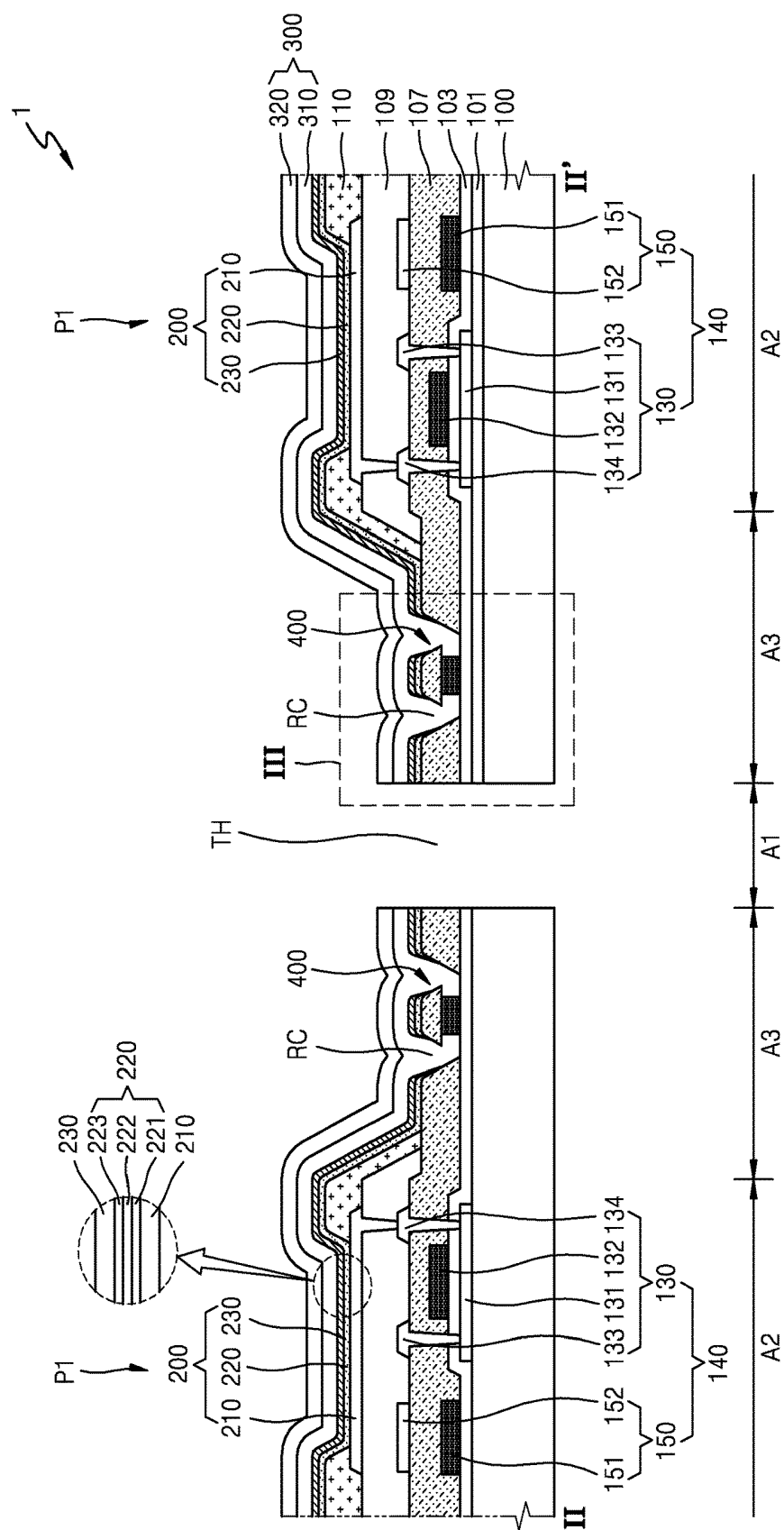


FIG. 4A

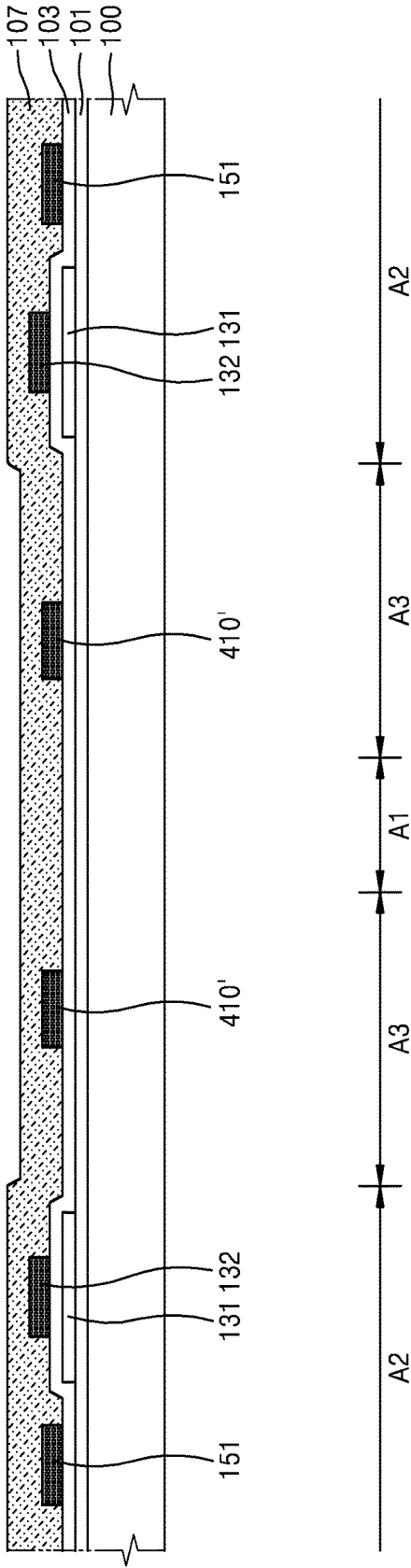


FIG. 4B.

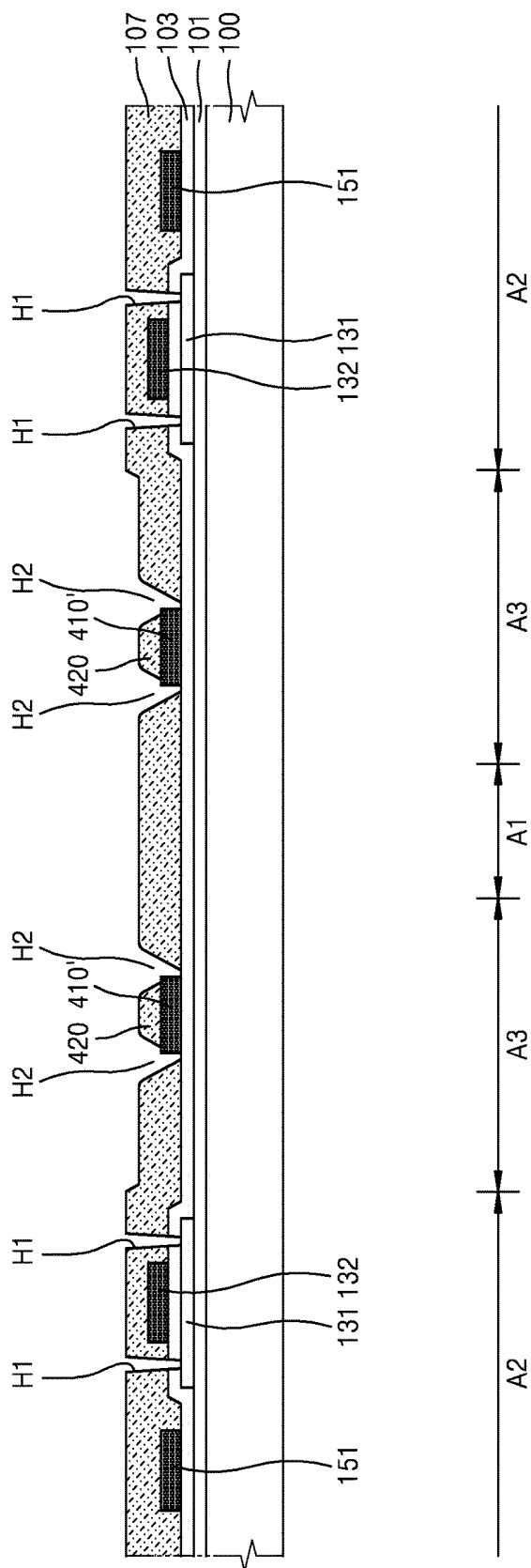


FIG. 4C

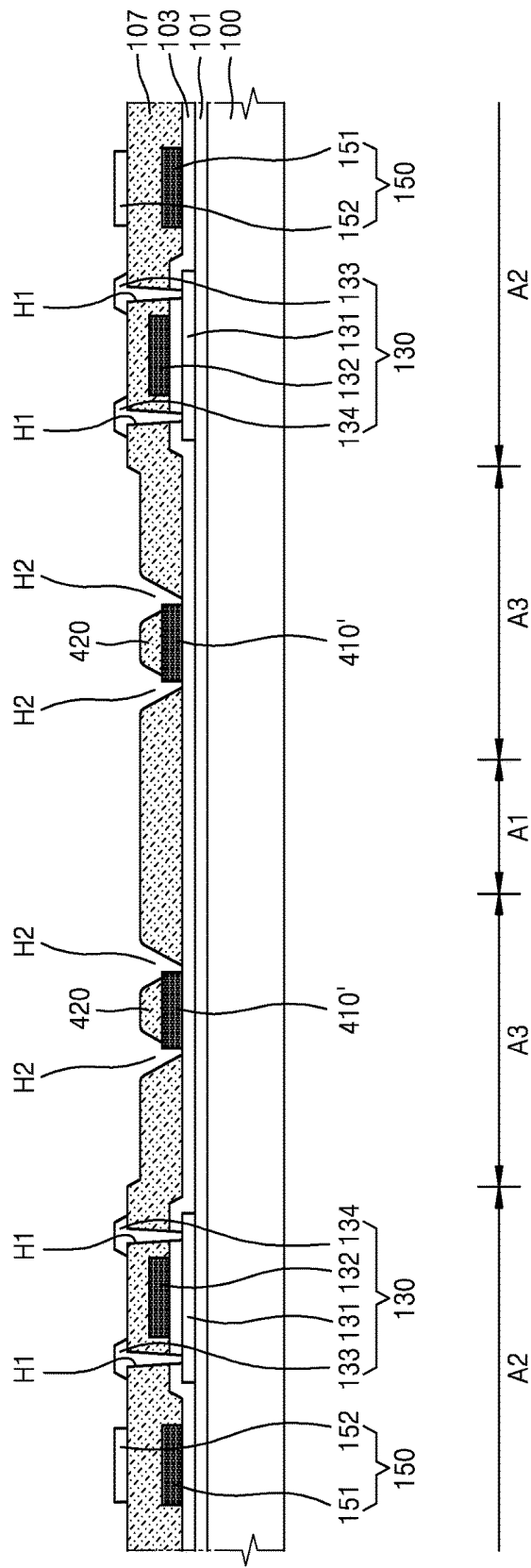


FIG. 4E

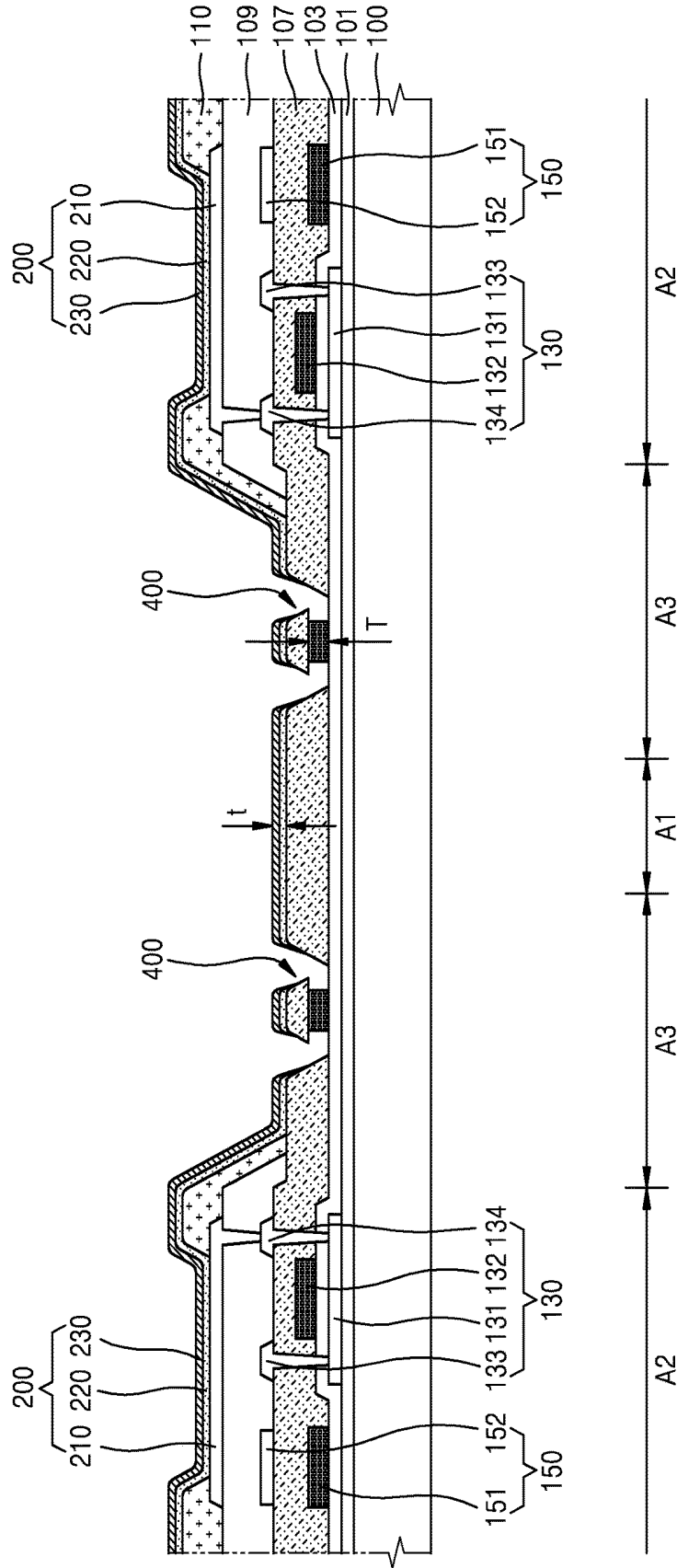


FIG. 4F

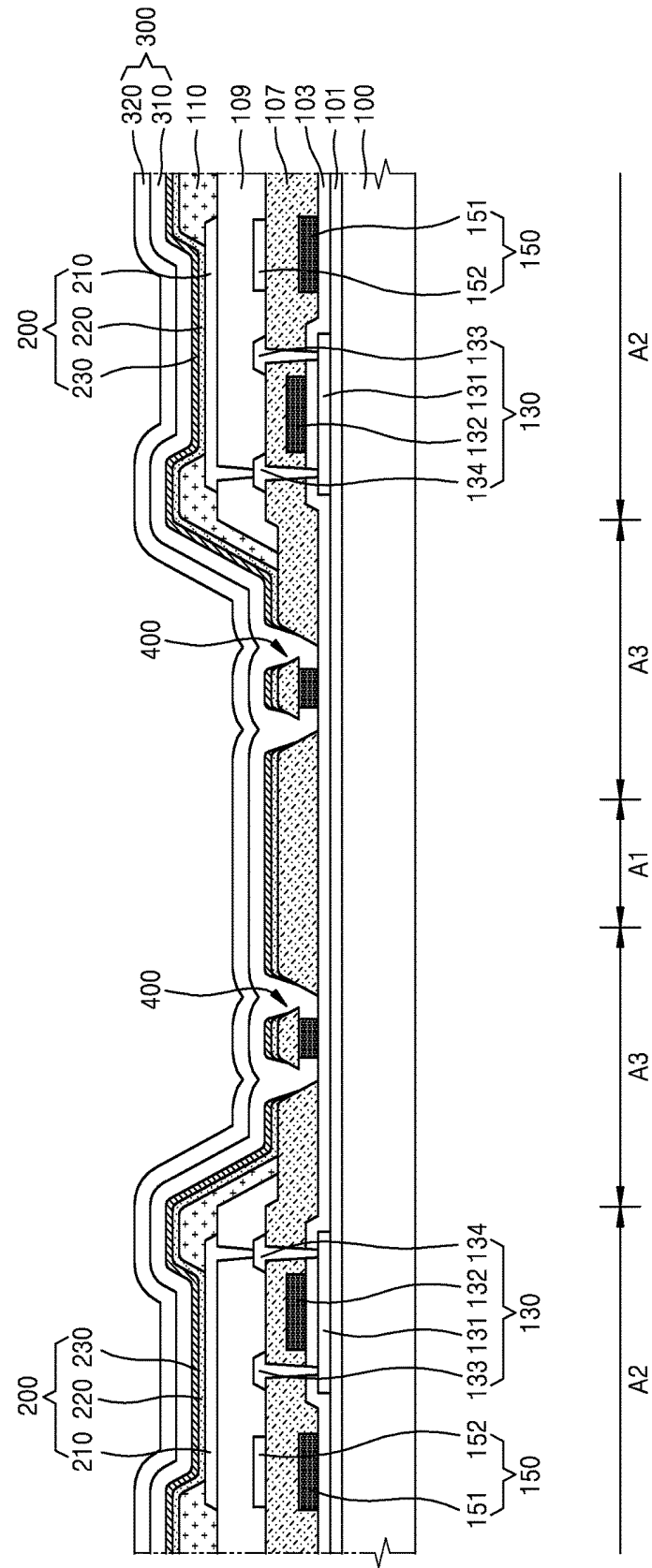


FIG. 5

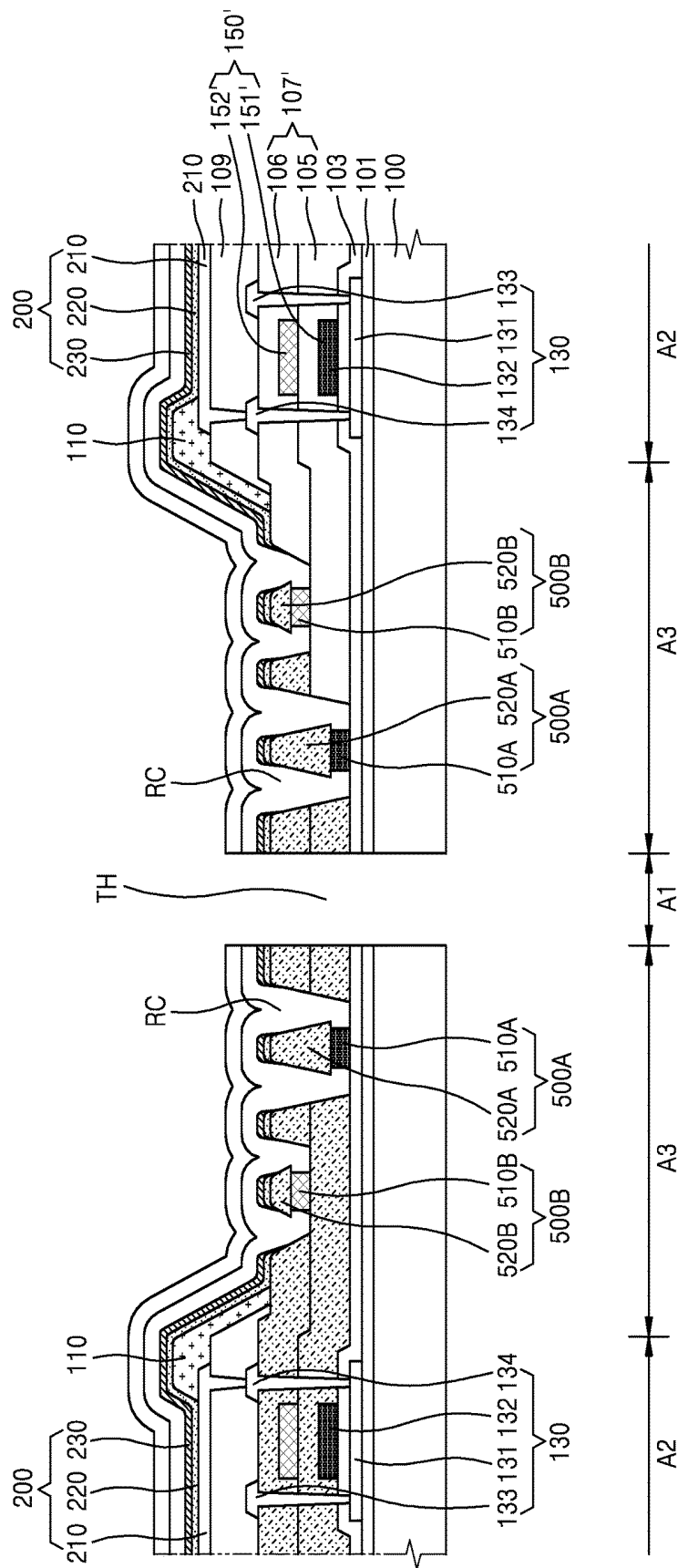


FIG. 6A

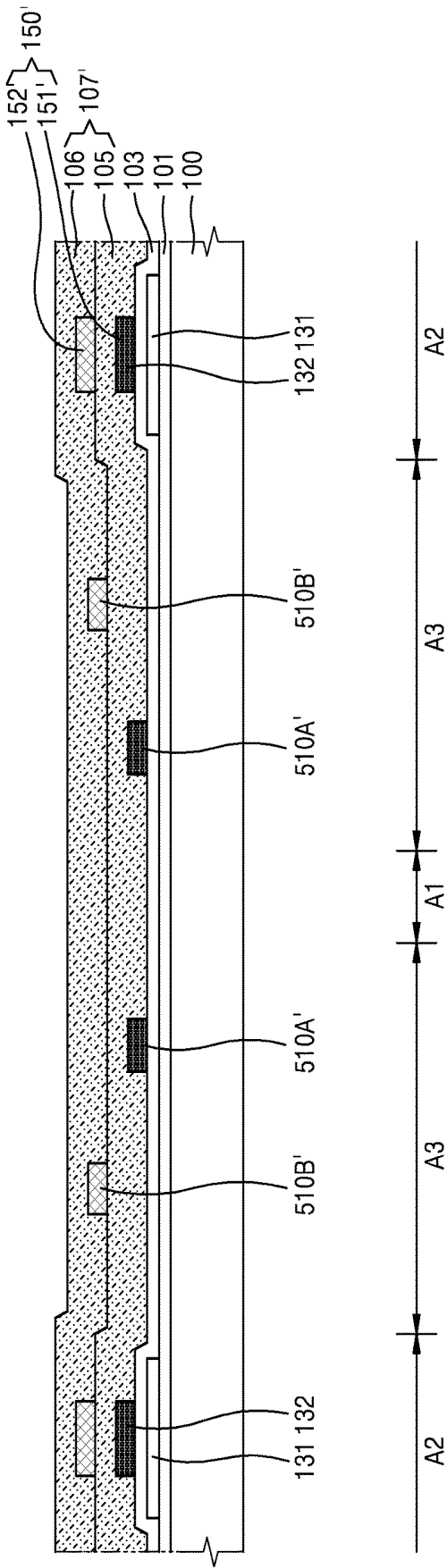


FIG. 6B

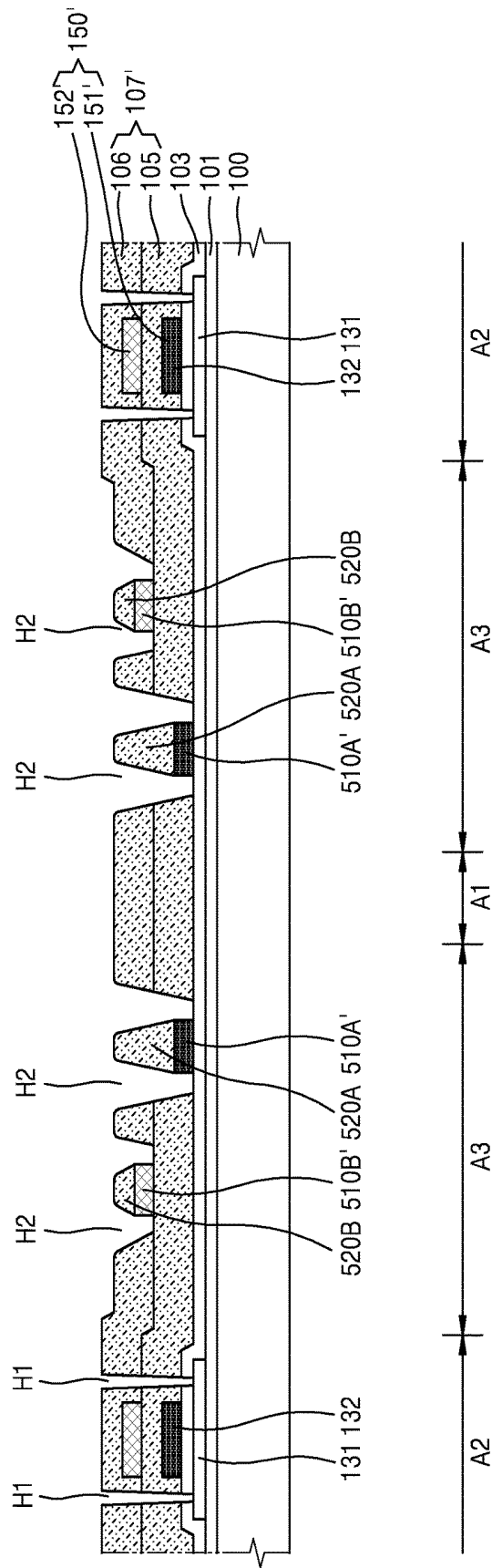


FIG. 6C

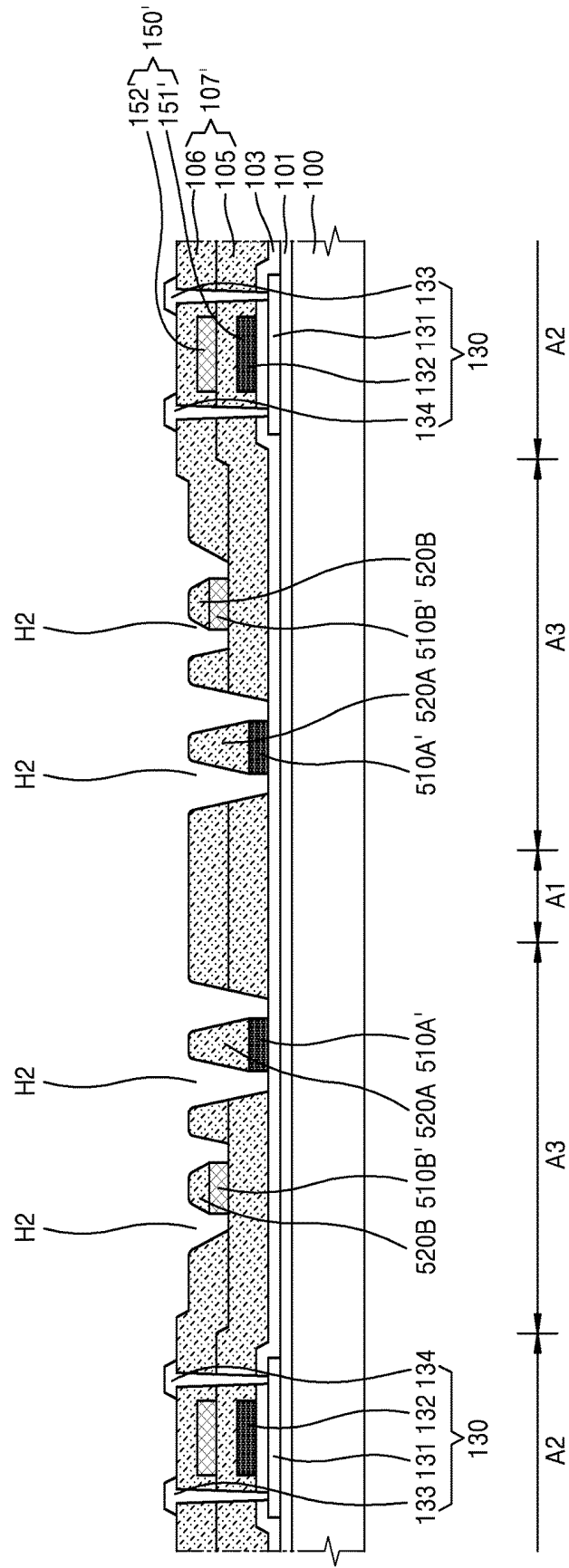


FIG. 6D

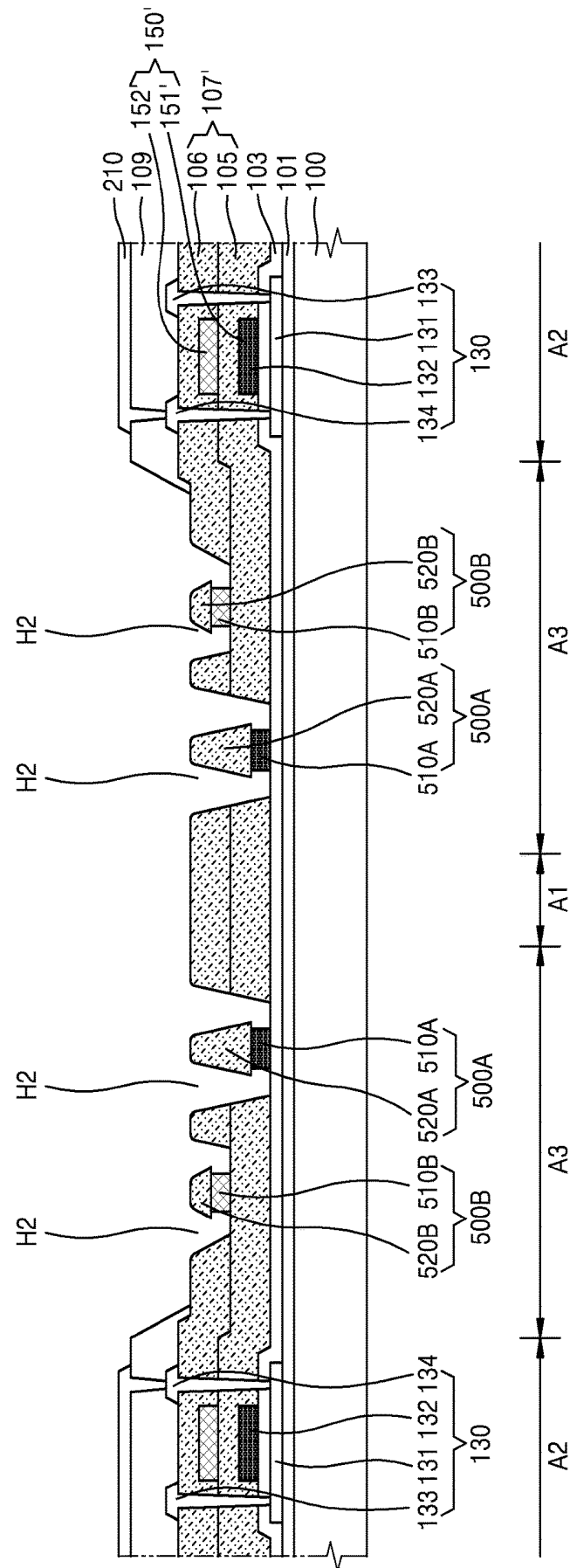


FIG. 6F

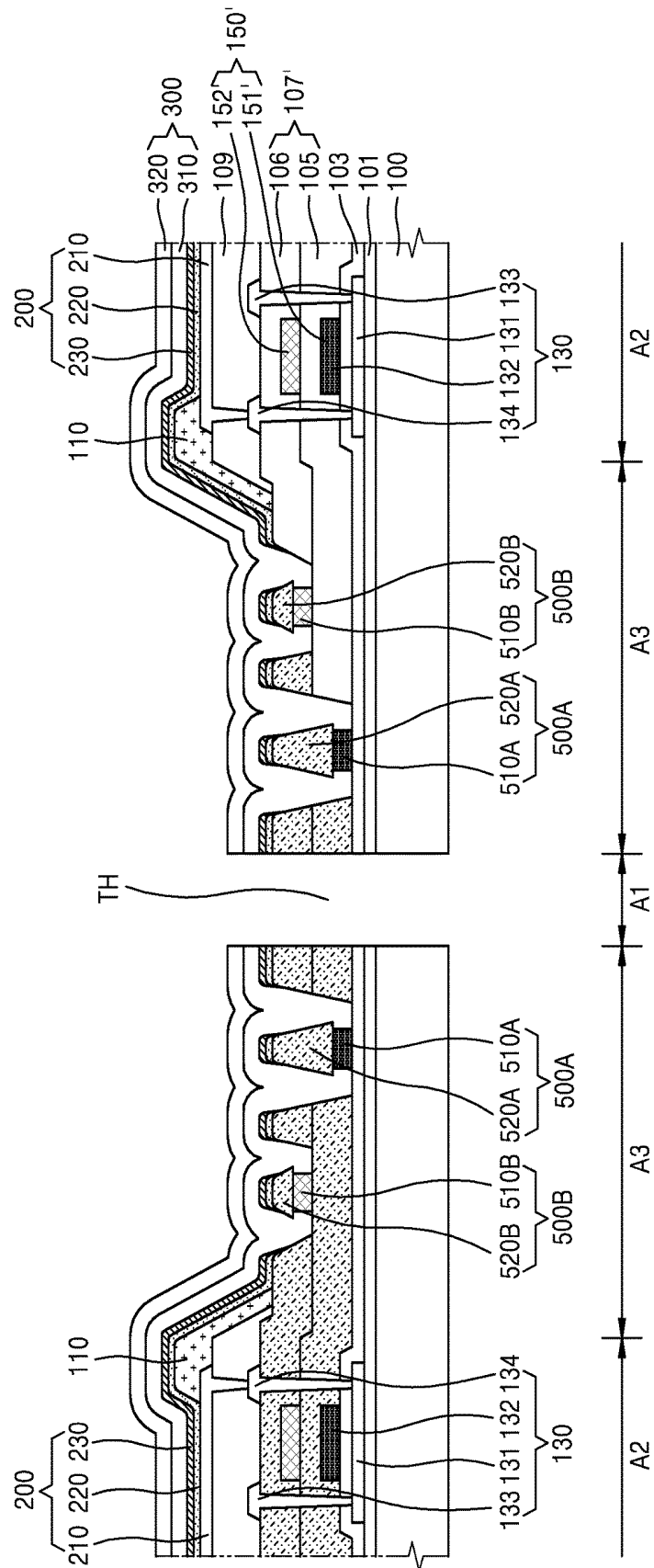


FIG. 7

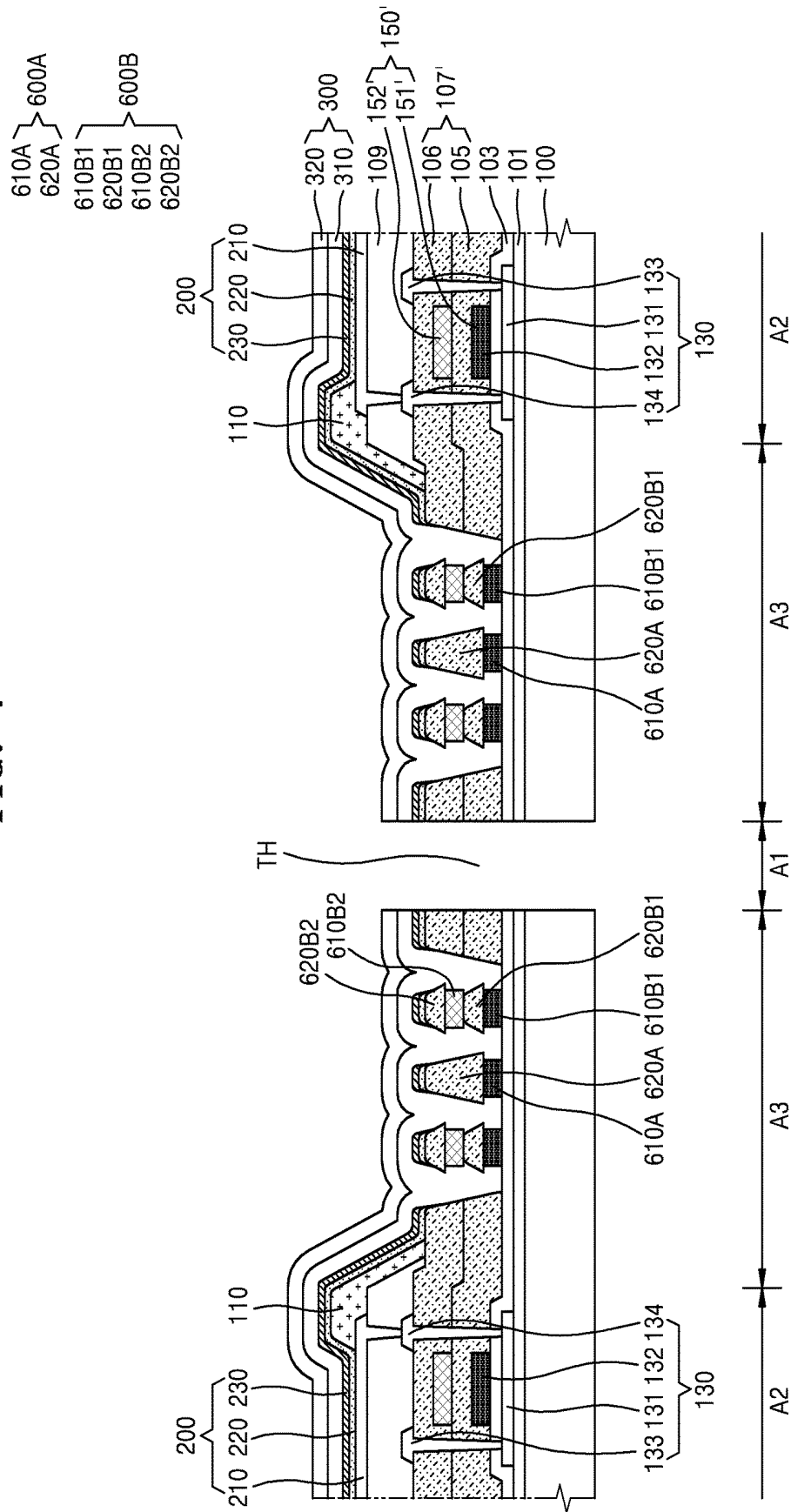


FIG. 8A

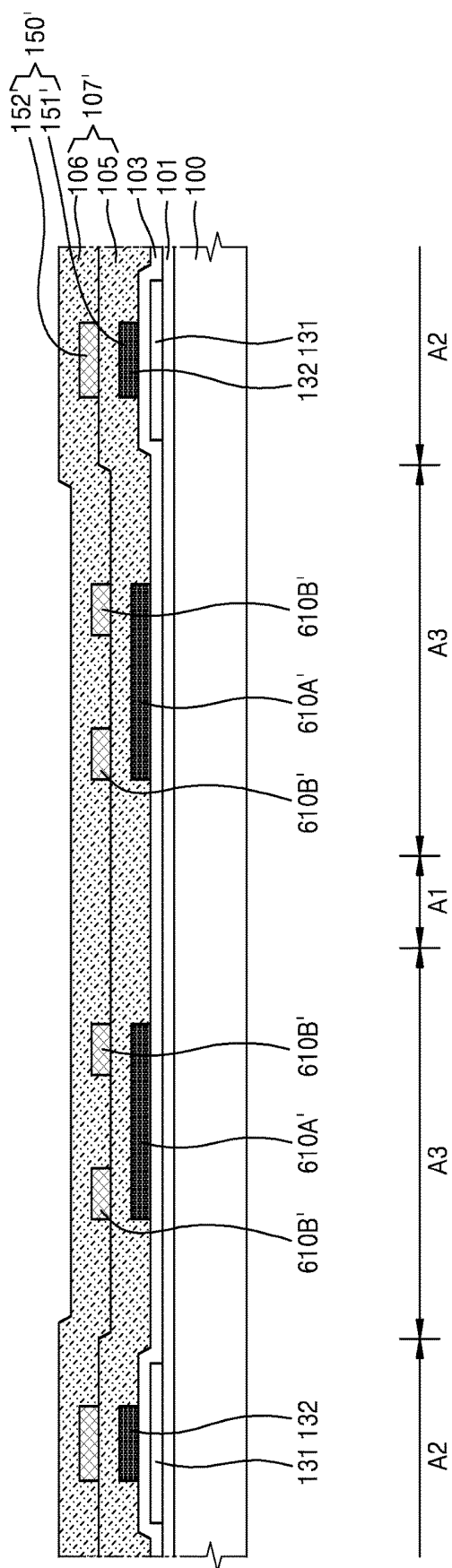


FIG. 8B

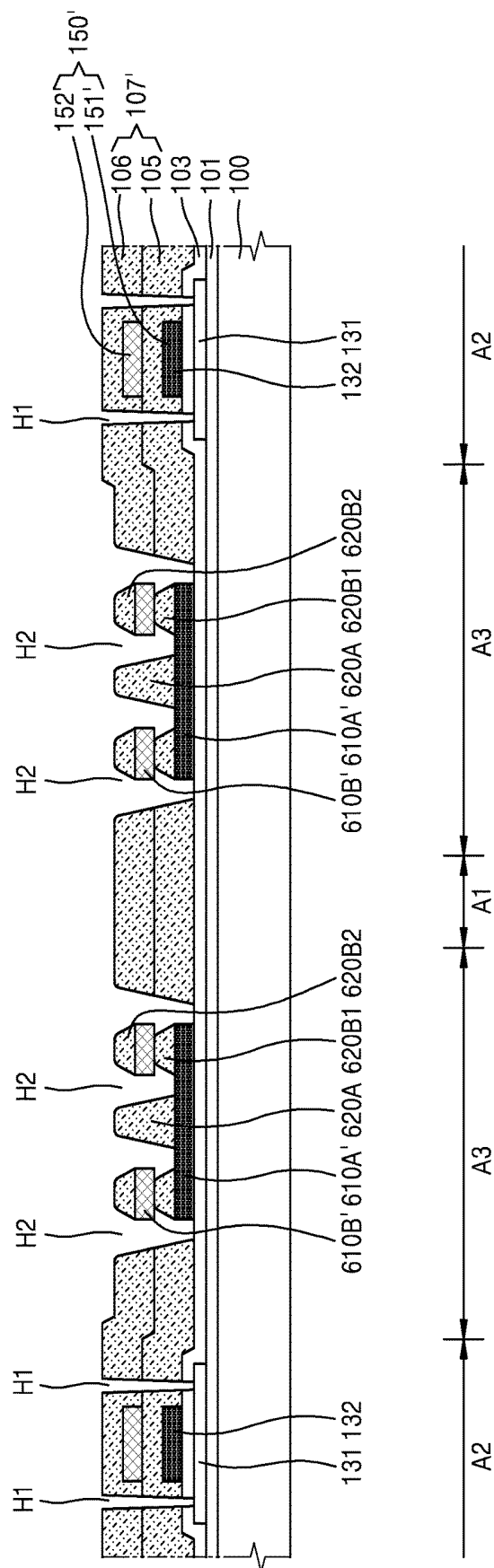


FIG. 10A

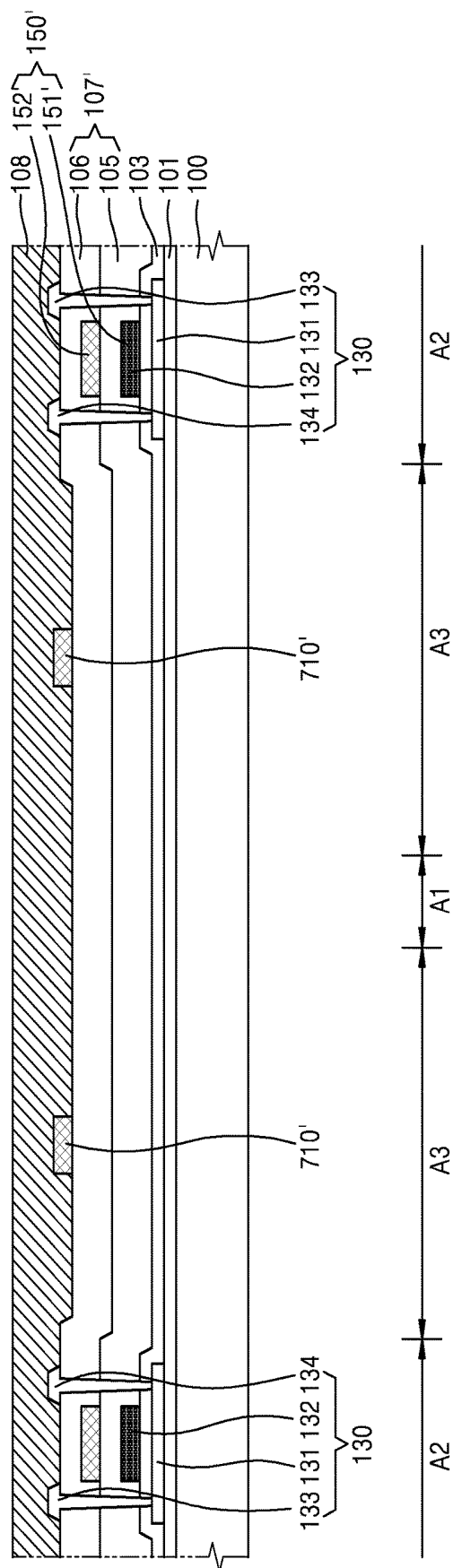


FIG. 10B

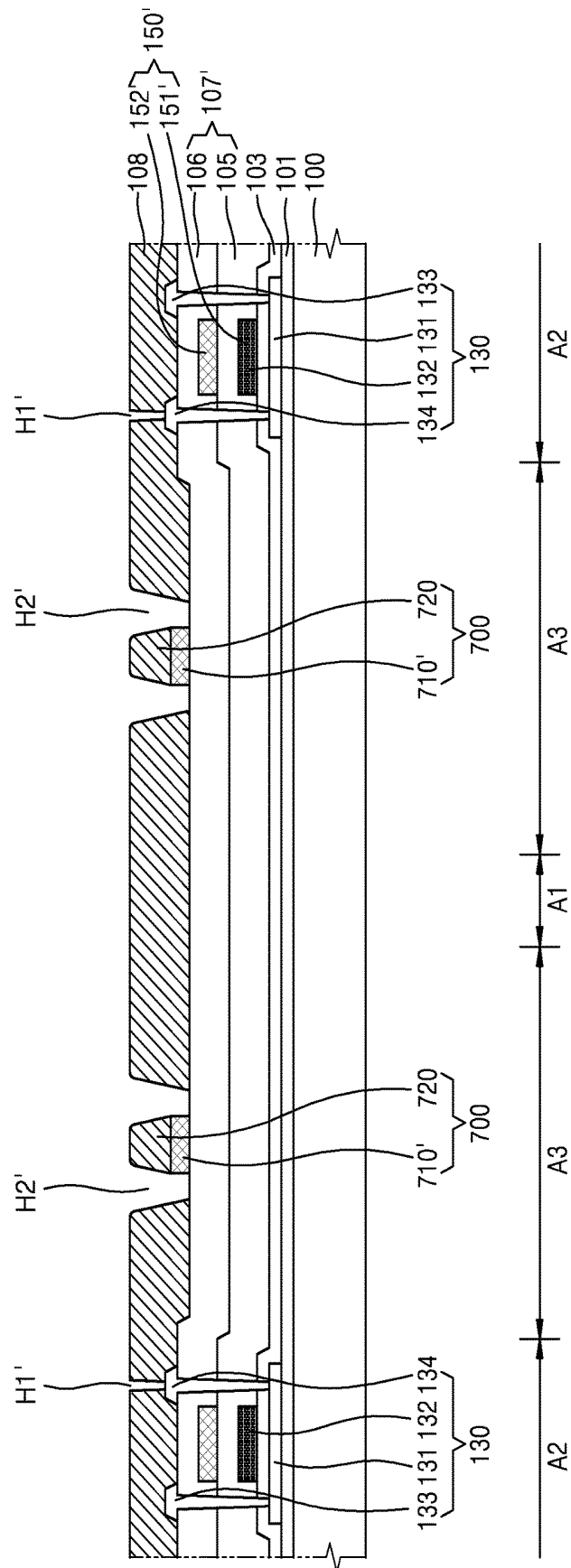


FIG. 10C

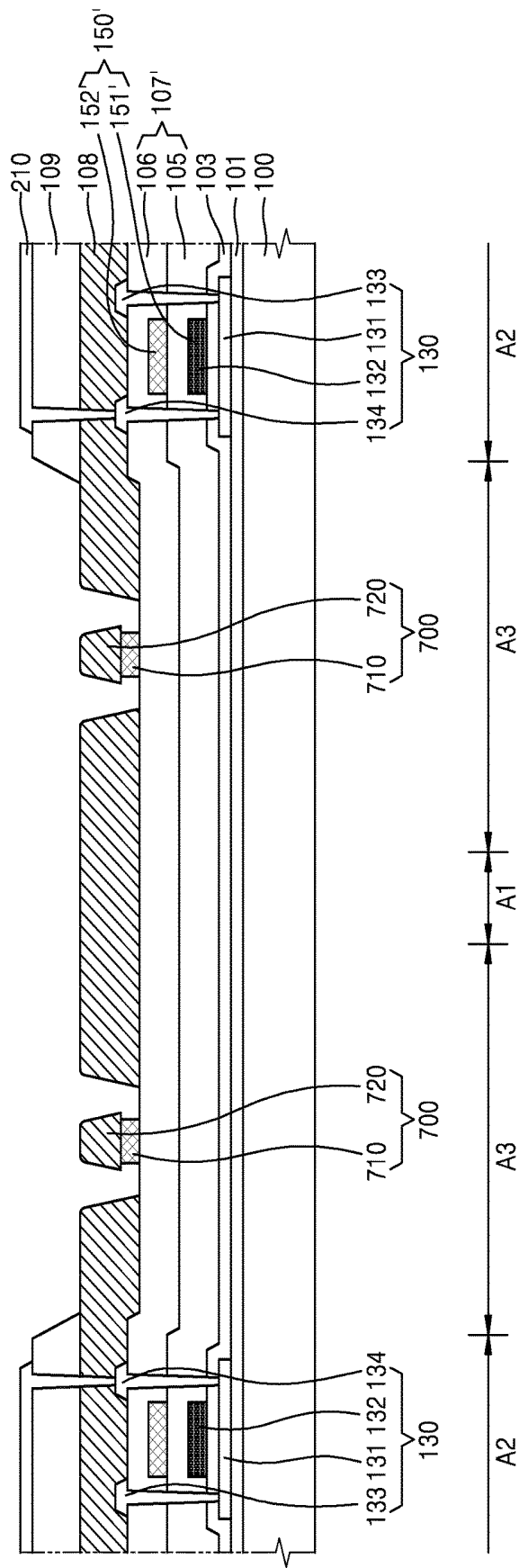


FIG. 10E

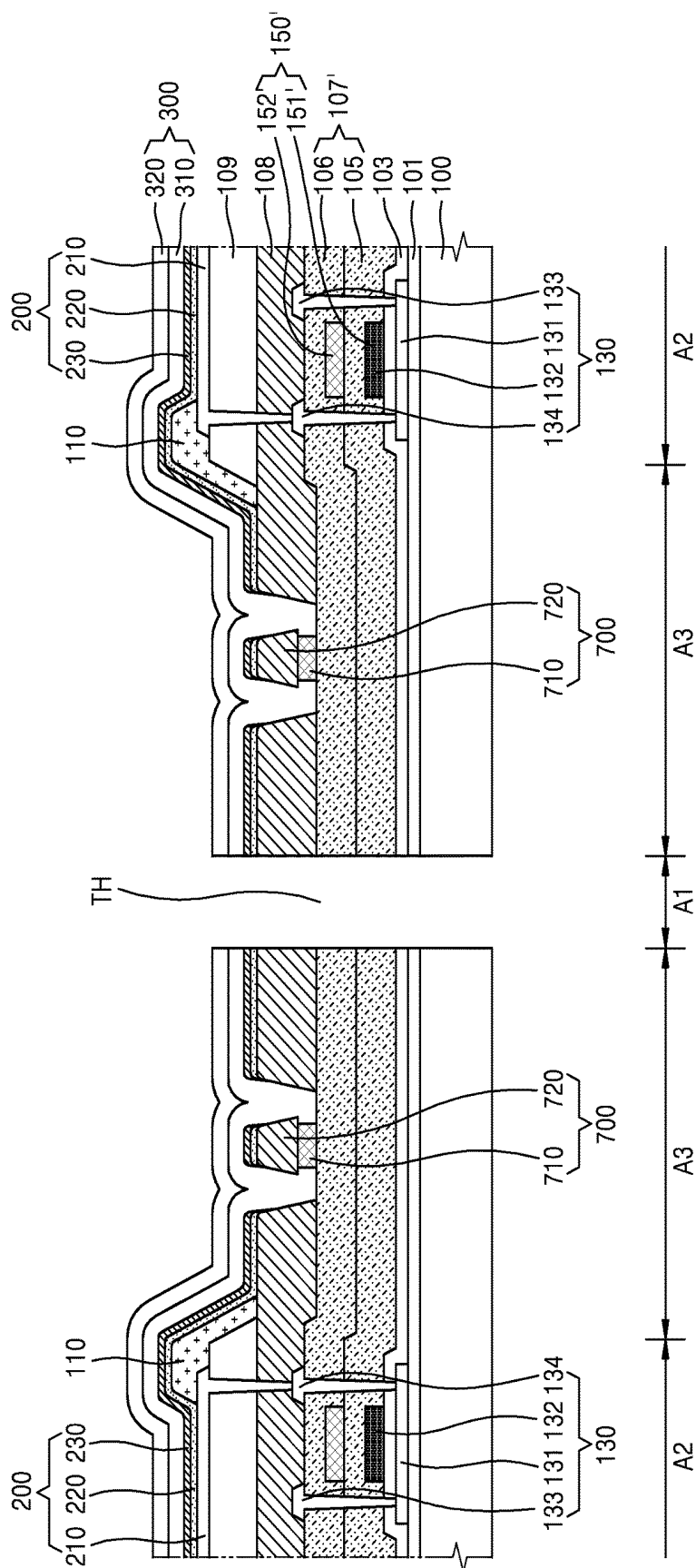


FIG. 11A

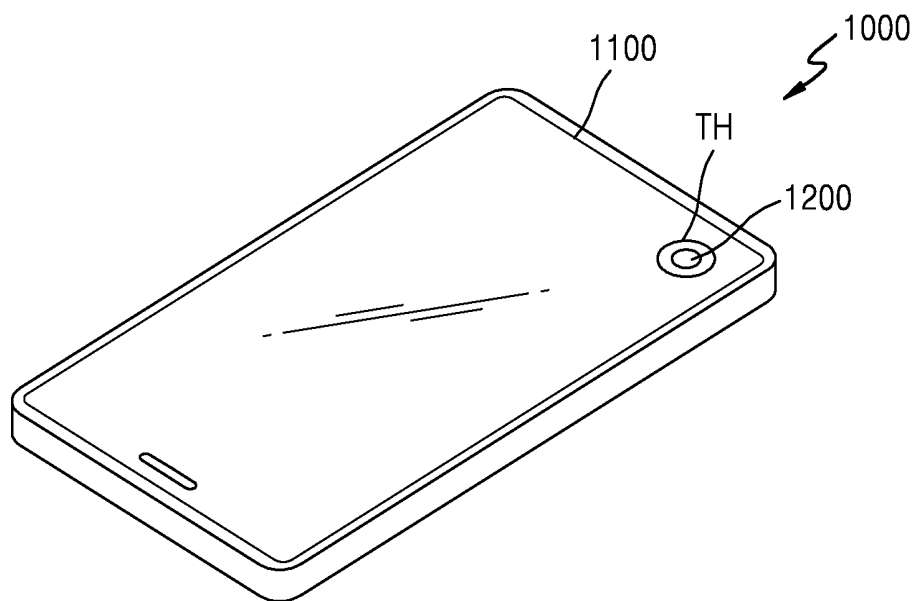


FIG. 11B

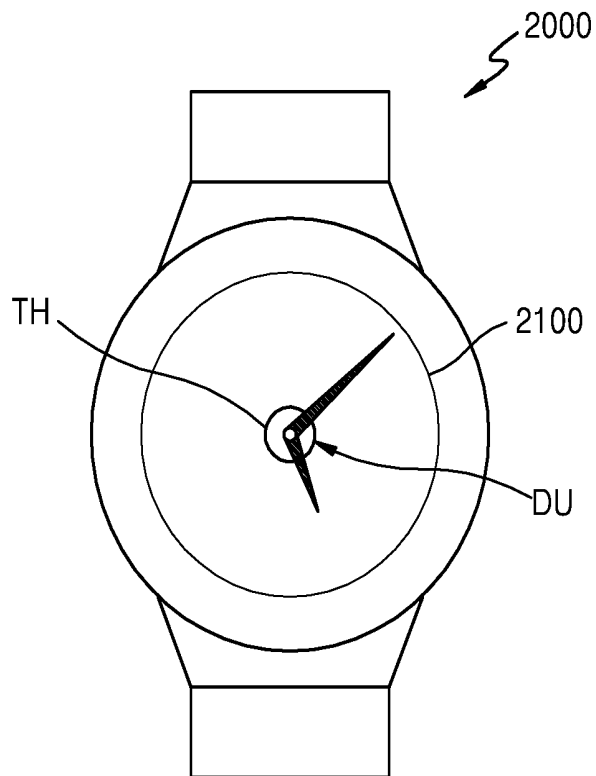
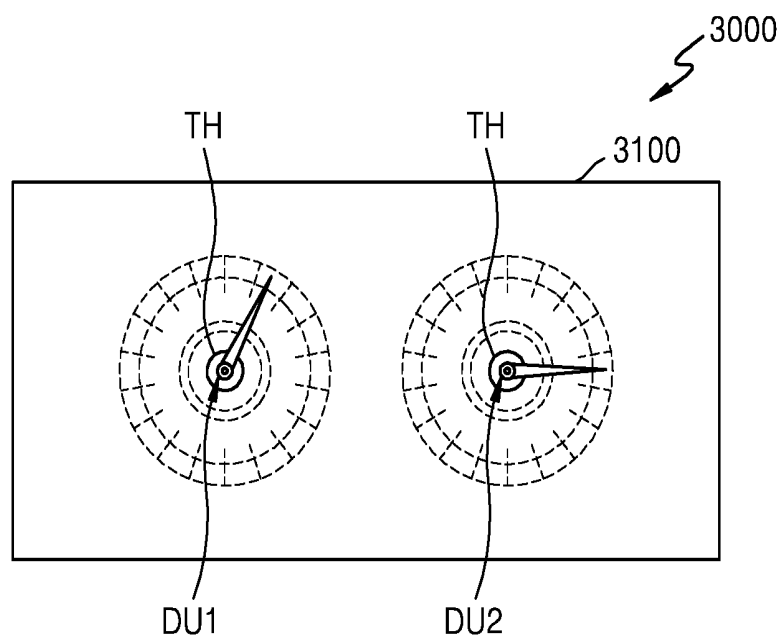


FIG. 11C



**ORGANIC LIGHT-EMITTING DISPLAY AND
METHOD OF MANUFACTURING THE SAME****CROSS-REFERENCE TO RELATED PATENT
APPLICATION(S)**

This application claims priority to and the benefit of Korean Patent Application No. 10-2015-0163351, filed on Nov. 20, 2015, and Korean Patent Application No. 10-2015-0191024, filed on Dec. 31, 2015, in the Korean Intellectual Property Office, the disclosures of which are incorporated herein in their entirety by reference.

BACKGROUND**1. Field**

Aspects of the present invention are related to organic light-emitting displays and methods of manufacturing the same.

2. Description of the Related Art

Use of conventional display devices has become diversified with an increasing range of uses due in part to the relatively small thickness and relatively light weight of the display devices.

In particular, flat panel display devices have been recently studied and manufactured.

Given that display devices may be formed in a flat shape, various suitable methods may be used to design the shape of the display devices. There has also been an increase in the functions that may be applied or linked to the display devices.

SUMMARY

Aspects of one or more embodiments of the present invention are directed toward a display device including a through-hole (e.g., an opening).

Additional aspects will be set forth in part in the description which follows and, in part, will be apparent from the description, or may be learned by practice of the presented embodiments.

According to one or more exemplary embodiments, there is provided an organic light-emitting display including: a substrate; an insulating layer on the substrate, the substrate and the insulating layer having an opening therethrough penetrating; a pixel array on the insulating layer, the pixel array including a plurality of pixels that surround the opening, a first pixel adjacent to the opening from among the plurality of pixels includes a pixel electrode layer, an intermediate layer on the pixel electrode layer, and an opposite electrode layer on the intermediate layer; and a stepped portion on the substrate and adjacent to the opening, the stepped portion having an under-cut step, wherein the intermediate layer including an organic emission layer, and wherein at least one of the intermediate layer and the opposite electrode layer extends toward the opening and is disconnected by the stepped portion.

In an embodiment, the substrate has a first area corresponding to the opening, a second area corresponding to the pixel array, and a third area between the first area and the second area, and the stepped portion is in the third area.

In an embodiment, the insulating layer includes a recess that is concave in a thickness direction of the insulating layer, and the stepped portion is within the recess.

In an embodiment, the stepped portion includes: a first layer within the recess; and a second layer over the first

layer, wherein a width of an upper portion of the first layer is less than a width of a lower portion of the second layer.

In an embodiment, the first layer and the second layer include different materials.

5 In an embodiment, the first layer includes metal.

In an embodiment, the first pixel further includes a pixel circuit electrically connected to the pixel electrode layer, and the pixel circuit includes a thin film transistor

10 (TFT) including a gate electrode, an active layer, a source electrode, and a drain electrode, and the pixel circuit further includes a storage capacitor including a lower electrode and an upper electrode.

In an embodiment, the first layer includes a same material as that of one of the gate electrode, the source electrode, the drain electrode, the lower electrode, and the upper electrode.

In an embodiment, the second layer includes a same material as that of the insulating layer.

20 In an embodiment, a thickness of the first layer is greater than a thickness of the at least one layer.

In an embodiment, the organic light-emitting display further includes a protection layer that covers the at least one layer.

25 In an embodiment, the protection layer includes at least one of an organic layer and an inorganic layer, the organic layer including organic-inorganic composite particles.

According to one or more exemplary embodiments, there is provided a method of manufacturing an organic light-emitting display, the method including: forming an insulating layer on a substrate, the substrate having a first area, a second area, and a third area between the first area and the second area; forming a stepped portion in the third area of the substrate, the stepped portion having an under-cut step; forming a pixel array in the second area of the substrate and including a plurality of pixels; and forming an opening that corresponds to the first area and penetrates through the substrate and the insulating layer, wherein the forming of the pixel array includes: forming a pixel electrode layer; forming an intermediate layer on the pixel electrode layer, the intermediate layer including an organic emission layer; and forming an opposite electrode layer on the intermediate layer, and wherein at least one of the intermediate layer and the opposite electrode layer extends toward the opening and is disconnected by the stepped portion.

45 In an embodiment, the stepped portion includes a first layer metal and a second layer over the first layer, the first layer including metal, and a width of an upper surface of the first layer is less than a width of a lower surface of the second layer.

50 In an embodiment, the forming of the stepped portion includes: forming a preliminary first layer below the insulating layer; partially etching the insulating layer such that a portion of the insulating layer remaining over the preliminary first layer forms the second layer of the stepped portion and that an end of the preliminary first layer is exposed; and forming the first layer by removing the end of the preliminary first layer.

55 In an embodiment, the forming of the first layer and the forming of the pixel electrode layer are performed during a same etching process.

In an embodiment, the method further includes: forming a pixel circuit in the second area of the substrate, the pixel circuit being connected to the pixel electrode layer, the pixel circuit including a thin film transistor (TFT) including a gate electrode, an active layer, a source electrode, and a drain electrode, and the pixel circuit further including a storage capacitor including a lower electrode and an upper electrode.

In an embodiment, the first layer includes a same material as that of one of the gate electrode, the source electrode, the drain electrode, the lower electrode, and the upper electrode.

In an embodiment, a thickness of the first layer is greater than a thickness of the at least one layer.

In an embodiment, the method further includes forming a protection layer that covers a disconnected portion of the at least one layer.

BRIEF DESCRIPTION OF THE DRAWINGS

These and/or other aspects will become apparent and more readily appreciated from the following description of the exemplary embodiments, taken in conjunction with the accompanying drawings in which:

FIG. 1 is a schematic plan view of an organic light-emitting display according to an embodiment of the present invention;

FIG. 2 is a cross-sectional view taken along the line II-II' of FIG. 1, which shows a cross-section of an organic light-emitting display according to an embodiment of the present invention;

FIG. 3 is a cross-sectional view showing the region III extracted from the cross-section of FIG. 2;

FIGS. 4A-4G are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to an embodiment of the present invention;

FIG. 5 is a cross-sectional view of an organic light-emitting display according to another embodiment of the present invention;

FIGS. 6A-6F are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to another embodiment;

FIG. 7 is a cross-sectional view of an organic light-emitting display according to another embodiment of the present invention;

FIGS. 8A-8E are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to another embodiment of the present invention;

FIG. 9 is a cross-sectional view of an organic light-emitting display according to another embodiment of the present invention;

FIGS. 10A-10E are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to another embodiment of the present invention; and

FIGS. 11A-11C illustrate electronic apparatuses including organic light-emitting displays according to embodiments of the present invention.

DETAILED DESCRIPTION

As the invention allows for various suitable changes and numerous embodiments, particular embodiments will be illustrated in the drawings and described in detail in the written description. Hereinafter, effects and features of the present invention and a method for accomplishing them will be described more fully with reference to the accompanying drawings, in which exemplary embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the exemplary embodiments set forth herein.

One or more embodiments of the invention will be described below in more detail with reference to the accompanying drawings. Those components that are the same or are in correspondence are referenced using the same refer-

ence numerals regardless of the figure number, and repeat explanations may not be provided.

Sizes of elements in the drawings may be exaggerated for convenience of explanation. In other words, because sizes and thicknesses of components in the drawings are arbitrarily illustrated for convenience of explanation, the following embodiments are not limited thereto.

FIG. 1 is a schematic plan view of an organic light-emitting display 1 according to an embodiment of the present invention.

Referring to FIG. 1, the organic light-emitting display 1 includes a display area DA and a non-display area NA.

A through-hole (e.g., an opening) TH is in the display area DA, and a pixel array 10 including pixels P that surround the through-hole TH. Each pixel P of the pixel array 10 includes a pixel circuit and an organic light-emitting diode (OLED) electrically connected to the pixel circuit, and provides an image via light emitted by the OLED.

The non-display area NA may surround the display area DA, and a driving unit (e.g., a driver), such as a scan driving unit (e.g., a scan driver) and a data driving unit (e.g., a data driver), for transmitting a preset or predetermined signal to each pixel P of the display area DA.

Although the through-hole TH is in the center of the display area DA of the organic light-emitting display 1 in FIG. 1, embodiments are not limited thereto. The through-hole TH may be surrounded by the pixels P and at any location in the display area DA, but a location of the through-hole TH is not limited thereto.

In FIG. 1, the through-hole TH is circular, and one through-hole TH is formed. However, embodiments are not limited thereto. The through-hole TH may have any of various suitable shapes, for example, a polygon (e.g., a rectangle) and an oval, and the number of through-holes TH formed is not limited to one.

Although the display area DA is circular in FIG. 1, embodiments are not limited thereto. The display area DA may have any of various suitable shapes, for example, a polygon (e.g., a rectangle) and an oval.

FIG. 2 is a cross-sectional view taken along the line II-II' of FIG. 1, which shows a cross-section of the organic light-emitting display 1 according to an embodiment of the present invention. FIG. 3 is a cross-sectional view showing the region III extracted from the cross-section of FIG. 2.

Referring to FIG. 2, a substrate 100 may be formed of a material such as glass, metal, or an organic material. According to an embodiment, the substrate 100 may be formed of a flexible material. For example, the substrate 100 may be formed of a material, such as polyimide (PI) and/or the like, to be easily bent or rolled. This is only an example, and embodiments are not limited thereto.

The substrate 100 includes a first area A1 corresponding to the through-hole TH, a second area A2 in which the plurality of pixels P are positioned, and a third area A3 between the first area A1 and the second area A2.

The first area A1 of the substrate 100 is an area in which the through-hole TH is located, and the through-hole TH penetrates through the first area A1 of substrate 100. The through-hole TH also penetrates through a plurality of layers positioned on/over the substrate 100, for example, insulating layers, namely, a buffer layer 101, a gate insulating layer 103, and an interlayer insulating layer 107, an intermediate layer 220 including an organic emission layer, an opposite electrode layer 230, and a protection layer 300.

The plurality of pixels P is located in the second area A2 of the substrate 100. For convenience of explanation, FIG.

2 illustrates pixels P1 (hereinafter, referred to as first pixels) adjacent to the through-hole TH among the plurality of pixels P.

A buffer layer 101 is disposed on the substrate 100. The buffer layer 101 may reduce or prevent infiltration of a foreign material, moisture, or ambient air below the substrate 100 and may provide a flat surface to the substrate 100. The buffer layer 101 may include an inorganic material, such as oxide, nitride and/or the like.

A pixel circuit 140 including a thin film transistor (TFT) 130 and a storage capacitor 150 is positioned on the buffer layer 101.

The TFT 130 includes an active layer 131, a gate electrode 132, a source electrode 133, and a drain electrode 134. The gate insulating layer 103 is between the active layer 131 and the gate electrode 132, and the interlayer insulating layer 107 is between the gate electrode 132 and the source and drain electrodes 133 and 134. Although a top gate-type transistor in which the gate electrode 132 is disposed above the active layer 131 is illustrated in the present embodiment, embodiments are not limited thereto. According to another embodiment, the TFT 130 may be a bottom gate-type transistor.

The active layer 131 may include amorphous silicon, polycrystalline silicon, and/or the like. According to another embodiment, the active layer 131 may include oxide of at least one of indium (In), gallium (Ga), stannum (Sn), zirconium (Zr), vanadium (V), hafnium (Hf), cadmium (Cd), germanium (Ge), chromium (Cr), titanium (Ti), zinc (Zn), and/or the like.

The gate insulating layer 103 may include an inorganic material including oxide, nitride, and/or the like. For example, the gate insulating layer 103 may include silicon oxide (SiO₂), silicon nitride (SiN_x), silicon oxynitride (SiON), aluminum oxide (Al₂O₃), titanium oxide (TiO₂), tantalum oxide (Ta₂O₅), hafnium oxide (HfO₂), zinc oxide (ZnO₂), and/or the like.

The gate electrode 132 may include a low resistance metal material. For example, the gate electrode 132 may include a conductive material including molybdenum (Mo), aluminum (Al), copper (Cu), titanium (Ti), and/or the like, and may include a single layer or multi-layers including the aforementioned materials.

The interlayer insulating layer 107 may include an inorganic material including oxide, nitride, and/or the like. For example, the interlayer insulating layer 107 may include silicon oxide (SiO₂), silicon nitride (SiN_x), silicon oxynitride (SiON), aluminum oxide (Al₂O₃), titanium oxide (TiO₂), tantalum oxide (Ta₂O₅), hafnium oxide (HfO₂), zinc oxide (ZnO₂), and/or the like.

The source and drain electrodes 133 and 134 may include a conductive material. For example, each of the source and drain electrodes 133 and 134 may include a conductive material including molybdenum (Mo), aluminum (Al), copper (Cu), and/or titanium (Ti), and may include multiple layers or a single layer including the aforementioned materials. According to a non-restrictive embodiment, each of the source and drain electrodes 133 and 134 may have a multi-layer structure of Ti/Al/Ti.

The storage capacitor 150 includes a lower electrode 151 and an upper electrode 152 positioned on different layers with the interlayer insulating layer 107 therebetween. According to an embodiment, the lower electrode 151 may be disposed on the same layer on which the gate electrode 132 is disposed, and the upper electrode 152 may be disposed on the same layer on which the source and drain electrodes 133 and 134 are disposed.

An OLED 200 is electrically connected to the pixel circuit 140 with the planarization insulating layer 109 therebetween. The OLED 200 includes a pixel electrode layer 210, the intermediate layer 220 disposed on the pixel electrode layer 210, and the opposite electrode layer 230 disposed on the intermediate layer 220.

The pixel electrode layer 210 may be a transparent (or semi-transparent) electrode or a reflective electrode. The (semi-)transparent electrode may include indium tin oxide (ITO), indium zinc oxide (IZO), zinc oxide (ZnO), indium oxide (In₂O₃), indium gallium oxide (IGO), aluminum zinc oxide (AZO), and/or the like. The reflective electrode may include a reflective layer including silver (Ag), magnesium (Mg), aluminum (Al), platinum (Pt), palladium (Pd), gold (Au), nickel (Ni), neodymium (Nd), iridium (Ir), chromium (Cr), or a combination thereof, and may further include a layer formed of ITO, IZO, ZnO, In₂O₃, and/or the like on the reflective layer.

In the magnified portion of FIG. 2, the intermediate layer 220 may include an organic emission layer 222, and a first functional layer 221 and a second functional layer 223 respectively disposed above and below the organic emission layer 222.

The first functional layer 221 may include a hole transport layer (HTL) and/or a hole injection layer (HIL), and the second functional layer 223 may include an electron transport layer (ETL) and/or an electron injection layer (EIL). The intermediate layer 220 may selectively include the HTL, the HIL, the ETL, and the EIL according to some embodiments.

The opposite electrode layer 230 may be a reflective electrode or a transparent (or semi-transparent). The reflective electrode may include at least one of Li, Ca, LiF/Ca, LiF/Al, Al, Ag, and Mg. The transparent (or semi-transparent) electrode may include a layer formed of Li, Ca, LiF/Ca, LiF/Al, Al, Mg and/or a compound thereof, and may further include a layer formed of a transparent (or semi-transparent) material, such as ITO, IZO, ZnO, In₂O₃, and/or the like on the afore-mentioned layer.

At least one of the intermediate layer 220 and the opposite electrode layer 230 extends toward the through-hole TH and covers the third area A3 of the substrate 100 as shown in FIG. 2. According to the present embodiment, for convenience of explanation, both the intermediate layer 220 and the opposite electrode layer 230 extend toward the through-hole TH and cover the third area A3.

An interface between layers that constitute the intermediate layer 220 and the opposite electrode layer 230 may serve as a path via which external moisture permeates. When moisture permeates, the OLED 200 may be degraded.

A stepped portion 400 is located in the third area A3 of the substrate 100 and blocks the path via which external moisture permeates.

Referring to FIGS. 2 and 3, the stepped portion 400 is positioned within a recess RC included in the interlayer insulating layer 107. The recess RC is concave in a thickness direction of the interlayer insulating layer 107. The stepped portion 400 includes a first layer 410 and a second layer 420 disposed over the first layer 410, and has an undercut structure in which a width W1 of an upper surface (or upper portion) of the first layer 410 is less than a width W2 of a lower surface (or lower portion) of the second layer 420.

The intermediate layer 220 and the opposite electrode layer 230 are disconnected by the stepped portion 400 having an under-cut step in the third area A3. Because the intermediate layer 220 and the opposite electrode layer 230 are disconnected by the stepped portion 400, even when

moisture permeates along the interface between the layers that constitute the intermediate layer **220** and the opposite electrode layer **230** via the through-hole TH, the moisture may be prevented or substantially prevented from heading toward the OLED **200**.

A thickness T of the first layer **410** may be greater than a thickness t of at least one of the intermediate layer **220** and the opposite electrode layer **230**. In this case, the disconnection of the intermediate layer **220** and the opposite electrode layer **230** may be more effectively induced.

The first layer **1** may include metal. For example, the first layer **410** may be disposed on the same layer on which the gate electrode **132** of the TFT **130** and/or the lower electrode **151** of the storage capacitor **150** are disposed, and may include the same or substantially the same material as that used to form the gate electrode **132** of the TFT **130** and/or the lower electrode **151** of the storage capacitor **150**.

The second layer **420** may include the same or substantially the same material as that used to form the interlayer insulating layer **107**.

The protection layer **300** is disposed on the substrate **100** and covers at least one of the intermediate layer **220** and the opposite electrode layer **230** disconnected by the stepped portion **400**.

The protection layer **300** includes at least one of an inorganic layer **310** and an organic layer **320** including organic-inorganic composite particles.

The inorganic layer **310** may include silicon oxide (SiO₂), silicon nitride (SiN_x), silicon oxynitride (SiON), aluminum oxide (Al₂O₃), titanium oxide (TiO₂), tantalum oxide (Ta₂O₅), hafnium oxide (HfO₂), zinc oxide (ZnO₂), and/or the like.

The organic layer **320** including the organic-inorganic composite particles is an organic layer in which organic-inorganic composite particles are formed within a free volume. The organic layer **320** including the organic-inorganic composite particles may be formed, for example, by sequential vapor infiltration (SVI).

For example, an organic layer including acryl, polyolefin, polyimide (PI), polyurethane, polyethylene terephthalate (PET), polyethylene naphthalate (PEN), polybutylene terephthalate (PBT), polyethersulfone (PES), and/or the like is formed.

Thereafter, an inorganic material is infiltrated into the free volume existing within the organic layer to thereby form the organic layer **320** including the organic-inorganic composite particles. Inorganic particles infiltrated into the free volume are chemically combined with a chemical reactor of an organic material used to form the organic layer to thereby form the organic-inorganic composite particles. Barrier characteristics of blocking moisture via the organic-inorganic composite particles within the free volume may improve.

FIGS. 4A-4G are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to an embodiment of the present invention. FIGS. 4A-4G correspond to a method of manufacturing the organic light-emitting display **1** shown in FIGS. 2 and 3.

Referring to FIG. 4A, the buffer layer **101** is formed on the substrate **100** including the first through third areas A1, A2, and A3, and a semiconductor layer is formed on the buffer layer **101** and then patterned to thereby form the active layer **131** in the second area A2. The buffer layer **101** may include an inorganic material such as oxide, nitride, and/or the like.

The active layer **131** may include amorphous silicon, polycrystalline silicon, and/or the like. According to another

embodiment, the active layer **131** may include oxide of at least one selected from the group consisting of indium (In), gallium (Ga), stannum (Sn), zirconium (Zr), vanadium (V), hafnium (Hf), cadmium (Cd), germanium (Ge), chromium (Cr), titanium (Ti), and zinc (Zn).

Thereafter, the gate insulating layer **103** is formed on the substrate **100**, and a metal layer is formed and then patterned to thereby form the gate electrode **132** of the TFT **130** in the second area A2, the lower electrode **151** of the storage capacitor **150** in the second area A2, and a preliminary first layer **410'** in the third area A3.

The gate insulating layer **103** may include an inorganic material including oxide or nitride, and materials thereof are as described above.

The gate electrode **132**, the lower electrode **151**, and the preliminary first layer **410'** are positioned on the same layer and include the same or substantially the same material. The preliminary first layer **410'**, the gate electrode **132**, and the lower electrode **151** may include a low resistance metal material. For example, the preliminary first layer **410'**, the gate electrode **132**, and the lower electrode **151** may include a conductive material including molybdenum (Mo), aluminum (Al), copper (Cu), titanium (Ti), and/or the like, and may include a single layer or multi-layers including the aforementioned materials.

Next, the interlayer insulating layer **107** is formed on the substrate **100**. The interlayer insulating layer **107** may include an inorganic material including oxide or nitride, and materials thereof are as described above.

Referring to FIG. 4B, holes are formed in the interlayer insulating layer **107** via etching, for example. Via wet or dry etching, first holes H1 and second holes H2 are formed in the interlayer insulating layer **107**. The first holes H1 are located in the second area A2, and the second holes H2 are located in the third area A3.

Some regions of the active layer **131** in the second area A2, for example, a source region and a drain region, are exposed via the first holes H1. An end of the preliminary first layer **410'** in the third area A3 are exposed via the second holes H2.

During the etching process for forming the second holes H2, a portion of the interlayer insulating layer **107** remains on the preliminary first layer **410'**. The portion of the interlayer insulating layer **107** remaining on the preliminary first layer **410'** corresponds to the second layer **420** of the stepped portion **400** described above with reference to FIG. 2.

Referring to FIG. 4C, a metal layer is formed on the interlayer insulating layer **107** and then patterned to thereby form the source and drain electrodes **133** and **134** of the TFT **130** and the upper electrode **152** of the storage capacitor **150**.

The source and drain electrodes **133** and **134** are connected to the some regions of the active layer **131**, for example, the source region and the drain region, respectively, which are exposed via the first holes H1. The upper electrode **152** overlaps the lower electrode **151** with the interlayer insulating layer **107** therebetween.

The source and drain electrodes **133** and **134** and the upper electrode **152** are positioned on the same layer and include the same or substantially the same material. For example, the source and drain electrodes **133** and **134** and the upper electrode **152** may include a conductive material. For example, the source and drain electrodes **133** and **134** and the upper electrode **152** may include a conductive material including molybdenum (Mo), aluminum (Al), copper (Cu), titanium (Ti), and/or the like, and may include multiple layers or a single layer including the aforemen-

tioned materials. According to a non-restrictive embodiment, each of the source and drain electrodes **133** and **134** may have a multi-layer structure of Ti/Al/Ti.

Referring to FIG. 4D, the planarization insulating layer **109** is formed in the second area **A2** of the substrate **100**.

The planarization insulating layer **109** may include a commercial polymer such as polymethyl methacrylate (PMMA) or polystyrene (PS), a polymer derivative having a phenol-based group, an acryl-based polymer, an imide-based polymer, an acryl ether-based polymer, an amide-based polymer, a fluorine-based polymer, a p-xylene-based polymer, a vinyl alcohol-based polymer, a blend thereof, and/or the like.

Thereafter, a conductive layer is formed on the planarization insulating layer **109** and then patterned to form the pixel electrode layer **210**. The conductive layer may be patterned via wet etching to form the pixel electrode layer **210**.

During the formation of the pixel electrode layer **210**, the stepped portion **400** is also formed. While the end of the preliminary first layer **410'** exposed via the second holes **H2** are being etched (under-cut etched) by an etchant used during the etching process for forming the pixel electrode layer **210**, the first layer **410** is formed. The first layer **410** may be narrower than the second layer **420**. Via undercut etching, the first layer **410** and the second layer **420** previously formed over the first layer **410** form the stepped portion **400**. The upper surface (or upper portion) of the first layer **410** is narrower than the lower surface (or lower portion) of the second layer **420**.

Referring to FIG. 4E, the pixel defining layer **110** exposing the pixel electrode layer **210** is formed on the substrate **100**, and the intermediate layer **220** and the opposite electrode layer **230** are formed on the pixel defining layer **110**.

At least one of the intermediate layer **220** and the opposite electrode layer **230** covers an entire upper surface of the substrate **100**. For convenience of explanation, a case where both the intermediate layer **220** and the opposite electrode layer **230** cover the entire upper surface of the substrate **100** will now be described.

The intermediate layer **220** includes an organic emission layer. The intermediate layer **220** may further include at least one of an HTL, an HIL, an ETL, and an EIL according to embodiments. According to a non-restrictive embodiment, the intermediate layer **220** may be formed via a deposition process using a fine metal mask (FMM), and the opposite electrode layer **230** may be formed via vacuum deposition and/or the like.

During the formation of the intermediate layer **220** and the opposite electrode layer **230**, the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the stepped portion **400** having an under-cut structure. As described above, the disconnection may be effectively induced by forming the first layer **410** of the stepped portion **400** to have a greater thickness than at least one of the intermediate layer **220** and the opposite electrode layer **230**.

Referring to FIG. 4F, the protection layer **300** is formed on the substrate **100**. The protection layer **300** includes at least one of the organic layer **320** including organic-inorganic composite particles and the inorganic layer **310**.

The inorganic layer **310** may include silicon oxide (SiO_2), silicon nitride (SiNx), silicon oxynitride (SiON), aluminum oxide (Al_2O_3), titanium oxide (TiO_2), tantalum oxide (Ta_2O_5), hafnium oxide (HfO_2), zinc oxide (ZnO_2), and/or the like, and may be formed by chemical vapor deposition.

The organic layer **320** including the organic-inorganic composite particles may be formed by SVI.

First, an organic layer including an organic material such as polymer is formed on the substrate **100**. For example, the organic layer may include acryl, polyolefin, polyimide (PI), polyurethane, polyethylene terephthalate (PET), polyethylene naphthalate (PEN), polybutylene terephthalate (PBT), polyethersulfone (PES), and/or the like.

Then, an inorganic material is infiltrated into a free volume existing within the organic layer by SVI. The inorganic material may include Al, Si, and/or the like. The inorganic material infiltrated into the free volume is chemically combined with a chemical reactor of the organic layer to thereby form the organic-inorganic composite particles. The organic layer including the organic-inorganic composite particles has barrier characteristics of blocking moisture.

Referring to FIG. 4G, the through-hole (e.g., opening) TH penetrating through the first area **A1** of the substrate **100** is formed by using laser and/or the like.

In the magnified portion of FIG. 4G, the layers that constitute the intermediate layer **220** and the opposite electrode layer **230** are exposed via a process of forming the through-hole TH. External moisture H_2O may head toward the OLED **200** via the interface between the layers exposed via the through-hole TH.

However, according to an embodiment, because the layers that constitute the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the stepped portion **400**, moisture infiltrated along the interface between the layers may be prevented or substantially prevented from heading toward the OLED **200**.

FIG. 5 is a cross-sectional view of an organic light-emitting display according to another embodiment of the present invention.

The organic light-emitting display of FIG. 5 is different from the organic light-emitting display **1** described above with reference to FIG. 2 in terms of a storage capacitor **150'**, an interlayer insulating layer **107'**, and stepped portions **400A** and **400B**. Differences therebetween will now be focused on and further described.

The storage capacitor **150'** in the second area **A2** of the substrate **100** may overlap the TFT **130**.

According to an embodiment, a lower electrode **151'** of the storage capacitor **150'** may be disposed on the same layer on which the gate electrode **132** of the TFT **130** is disposed, and may include the same or substantially the same material as that used to form the gate electrode **132**. For example, the gate electrode **132** of the TFT **130** may perform a function of the lower electrode **151'** of the storage capacitor **150'**.

According to an embodiment, an upper electrode **152'** of the storage capacitor **150'** may be disposed between the gate electrode **132** of the TFT **130** and the source and drain electrodes **133** and **134**.

The upper electrode **152'** may include a conductive material including molybdenum (Mo), aluminum (Al), copper (Cu), titanium (Ti), and/or the like, and may include multiple layers or a single layer including the aforementioned materials.

According to a non-restrictive embodiment, the upper electrode **152'** may have a multi-layer structure of Mo/Al/Mo.

The interlayer insulating layer **107'** may include a first interlayer insulating layer **105** between the lower electrode **151'** and the upper electrode **152'** of the storage capacitor **150'**, and a second interlayer insulating layer **106** between the upper electrode **152'** of the storage capacitor **150'** and the source and drain electrodes **133** and **134** of the TFT **130**.

The first and second interlayer insulating layers **105** and **106** may include an inorganic material. The first and second

interlayer insulating layers **105** and **106** may include oxide or nitride. For example, the first and second interlayer insulating layers **105** and **106** may include silicon oxide (SiO_2), silicon nitride (SiN_x), silicon oxynitride (SiON), aluminum oxide (Al_2O_3), titanium oxide (TiO_2), tantalum oxide (Ta_2O_5), hafnium oxide (HfO_2), zinc oxide (ZnO_2), and/or the like.

A recess RC included in the interlayer insulating layer **107'** is located in the third area **A3** of the substrate **100**, and the plurality of stepped portions **500A** and **500B** having a undercut structure are included. For convenience of explanation, one of the plurality of stepped portions **500A** and **500B** is referred to as a first stepped portion **500A**, and the other is referred to as a second stepped portion **500B**.

The first stepped portion **500A** includes a first layer **510A** and a second layer **520A** disposed over the first layer **510A**, and has an undercut structure in which an upper surface (or upper portion) of the first layer **510A** is narrower than a lower surface (or lower portion) of the second layer **520A**.

During the formation of the intermediate layer **220** and the opposite electrode layer **230**, the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the first stepped portion **500A** having an under-cut step. The first layer **510A** of the first stepped portion **500A** may be formed to have a greater thickness than at least one of the intermediate layer **220** and the opposite electrode layer **230**, and thus the disconnection of the intermediate layer **220** and the opposite electrode layer **230** may be effectively induced.

The first layer **510A** of the first stepped portion **500A** may include metal. For example, the first layer **510A** may be disposed on the same layer on which the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'** are disposed, and may include the same or substantially the same material as that used to form the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'**.

The second layer **520A** of the first stepped portion **500A** may include the same material as that used to form the interlayer insulating layer **107'**. For example, the second layer **520A** may be formed as a double layer including the same or substantially the same material as that used to form the first and second interlayer insulating layers **105** and **106**.

The second stepped portion **500B** includes a first layer **5106** and a second layer **520B** disposed over the first layer **5106**, and has an undercut structure in which an upper surface (or upper portion) of the first layer **5106** is narrower than a lower surface (or lower portion) of the second layer **520B**.

During the formation of the intermediate layer **220** and the opposite electrode layer **230**, the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the second stepped portion **500B** having an under-cut step. The first layer **5106** of the second stepped portion **500B** may be formed to have a greater thickness than at least one of the intermediate layer **220** and the opposite electrode layer **230**, and thus the disconnection of the intermediate layer **220** and the opposite electrode layer **230** may be effectively induced.

The first layer **5106** of the second stepped portion **500B** may include metal. For example, the first layer **5106** may be disposed on the same layer on which the upper electrode **152'** of the storage capacitor **150'** is disposed, and may include the same or substantially the same material as that used to form the upper electrode **152'** of the storage capacitor **150'**.

The second layer **520B** of the second stepped portion **500B** may include the same or substantially the same material as that used to form the second interlayer insulating layer **106**.

FIGS. **6A-6F** are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to another embodiment of the present invention. FIGS. **6A-7F** correspond to a method of manufacturing the organic light-emitting display described above with reference to FIG. **5**.

Referring to FIG. **6A**, the buffer layer **101** is formed on the substrate **100** including the first through third areas **A1**, **A2**, and **A3**, and a semiconductor layer is formed on the buffer layer **101** and then patterned to thereby form the active layer **131** in the second area **A2**. Materials used to form the buffer layer **101** and the active layer **131** are as described above.

Thereafter, the gate insulating layer **103** is formed on the substrate **100**, and a metal layer is formed and then patterned to thereby form the gate electrode **132** of the TFT **130** in the second area **A2**, the lower electrode **151'** of the storage capacitor **150'** in the second area **A2**, and a preliminary first layer **510A'** (hereinafter, referred to as a first preliminary first layer) in the third area **A3**.

Next, the first interlayer insulating layer **105** is formed on the substrate **100**, and a metal layer is formed and then patterned to thereby form the upper electrode **152'** of the storage capacitor **150'** in the second area **A2** and a preliminary first layer **5106'** (hereinafter, referred to as a second preliminary first layer) in the third area **A3**.

The first preliminary first layer **510A'** is disposed on the same layer on which the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'** are disposed, and includes the same or substantially the same material as that used to form the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'**. The second preliminary first layer **5106'** is disposed on the same layer on which the upper electrode **152'** of the storage capacitor **150'** is disposed, and includes the same or substantially the same material as that used to form the upper electrode **152'** of the storage capacitor **150'**.

The second interlayer insulating layer **106** is formed on the substrate **100** to cover the first preliminary first layer **510A'** and the second preliminary first layer **510B'**.

Referring to FIG. **6B**, holes penetrating through the interlayer insulating layer **107'** are formed via etching. For example, first holes **H1** and second holes **H2** penetrating through the first and second interlayer insulating layers **105** and **106** are formed via wet or dry etching. The first holes **H1** are located in the second area **A2**, and the second holes **H2** are located in the third area **A3**.

Some regions of the active layer **131** in the second area **A2**, for example, a source region and a drain region, are exposed via the first holes **H1**. Ends of the first and second preliminary first layers **510A'** and **510B'** in the third area **A3** are exposed via the second holes **H2**.

Referring to FIG. **6C**, a metal layer is formed on the interlayer insulating layer **107'** and then patterned to thereby form the source and drain electrodes **133** and **134** of the TFT **130**. The source and drain electrodes **133** and **134** are respectively connected to the some regions of the active layer **131**, for example, the source region and the drain region, exposed via the first holes **H1** (see, e.g., FIG. **6B**).

Referring to FIG. **6D**, the planarization insulating layer **109** is formed in the second area **A2** of the substrate **100**, and

a conductive layer is formed on the planarization insulating layer **109** and then patterned to form the pixel electrode layer **210**.

During the formation of the pixel electrode layer **210**, the first and second stepped portions **500A** and **500B** are also formed. For example, while the ends of the first and second preliminary first layer **510A'** and **510B'** exposed via the second holes **H2** are being etched (under-cut etched) by an etchant used during the etching process for forming the pixel electrode layer **210**, the first layers **510A** and **510B**, which are narrower than the second layers **520A** and **520B**, are formed.

The first layers **510A** and **510B** and the second layers **520A** and **520B** form the first and second stepped portions **500A** and **500B**, respectively. The upper surfaces (or upper portions) of the first layers **510A** and **510B** are narrower than the lower surfaces (or lower portions) of the second layers **520A** and **520B**.

Referring to FIG. 6E, the pixel defining layer **110** exposing the pixel electrode layer **210** is formed on the substrate **100**, and the intermediate layer **220** and the opposite electrode layer **230** are formed on the pixel defining layer **110**. At least one of the intermediate layer **220** and the opposite electrode layer **230** covers an entire upper surface of the substrate **10**, but is disconnected by the first and second stepped portions **500A** and **500B**.

Referring to FIG. 6F, the protection layer **300** is formed on the substrate **100**, and then the through-hole (e.g., the opening) **TH** penetrating through the first area **A1** of the substrate **100** is formed.

The protection layer **300** includes at least one of the organic layer **320** including organic-inorganic composite particles and the inorganic layer **310**, and materials thereof are as described above.

FIG. 7 is a cross-sectional view of an organic light-emitting display according to another embodiment of the present invention.

The organic light-emitting display of FIG. 7 is different from the organic light-emitting display of FIG. 5 in terms of the structure of a stepped portion. Differences therebetween will now be focused on and further described.

A first stepped portion **600A** includes a first layer **610A** and a second layer **620A** disposed over the first layer **610A**, and has an undercut structure in which an upper surface (or upper portion) of the first layer **610A** is narrower than a lower surface (or lower portion) of the second layer **620A**.

During the formation of the intermediate layer **220** and the opposite electrode layer **230**, the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the first stepped portion **600A** having an under-cut step. The first layer **610A** of the first stepped portion **600A** may be formed to have a greater thickness than at least one of the intermediate layer **220** and the opposite electrode layer **230**, and thus the disconnection of the intermediate layer **220** and the opposite electrode layer **230** may be effectively induced.

The first layer **610A** of the first stepped portion **600A** may include metal. For example, the first layer **610A** may be disposed on the same layer on which the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'** are disposed, and may include the same or substantially the same material as that used to form the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'**.

The second layer **620A** of the first stepped portion **600A** may include the same or substantially the same material as that used to form the interlayer insulating layer **107'**. For example, the second layer **620A** may be formed as a double

layer including the same or substantially the same material as that used to form the first and second interlayer insulating layers **105** and **106**.

The second stepped portion **600B** may include first layers **610B1** and **610B2** and second layers **620B1** and **620B2S** that are alternately stacked one on another. Upper surfaces (or upper portions) of the first layers **610B1** and **610B2** are narrower than lower surfaces (or lower portions) of the second layers **620B1** and **620B2** directly above the first layers **610B1** and **610B2**, respectively.

During the formation of the intermediate layer **220** and the opposite electrode layer **230**, the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the second stepped portion **600B** having an under-cut step. The first layer **610B1**, the second layer **620B1**, and the first layer **610B2** disposed below the second layer **620B2** corresponding to an uppermost layer of the second stepped portion **600B** may be thicker than at least one of the intermediate layer **220** and the opposite electrode layer **230**, and thus the disconnection of the intermediate layer **220** and the opposite electrode layer **230** may be effectively induced.

The first layers **610B1** and **610B2** of the second stepped portion **600B** may include metal. For example, the first layer **610B1** may be disposed on the same layer on which the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'** are disposed, and may include the same or substantially the same material as that used to form the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'**. The first layer **610B2** may be disposed on the same layer on which the upper electrode **152'** of the storage capacitor **150'** is disposed, and may include the same or substantially the same material as that used to form the upper electrode **152'** of the storage capacitor **150'**.

The second layers **620B1** and **620B2** of the second stepped portion **600B** may include an insulative material used to form the insulating layer **107'**. For example, the second layer **620B1** may be disposed on the same layer on which the first interlayer insulating layer **105** is disposed, and may include the same or substantially the same material as that used to form the first interlayer insulating layer **105**. The second layer **620B2** may be disposed on the same layer on which the second interlayer insulating layer **106** is disposed, and may include the same or substantially the same material as that used to form the second interlayer insulating layer **106**.

FIGS. 8A-8E are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to another embodiment of the present invention. FIGS. 8A-8E correspond to a method of manufacturing the organic light-emitting display described above with reference to FIG. 7.

Referring to FIG. 8A, the buffer layer **101** is formed on the substrate **100** including the first through third areas **A1**, **A2**, and **A3**, and a semiconductor layer is formed on the buffer layer **101** and then patterned to thereby form the active layer **131** in the second area **A2**. Materials used to form the buffer layer **101** and the active layer **131** are as described above.

Thereafter, the gate insulating layer **103** is formed on the substrate **100**, and a metal layer is formed and then patterned to thereby form the gate electrode **132** of the TFT **130** in the second area **A2**, the lower electrode **151'** of the storage capacitor **150'** in the second area **A2**, and a preliminary first layer **610A'** (hereinafter, referred to as a first preliminary first layer) in the third area **A3**.

Next, the first interlayer insulating layer **105** is formed on the substrate **100**, and a metal layer is formed and then patterned to thereby form the upper electrode **152'** of the storage capacitor **150'** in the second area **A2** and a preliminary first layer **610B'** (hereinafter, referred to as a second preliminary first layer) in the third area **A3**.

The first preliminary first layer **610A'** is disposed on the same layer on which the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'** are disposed, and includes the same or substantially the same material as that used to form the gate electrode **132** of the TFT **130** and the lower electrode **151'** of the storage capacitor **150'**. The second preliminary first layer **610B'** is disposed on the same layer on which the upper electrode **152'** of the storage capacitor **150'** is disposed, and includes the same or substantially the same material as that used to form the upper electrode **152'** of the storage capacitor **150'**. The second preliminary first layer **610B'** may overlap a portion of the first preliminary first layer **610A'**.

The second interlayer insulating layer **106** is formed on the substrate **100** to cover the first preliminary first layer **610A'** and the second preliminary first layer **610B'**.

Referring to FIG. **8B**, holes penetrating through the interlayer insulating layer **107'** are formed via etching. For example, first holes **H1** and second holes **H2** penetrating through the first and second interlayer insulating layers **105** and **106** are formed via wet or dry etching. The first holes **H1** are located in the second area **A2**, and the second holes **H2** are located in the third area **A3**.

Some regions of the active layer **131** in the second area **A2**, for example, a source region and a drain region, are exposed via the first holes **H1**. Ends of the first and second preliminary first layers **610A'** and **610B'** in the third area **A3** are exposed via the second holes **H2**, and insulating layers remain on the first preliminary first layer **610A'** and the second preliminary first layer **610B'**. The remaining insulating layers form the second layers **620A**, **620B1**, and **620B2** of the first and second stepped portions **600A** and **600B**, which will be described later.

Referring to FIG. **8C**, a metal layer is formed on the interlayer insulating layer **107'** and then patterned to thereby form the source and drain electrodes **133** and **134** of the TFT **130**. The source and drain electrodes **133** and **134** are respectively connected to the some regions of the active layer **131**, for example, the source region and the drain region, exposed via the first holes **H1** (see, e.g., FIG. **8B**).

Then, the planarization insulating layer **109** is formed in the second area **A2** of the substrate **100**, and a conductive layer is formed on the planarization insulating layer **109** and then patterned to form the pixel electrode layer **210**.

During the formation of the pixel electrode layer **210**, the first and second stepped portions **600A** and **600B** are also formed. For example, while the ends of the first and second preliminary first layer **610A'** and **610B'** exposed via the second holes **H2** are being etched (under-cut etched) by an etchant used during the etching process for forming the pixel electrode layer **210**, the first layers **610A**, **610B1**, and **610B2**, which are narrower than the second layers **620A**, **620B1**, and **620B2**, are formed.

The first layers **610A**, **610B1**, and **610B2** and the second layers **620A**, **620B1**, and **620B2** having different widths via undercut etching form the first and second stepped portions **600A** and **600B**. An upper surface (or upper portion) of each of the first layers **610A**, **610B1**, and **610B2** is narrower than a lower surface (or lower portion) of each of the second layers **620A**, **620B1**, and **620B2**.

Referring to FIG. **8D**, the pixel defining layer **110** exposing the pixel electrode layer **210** is formed on the substrate **100**, and the intermediate layer **220** and the opposite electrode layer **230** are formed on the pixel defining layer **110**. At least one of the intermediate layer **220** and the opposite electrode layer **230** covers an entire upper surface of the substrate **10**, but is disconnected by the first and second stepped portions **600A** and **600B**.

Referring to FIG. **8E**, the protection layer **300** is formed on the substrate **100**, and then the through-hole (e.g., the opening) **TH** penetrating through the first area **A1** of the substrate **100** is formed.

The protection layer **300** includes at least one of the organic layer **320** including organic-inorganic composite particles and the inorganic layer **310**, and materials thereof are as described above.

FIG. **9** is a cross-sectional view of an organic light-emitting display according to another embodiment of the present invention.

The organic light-emitting display of FIG. **9** is different from the organic light-emitting display of FIG. **5** in terms of the structure of a stepped portion. Differences therebetween will now be focused on and further described.

A stepped portion **700** includes a first layer **710** and a second layer **720** disposed over the first layer **710**, and has an undercut structure in which an upper surface (or upper portion) of the first layer **710** is narrower than a lower surface (or lower portion) of the second layer **720**.

During the formation of the intermediate layer **220** and the opposite electrode layer **230**, the intermediate layer **220** and the opposite electrode layer **230** are disconnected by the stepped portion **700** having an under-cut step. The first layer **710** of the stepped portion **700** may be formed to have a greater thickness than at least one of the intermediate layer **220** and the opposite electrode layer **230**, and thus the disconnection of the intermediate layer **220** and the opposite electrode layer **230** may be effectively induced.

The first layer **710** of the stepped portion **700** may include metal. For example, the first layer **710** may be disposed on the same layer on which the source and drain electrodes **133** and **134** of the TFT **130** are disposed, and may include the same or substantially the same material as that used to form the source and drain electrodes **133** and **134** of the TFT **130**.

The second layer **720** of the stepped portion **700** may include the same or substantially the same material as that used to form a protective insulating layer **108** positioned on the interlayer insulating layer **107'**. The protective insulating layer **108** may include an inorganic material including oxide or nitride.

FIGS. **10A-10E** are cross-sectional views illustrating a method of manufacturing an organic light-emitting display, according to another embodiment of the present invention. FIGS. **10A-10E** correspond to a method of manufacturing the organic light-emitting display described above with reference to FIG. **9**.

Referring to FIG. **10A**, the buffer layer **101** is formed on the substrate **100** including the first through third areas **A1**, **A2**, and **A3**, and the TFT **130** and the storage capacitor **150'** are formed in the second area **A2**. A detailed method of forming the TFT **130** and the storage capacitor **150'** is substantially as described above with reference to FIGS. **6A-6F** and FIGS. **8A-8E**.

A preliminary first layer **710'** is formed together with the source and drain electrodes **133** and **134** of the TFT **130** during the same process. The preliminary first layer **710'** is formed on the same layer on which the source and drain electrodes **133** and **134** are formed, and includes the same or

substantially the same material as that used to form the source and drain electrodes **133** and **134**.

The protective insulating layer **108** is formed on the source electrode **133**, the drain electrode **134**, and the preliminary first layer **710'**.

Referring to FIG. **10B**, holes penetrating through the protective insulating layer **108** are formed via etching. For example, first holes **H1'** and second holes **H2'** penetrating through the protective insulating layer **108** are formed via wet or dry etching. The first holes **H1'** are located in the second area **A2**, and the second holes **H2'** are located in the third area **A3**.

One of the source and drain electrodes **133** and **134** in the second area **A2** is exposed via the first holes **H1'**. An end of the preliminary first layer **710'** in the third area **A3** is exposed via the second holes **H2'**, and an insulating layer remains on the preliminary first layer **710'**. The remaining insulating layer forms the second layer **720** of the stepped portion **700**, which will be described later.

Referring to FIG. **10C**, the planarization insulating layer **109** is formed in the second area **A2** of the substrate **100**, and a conductive layer is formed on the planarization insulating layer **109** and then patterned to form the pixel electrode layer **210**.

During the formation of the pixel electrode layer **210**, the stepped portion **700** is also formed. While the end of the preliminary first layer **710'** exposed via the second holes **H2'** is being etched (under-cut etched) by an etchant used during the etching process for forming the pixel electrode layer **210**, the first layer **710** is formed. The first layer **710** may be narrower than the second layer **720**.

The first layer **710** and the second layer **720** having different widths form the stepped portion **700** via undercut etching. The upper surface (or upper portion) of the first layer **710** is narrower than the lower surface (or lower portion) of the second layer **720**.

Referring to FIG. **10D**, the pixel defining layer **110** exposing the pixel electrode layer **210** is formed on the substrate **100**, and the intermediate layer **220** and the opposite electrode layer **230** are formed on the pixel defining layer **110**. At least one of the intermediate layer **220** and the opposite electrode layer **230** covers an entire upper surface of the substrate **100**, but is disconnected by the stepped portion **700**.

Referring to FIG. **10E**, the protection layer **300** is formed on the substrate **100**, and then the through-hole (e.g., the opening) **TH** penetrating through the first area **A1** of the substrate **100** is formed.

The protection layer **300** includes at least one of the organic layer **320** including organic-inorganic composite particles and the inorganic layer **310**, and materials thereof are as described above.

FIGS. **11A-11C** illustrate electronic apparatuses including organic light-emitting displays according to embodiments of the present invention.

Referring to FIG. **11A**, the organic light-emitting displays according to the above-described embodiments may be included in a mobile phone **1000**. A pixel array of the organic light-emitting displays according to the above-described embodiments may form a display **1100** of the mobile phone **1000**, and a component **1200** such as a camera may be positioned within the through-hole **TH**.

The position of the through-hole **TH** is not limited to the position illustrated in FIG. **11A**. According to another embodiment, the through-hole **TH** may be disposed on the

center of a bottom of the display **1100** of the mobile phone **1000**. In this case, a button may be positioned within the through-hole **TH**.

Referring to FIG. **11B**, the organic light-emitting displays according to the above-described embodiments may be included in a smart watch **2000**. A pixel array of the organic light-emitting displays according to the above-described embodiments may form a display **2100** of the smart watch **2000**, and a driving component **DU** including a minute hand and an hour hand may be disposed within the through-hole **TH**.

Referring to FIG. **11C**, the organic light-emitting displays according to the above-described embodiments may be included in a dashboard **3000** for vehicles. A pixel array of the organic light-emitting displays according to the above-described embodiments may form a display **3100** of the dashboard **3000** for vehicles. A plurality of through-holes (e.g., a plurality of openings) **TH** may be included.

According to an embodiment, the through-holes **TH** may respectively include a first driving component **DU1** including a needle that displays an engine RPM, and a second driving component **DU2** including a needle that displays a speed.

Embodiments of the present invention provide an organic light-emitting display and a method of manufacturing the same, by which a stepped portion having an undercut structure is disposed to block a path via which moisture is infiltrated in a lateral direction.

It should be understood that embodiments described herein should be considered in a descriptive sense only and not for purposes of limitation. Descriptions of features or aspects within each embodiment should typically be considered as available for other similar features or aspects in other embodiments.

When a certain embodiment may be implemented differently, a specific process order may be performed differently from the described order. For example, two consecutively described processes may be performed substantially at the same time or performed in an order opposite to the described order.

It will be understood that, although the terms "first", "second", "third", etc., may be used herein to describe various elements, components, regions, layers and/or sections, these elements, components, regions, layers and/or sections should not be limited by these terms. These terms are used to distinguish one element, component, region, layer or section from another element, component, region, layer or section.

Thus, a first element, component, region, layer or section discussed below could be termed a second element, component, region, layer or section, without departing from the spirit and scope of the inventive concept.

Spatially relative terms, such as "beneath", "below", "lower", "under", "above", "upper" and the like, may be used herein for ease of description to describe one element or feature's relationship to another element(s) or feature(s) as illustrated in the figures. It will be understood that the spatially relative terms are intended to encompass different orientations of the device in use or in operation, in addition to the orientation depicted in the figures. For example, if the device in the figures is turned over, elements described as "below" or "beneath" or "under" other elements or features would then be oriented "above" the other elements or features. Thus, the example terms "below" and "under" can encompass both an orientation of above and below. The device may be otherwise oriented (e.g., rotated 90 degrees or at other orientations) and the spatially relative descriptors

used herein should be interpreted accordingly. In addition, it will also be understood that when a layer is referred to as being “between” two layers, it can be the only layer between the two layers, or one or more intervening layers may also be present.

The terminology used herein is for the purpose of describing particular embodiments and is not intended to be limiting of the inventive concept. As used herein, the singular forms “a” and “an” are intended to include the plural forms as well, unless the context clearly indicates otherwise. It will be further understood that the terms “include,” “including,” “comprises,” and/or “comprising,” when used in this specification, specify the presence of stated features, integers, steps, operations, elements, and/or components, but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, and/or groups thereof. As used herein, the term “and/or” includes any and all combinations of one or more of the associated listed items. Expressions such as “at least one of,” when preceding a list of elements, modify the entire list of elements and do not modify the individual elements of the list. Further, the use of “may” when describing embodiments of the inventive concept refers to “one or more embodiments of the inventive concept.” Also, the term “exemplary” is intended to refer to an example or illustration.

It will be understood that when an element or layer is referred to as being “on,” “connected to,” “coupled to,” or “adjacent” another element or layer, it can be directly on, connected to, coupled to, or adjacent the other element or layer, or one or more intervening elements or layers may be present. When an element or layer is referred to as being “directly on,” “directly connected to,” “directly coupled to,” or “immediately adjacent” another element or layer, there are no intervening elements or layers present.

As used herein, the term “substantially,” “about,” and similar terms are used as terms of approximation and not as terms of degree, and are intended to account for the inherent variations in measured or calculated values that would be recognized by those of ordinary skill in the art.

As used herein, the terms “use,” “using,” and “used” may be considered synonymous with the terms “utilize,” “utilizing,” and “utilized,” respectively.

The organic light-emitting diode (OLED) display and/or any other relevant devices or components according to embodiments of the present invention described herein may be implemented utilizing any suitable hardware, firmware (e.g. an application-specific integrated circuit), software, or a suitable combination of software, firmware, and hardware. For example, the various components of the OLED display may be formed on one integrated circuit (IC) chip or on separate IC chips. Further, the various components of the OLED display may be implemented on a flexible printed circuit film, a tape carrier package (TCP), a printed circuit board (PCB), or formed on a same substrate. Further, the various components of the OLED display may be a process or thread, running on one or more processors, in one or more computing devices, executing computer program instructions and interacting with other system components for performing the various functionalities described herein. The computer program instructions are stored in a memory which may be implemented in a computing device using a standard memory device, such as, for example, a random access memory (RAM). The computer program instructions may also be stored in other non-transitory computer readable media such as, for example, a CD-ROM, flash drive, or the like. Also, a person of skill in the art should recognize that the functionality of various computing devices may be

combined or integrated into a single computing device, or the functionality of a particular computing device may be distributed across one or more other computing devices without departing from the scope of the exemplary embodiments of the present invention.

While one or more embodiments have been described with reference to the figures, it will be understood by those of ordinary skill in the art that various suitable changes in form and details may be made therein without departing from the spirit and scope as defined by the following claims, and equivalents thereof.

What is claimed is:

1. An organic light-emitting display comprising:

a substrate comprising a first area, a second area surrounding the first area, and a third area between the first area and the second area;

an insulating layer on the substrate, the substrate and the insulating layer having an opening therethrough penetrating, the opening being in the first area;

a pixel array on the insulating layer, the pixel array comprising a plurality of pixels that are in the second area and surround the opening, a first pixel adjacent to the third area from among the plurality of pixels comprises a pixel electrode layer, an intermediate layer on the pixel electrode layer, and an opposite electrode layer on the intermediate layer; and

a stepped portion in the third area to be adjacent to the opening, the stepped portion having an under-cut step and being offset from the second area,

wherein the intermediate layer comprises an organic emission layer, and

wherein at least one of the intermediate layer or the opposite electrode layer extends toward the opening and is disconnected by the stepped portion.

2. An organic light-emitting display comprising:

a substrate;

an insulating layer on the substrate, the substrate and the insulating layer having an opening therethrough penetrating;

a pixel array on the insulating layer, the pixel array comprising a plurality of pixels that surround the opening, a first pixel adjacent to the opening from among the plurality of pixels comprises a pixel electrode layer, an intermediate layer on the pixel electrode layer, and an opposite electrode layer on the intermediate layer; and

a stepped portion on the substrate and adjacent to the opening, the stepped portion having an under-cut step, wherein the intermediate layer comprises an organic emission layer,

wherein at least one of the intermediate layer or the opposite electrode layer extends toward the opening and is disconnected by the stepped portion,

wherein the insulating layer comprises a recess that is concave in a thickness direction of the insulating layer, and

wherein the stepped portion is within the recess.

3. The organic light-emitting display of claim 2, wherein the stepped portion comprises:

a first layer within the recess; and

a second layer over the first layer,

wherein a width of an upper portion of the first layer is less than a width of a lower portion of the second layer.

4. The organic light-emitting display of claim 3, wherein the first layer and the second layer comprise different materials.

5. The organic light-emitting display of claim 3, wherein the first layer comprises metal.

6. The organic light-emitting display of claim 3, wherein the first pixel further comprises a pixel circuit electrically connected to the pixel electrode layer, and wherein the pixel circuit comprises a thin film transistor (TFT) comprising a gate electrode, an active layer, a source electrode, and a drain electrode, and the pixel circuit further comprises a storage capacitor comprising a lower electrode and an upper electrode.

7. The organic light-emitting display of claim 6, wherein the first layer comprises a same material as that of one of the gate electrode, the source electrode, the drain electrode, the lower electrode, and the upper electrode.

8. The organic light-emitting display of claim 3, wherein the second layer comprises a same material as that of the insulating layer.

9. The organic light-emitting display of claim 3, wherein a thickness of the first layer is greater than a thickness of at least one of the intermediate layer or the opposite electrode layer.

10. The organic light-emitting display of claim 9, further comprising a protection layer that covers the at least one of the intermediate layer or the opposite electrode layer.

11. The organic light-emitting display of claim 10, wherein the protection layer comprises at least one of an organic layer and an inorganic layer, the organic layer comprising organic-inorganic composite particles.

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