



US008907559B2

(12) **United States Patent**  
**Yamazaki**

(10) **Patent No.:** **US 8,907,559 B2**  
(45) **Date of Patent:** **\*Dec. 9, 2014**

(54) **SEMICONDUCTOR DEVICE HAVING  
DISPLAY PORTION WITH PLURAL PIXELS**

*H01L 51/50* (2006.01)  
*H01L 27/32* (2006.01)  
*H01L 51/00* (2006.01)

(71) Applicant: **Semiconductor Energy Laboratory  
Co., Ltd.**, Atsugi (JP)

(52) **U.S. CL.**  
CPC ..... *H01L 27/3211* (2013.01); *H01L 51/5016*  
(2013.01); *Y10S 428/917* (2013.01); *H01L*  
*51/0085* (2013.01); *H01L 27/3244* (2013.01);  
*H01L 51/0077* (2013.01)

(72) Inventor: **Shunpei Yamazaki**, Tokyo (JP)

(73) Assignee: **Semiconductor Energy Laboratory  
Co., Ltd.**, Atsugi-shi, Kanagawa-ken  
(JP)

USPC ..... **313/504**; 313/506; 313/509; 428/917  
(58) **Field of Classification Search**  
USPC ..... 313/504, 506, 509  
See application file for complete search history.

(\*) Notice: Subject to any disclaimer, the term of this  
patent is extended or adjusted under 35  
U.S.C. 154(b) by 0 days.

(56) **References Cited**

This patent is subject to a terminal dis-  
claimer.

**U.S. PATENT DOCUMENTS**

4,945,009 A 7/1990 Taguchi  
4,974,942 A 12/1990 Gross

(Continued)

(21) Appl. No.: **14/198,852**

**FOREIGN PATENT DOCUMENTS**

(22) Filed: **Mar. 6, 2014**

EP 0 390 551 A2 10/1990  
EP 0 851 715 A1 7/1998

(65) **Prior Publication Data**

US 2014/0183542 A1 Jul. 3, 2014

(Continued)

**Related U.S. Application Data**

**OTHER PUBLICATIONS**

(63) Continuation of application No. 13/613,241, filed on  
Sep. 13, 2012, now Pat. No. 8,674,599, which is a  
continuation of application No. 13/045,614, filed on  
Mar. 11, 2011, now Pat. No. 8,304,985, which is a  
continuation of application No. 12/049,423, filed on  
Mar. 17, 2008, now Pat. No. 7,915,808, which is a  
continuation of application No. 11/105,414, filed on  
Apr. 14, 2005, now Pat. No. 7,400,087, which is a  
continuation of application No. 09/871,805, filed on  
Jun. 4, 2001, now Pat. No. 7,339,317.

Baldo, M A et al., "Highly Efficient Phosphorescent Emission from  
Organic Electroluminescent Devices", Nature vol. 395, Sep. 10,  
1998, pp. 151-154.

(Continued)

*Primary Examiner* — Karabi Guharay

(74) *Attorney, Agent, or Firm* — Fish & Richardson P.C.

(30) **Foreign Application Priority Data**

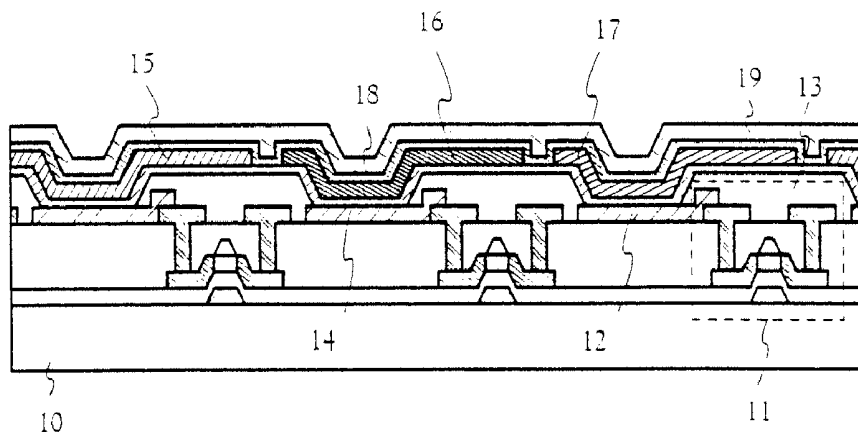
Jun. 5, 2000 (JP) ..... 2000-168325

(57) **ABSTRACT**

(51) **Int. Cl.**  
*H01J 1/62* (2006.01)  
*H01L 27/00* (2006.01)

There is provided a light emitting device which enables a  
color display with good color balance. A triplet compound is  
used for a light emitting layer of an EL element that emits red  
color, and a singlet compound is used for a light emitting layer  
of an EL element that emits green color and a light emitting  
layer of an EL element that emits blue color. Thus, an opera-  
tion voltage of the EL element emitting red color may be  
made the same as the EL element emitting green color and the  
EL element emitting blue color. Accordingly, the color dis-  
play with good color balance can be realized.

**18 Claims, 14 Drawing Sheets**



(56)

## References Cited

## U.S. PATENT DOCUMENTS

5,216,331	A	6/1993	Hosokawa	
5,294,810	A	3/1994	Egusa	
5,457,565	A	10/1995	Namiki	
5,485,055	A	1/1996	Keyser	
5,529,853	A	6/1996	Hamada	
5,702,833	A	12/1997	Nagai	
5,703,436	A	12/1997	Forrest	
5,742,129	A	4/1998	Nagayama	
5,756,224	A	5/1998	Borner	
5,858,564	A	1/1999	Tamura	
5,928,802	A	7/1999	Shi	
5,932,362	A	8/1999	Nagai	
5,932,892	A	8/1999	Hseuh	
5,935,720	A	8/1999	Chen	
5,990,629	A	11/1999	Yamada	
6,046,547	A	4/2000	Nishio	
6,072,278	A	6/2000	Keyser	
6,097,147	A	8/2000	Baldo	
6,133,693	A	10/2000	Keyser	
6,160,272	A	12/2000	Arai	
6,175,345	B1	1/2001	Kuribayashi	
6,191,764	B1	2/2001	Kono	
6,194,837	B1	2/2001	Ozawa	
6,204,610	B1	3/2001	Komiya	
6,246,179	B1	6/2001	Yamada	
6,303,238	B1	10/2001	Thompson	
6,310,360	B1	10/2001	Forrest	
6,358,633	B1	3/2002	Sano	
6,359,606	B1	3/2002	Yudasaka	
6,366,025	B1	4/2002	Yamada	
6,420,834	B2	7/2002	Yamazaki	
6,433,486	B1	8/2002	Yokoyama	
6,448,710	B1	9/2002	Asai	
6,533,631	B2	3/2003	Asai	
6,559,594	B2	5/2003	Fukunaga	
6,608,449	B2	8/2003	Fukunaga	
6,641,933	B1	11/2003	Yamazaki	
6,689,492	B1	2/2004	Yamazaki	
6,730,966	B2	5/2004	Koyama	
6,750,608	B2	6/2004	Matsuura	
6,780,687	B2	8/2004	Nakajima	
6,830,828	B2	12/2004	Thompson	
6,864,628	B2	3/2005	Yamazaki	
6,872,604	B2	3/2005	Yamazaki	
6,878,470	B2	4/2005	Kawamura	
6,902,830	B2	6/2005	Thompson	
6,910,933	B1	6/2005	Matsuo	
6,972,966	B1 *	12/2005	Oishi et al.	361/803
7,001,536	B2	2/2006	Thompson	
7,042,151	B2	5/2006	Yamazaki	
7,129,632	B2	10/2006	Park	
7,199,519	B2	4/2007	Yamazaki	
7,291,406	B2	11/2007	Thompson	
7,312,572	B2	12/2007	Yamauchi	
7,339,317	B2 *	3/2008	Yamazaki	313/506
7,372,199	B2	5/2008	Yamazaki	
7,400,087	B2 *	7/2008	Yamazaki	313/504
7,537,844	B2	5/2009	Thompson	
7,821,200	B2	10/2010	Yamauchi	
8,405,594	B2	3/2013	Yamauchi	
8,558,773	B2	10/2013	Yamauchi	
2001/0015256	A1 *	8/2001	Yamazaki et al.	156/289
2001/0020922	A1	9/2001	Yamazaki	
2001/0045565	A1	11/2001	Yamazaki	
2001/0049197	A1	12/2001	Yamazaki	
2001/0051207	A1	12/2001	Yamagata	
2002/0024051	A1	2/2002	Yamazaki	
2002/0050786	A1	5/2002	Yamazaki	
2002/0068143	A1	6/2002	Silvernail	
2002/0153829	A1	10/2002	Asai	
2003/0044639	A1	3/2003	Fukuda	
2004/0065902	A1	4/2004	Yamazaki	
2005/0110398	A1	5/2005	Lee	

2005/0140280	A1	6/2005	Yamazaki
2005/0197031	A1	9/2005	Yamazaki
2009/0115348	A1	5/2009	Yamazaki

## FOREIGN PATENT DOCUMENTS

EP	0 987 774	A2	3/2000
GB	2344346	A	6/2000
JP	63-224190	A	9/1988
JP	02-261889	A	10/1990
JP	03-107188	A	5/1991
JP	03-115486	A	5/1991
JP	03-230583	A	10/1991
JP	03-230584	A	10/1991
JP	05-17765	A	1/1993
JP	07-094278	A	4/1995
JP	10-039791	A	2/1998
JP	10-060427	A	3/1998
JP	10-095971	A	4/1998
JP	10-148853	A	6/1998
JP	10-183112	A	7/1998
JP	10-214060	A	8/1998
JP	10-255983	A	9/1998
JP	10-308281	A	11/1998
JP	10-319909	A	12/1998
JP	11-111457	A	4/1999
JP	11-204259	A	7/1999
JP	11-256148	A	9/1999
JP	11-312581	A	11/1999
JP	11-329719	A	11/1999
JP	11-338786	A	12/1999
JP	2000-089691	A	3/2000
JP	2000-111721	A	4/2000
JP	2000-148087	A	5/2000
JP	2000-150152	A	5/2000
WO	WO 98/33165	A1	7/1998
WO	WO 00/16593	A1	3/2000

## OTHER PUBLICATIONS

Baldo, M A et al., "Very High-Efficiency Green Organic Light-Emitting Devices Based on Electrophosphorescence", *Applied Physics Letters* vol. 75, No. 1, Jul. 5, 1999, pp. 4-6.

Baldo, MA et al., "High-efficiency fluorescent organic light-emitting devices using a phosphorescent sensitizer", *Nature*, vol. 403, Feb. 17, 2000, pp. 750-753.

Hoshino, S, et al., "Electroluminescence from triplet excited states of benzophenone", *Appl. Phys. Lett. (Applied Physics Letters)*, Jul. 8, 1996, vol. 69, No. 2, pp. 224-226. (in English).

Inukai et al., "4.0-In. TFT-OLED Displays and a Novel Digital Driving Method," *SID Digest '00: SID International Symposium Digest of Technical Papers*, pp. 924-927, May 2000.

Kido et al., "Multilayer White Light-Emitting Organic Electroluminescent Device," *Science*, vol. 267, pp. 1332-1334, Mar. 3, 1995.

Kijima, Yasunori (Sony), "RGB Multicolor Element," *Japan Society of Applied Physics, Molecular Electronics and Bioelectronics Group*, 6th training session (1997) text titled "From Fundamentals to Applications of Organic EL Elements," by Japan Society of Applied Physics (Corp.)—Molecular Electronics and Bioelectronics Group, Dec. 11, 1997, pp. 155-163 (with full English Translation, pp. 1-16).

Koyama, J et al., "A 4.0-in. Poly Si TFT-LCD with Integrated 6-bit Digital Data Driver Using CGS Technology", *AM-LCD '99 Digest of Technical Papers*, 1999, pp. 29-32.

Koyama, J, "Taking Basic Patents of Circuit for Achieving Higher Definition of Organic EL Panel", *Nikkei Electronics*, No. 768, Apr. 24, 2000, pp. 163-170 and full English Translation.

Mizukami et al., "6-Bit Digital VGA OLED," *SID Digest '00: SID International Symposium Digest of Technical Papers*, pp. 912-915, May 2000.

Nishi et al., "High Efficiency TFT-OLED Display With Iridium-Complex as Triplet Emissive Center," *Proceedings of the 10th International Workshop on Inorganic and Organic Electroluminescence (EL '00)*, pp. 353-356, Dec. 2000.

(56)

**References Cited**

## OTHER PUBLICATIONS

O'Brien et al., "Improved Energy Transfer in Electrophosphorescent Devices", Jan. 18, 1999, Applied Physics Letters, vol. 74, No. 3, pp. 442-444.

Ohtani, H et al., "LP-B: Late-News Poster: A 60-in. HDTV Rear-Projector with Continuous-Grain-Silicon Technology", SID Digest '98: SID International Symposium Digest of Technical Papers, 1998, pp. 467-470.

Tohoku Pioneer Corporation has started to provide high-resolution 65000-color passive-matrix organic EL full-color panels to 'FOMA F901 iS'—the size is 1.0-inch, resolution is 141 ppi, and a phosphorescent material is used-', Pioneer sound.vision.soul, Jun. 1, 2005, Tohoku Pioneer Corporation.

Tsutsui et al., "Electroluminescence in Organic Thin Films", Photochemical Processes in Organized Molecular Systems, 1991, pp. 437-450.

Tsutsui et al., "High Quantum Efficiency in Organic Light-Emitting Devices with Iridium-Complex as a Triplet Emissive Center", Japanese Journal of Applied Physics vol. 38, Part 2, No. 12B, Dec. 15, 1999, pp. L1502-L1504.

"The Rise of Organic EL Aiming at 'Mobile Phones'", Nikkei Electronics, No. 765, Mar. 13, 2000, pp. 55-62 with full English Translation.

"2MM Thick Self-Emitting Display Device", Nikkei Sangyo Shimbun, Sep. 27, 1995, pp. 1 with full English Translation.

Office Action, Japanese Application Serial No. 2001-169098, dated Jul. 4, 2006, with full English Translation.

\* cited by examiner

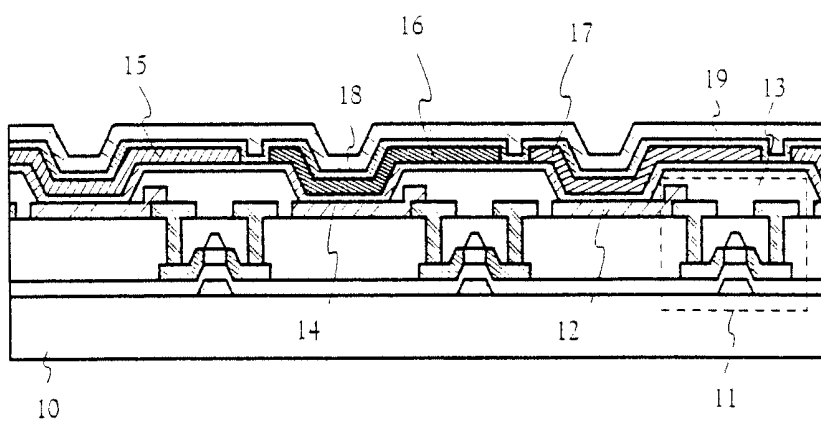


FIG. 1

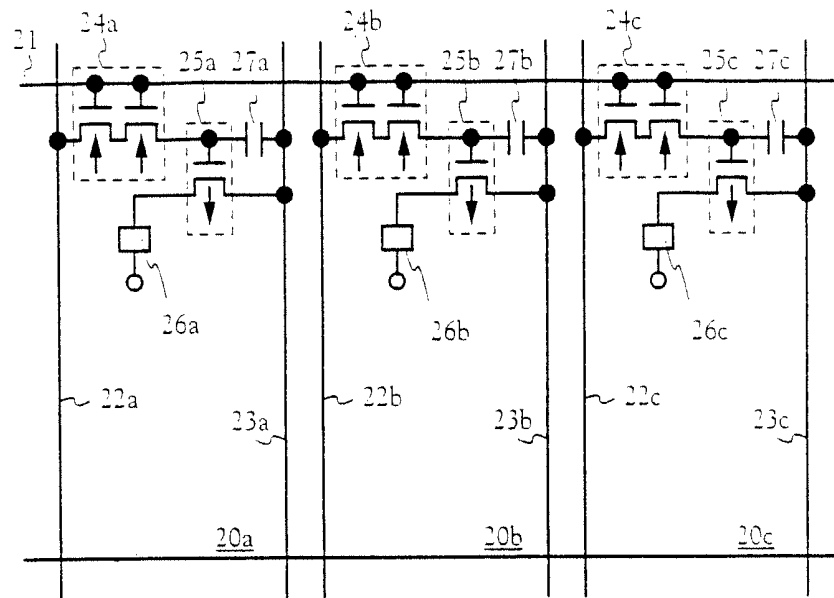


FIG. 2A

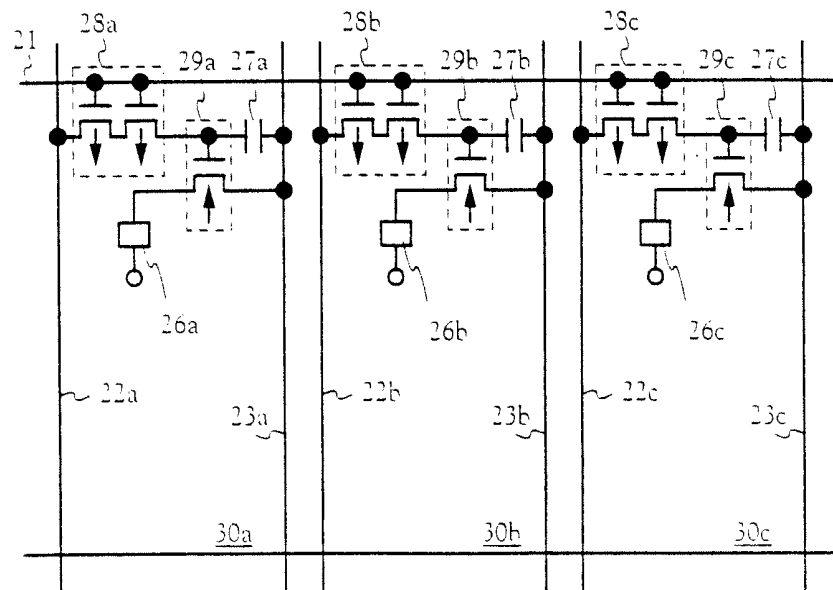


FIG. 2B

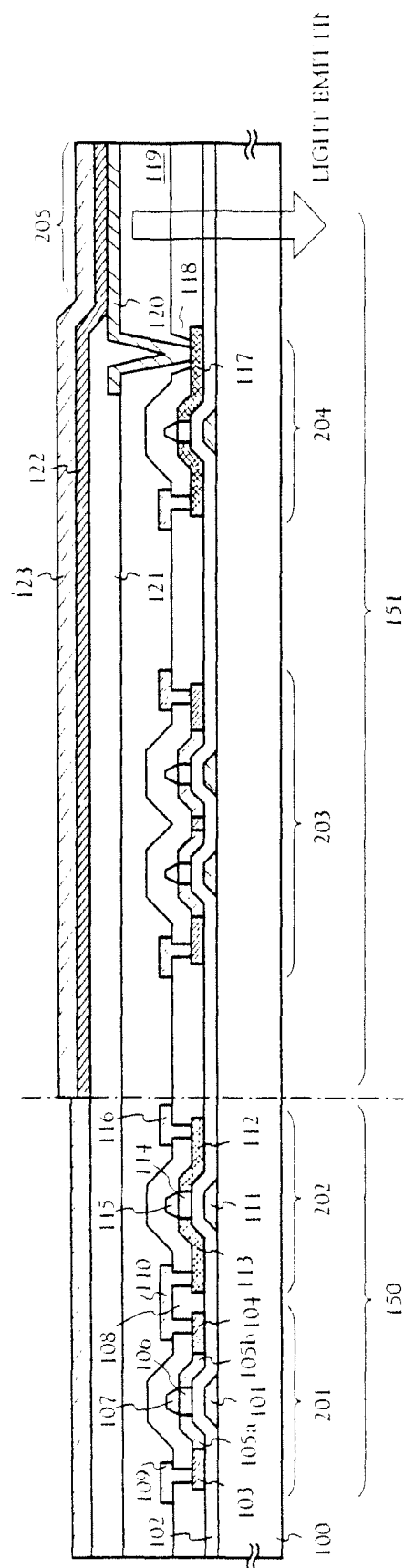


FIG. 3

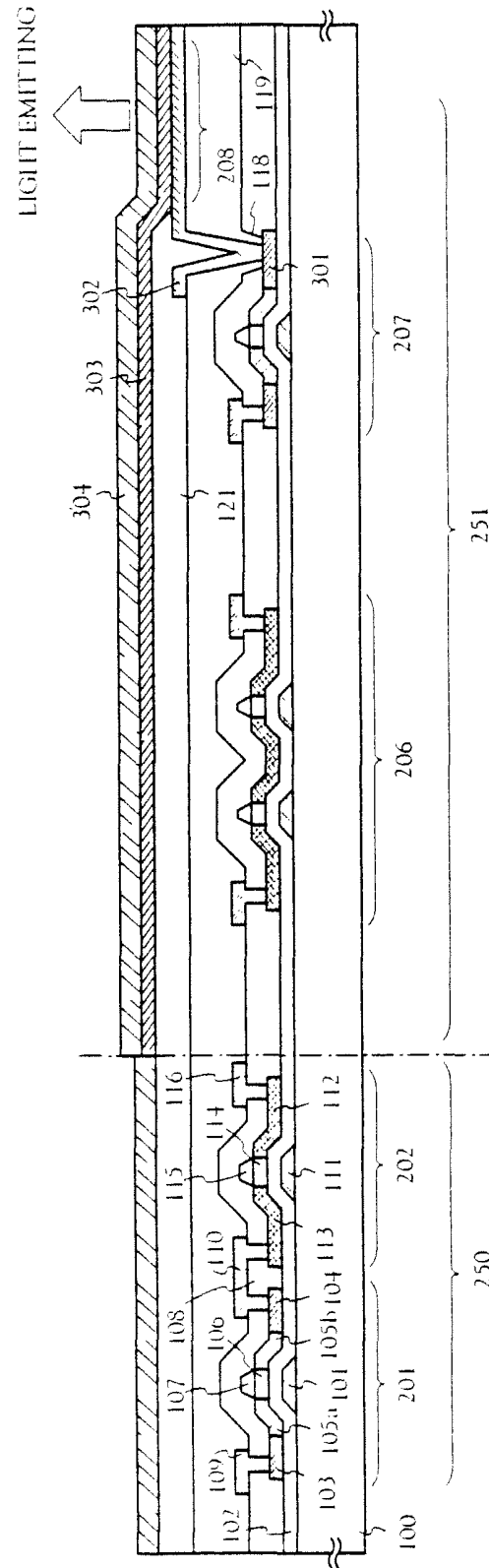


FIG. 4

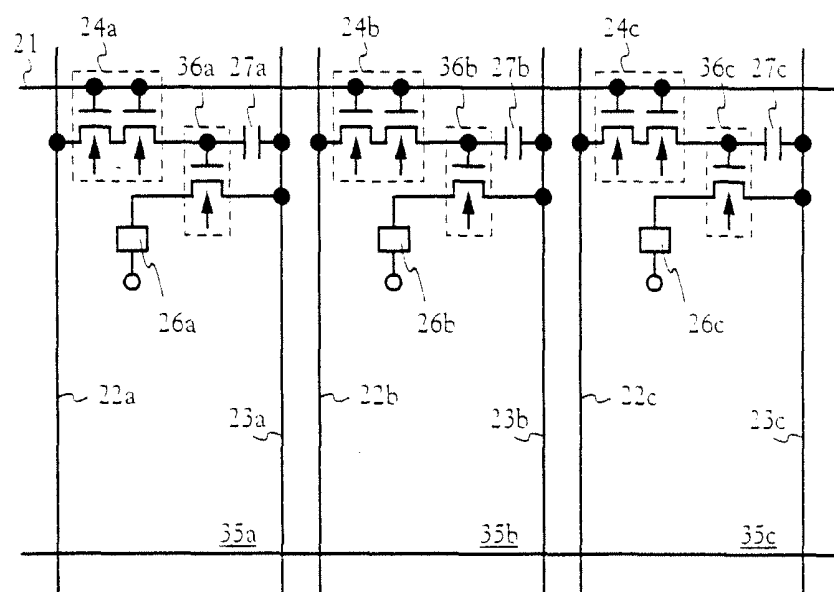


FIG. 5



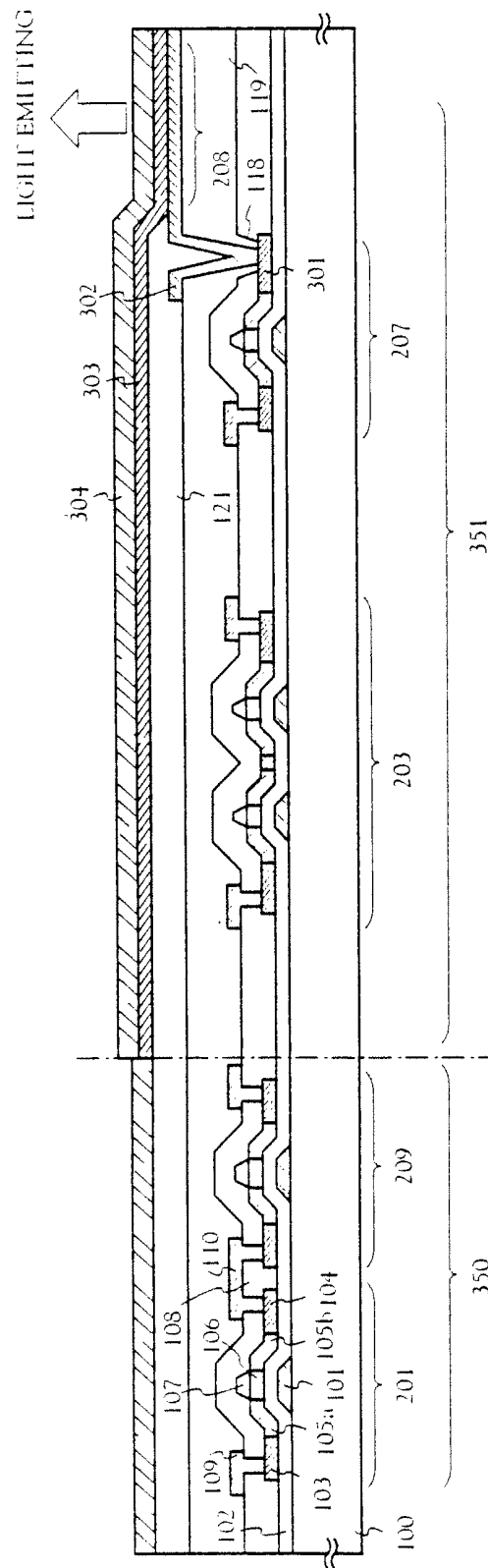


FIG. 6

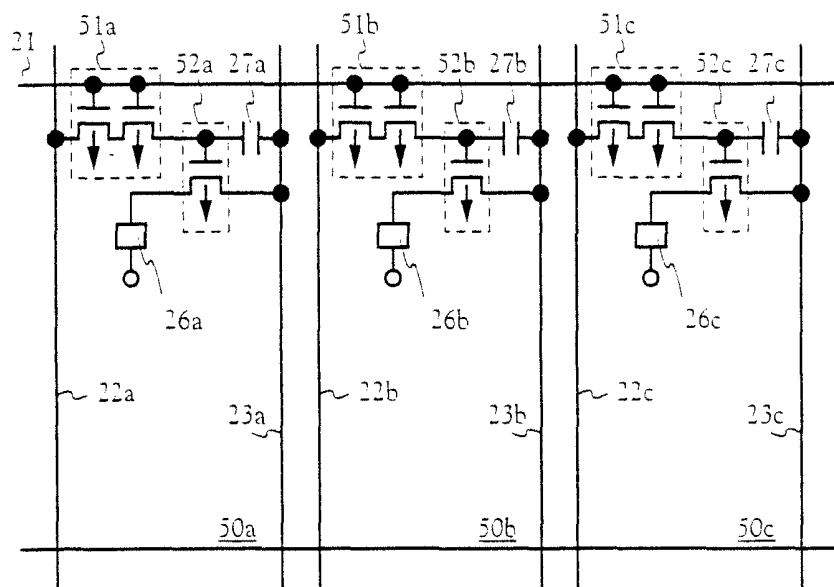


FIG. 7

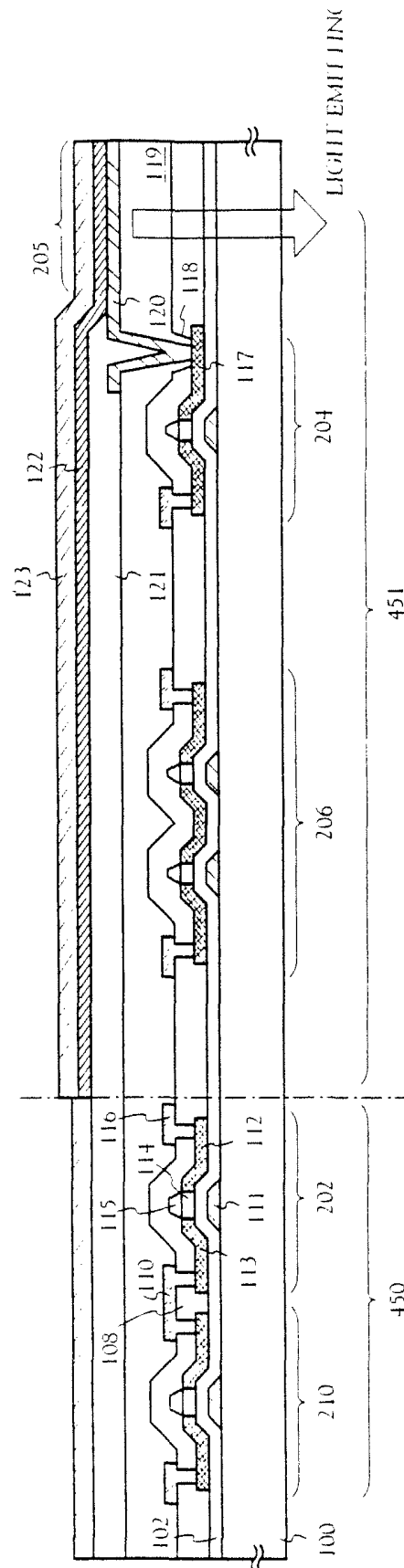


FIG. 8

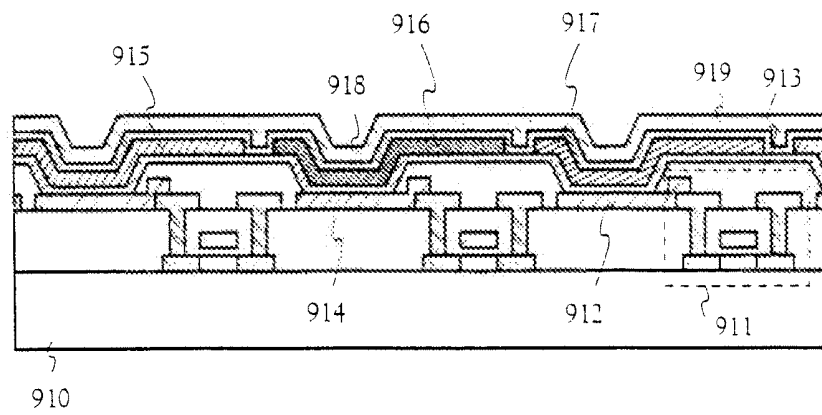


FIG. 9

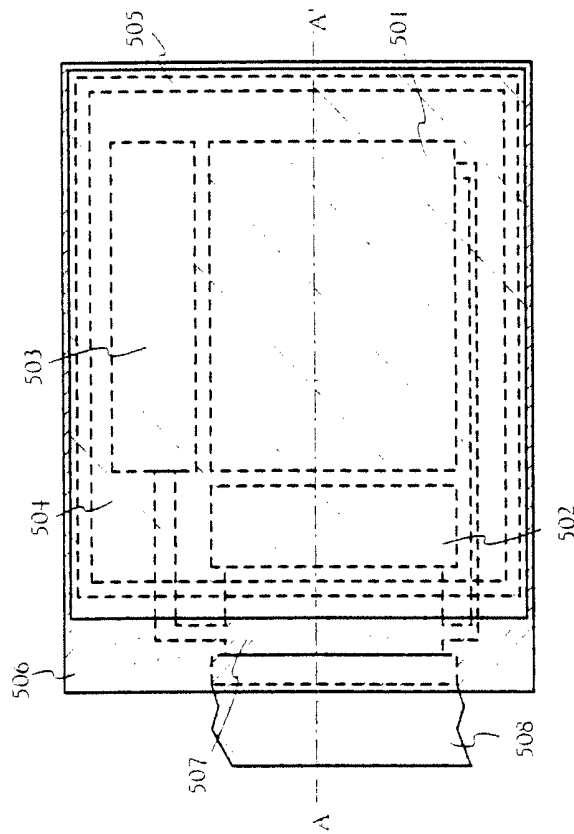


FIG. 10A

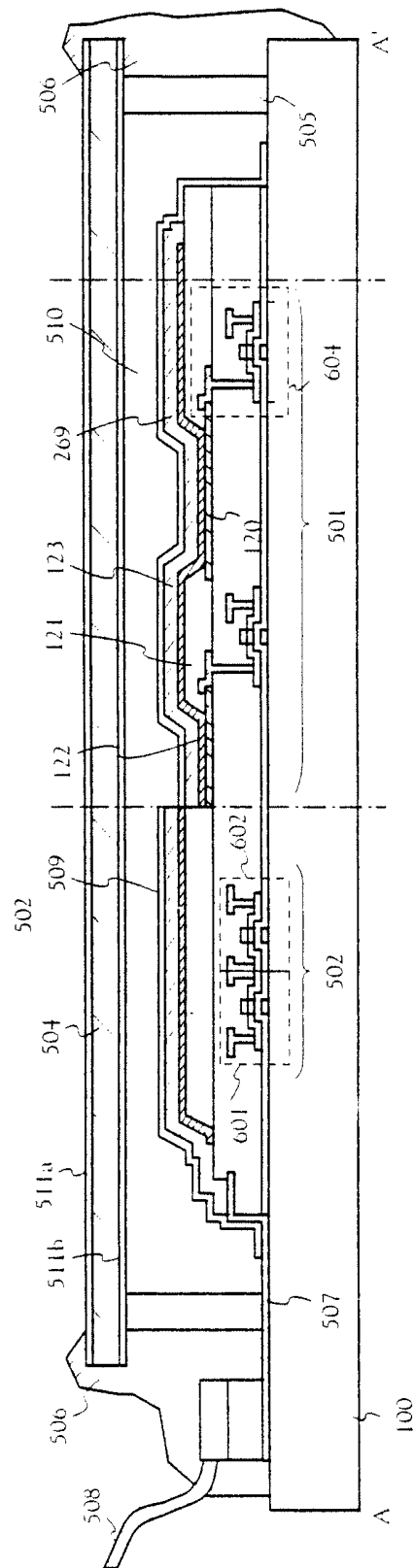


FIG. 10B

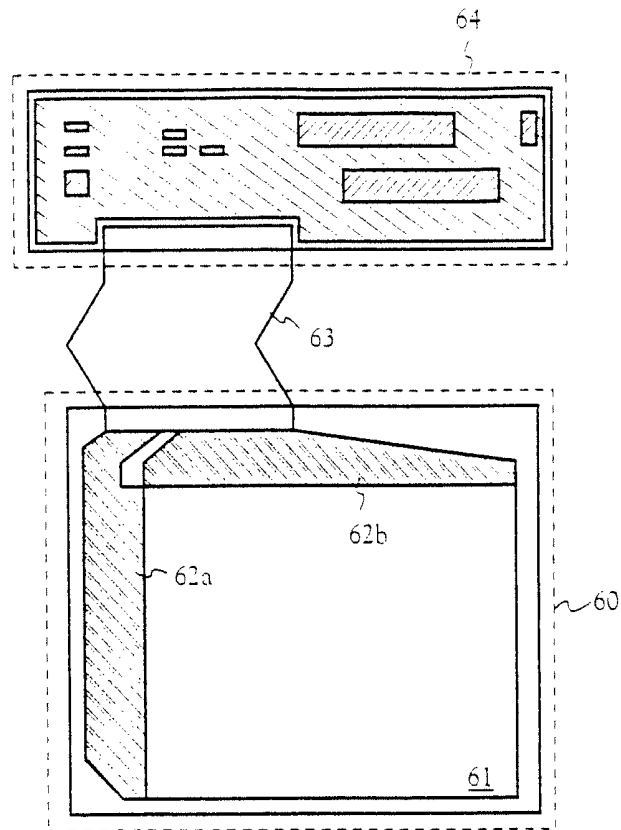


FIG. 11A

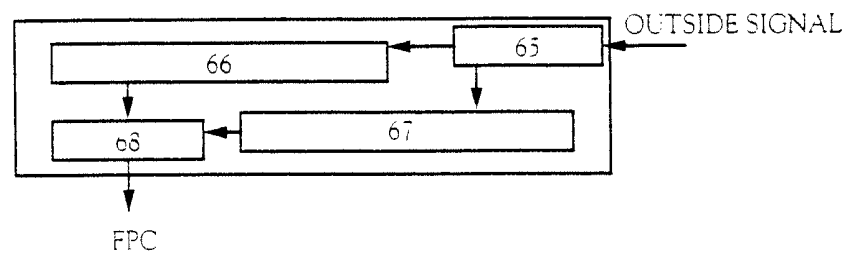


FIG. 11B

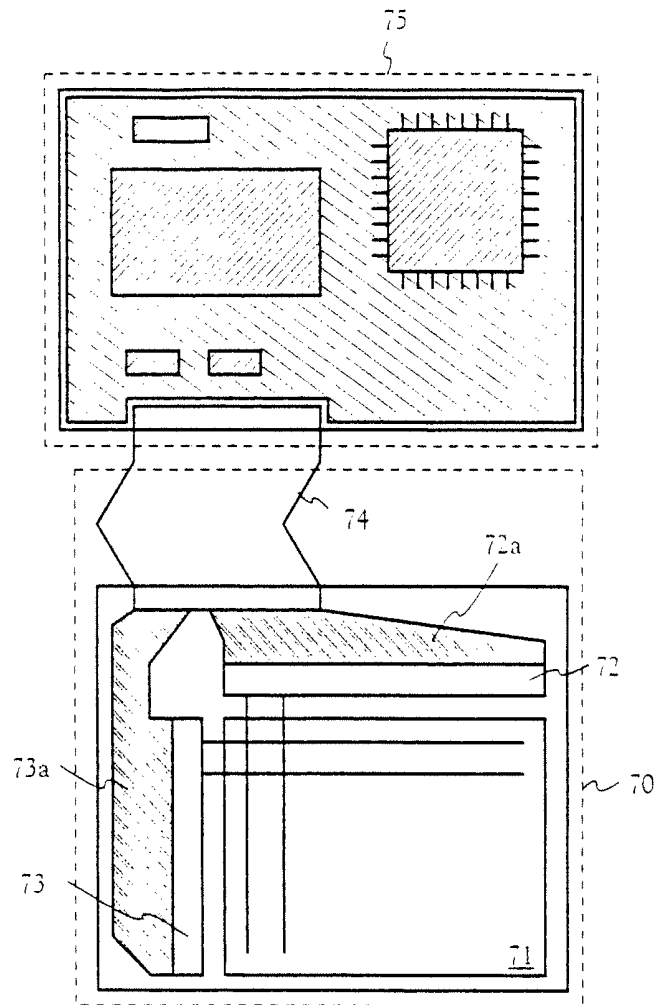


FIG. 12A

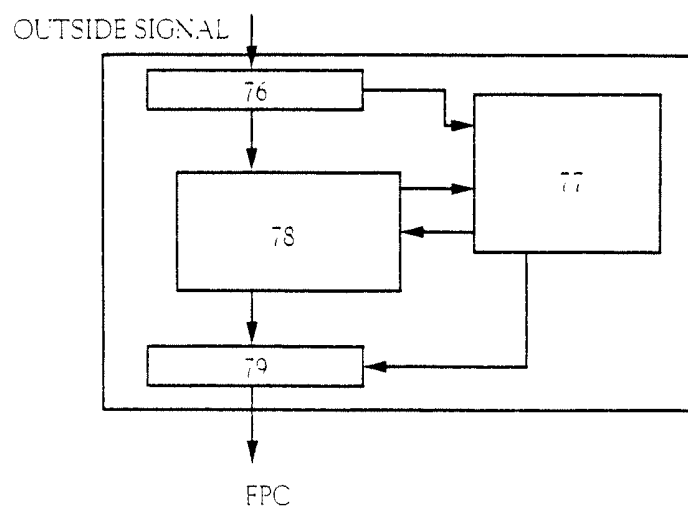


FIG. 12B

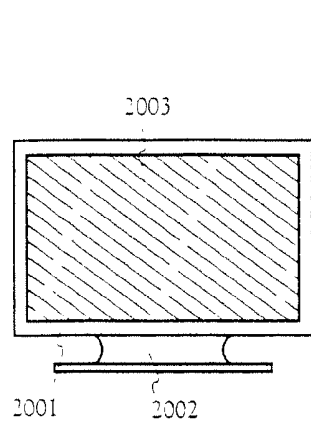


FIG. 13A

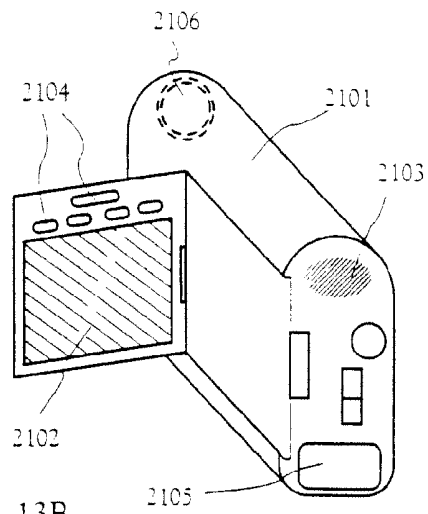


FIG. 13B

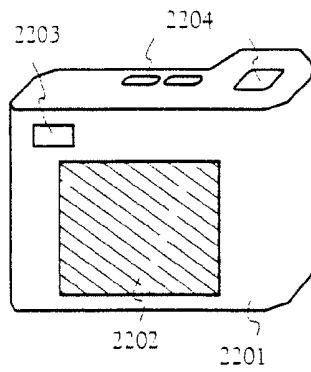


FIG. 13C

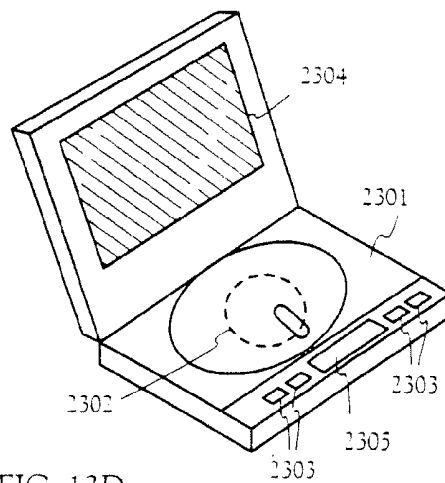


FIG. 13D

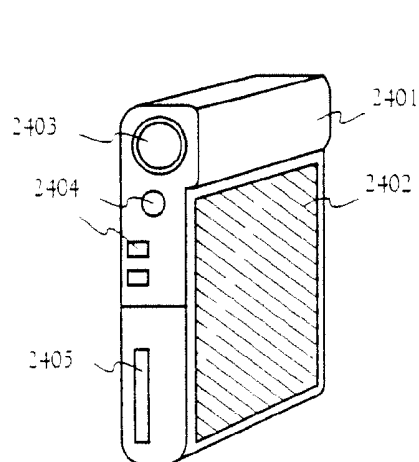


FIG. 13E

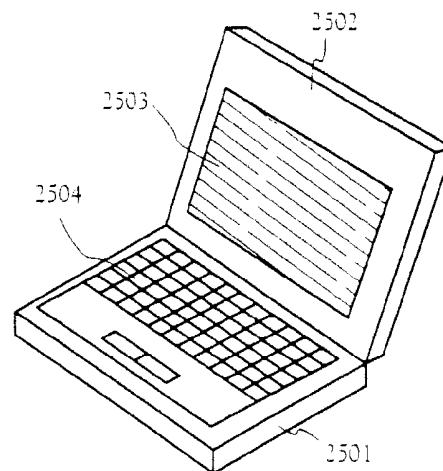


FIG. 13F



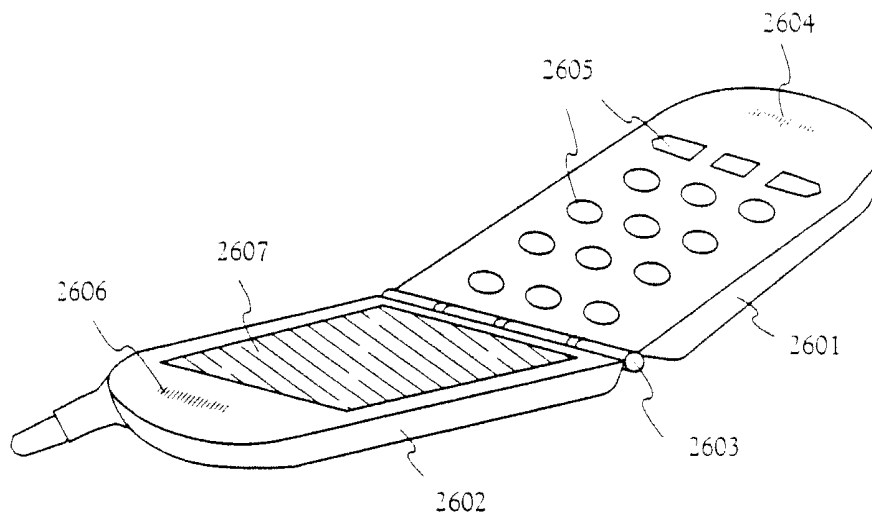


FIG. 14A

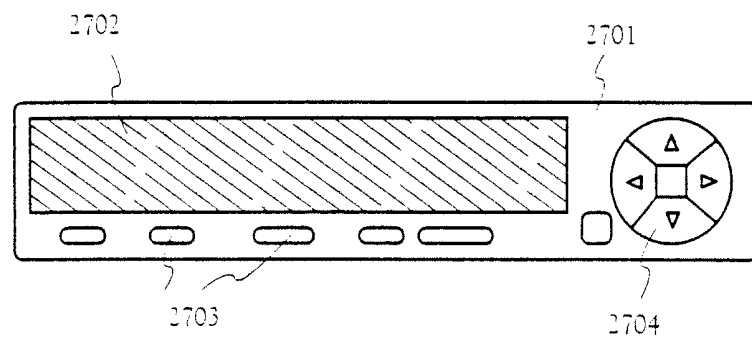


FIG. 14B

## SEMICONDUCTOR DEVICE HAVING DISPLAY PORTION WITH PLURAL PIXELS

### CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a continuation of U.S. application Ser. No. 13/613,241, filed Sep. 13, 2012, now U.S. Pat. No. 8,674,599, which is a continuation of U.S. application Ser. No. 13/045,614, filed Mar. 11, 2011, now U.S. Pat. No. 8,304,985, which is a continuation of U.S. application Ser. No. 12/049,423, filed Mar. 17, 2008, now U.S. Pat. No. 7,915,808, which is a continuation of U.S. application Ser. No. 11/105,414, filed Apr. 14, 2005, now U.S. Pat. No. 7,400,087, which is a continuation of U.S. application Ser. No. 09/871,805, filed Jun. 4, 2001, now U.S. Pat. No. 7,339,317, which claims the benefit of a foreign priority application filed in Japan as Serial No. 2000-168325 on Jun. 5, 2000, all of which are incorporated by reference.

### BACKGROUND OF THE INVENTION

#### 1. Field of the Invention

The present invention relates to a device (hereinafter, referred to as a light emitting device) having an element (hereinafter, referred to as a light emitting element) sandwiching a luminous material between electrodes. In particular, the present invention relates to a light emitting device having a light emitting element (hereinafter, referred to as an EL element) using an organic compound from which EL (electro luminescence) is obtained as a luminous material. Note that, an organic EL display and an organic light emitting diode (OLED) are included in a light emitting device of the present invention.

Further, the luminous materials that may be used for the present invention include all the luminous materials that luminesce (phosphorescence and/or fluorescence) via a singlet excitation or a triplet excitation, or via both the excitations.

#### 2. Description of the Related Art

In recent years, the development of an EL element with an organic EL film as a light emitting layer is progressing, and the EL elements using various organic EL films have been proposed. Also, experiments to realize a flat panel display using a light emitting device with such an EL element as a light emitting element have been conducted.

As a light emitting device using an EL element, there are known a passive matrix type and an active matrix type. The passive matrix type light emitting device is provided with stripe shaped anode and cathode which are orthogonal to each other, and uses an EL element having a structure sandwiching an EL film between the anode and the cathode. Further, the active matrix type light emitting device is provided with a thin film transistor (hereinafter, referred to as a TFT) for each pixel, and is of a method for controlling current flowing in the EL element by the TFT connected to one of an anode and a cathode of an EL element.

Further, there are proposed various methods for color display of a light emitting device using EL elements. There is known a method for performing color display by mixing luminescence of colors, with three pixels, a pixel which emits red light, a pixel which emits green light and a pixel which emits blue light as one unit.

Such a method is attracting attention since a bright color display is easily obtained. However, since the EL elements which emit light of respective colors use different organic EL films as light emitting layers, the brightness characteristic of the light emitting layer (the relationship between operation voltage and the brightness) differs. As a result, the operation voltage necessary in obtaining a desired brightness differs for each EL element, and further the reliability (life) of the light emitting layer differs for each EL element.

From the above, it is feared that not only there will be an increase in the kinds of power sources necessary for the light emitting device, but also that a shift in the color balance due to difference in the life (deterioration rate) of the EL element will be generated.

### SUMMARY OF THE INVENTION

The present invention has been made in view of the above problem, and therefore an object of the present invention is to provide a technique for keeping operation voltages of an EL element with red light emission, an EL element with green light emission and an EL element with blue light emission at a constant level, when a light emitting device is made to perform color display. Another object of the present invention is to provide a light emitting device that can perform color display with good color balance.

A further object of the present invention is to provide an electric appliance which has a display portion with high image quality, by employing the light emitting device which may perform color display with good color balance as its display portion.

In the present invention, there is a feature in that as a light emitting layer, an organic compound which emits light by a singlet exciton (singlet) (hereinafter, referred to as a singlet compound), and an organic compound which emits light by a triplet exciton (triplet) (hereinafter, referred to as a triplet compound) are used together. Note that, in this specification, the singlet compound refers to a compound which emits light via only a singlet excitation, and the triplet compound refers to a compound which emits light via only a triplet excitation.

As to a triplet compound, the organic compounds disclosed in the following articles may be given as typical materials.

(1) T. Tsutsui, C. Adachi, S. Saito, Photochemical Processes in Organized Molecular Systems, ed. K. Honda, (Elsevier Sci. Pub., Tokyo, 1991) p. 437.

(2) M. A. Baldo, D. F. O'Brien, Y. You, A. Shoustikov, S. Sibley, M. E. Thompson, S. R. Forrest, Nature 395 (1998) p. 151.

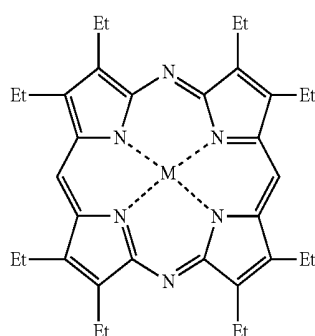
In these articles are disclosed the organic compounds shown by the following formulas.

(3) M. A. Baldo, S. Lamansky, P. E. Burrows, M. E. Thompson, S. R. Forrest, Appl. Phys. Lett., 75 (1999) p. 4.

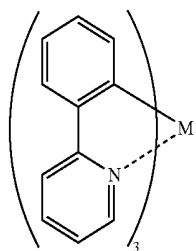
(4) T. Tsutsui, M. J. Yang, M. Yabuchi, K. Nakamura, T. Watanabe, T. Tsuji, Y. Fukuda, T. Wakimoto, S. Mayaguchi, Jpn. Appl. Phys., 38 (12B) (1999) L1502.

Further, the present inventors consider that not only the luminous materials disclosed in the above articles, but also the luminous materials represented by the following molecular formulas (specifically a metal complex or an organic compound) may be used.

3



[Chemical Formula 1]



[Chemical Formula 2]

In the above molecular formulas, M represents an element belonging to Groups 8 to 10 of the periodic table. In the above articles, platinum and iridium are used. Further, the present inventors consider that since nickel, cobalt and palladium are cheaper than platinum and iridium, they are more preferable in reducing the manufacturing cost of the light emitting device. Especially, since nickel can easily form a complex, the productivity is high and therefore preferable.

The triplet compound has higher luminous efficiency than the singlet compound, and the operation voltage (a voltage necessary for making an EL element emit light) may be decreased in obtaining the same light emitting brightness. This embodiment makes use of this feature.

FIG. 1 shows a cross sectional structure of a pixel portion of the light emitting device of the present invention. In FIG. 1, reference numeral 10 indicates an insulator, reference numeral 11 indicates a current controlling TFT, reference numeral 12 indicates a pixel electrode (anode), reference numeral 13 indicates an insulating film with an opening on the pixel electrode (hereinafter, referred to as a bank), reference numeral 14 indicates a hole injecting layer, reference numeral 15 indicates a light emitting layer which emits red light, reference numeral 16 indicates a light emitting layer which emits green light, reference numeral 17 indicates a light emitting layer which emits blue light, reference numeral 18 indicates an electron transporting layer, and reference numeral 19 indicates a cathode.

Note that, FIG. 1 shows an example of using a bottom gate type TFT (specifically an inverted stagger type TFT) as a current controlling TFT, but a top gate type TFT may be used. Further, known organic compounds or inorganic compounds may be used for the hole injecting layer 14, the light emitting layer 15 which emits red light, the light emitting layer 16 which emits green light, the light emitting layer 17 which emits blue light, or the electron transporting layer 18, respectively.

In this embodiment, the triplet compound is used as the light emitting layer 15 which emits red light, and the singlet compound is used as the light emitting layer 16 which emits green light and the light emitting layer 17 which emits blue light. That is, an EL element using a triplet compound is used

4

as an EL element which emits red light, and an EL element using a singlet compound is used as an EL element which emits green or blue light.

When using a low molecular organic compound as a light emitting layer, at present the life of a light emitting layer which emits red light is shorter than that of a light emitting layer which emits other colored light. This is because the luminous efficiency is lower than that of other colors, and in order to obtain the same light emitting brightness as other colors, the operation voltage has to be set higher and progress of deterioration for that amount is fast.

However, in the present invention, since the triplet compound with high luminous efficiency is used as the light emitting layer 15 which emits red light, the operation voltages may be made the same whilst the same luminous brightness as the light emitting layer 16 which emits green light and the light emitting layer 17 which emits blue light may be obtained. Accordingly, the deterioration of the light emitting layer 15 which emits red light does not progress significantly, and color display may be performed without causing a problem of shift in color balance, or the like. Further, suppressing the operation voltage as low is preferable also from the point of view that the margin of the withstand pressure of the transistor may be set low.

Note that, in the present invention, an example of using the triplet compound as the light emitting layer 15 which emits red light is shown, but further by using the triplet compound for the light emitting layer 16 which emits green light and the light emitting layer 17 which emits blue light, the operation voltages of the respective EL elements may be made the same.

Next, a circuit structure of a pixel portion of the light emitting device of the present invention is shown in FIGS. 2A and 2B. Note that, here a pixel including an EL element which emits red light (pixel (red)) 20a, a pixel including an EL element which emits green light (pixel (green)) 20b, and a pixel including an EL element which emits blue light (pixel (blue)) 20c are shown, and all the pixels have the same circuit structure.

In FIG. 2A, reference numerals 21 indicates a gate wiring, reference numerals 22a to 22c indicate source wirings (data wiring), and reference numerals 23a to 23c indicate current supply lines. The current supply lines 23a to 23c are wirings which determine the operation voltages of the EL elements, and the same voltage is applied to any of the pixels, the pixel 20a which emits red light, the pixel 20b which emits green light and the pixel 20c which emits blue light. Accordingly, the line width (thickness) of the wiring may all have the same design.

Further, reference numerals 24a to 24c indicate switching TFTs (TFTs for controlling the signal to be input to the gate of the current controlling TFT), and here the switching TFTs are formed of n-channel TFTs. Note that, here a structure where two channel forming regions exist between a source region and a drain region is illustrated, but there may be one or more than two channel forming regions.

Further, reference numerals 25a to 25c indicate current controlling TFTs (TFTs for controlling the current flowing in the EL element), and gate electrodes of the current controlling TFTs 25a to 25c are respectively connected to the switching TFTs 24a to 24c, source regions of the current controlling TFTs 25a to 25c are respectively connected to the current supply lines 23a to 23c, drain regions of the current controlling TFTs 25a to 25c are respectively connected to EL elements 26a to 26c. Note that, reference numerals 27a to 27c indicate capacitors which maintain the voltage applied to the

gate electrodes of the respective current controlling TFTs **25a** to **25c**. However, the capacitor **27a** to **27c** may be omitted.

Note that, FIG. 2A shows an example where the switching TFTs **24a** to **24c** formed of n-channel TFTs and the current controlling TFTs **25a** to **25c** formed of p-channel TFTs are provided. However, as shown in FIG. 2B, for pixel (red) **30a**, pixel (green) **30b** and pixel (blue) **30c**, switching TFTs **28a** to **28c** formed of p-channel TFTs and current controlling TFTs **29a** to **29c** formed of n-channel TFTs may also be provided, respectively.

Further, FIGS. 2A and 2B show an example where two TFTs are provided in one pixel, but the number of TFTs may be three or more (typically 3 to 6). In such a case, the n-channel TFTs and the p-channel TFTs may be combined in any way to be provided.

In FIGS. 2A and 2B, the EL element **26a** is an EL element emitting red color, and a triplet compound is used as a light emitting layer. Further, the EL element **26b** is an EL element which emits green light, the EL element **26c** is an EL element which emits blue light, and both use a singlet compound as the light emitting layer.

As described above, by using the triplet compound and the singlet compound properly, the operation voltages of the EL element which emits red light, the EL element which emits green light and the EL element which emits blue light may all be the same (10 V or less, preferably 3 to 10 V). Accordingly, it is possible to suppress the shift in color balance due to the difference in the life of the EL element, and the power source necessary for the light emitting device may be unified at 3 V or 5 V. Thus, there is an advantage that the circuit design becomes easier.

## BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagram showing a cross sectional structure of a pixel portion of a light emitting device of the present invention;

FIGS. 2A and 2B are diagrams showing circuit structures of the pixel portion of the light emitting device of the present invention;

FIG. 3 is a diagram showing a cross sectional structure of a pixel portion of a light emitting device of Embodiment 1;

FIG. 4 is a diagram showing a cross sectional structure of a pixel portion of a light emitting device of Embodiment 2;

FIG. 5 is a diagram showing a circuit structure of a pixel portion of a light emitting device of Embodiment 3;

FIG. 6 is a diagram showing a cross sectional structure of the pixel portion of the light emitting device of Embodiment 3;

FIG. 7 is a diagram showing a circuit structure of a pixel portion of a light emitting device of Embodiment 4;

FIG. 8 is a diagram showing a cross sectional structure of the pixel portion of the light emitting device of Embodiment 4;

FIG. 9 is a diagram showing a cross sectional structure of a pixel portion of a light emitting device of Embodiment 5;

FIGS. 10A and 10B are diagrams showing a structure of a driving circuit built-in light emitting device of Embodiment 6;

FIGS. 11A and 11B are diagrams showing a structure of a light emitting device externally mounted with a driver circuit of Embodiment 7;

FIGS. 12A and 12B are diagrams showing a structure of a light emitting device externally mounted with a controller of Embodiment 7;

FIGS. 13A to 13F are diagrams showing specific examples of electric apparatus of Embodiment 8; and

FIGS. 14A and 14B are diagrams showing other specific examples of electric apparatus of Embodiment 8.

## DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Embodiments of the present invention will be described in detail referring to the following embodiments.

[Embodiment 1]

In this embodiment, as a light emitting device of the present invention, an example of a light emitting device is shown, in which the device has a pixel portion **151** and a driver circuit **150** which drives the pixel portion on the same insulator (however, in a state before sealing). Note that, a CMOS circuit as a basic unit is shown for the driver circuit **150**, and one pixel is shown for the pixel portion **151**. However, in actuality the structure of the pixel portion is made by gathering a plurality of pixels as shown in FIG. 1.

In FIG. 3, reference numeral **100** indicates an insulator (including an insulating substrate, an insulating film or a substrate having an insulating film on the surface), with an n-channel TFT **201**, a p-channel TFT **202**, a switching TFT **203** formed of an n-channel TFT, and a current controlling TFT **204** formed of a p-channel TFT formed thereon. At this time, the circuit structure of the pixel portion is the structure shown in FIG. 2A. Further, in this embodiment, the TFTs are all formed of inverted stagger type TFTs.

First, the structures of the n-channel TFT **201** and the p-channel TFT **202** are described.

In the n-channel TFT **201**, reference numeral **101** indicates a gate electrode, reference numeral **102** indicates a gate insulating film, reference numeral **103** indicates a source region, reference numeral **104** indicates a drain region, reference numerals **105a** and **105b** indicate LDD (light doped drain) regions, reference numeral **106** indicates a channel forming region, reference numeral **107** indicates a channel protective film, reference numeral **108** indicates a first interlayer insulating film, reference numeral **109** indicates a source wiring, and reference numeral **110** indicates a drain wiring.

In the p-channel TFT **202**, reference numeral **111** indicates a gate electrode, reference numeral **102** indicates the gate insulating film, reference numeral **112** indicates a source region, reference numeral **113** indicates a drain region, reference numeral **114** indicates a channel forming region, reference numeral **115** indicates a channel protective film, reference numeral **108** indicates the first interlayer insulating film, reference numeral **116** indicates a source wiring and reference numeral **110** indicates the drain wiring. The drain wiring **110** is a wiring which is common with the n-channel TFT **201**.

The switching TFT **203** has a structure having two channel forming regions between a source region and a drain region. It may be easily understood with reference to the description of the structure of the n-channel TFT **201**, and thus, the explanation is omitted. Further, with reference to the description of the structure of the p-channel TFT **202**, the current controlling TFT **204** may be easily understood, and therefore the explanation is omitted.

Then, a second interlayer insulating film (leveling film) **119** is provided covering the n-channel TFT **201**, the p-channel TFT **202**, the switching TFT **203** and the current controlling TFT **204**.

Note that, before the second interlayer insulating film **119** is provided, a contact hole **118** is provided in the first interlayer insulating film **108** over a drain region **117** of the current controlling TFT **204**. This is for making the etching process easy when forming a contact hole in the second interlayer insulating film **119**.

Further, in the second interlayer insulating film **119**, a contact hole is formed to reach the drain region **117**, and a pixel electrode **120** connected to the drain region **117** is provided. The pixel electrode **120** functions as an anode of the EL element, and a conductive film with a large work function, typically an oxide conductive film is used. As the oxide conductive film, indium oxide, tin oxide, zinc oxide or a compound thereof may be used.

Next, reference numeral **121** indicates a bank, which is an insulating film provided to cover an end portion of the pixel electrode **120**. The bank **121** may be formed of an insulating film or a resin film including silicon. When using a resin film, carbon particles or metal particles are added so that the resistance of the resin film is made  $1 \times 10^6$  to  $1 \times 10^{12} \Omega\text{m}$  (preferably  $1 \times 10^8$  to  $1 \times 10^{10} \Omega\text{m}$ ). Thus, dielectric breakdown at the time of film formation may be suppressed.

Next, reference numeral **122** indicates an EL layer. Note that, in this specification, a laminate body with a hole injecting layer, a hole transporting layer, a hole preventing layer, an electron transporting layer, an electron injecting layer or an electron preventing layer combined with a light emitting layer is referred to as an EL layer. It is a feature of the present invention that the singlet compound and the triplet compound are used together as the light emitting layer.

Note that, in this embodiment, the triplet compound is used as an organic compound used in the EL element which emits red light, and the singlet compound is used as an organic compound used in the EL element which emits green light and the EL element which emits blue light. At this time as the triplet compound, the organic compounds mentioned above may be used, and as the singlet compound, an  $\text{Alq}_3$  (aluminum quinolinolate complex) with a fluorescent pigment coevaporated may be used.

Next, reference numeral **123** indicates a cathode of an EL element, which uses a conductive film with a small work function. As the conductive film with a small work function, a conductive film containing an element belonging to Group 1 or 2 of the periodic table may be used. In this embodiment, a conductive film formed of a compound of lithium and aluminum may be used.

Note that, a laminating body **205** formed of the pixel electrode (anode) **120**, the EL layer **122** and the cathode **123** is the EL element. The light emission generated by the EL element **205** is irradiated to the side of the insulator **100** (the direction of the arrow in the figure). Further, when using the p-channel TFT for the current controlling TFT **204** as in this embodiment, the drain region **117** of the current controlling TFT **204** is preferably connected with an anode of the EL element **205**.

Note that, although not shown here, after the formation of the cathode **123**, it is effective to provide a passivation film to completely cover the EL element **205**. The passivation film is formed of an insulating film including a carbon film, a silicon nitride film or a silicon nitride oxide film, and may be formed of a single layer or a lamination layer of the insulating film.

At this time, it is preferable to use a film with good coverage as the passivation film, and it is effective to use a carbon film, especially a DLC (diamond like carbon) film.

The DLC film may be formed in a temperature range between a room temperature and  $100^\circ\text{C}$ , and therefore, the DLC film may be easily formed above the EL layer **122** with low heat resistance. Further, the blocking effect of the DLC film to oxygen is high, and oxidation of the EL layer **122** may be suppressed. Therefore, the problem of oxidation of the EL layer **122** during the sealing process to be subsequently performed may be prevented.

In the light emitting device of the present invention having the pixel portion and the driver circuit with the above struc-

tures, the singlet compound and the triplet compound for the EL elements are used properly, so that the operation voltages of the EL elements may be made the same, and a good color display with excellent color balance may be performed.

Further, the operation voltages of the EL elements may all be made 10V or less (typically 3 to 10V), so that an advantage that the circuit design becomes easy is obtained.

[Embodiment 2]

In this embodiment, as a light emitting device of the present invention, an example of a light emitting device is shown, in which the device has a pixel portion and a driver circuit which drives the pixel portion on the same insulator (however, in a state before sealing). Note that, a CMOS circuit as a basic unit is shown for the driver circuit **250**, and one pixel is shown for the pixel portion **251**. However, in practice the structure of the pixel portion is made as shown in FIG. 1. Further, the portions with the same symbols attached as FIG. 3 may refer to the description of Embodiment 1.

In FIG. 4, reference numeral **100** indicates the insulator, with the n-channel TFT **201**, the p-channel TFT **202**, a switching TFT **206** formed of a p-channel TFT, and a current controlling TFT **207** formed of an n-channel TFT formed thereon. At this time, the circuit structure of the pixel portion **251** is the structure shown in FIG. 2B. Further, in this embodiment, the TFTs are all formed of inverted stagger type TFTs.

The descriptions of the n-channel TFT **201** and the p-channel TFT **202** may be referred to Embodiment 1 and thus the descriptions will be omitted. Further, the switching TFT **206** has a structure having two channel forming regions between a source region and a drain region, but may be easily understood by referring to the description of the structure of the p-channel TFT **202**. Thus, the description is omitted. In addition, the current controlling TFT **207** may be easily understood by referring to the description of the structure of the n-channel TFT **201**, and thus the description is omitted.

In the case of this embodiment, the structure of an EL element differs from that of Embodiment 1. A drain region **301** of the current controlling TFT **207** is connected with a pixel electrode **302**. The pixel electrode **302** is an electrode which functions as a cathode of an EL element **208**, and is formed using a conductive film containing an element belonging to Group 1 or 2 of the periodic table. In this embodiment, a conductive film formed of a compound of lithium and aluminum is used.

Further, the EL element **208** is formed of the pixel electrode (cathode) **302**, an EL layer **303** and an anode **304**. Note that, in this embodiment, a triplet compound is used as an organic compound used for an EL element which emits red light, and a singlet compound is used as an organic compound used for an EL element which emits green light and an EL element which emits blue light. At this time, as the triplet compound, the organic compounds mentioned above may be used, and as the singlet compound, an  $\text{Alq}_3$  (aluminum quinolinolate complex) with a fluorescent pigment coevaporated may be used.

Further, in this embodiment, as the anode **304**, an oxide conductive film with gallium oxide added to zinc oxide is used. Since the oxide conductive film transmits visible light, the light generated in the EL element **208** is irradiated toward the top surface of the anode **304** (in the direction of the arrow in the figure). Note that, when using the n-channel TFT for the current controlling TFT **207** as in this embodiment, it is preferable that the drain region **301** of the current controlling TFT **207** is connected to the cathode of the EL element **208**.

Note that, although not shown here, after the formation of the anode **304**, it is effective to provide a passivation film to completely cover the EL element **208**. The passivation film is

formed of an insulating film including a carbon film, a silicon nitride film or a silicon nitride oxide film, and may be formed of a single layer or a lamination layer of the insulating film.

In the light emitting device of the present invention having the pixel portion and the driver circuit with the above structures, the singlet compound and the triplet compound for the EL elements are used properly, so that the operation voltages of the EL elements may be made the same, and a good color display with excellent color balance may be performed.

Further, the operation voltages of the EL elements may all be made 10V or less (typically 3 to 10V), so that an advantage that the circuit design becomes easy is obtained.

Note that, the structure of this embodiment may be implemented in combination with the structure in Embodiment 1. [Embodiment 3]

In this embodiment, as a light emitting device of the present invention, a case where a pixel portion and a driver circuit are all formed of n-channel TFTs is described. Note that, the circuit structure of a pixel of this embodiment is as shown in FIG. 5. Further, the description in FIGS. 2A and 2B may be referred to for portions with the same symbols attached as in FIGS. 2A and 2B.

As shown in FIG. 5, the switching TFTs 24a to 24c and current controlling TFTs 36a to 36c formed respectively for a pixel (red) 35a, a pixel (green) 35b and a pixel (blue) 33c, are all formed of n-channel TFTs.

Here the cross sectional structure of the light emitting device of this embodiment (however, in a state before sealing) is shown in FIG. 6. Note that, a CMOS circuit as a basic unit is shown for the driver circuit 350, and one pixel is shown for the pixel portion 351. However, in actuality the structure of the pixel portion 351 is as shown in FIG. 1. Further, for the portions where the same symbols as in FIGS. 3 and 4 are attached, the description in Embodiments 1 or 2 may be referred to.

In FIG. 6, reference numeral 100 indicates the insulator, with the n-channel TFT 201, an n-channel TFT 209, the switching TFT 203 formed of an n-channel TFT, and the current controlling TFT 207 formed of an n-channel TFT formed thereon.

At this time, the circuit structure of the pixel portion is the structure shown in FIG. 5.

Further, in this embodiment, the TFTs are all formed of inverted stagger type TFTs.

At this time, the n-channel TFTs may all be enhancement type TFTs, or may all be depression type TFTs. Of course, both may be used properly in combination. The enhancement type or the depression type, may be selected by adding n-type or p-type impurities into the channel forming region.

The n-channel TFT 201 and the n-channel TFT 209 have the same structure. The explanation may be referred to Embodiment 1, and therefore is omitted. Further, the switching TFT 203 has a structure where two channel forming regions exist between a source region and a drain region, and it may be easily understood by referring to the description of the structure of the n-channel TFT 201. Therefore, the description is omitted. Further, the current controlling TFT 207 may easily be understood by referring to the description of the structure of the n-channel TFT 201, and therefore the description is omitted.

In the case of this embodiment, the structure of the EL element is the same as Embodiment 2. That is, in this embodiment, since an n-channel TFT is used for the current controlling TFT 207, it is preferable that the cathode 302 of the EL element 208 is connected to the drain region 301 of the current controlling TFT 207. Embodiment 2 may be referred to for the description related to the EL element.

Note that, although not shown here, after the formation of the anode 304, it is effective to provide a passivation film to completely cover the EL element 208. The passivation film is formed of an insulating film including a carbon film, a silicon nitride film or a silicon nitride oxide film, and may be formed of a single layer or a lamination layer of the insulating film.

In the light emitting device of the present invention having the pixel portion 351 and the driver circuit 350 with the above structures, the singlet compound and the triplet compound for the EL elements are used properly, so that the operation voltages of the EL elements may be made the same, and a good color display with excellent color balance may be performed. Further, since all the operation voltages of the EL elements may be made 10V or less (typically 3 to 10V), there is obtained an advantage that the circuit design is easily made.

Furthermore, according to the structure of this embodiment, a photolithography process for forming a p-channel TFT can be omitted. Thus, the manufacturing process can be simplified.

Note that the structure of this embodiment can be implemented in combination with the structure described in Embodiment 1 or Embodiment 2.

[Embodiment 4]

In this embodiment, the case where a pixel portion and a driver circuit are all formed of p-channel TFTs in a light emitting device of the present invention is explained. Note that the circuit configuration of a pixel in this embodiment is as shown in FIG. 7. In addition, the explanation for FIGS. 2A and 2B may be referred as to the portions indicated by the same reference symbols as those in FIGS. 2A and 2B.

As shown in FIG. 7, switching TFTs 51a to 51c and current controlling TFTs 52a to 52c, which are respectively provided in a pixel (red) 50a, a pixel (green) 50b, and a pixel (blue) 50c, are all formed of p-channel TFTs.

FIG. 8 shows a cross-sectional structure of the light emitting device in this embodiment (in the state before sealing). Note that a CMOS circuit as a basic unit is shown for the driver circuit and one pixel is shown for the pixel portion. However, in actuality, the structure of the pixel portion is as shown in FIG. 1. Further, the explanation in Embodiment 1 or Embodiment 2 may be referred to as to the portions indicated by the same reference symbols as those in FIG. 3 or FIG. 4.

In FIG. 8, reference numeral 100 indicates the insulator, with a p-channel TFT 210, the p-channel TFT 202, the switching TFT 206 formed of a p-channel TFT, and the current controlling TFT 204 formed of a p-channel TFT formed thereon. At this time, the circuit configuration of the pixel portion 451 is as shown in FIG. 7.

Further, in this embodiment, the TFTs are all formed of p-channel inverted stagger type TFTs. At this time, all the p-channel TFTs may be enhancement type TFTs and may be depression type TFTs. Of course, the p-channel TFTs may be formed of using both types of the TFTs properly in combination. The enhancement type or the depression type may be selected by adding an n-type impurity or a p-type impurity in a channel forming region.

The p-channel TFT 210 and the p-channel TFT 202 have the same structure, and the explanation therefor is omitted since Embodiment 1 may be referred thereto. Further, the switching TFT 206 has the structure in which two channel forming regions are interposed between a source region and a drain region. Since the switching TFT 206 can be easily understood with reference to the explanation for the structure of the p-channel TFT 202, the explanation therefor is omitted. In addition, since the current controlling TFT 204 can be easily understood with reference to the explanation for the p-channel TFT 202, the explanation therefor is omitted.

In case of this embodiment, the structure of an EL element is the same as that in Embodiment 1. That is, in this embodiment, a p-channel TFT is used for the current controlling TFT **204**, and thus, it is preferable that the drain region **117** of the current controlling TFT **204** is connected with the anode **120** of the EL element **205**. The explanation for the EL element may be referred to Embodiment 1.

Note that although not shown, it is effective to provide a passivation film so as to entirely cover the EL element **205** after the formation of the cathode **123**. A single layer or a lamination layer of the insulating film comprising a carbon film, a silicon nitride film, or a silicon oxide nitride film is used for the passivation film.

In a light emitting device of the present invention, which includes the pixel portion **451** and the driver circuit **450** having the above structures, the operation voltages of the EL elements may be made the same since a singlet compound and a triplet compound are properly used for the EL elements. Thus, a good color display with excellent color balance may be realized.

Further, since all the operation voltages of the EL elements may be made 10 V or less (typically 3 to 10 V), there is obtained an advantage that the circuit design is easily made.

Furthermore, according to the configuration of this embodiment, a photolithography process for forming an n-channel TFT can be omitted. Thus, the manufacturing process can be simplified.

Note that the configuration of this embodiment can be implemented in combination with the configuration described in Embodiment 1 or Embodiment 2.

[Embodiment 5]

An example of using the top gate TFT (specifically planar TFT) as a switching TFT and the current control TFT is shown in this embodiment.

FIG. 9 shows a cross sectional structure of the pixel portion in the active matrix type light emitting device of this embodiment. In FIG. 9, reference numeral **910** shows an insulator, reference numeral **911** shows a current control TFT, reference numeral **912** shows a pixel electrode (anode), reference numeral **913** shows a bank, reference numeral **914** shows a known hole injecting layer, reference numeral **915** shows a light emitting layer which emits red color, reference numeral **916** shows a light emitting layer which emits green color, reference numeral **917** shows a light emitting layer which emits blue color, reference numeral **918** shows a known electron transporting layer, and reference numeral **919** shows a cathode.

Here in this embodiment, a triplet compound is used as a light emitting layer **915** which emits red color, and a singlet compound is used as a light emitting layer **916** which emits green color and a light emitting layer **917** which emits blue color. That is, an EL element using a singlet compound is an EL element which emits green color or blue color, and an EL element using the above-mentioned triplet compound is an EL element which emits red color.

However, in this embodiment since a triplet compound with high luminous efficiency is used as the light emitting layer **915** which emits red color, the same light emitting brightness as the light emitting layer **916** which emits green color and the light emitting layer **917** which emits blue color may be obtained while the operation voltage is made the same. Accordingly, the deterioration of the light emitting layer **915** which emits red color does not progress significantly, and color display may be performed without causing a problem such as color shift. Further, suppression of the operation voltage is preferable considering that the margin of the resistance of the transistor may be set low.

Note that, in this embodiment an example of using a triplet compound as the light emitting layer **915** which emits red color is shown, and a triplet compound may be used as the light emitting layer **916** which emits green color or the light emitting layer **917** which emits blue color.

A circuit structure in the case this embodiment is implemented is shown in FIG. 2.

Note that, the structures of this embodiment may be implemented in combination with any of the structures of Embodiments 1 to 4.

[Embodiment 6]

Further, the light emitting device of the embodiment after the seal (or encapsulation) step for protecting the EL element is performed will be described with reference to FIGS. **10A** and **10B**. An example of the seal step of structure shown in Embodiment 1 (FIG. 3). Further the seal structure of this embodiment may be implemented in combination with any of the structures of Embodiments 1 to 5. Note that, reference numerals used in FIG. 3 is cited as needed.

FIG. **10A** is a top view showing a state where steps up to sealing of an EL element are performed, and FIG. **10B** is a cross sectional view of FIG. **10A** taken along with the line A-A'. Reference numeral **501** of a portion shown by a dotted line designates a pixel portion; **502**, a source side driving circuit, and **503**, a gate side driving circuit. Reference numeral **504** designates a cover member; **505**, a first seal member, and **506**, a second seal member.

Note that, reference numeral **508** designates a wiring line for transmitting signals inputted to the source side driving circuit **502** and the gate side driving circuit **503**, which receives a video signal and a clock signal from an FPC (Flexible Print Circuit) as an external input terminal. Note that, although only the FPC is shown here, a print wiring board (PWB) may be attached to the FPC.

Next, a cross sectional structure will be described with reference to FIG. **10B**. A pixel portion **501** and a source side driving circuit **502** are formed on the top of an insulator **100**, and the pixel portion **501** is formed of a plurality of pixels including a current controlling TFT **204** and a pixel electrode **120** electrically connected to its drain. The source side driving circuit **502** is formed by using a CMOS circuit in which an n-channel TFT **201** and a p-channel TFT **202** are combined. Note that, a polarizing plate (typically, a circular polarizing plate) may be bonded to the insulator **501**.

The pixel electrode **120** functions as an anode of the EL element. Banks **121** are formed at both ends of the pixel electrode **120**, and an EL layer **122** and a cathode **123** of the EL element are formed on the pixel electrode **120**. The cathode **123** functions also as a wiring line common to all pixels, and is electrically connected to the FPC **508** through the connection wiring line **507**. Further, all elements included in the pixel portion **501** and the source side driving circuit **502** are covered with a passivation film **509**.

A cover member **504** is bonded with a first seal member **505**. A spacer may be provided to secure an interval between the cover member **504** and the EL element.

A space **510** is formed inside of the first seal member **505**. It is desirable that the first seal member **505** is a material which water or oxygen does not permeate. Further, it is effective to provide a material having a moisture absorption effect or a material having an oxidation preventing effect in the inside of the space **510**.

Note that, it is appropriate that carbon films (specifically, diamond-like carbon films) **511a** and **511b** as protection films are formed to a thickness of 2 to 30 nm on the front surface and the rear surface of the cover member **504**. The carbon film

like this has a role to prevent the infiltration of oxygen and water and to mechanically protect the surface of the cover member **504**.

Besides, after the cover member **504** is adhered, a second seal member **506** is provided so as to cover the exposed surface of the first seal member **505**. The second seal member **506** can be made of the same material as the first seal member **505**.

By encapsulating the EL element in the structure as described above, the EL element can be completely cut off from the outside, and it is possible to prevent a material accelerating deterioration due to oxidation of the EL layer such as moisture or oxygen, from infiltrating from the outside. Accordingly, the light emitting device having high reliability can be obtained.

Note that, as shown in FIGS. **10A** and **10B**, the light emitting device in which the pixel portion and the driving circuit are provided on the same substrate and the FPC is attached, is especially called a driving circuit built-in light emitting device in the present specification.

[Embodiment 7]

In Embodiment 6, the driving circuit built-in light emitting device shown in FIGS. **10A** and **10B** is given as the example in which a pixel portion and a driver circuit are integrally formed on the same insulator. However, it is possible to provide the driver circuit as an external IC (integrated circuit). In this case, the structure is as shown in FIG. **11A**.

In the module shown in FIG. **11A**, a substrate **60** (including a pixel portion **61** and wirings **62a** and **62b**), on which the pixel portion including a TFT and an EL element is formed, is provided with an FPC **63**, and a printed wiring board **64** is attached to the substrate **60** through the FPC **63**. Here, FIG. **11B** is a functional block diagram of the printed wiring board **64**.

As shown in FIG. **11B**, an IC functioning as at least I/O ports (also referred to as input or output portions) **65** and **68**, a source driver circuit **66**, and a gate driver circuit **67** is provided inside the printed wiring board **64**.

As described above, a module in which an FPC is attached to a substrate on which a pixel portion is formed, and a printed wiring board having a function of a driver circuit is attached to the substrate through the FPC is referred to as a light emitting module with an external driver circuit particularly in this specification.

Further, in the module shown in FIG. **12A**, an FPC **74** is attached to a driving circuit built-in light emitting device **70** (including a pixel portion **71**, a source driver circuit **72**, a gate driver circuit **73**, and wirings **72a** and **73a**), and a printed wiring board **75** is attached to the light emitting device **70** through the FPC **74**. Here, FIG. **12B** is a functional block diagram of the printed wiring board **75**.

As shown in FIG. **12B**, an IC functioning as at least I/O ports **76** and **79**, and a control portion **77** is provided inside the printed wiring board **75**. Note that a memory portion **78** is provided here, but it is not necessarily required. Further, the control portion **77** has a function for controlling a driver circuit, correction of image data and the like.

As described above, a module in which a printed wiring board having a function of a controller is attached to a driving circuit built-in light emitting device in which a pixel portion and a driver circuit are formed on a surface of a substrate is referred to as a light emitting module with an external controller particularly in this specification.

[Embodiment 8]

The light-emitting device (including the module of which state is shown in Embodiment 7) formed by implementing this invention may be used as a display portion of various

electrical apparatuses. As electrical apparatuses of this invention, there are such as a video camera, a digital camera, a goggle type display (head mounted display), a navigation system, a audio equipment, a note type personal computer, a game apparatus, a portable information terminal (such as a mobile computer, a portable telephone, a portable game apparatus or an electronic book), and an image playback device with a recording medium. Specific examples of the electronic equipment are shown in FIGS. **13A-13B** and **14A-14B**.

FIG. **13A** shows an EL display and includes a casing **2001**, a supporting base **2002** and a display portion **2003**. The light-emitting device of this invention may be used for the display portion **2003**. When using the EL light-emitting device in the display portion **2003**, it is a self-light emitting type so that a back light is not necessary and the display portion may be made thin.

FIG. **13B** shows a video camera, which contains a main body **2101**, a display portion **2102**, a sound input portion **2103**, operation switches **2104**, a battery **2105**, and an image receiving portion **2106**. The light-emitting device and the liquid crystal display device of this invention can be applied to the display portion **2102**.

FIG. **13C** shows a digital camera, which contains a main body **2201**, a display portion **2202**, an eye contact portion **2203**, and operation switches **2204**. The light emitting-device of this invention can be applied to the display portion **2202**.

FIG. **13D** shows an image playback device equipped with a recording medium (specifically, a DVD playback device), which contains a main body **2301**, a recording medium (such as a CD, LD or DVD) **2302**, operation switches **2303**, a display portion (a) **2304**, a display portion (b) **2305** and the like. The display portion (a) is mainly used for displaying image information. The display portion (b) **2305** is mainly used for displaying character information. The light-emitting device of this invention can be applied to the display portion (a) and the display portion (b). Note that, the image playback device equipped with the recording medium includes devices such as CD playback device, and game machines.

FIG. **13E** shows a portable (mobile) computer, which contains a main body **2401**, a display portion **2402**, an image receiving portion **2403**, operation switches **2404** and a memory slot **2405**. The light-emitting device of this invention can be applied to the display portion **2402**. This portable computer may record information to a recording medium that has accumulated flash memory or non-volatile memory, and playback such information.

FIG. **13F** shows a personal computer, which contains a main body **2501**, a casing **2502**, a display portion **2503**, and a keyboard **2504**. The light-emitting device of this invention can be applied to the display portion **2503**.

The above electronic apparatuses more often display information sent through electron communication circuits such as the Internet or the CATV (cable television), and especially image information display is increasing. When using the light-emitting device having the EL element in the display portion, since the response speed of the EL element is extremely fast, it becomes possible to display pictures without delay.

Further, since the light emitting portion of the light-emitting device consumes power, it is preferable to display information so that the light emitting portion is as small as possible. Therefore, when using the light-emitting device in the portable information terminal, especially in the display portion where character information is mainly shown in a cellular phone or an audio equipment, it is preferable to drive so that the character information is formed of a light emitting portion with the non-light emitting portion as a background.



Here, FIG. 14A shows a portable telephone, and reference numeral **2601** shows a portion (operation portion) which performs key operation, and reference numeral **2602** shows a portion which performs information display (information display portion), and the operation portion **2601** and the information display portion **2602** are connected by the connecting portion **2603**. Further, the operation portion **2601** is provided with a sound input portion **2604**, operation switches **2605**, and the information display portion **2602** is provided with a sound output portion **2606**, a display portion **2607**.

The light-emitting device of this invention may be used as the display portion **2607**.

Note that, when using the light-emitting device to the display portion **2607**, the consumption power of the portable telephone may be suppressed by displaying white letters in the background of the black color.

In the case of the portable telephone shown in FIG. 14A, the light-emitting device used in the display portion **2604** is incorporated with a sensor (a CMOS sensor) by a CMOS circuit, and may be used as an authentication system terminal for authenticating the user by reading the fingerprints or the hand print of the user. Further, light emission may be performed by taking into consideration the brightness (illumination) of outside and making information display at a contrast that is already set.

Further, the low power consumption may be attained by decreasing the brightness when using the operating switch **2605** and increasing the brightness when the use of the operation switch is finished. Further, the brightness of the display portion **2604** is increased when a call is received, and low power consumption is attained by decreasing the brightness during a telephone conversation. Further, when using the telephone continuously, by making it have a function so that display is turned off by time control unless it is reset, low power consumption is realized. It should be noted that this control may be operated by hand.

Further, FIG. 14B shows a car mounted type audio, which contains a casing **2701**, a display portion **2702**, and operation switches **2703** and **2704**. The light-emitting device this invention can be applied to the display portion **2702**. Further, in this embodiment, a car mounted audio (car audio) is shown, but it may be used in a fixed type audio (audio component). Note that, when using a light-emitting device in the display portion **2704**, by displaying white characters in a black background, power consumption may be suppressed.

Further, electrical apparatuses shown above are incorporated with a light sensor in the light-emitting device which are used in the display portion, and it is possible to provide means to detect the brightness of the environment of use. When using the light-emitting device in the display portion, it is may have a function that modulates the light-emission brightness according to the brightness of the environment of use.

Specifically, this is implemented by providing an image sensor (surface shape, linear or a dotted sensor) formed by a CMOS circuit on the light-emitting device using the display portion, and providing a CCD (charge coupled device) on the main body or the casing. The user may recognize the image or the character information without trouble if a brightness of a contrast ratio of 100 to 150 may be maintained as compared to the brightness of the environment of use. Namely, in the case the environment of use is dark, it is possible to suppress the consumption power by suppressing the brightness of the image.

As in the above, the applicable range of this invention is extremely wide, and may be used for various electrical equipment. Further, the electrical apparatuses of this embodiment

may use the light-emitting device and module containing any of the structures of Embodiments 1 to 7.

By implementing the present invention, the operation voltages of the EL element which emits red light, the EL element which emits green light, the EL element which emits blue light may be made the same, and a light emitting device which may perform a color display with good color balance may be provided.

Further, by using a light emitting device which may perform color display with a good color balance in the display portion, an electric appliance having a good quality display portion may be provided.

What is claimed is:

1. A semiconductor device comprising:

a display portion over a first substrate, the display portion comprising a first pixel and a second pixel, wherein each of the first pixel and the second pixel comprises:

a transistor comprising a gate electrode, a gate insulating layer, a semiconductor layer, a source electrode, and a drain electrode;

an interlayer insulating film over the transistor;

a pixel electrode over the interlayer insulating film, the pixel electrode being electrically connected to one of the source electrode and the drain electrode;

a first insulating layer over the interlayer insulating film, the first insulating layer covering an edge portion of the pixel electrode;

an electroluminescent layer over the pixel electrode and the first insulating layer, the electroluminescent layer comprising a light-emitting layer;

a cathode over the electroluminescent layer,

wherein the electroluminescent layer in the first pixel includes iridium, and

wherein the electroluminescent layer in the second pixel comprises a fluorescent material.

2. The semiconductor device according to claim 1, further comprising a second insulating layer over the cathode.

3. The semiconductor device according to claim 1, wherein the first pixel and the second pixel are red emissive and blue emissive, respectively.

4. The semiconductor device according to claim 1, wherein the pixel electrode and the cathode are configured so that light emitted in the light-emitting layer is extracted through the cathode.

5. The semiconductor device according to claim 1, wherein the first insulating layer has a taper shape.

6. The semiconductor device according to claim 1, further comprising a second substrate over the cathode,

wherein the first substrate and the second substrate are bonded to each other with a first sealant and a second sealant,

wherein the second sealant is located outside the first sealant and in contact with a side surface of the first substrate and a side surface of the second substrate.

7. The semiconductor device according to claim 6, further comprising:

a wiring over the first substrate, the wiring being covered by the first sealant; and

a flexible printed circuit connected to the wiring.

8. An electronic device comprising the semiconductor device according to claim 1, wherein the display portion is configured to modulate luminance in accordance with brightness of environment of use.

9. An electronic device comprising:

a housing equipped with a charge coupled device and the semiconductor device according to claim 1.

17

10. A semiconductor device comprising:  
 a display portion over a first substrate, the display portion  
 comprising a first pixel and a second pixel,  
 wherein each of the first pixel and the second pixel com-  
 prises:  
     a semiconductor layer;  
     a gate electrode over the semiconductor layer;  
     a source electrode and a drain electrode connected to the  
     semiconductor layer;  
     a pixel electrode connected to one of the source elec-  
     trode and the drain electrode;  
     a first insulating layer covering an edge portion of the  
     pixel electrode;  
     an electroluminescent layer over the pixel electrode and  
     the first insulating layer, the electroluminescent layer  
     comprising a light-emitting layer; and  
     a cathode over the electroluminescent layer,  
 wherein the electroluminescent layer in the first pixel  
 includes iridium, and  
 wherein the electroluminescent layer in the second pixel  
 comprises a fluorescent material.
11. The semiconductor device according to claim 10, fur-  
 ther comprising a second insulating layer over the cathode.
12. The semiconductor device according to claim 10,  
 wherein the first pixel and the second pixel are red emissive  
 and blue emissive, respectively.

18

13. The semiconductor device according to claim 10,  
 wherein the pixel electrode and the cathode are configured so  
 that light emitted in the light-emitting layer is extracted  
 through the cathode.
14. The semiconductor device according to claim 10,  
 wherein the first insulating layer has a taper shape.
15. The semiconductor device according to claim 10, fur-  
 ther comprising a second substrate over the cathode,  
 wherein the first substrate and the second substrate are  
 bonded to each other with a first sealant and a second  
 sealant,  
 wherein the second sealant is located outside the first seal-  
 ant and in contact with a side surface of the first substrate  
 and a side surface of the second substrate.
16. The semiconductor device according to claim 15, fur-  
 ther comprising:  
     a wiring over the first substrate, the wiring being covered  
     by the first sealant; and  
     a flexible printed circuit connected to the wiring.
17. An electronic device comprising the semiconductor  
 device according to claim 10, wherein the display portion is  
 configured to modulate luminance in accordance with bright-  
 ness of environment of use.
18. An electronic device comprising:  
     a housing equipped with a charge coupled device and the  
     semiconductor device according to claim 10.

\* \* \* \* \*

UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

PATENT NO. : 8,907,559 B2  
APPLICATION NO. : 14/198852  
DATED : December 9, 2014  
INVENTOR(S) : Shunpei Yamazaki

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

In the Specification

Column 4, line 65, replace "23a" with --25a--;

Column 9, line 25, replace "33c" with --35c--;

Column 10, line 22, after "Embodiment" replace "I" with --1--;

Column 12, line 26, after "circuit" replace ",", with --;--;

Column 12, line 28, after "member" replace ",", with --;--; and

Column 14, line 50, replace "2303" with --2503--.

Signed and Sealed this  
Twenty-first Day of July, 2015



Michelle K. Lee  
*Director of the United States Patent and Trademark Office*

专利名称(译)	具有多个像素的显示部分的半导体器件		
公开(公告)号	<a href="#">US8907559</a>	公开(公告)日	2014-12-09
申请号	US14/198852	申请日	2014-03-06
[标]申请(专利权)人(译)	株式会社半导体能源研究所		
申请(专利权)人(译)	半导体能源研究所有限公司.		
当前申请(专利权)人(译)	半导体能源研究所有限公司.		
[标]发明人	YAMAZAKI SHUNPEI		
发明人	YAMAZAKI, SHUNPEI		
IPC分类号	H01L51/30 H05B33/00 H01L51/50 H05B33/14 B32B9/00 B32B19/00 H01J1/62 H01L51/00 H01L27/32 H01L27/00		
CPC分类号	H01L51/0077 H01L27/3211 H01L51/5016 H01L27/3244 H01L51/0085 Y10S428/917 H01L27/3246 H01L27/1214 H01L27/3248 H01L27/3262 H01L51/0087 H01L51/5234 H01L2251/301		
代理机构(译)	FISH & RICHARDSON P.C.		
优先权	2000168325 2000-06-05 JP 13/045614 2012-11-06 US 12/049423 2011-03-29 US 11/105414 2008-07-15 US 09/871805 2008-03-04 US		
其他公开文献	US20140183542A1		
外部链接	<a href="#">Espacenet</a> <a href="#">USPTO</a>		

# 摘要(译)

提供一种发光装置，其能够实现具有良好色彩平衡的彩色显示。三重化合物用于发射红色的EL元件的发光层，单重化合物用于发射绿色的EL元件的发光层和发射蓝色的EL元件的发光层颜色。因此，发射红色的EL元件的工作电压可以与发射绿色的EL元件和发射蓝色的EL元件相同。因此，可以实现具有良好色彩平衡的彩色显示。

