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(54) **SOLUTION PROCESSABLE DOPED TRIARYLAMINE HOLE INJECTION MATERIALS**

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(57) **ABSTRACT**

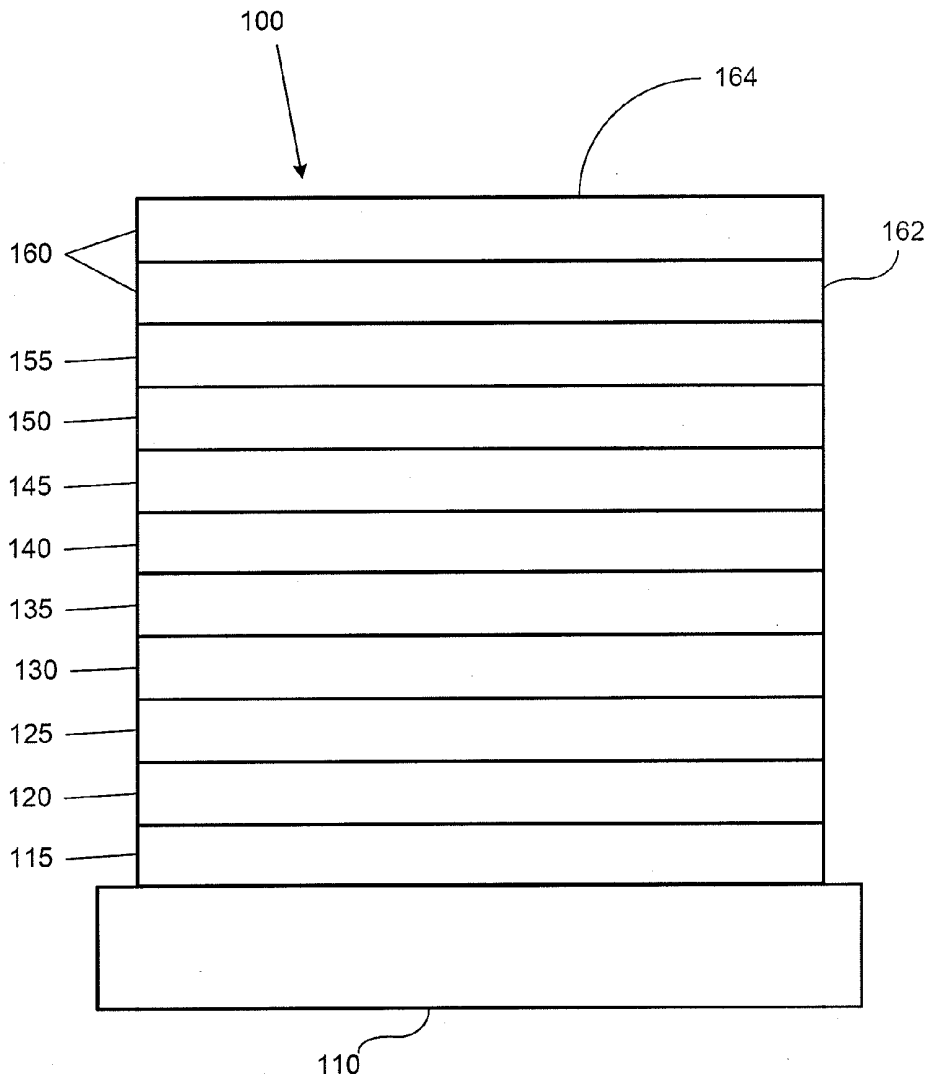
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Methods for fabricating a solution-processed OLED are provided. The methods include depositing an organic layer comprising mixture of an organic electron acceptor and an organic electron donor to form a layer that is insoluble to a non-polar solvent. Devices containing the organic layer may demonstrate improved lifetime and have a lower operating voltage while maintaining good luminous efficiency.

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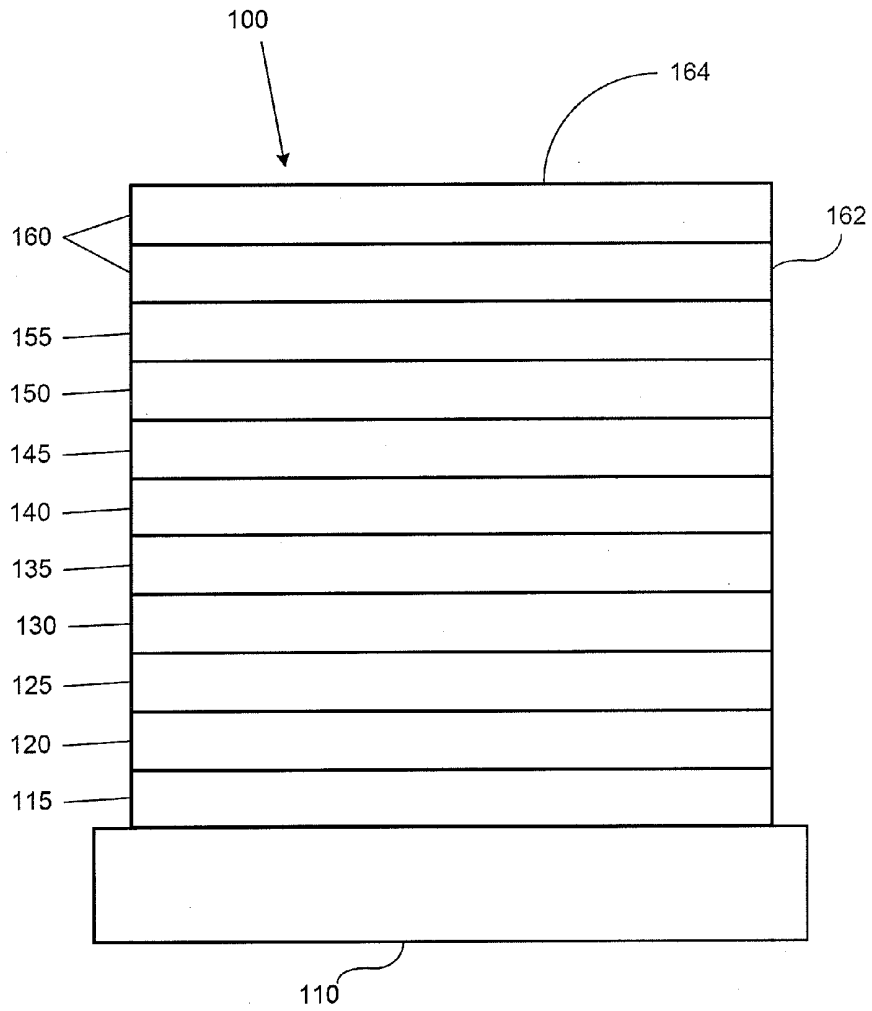


FIGURE 1

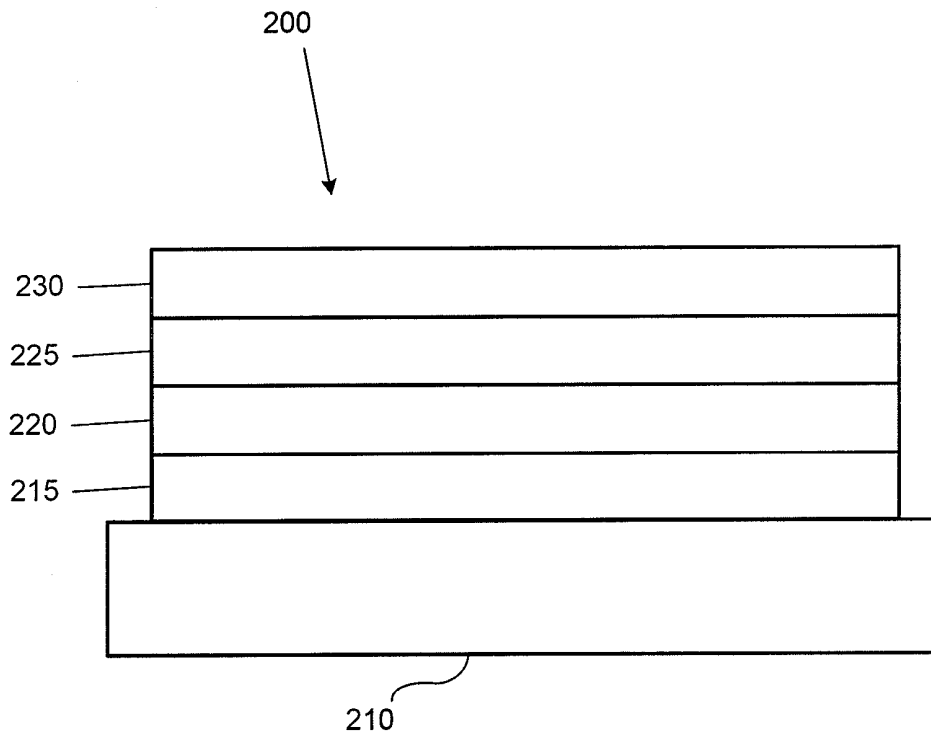


FIGURE 2

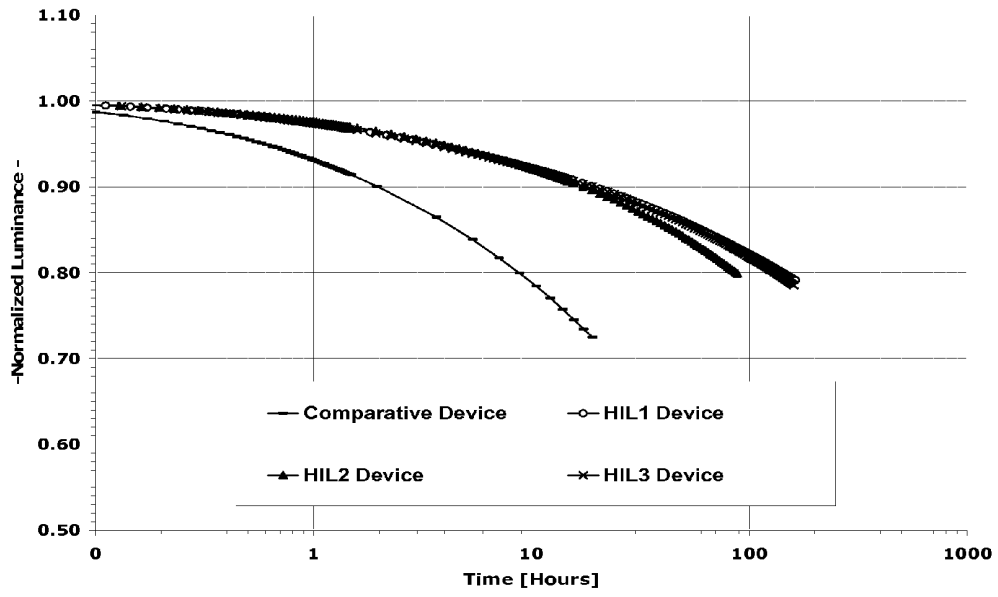


FIGURE 3

**SOLUTION PROCESSABLE DOPED
TRIARYLAMINE HOLE INJECTION
MATERIALS**

[0001] The claimed invention was made by, on behalf of, and/or in connection with one or more of the following parties to a joint university corporation research agreement: Regents of the University of Michigan, Princeton University, The University of Southern California, and the Universal Display Corporation. The agreement was in effect on and before the date the claimed invention was made, and the claimed invention was made as a result of activities undertaken within the scope of the agreement.

FIELD OF THE INVENTION

[0002] The present invention relates to organic light emitting devices (OLEDs). More specifically, the present invention relates to methods for fabricating a device containing an organic layer comprising an organic electron donor and an organic electron acceptor that forms a layer insoluble to a non-polar solvent, and devices containing the organic layer.

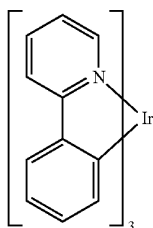
BACKGROUND

[0003] Opto-electronic devices that make use of organic materials are becoming increasingly desirable for a number of reasons. Many of the materials used to make such devices are relatively inexpensive, so organic opto-electronic devices have the potential for cost advantages over inorganic devices. In addition, the inherent properties of organic materials, such as their flexibility, may make them well suited for particular applications such as fabrication on a flexible substrate. Examples of organic opto-electronic devices include organic light emitting devices (OLEDs), organic phototransistors, organic photovoltaic cells, and organic photodetectors. For OLEDs, the organic materials may have performance advantages over conventional materials. For example, the wavelength at which an organic emissive layer emits light may generally be readily tuned with appropriate dopants.

[0004] OLEDs make use of thin organic films that emit light when voltage is applied across the device. OLEDs are becoming an increasingly interesting technology for use in applications such as flat panel displays, illumination, and backlighting. Several OLED materials and configurations are described in U.S. Pat. Nos. 5,844,363, 6,303,238, and 5,707,745, which are incorporated herein by reference in their entirety.

[0005] One application for phosphorescent emissive molecules is a full color display. Industry standards for such a display call for pixels adapted to emit particular colors, referred to as "saturated" colors. In particular, these standards call for saturated red, green, and blue pixels. Color may be measured using CIE coordinates, which are well known to the art.

[0006] One example of a green emissive molecule is tris(2-phenylpyridine) iridium, denoted Ir(ppy)₃, which has the structure:



[0007] In this, and later figures herein, we depict the dative bond from nitrogen to metal (here, Ir) as a straight line.

[0008] As used herein, the term "organic" includes polymeric materials as well as small molecule organic materials that may be used to fabricate organic opto-electronic devices. "Small molecule" refers to any organic material that is not a polymer, and "small molecules" may actually be quite large. Small molecules may include repeat units in some circumstances. For example, using a long chain alkyl group as a substituent does not remove a molecule from the "small molecule" class. Small molecules may also be incorporated into polymers, for example as a pendent group on a polymer backbone or as a part of the backbone. Small molecules may also serve as the core moiety of a dendrimer, which consists of a series of chemical shells built on the core moiety. The core moiety of a dendrimer may be a fluorescent or phosphorescent small molecule emitter. A dendrimer may be a "small molecule," and it is believed that all dendrimers currently used in the field of OLEDs are small molecules.

[0009] As used herein, "top" means furthest away from the substrate, while "bottom" means closest to the substrate. Where a first layer is described as "disposed over" a second layer, the first layer is disposed further away from substrate. There may be other layers between the first and second layer, unless it is specified that the first layer is "in contact with" the second layer. For example, a cathode may be described as "disposed over" an anode, even though there are various organic layers in between.

[0010] As used herein, "solution processible" means capable of being dissolved, dispersed, or transported in and/or deposited from a liquid medium, either in solution or suspension form.

[0011] A ligand may be referred to as "photoactive" when it is believed that the ligand directly contributes to the photoactive properties of an emissive material. A ligand may be referred to as "ancillary" when it is believed that the ligand does not contribute to the photoactive properties of an emissive material, although an ancillary ligand may alter the properties of a photoactive ligand.

[0012] As used herein, and as would be generally understood by one skilled in the art, a first "Highest Occupied Molecular Orbital" (HOMO) or "Lowest Unoccupied Molecular Orbital" (LUMO) energy level is "greater than" or "higher than" a second HOMO or LUMO energy level if the first energy level is closer to the vacuum energy level. Since ionization potentials (IP) are measured as a negative energy relative to a vacuum level, a higher HOMO energy level corresponds to an IP having a smaller absolute value (an IP that is less negative). Similarly, a higher LUMO energy level corresponds to an electron affinity (EA) having a smaller absolute value (an EA that is less negative). On a conventional energy level diagram, with the vacuum level at the top, the LUMO energy level of a material is higher than the HOMO energy level of the same material. A "higher" HOMO or LUMO energy level appears closer to the top of such a diagram than a "lower" HOMO or LUMO energy level.

[0013] As used herein, and as would be generally understood by one skilled in the art, a first work function is "greater than" or "higher than" a second work function if the first work function has a higher absolute value. Because work functions are generally measured as negative numbers relative to vacuum level, this means that a "higher" work function is more negative. On a conventional energy level diagram, with the vacuum level at the top, a "higher" work function is

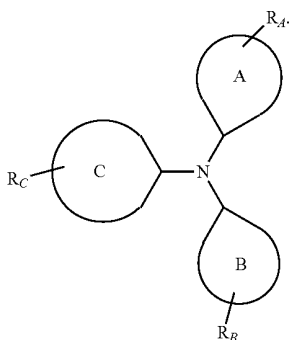
illustrated as further away from the vacuum level in the downward direction. Thus, the definitions of HOMO and LUMO energy levels follow a different convention than work functions.

[0014] More details on OLEDs, and the definitions described above, can be found in U.S. Pat. No. 7,279,704, which is incorporated herein by reference in its entirety.

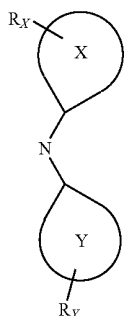
SUMMARY OF THE INVENTION

[0015] A method of fabricating an organic light emitting device is provided. The method comprises providing an electrode, depositing a first organic layer in contact with the electrode by a solution process, and heating the first organic layer to form a layer that is insoluble in a non-polar solvent. Preferably, the electrode is an anode, and the first organic layer is deposited in contact with the anode.

[0016] The first organic layer comprises an organic electron acceptor and an organic electron donor having the formula:

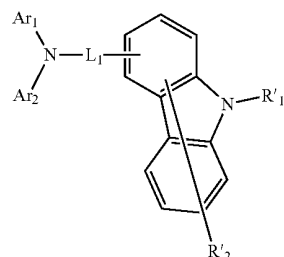


[0017] A, B, and C are 5 or 6 membered cyclic or heterocyclic rings. R_A , R_B , and R_C are independent selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl. R_A , R_B , and R_C are optionally fused to A, B, and C. At least two of R_A , R_B , and R_C contain the structure:



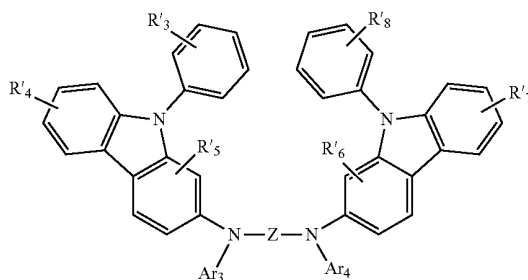
[0018] X and Y are independently 5 or 6 membered cyclic or heterocyclic rings. R_X and R_Y are independently selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl. R_X and R_Y are optionally fused to X and Y. R_X and R_Y are optionally connected to A and B.

[0019] In one aspect, the organic electron donor has the formula:



[0020] L_1 represents a substituted or unsubstituted arylene group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted fluorenylene group, or a substituted or unsubstituted heteroarylene group having 5 to 60 atoms forming a ring; Ar_1 and Ar_2 each independently represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring or a substituted or unsubstituted heteroaryl group having 5 to 60 atoms forming a ring; R'_1 represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring; R'_2 represents a hydrogen atom, a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted alkyl group having 1 to 50 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 50 carbon atoms, a substituted or unsubstituted aryloxy group having 6 to 50 atoms forming a ring, a substituted or unsubstituted arylthio group having 5 to 50 atoms forming a ring, a substituted or unsubstituted alkoxycarbonyl group having 2 to 50 carbon atoms, an amino group substituted by a substituted or unsubstituted aryl group having 6 to 50 carbon atoms forming the aromatic ring, a halogen atom, a cyano group, a nitro group, a hydroxyl group or a carboxyl group; with the proviso that neither Ar_1 nor Ar_2 contains a fluorene structure, and that the number of a carbazole structures in the aromatic amine derivative represented by the formula is 1 or 2.

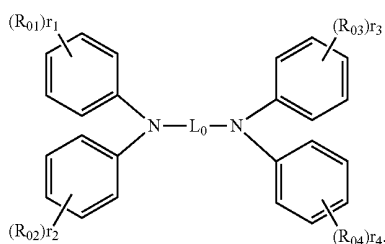
[0021] In another aspect, the organic electron donor has the formula:



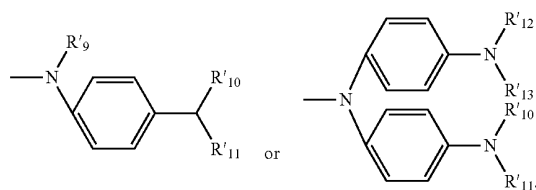
[0022] Z is selected from the group consisting of a substituted or unsubstituted C1-C30 alkylene group, a substituted or unsubstituted C2-C30 alkenylene group, a substituted or unsubstituted C6-C30 arylene group, a substituted or unsubstituted C2-C30 heteroarylene group, and a substituted or unsubstituted C2-C30 heterocyclic group; each of R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 is independently selected from the group

consisting of a hydrogen atom, a substituted or unsubstituted C1-C30 alkyl group, a substituted or unsubstituted C1-C30 alkoxy group, a substituted or unsubstituted C6-C30 aryl group, a substituted or unsubstituted C6-C30 aryloxy group, a substituted or unsubstituted C2-C30 heterocyclic group, a substituted or unsubstituted C6-C30 condensed polycyclic group, a hydroxy group, a cyano group, and a substituted or unsubstituted amino group, and, alternatively, two or more adjacent groups among R₁['], R₂['], R₃['], R₄['], R₅['], R₆['], R₇['], and R₈['] can be connected to each other to form a saturated or unsaturated carbocycle; and wherein each of Ar₃ and Ar₄ are independently a substituted or unsubstituted C6-C30 aryl group or a substituted or unsubstituted C2-C30 heteroaryl group.

[0023] In yet another aspect, the organic electron donor has the formula:

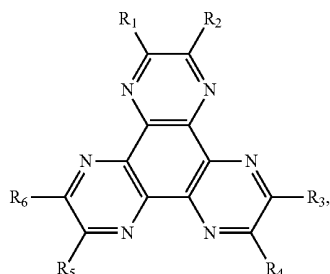


[0024] L₀ is any one of o-, p-, and m-phenylene groups which have two, three or four rings and which have a substituent with the proviso that when L₀ is a phenylene group having four rings, the phenylene group may have an unsubstituted or substituted aminophenyl group somewhere therein, and R₀₁, R₀₂, R₀₃ and R₀₄ are any one of the following groups:



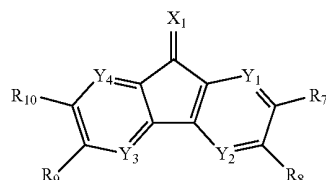
[0025] R₉['], R₁₀['], R₁₁['], R₁₂['] and R₁₃['] are each a substituted or unsubstituted aryl group, and r₁, r₂, r₃ and r₄ are each an integer of 0 to 5 with the proviso that r₁+r₂+r₃+r₄≧1.

[0026] In one aspect, the organic electron acceptor is selected from the group consisting of:

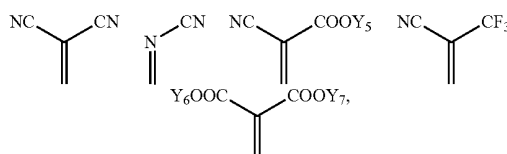


[0027] R₁, R₂, R₃, R₄, R₅, and R₆ are independently chosen from the group consisting of hydrogen, halogen, nitrile, nitro, sulfonyl, sulfoxide, sulfonamide, sulfonate, trifluoromethyl,

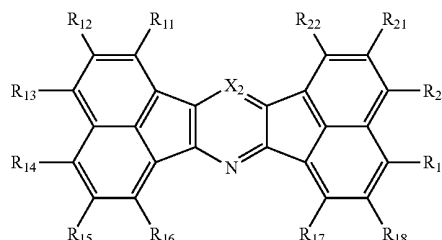
ester, amide, straight-chain or branched C1-C12 alkoxy, straight-chain or branched C1-C12 alkyl, aromatic or non-aromatic (substituted or unsubstituted) heterocyclic, substituted or unsubstituted aryl, mono- or di-(substituted or unsubstituted)aryl-amine, and (substituted or unsubstituted)alkyl-(substituted or unsubstituted)aryl-amine; or where R₁ and R₂, R₃ and R₄, and R₅ and R₆ combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted;



[0028] Y₁ to Y₄ are independently a carbon atom or a nitrogen atom. R₇ to R₁₀ are independently a hydrogen atom, an alkyl group, a substituted or unsubstituted aryl group, a substituted or unsubstituted heterocycle, a halogen atom, a fluoroalkyl group or a cyano group. R₇ and R₈, and R₉ and R₁₀ are independently bonded to form a substituted or unsubstituted aromatic ring or a substituted or unsubstituted heterocycle. X₁ is selected from the group consisting of:



[0029] Y₅ to Y₇ are independently a hydrogen atom, a fluoroalkyl group, an alkyl group, an aryl group or a heterocyclic group; and Y₆ and Y₇ may form a ring;

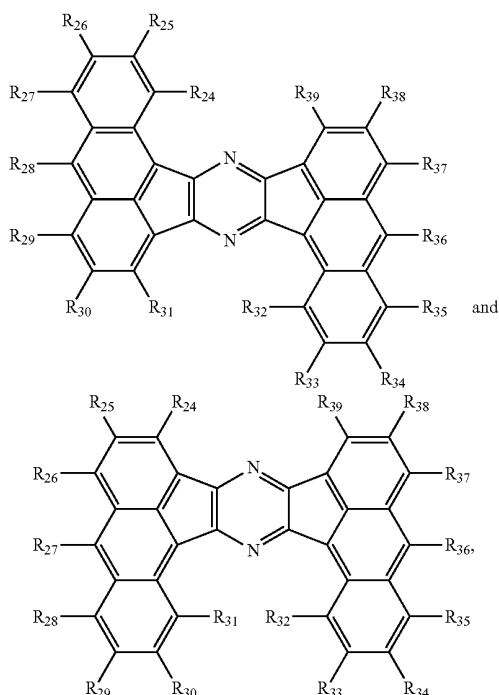


[0030] X₂ is

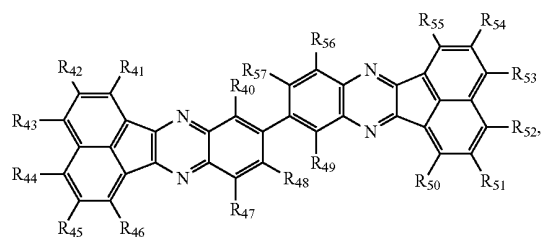


[0031] C(R₂₃) or N, R₁₁ to R₂₃ each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R₁₁ to R₂₃ each represent a cyano group, a trif-

luoromethyl group or a fluorine atom and that those of R₁₁ to R₂₃, which are adjacent to one another, may be linked together to form a ring structure;

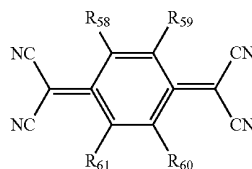


[0032] R₂₄ to R₃₉ each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R₂₄ to R₃₉ each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R₂₄ to R₃₉ which are adjacent to one another, may be linked together to form a ring structure;



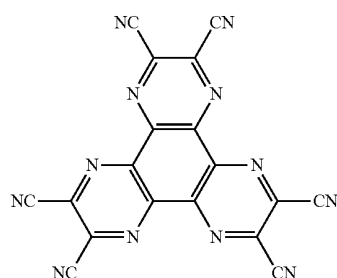
[0033] R₄₀ to R₅₇ each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a

halogen atom, or a cyano group, provided that at least two of R₄₀ to R₅₇ each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R₄₀ to R₅₇ which are adjacent to one another, may be linked together to form a ring structure; and



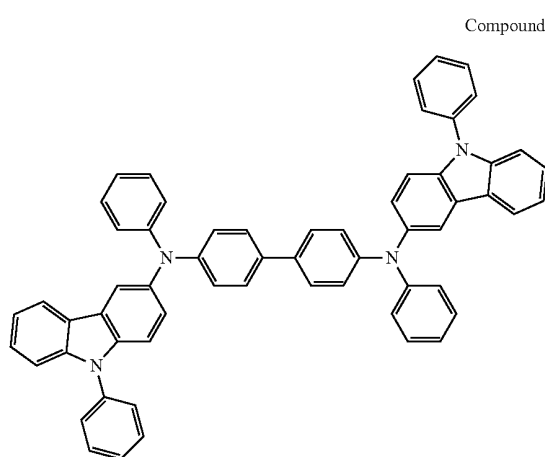
[0034] R₅₈-R₆₁ independently represents hydrogen, fluorine, or substituents independently selected from nitrile (—CN), nitro (—NO₂), sulfonyl (—SO₂R), sulfoxide (—SOR), trifluoromethyl (—CF₃), ester (—CO-DR), amide (—CONHR or —CO—NRR'), substituted or unsubstituted aryl, substituted or unsubstituted heteroaryl, or substituted or unsubstituted alkyl, where R and R' include substituted or unsubstituted alkyl or aryl; or R₅₈ and R₅₉, or R₆₀ and R₆₁, combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted.

[0035] Preferably, the organic electron acceptor is:



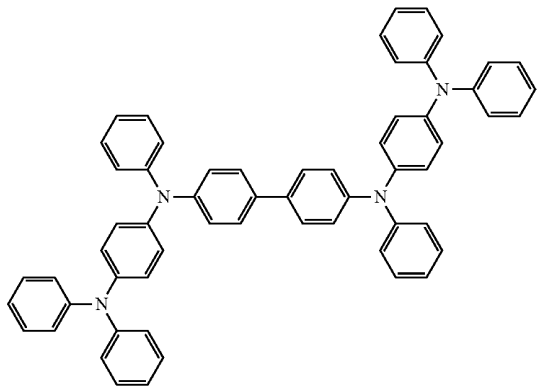
Dopant 1

[0036] Preferably, the organic electron donor is selected from the group consisting of:



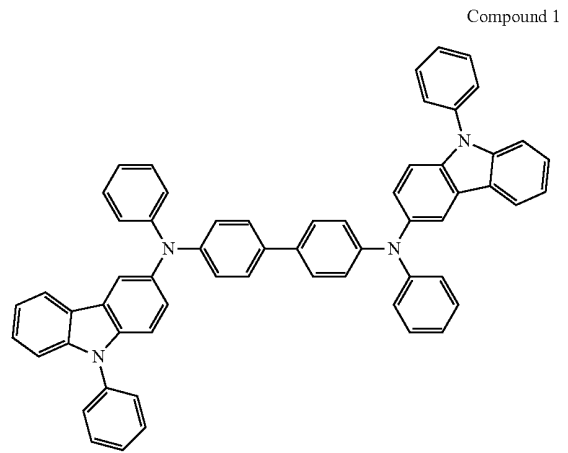
Compound 1

-continued

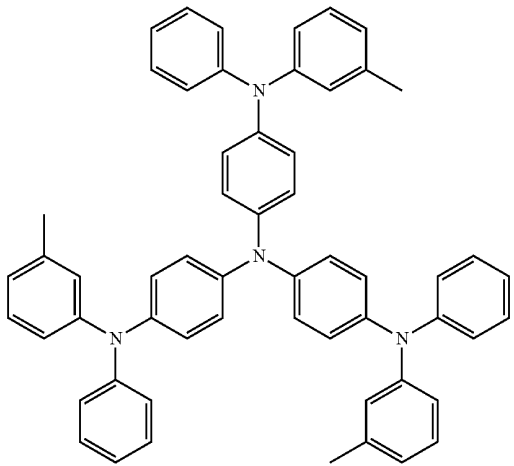


and

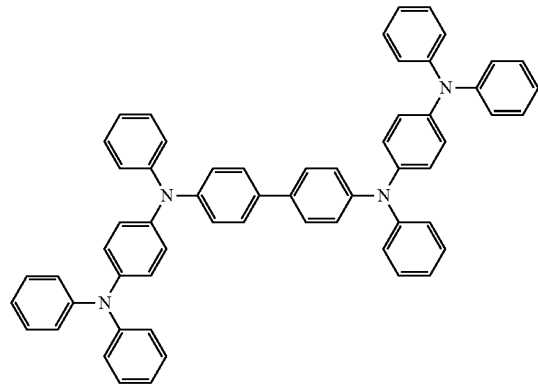
[0038] the organic electron donor is selected from the group consisting of:



Compound 3

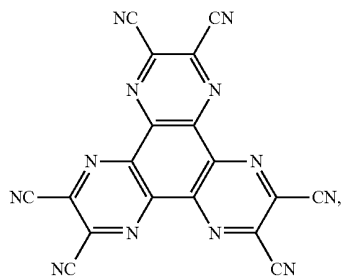


Compound 2

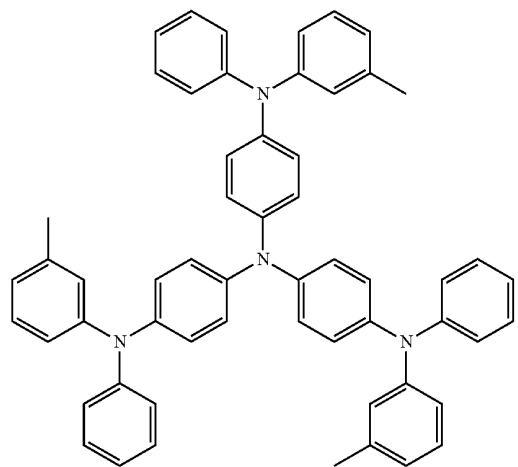


Compound 3

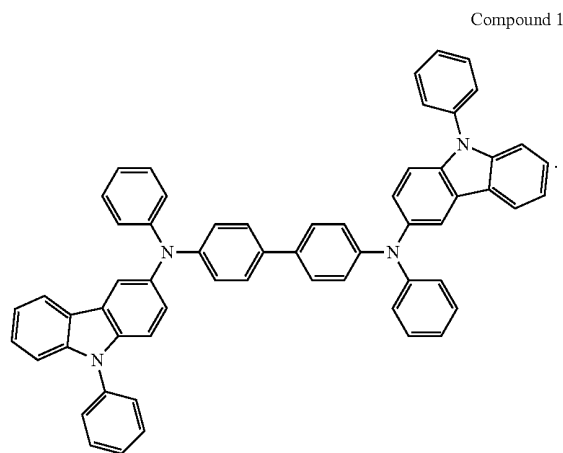
[0037] More preferably, the organic electron acceptor is:



Dopant 1



[0039] Most preferably, the organic electron acceptor is Dopant 1 and the organic electron donor is:



[0040] In one aspect, a second organic layer containing a non-polar solvent is deposited over the first organic layer, and the first organic layer is insoluble to the non-polar solvent in the second organic layer. Preferably, the first organic layer is a hole injection layer. Preferably, the second organic layer is a hole transporting layer, a hole blocking layer, an electron transporting layer, an electron injection layer, or an emissive layer.

[0041] Non-polar solvents, as used herein, have a polarity index equal to or less than 3.5. In one aspect, the non-polar solvent is selected from the group consisting of benzene, carbon tetrachloride, cyclohexane, 1,2-dichloroethane, dichloromethane, di-ethyl ether, heptane, hexane, methyl-*t*-butyl ether, pentane, di-*iso*-propyl ether, toluene, and xylene. Preferably, the non-polar solvent is toluene.

[0042] In one aspect, the solution process is spin coating or inkjet printing.

[0043] In another aspect, the organic electron acceptor and the organic electron donor are mixed at a mole ratio of 1:1 or 2:1.

[0044] In yet another aspect, the insoluble organic layer forms when the composition is heated at a temperature no less than about 100° C. and no more than about 250° C.

[0045] Additionally, a first device is provided, the device comprising an organic light emitting device, which further comprises an anode; a cathode; and a first organic layer disposed between the anode and the cathode, the organic layer comprising an electron acceptor and an electron donor. Selections for the substituents, solvents, organic electron acceptor and organic electron donor mole ratio, and temperature described as preferred for the method are also preferred for use in a device that comprises an organic layer comprising the electron acceptor and the electron donor. These selections include those described at least for A, B, C, R_A, R_B, R_C, X, Y, R_X, R_Y, R₁-R₆₁, Y₁-Y₇, X₁, X₂, R'₁-R'₁₃, Ar₁-Ar₄, L₀, L₁, Z, r₁-r₄, and R₀₁-R₀₄.

BRIEF DESCRIPTION OF THE DRAWINGS

[0046] FIG. 1 shows an organic light emitting device.

[0047] FIG. 2 shows an inverted organic light emitting device that does not have a separate electron transport layer.

[0048] FIG. 3 shows a plot of device lifetimes.

DETAILED DESCRIPTION

[0049] Generally, an OLED comprises at least one organic layer disposed between and electrically connected to an anode and a cathode. When a current is applied, the anode injects holes and the cathode injects electrons into the organic layer(s). The injected holes and electrons each migrate toward the oppositely charged electrode. When an electron and hole localize on the same molecule, an "exciton," which is a localized electron-hole pair having an excited energy state, is formed. Light is emitted when the exciton relaxes via a photoemissive mechanism. In some cases, the exciton may be localized on an excimer or an exciplex. Non-radiative mechanisms, such as thermal relaxation, may also occur, but are generally considered undesirable.

[0050] The initial OLEDs used emissive molecules that emitted light from their singlet states ("fluorescence") as disclosed, for example, in U.S. Pat. No. 4,769,292, which is incorporated by reference in its entirety. Fluorescent emission generally occurs in a time frame of less than 10 nanoseconds.

[0051] More recently, OLEDs having emissive materials that emit light from triplet states ("phosphorescence") have been demonstrated. Baldo et al., "Highly Efficient Phosphorescent Emission from Organic Electroluminescent Devices," *Nature*, vol. 395, 151-154, 1998; ("Baldo-I") and Baldo et al., "Very high-efficiency green organic light-emitting devices based on electrophosphorescence," *Appl. Phys. Lett.*, vol. 75, No. 3, 4-6 (1999) ("Baldo-II"), which are incorporated by reference in their entireties. Phosphorescence is described in more detail in U.S. Pat. No. 7,279,704 at cols. 5-6, which are incorporated by reference.

[0052] FIG. 1 shows an organic light emitting device 100. The figures are not necessarily drawn to scale. Device 100 may include a substrate 110, an anode 115, a hole injection layer 120, a hole transport layer 125, an electron blocking layer 130, an emissive layer 135, a hole blocking layer 140, an electron transport layer 145, an electron injection layer 150, a protective layer 155, and a cathode 160. Cathode 160 is a compound cathode having a first conductive layer 162 and a second conductive layer 164. Device 100 may be fabricated by depositing the layers described, in order. The properties and functions of these various layers, as well as example materials, are described in more detail in U.S. Pat. No. 7,279,704 at cols. 6-10, which are incorporated by reference.

[0053] More examples for each of these layers are available. For example, a flexible and transparent substrate-anode combination is disclosed in U.S. Pat. No. 5,844,363, which is incorporated by reference in its entirety. An example of a p-doped hole transport layer is m-MTDATA doped with F.sub.4-TCNQ at a molar ratio of 50:1, as disclosed in U.S. Patent Application Publication No. 2003/0230980, which is incorporated by reference in its entirety. Examples of emissive and host materials are disclosed in U.S. Pat. No. 6,303,238 to Thompson et al., which is incorporated by reference in its entirety. An example of an n-doped electron transport layer is BPhen doped with Li at a molar ratio of 1:1, as disclosed in U.S. Patent Application Publication No. 2003/0230980, which is incorporated by reference in its entirety. U.S. Pat. Nos. 5,703,436 and 5,707,745, which are incorporated by reference in their entireties, disclose examples of cathodes including compound cathodes having a thin layer of metal such as Mg:Ag with an overlying transparent, electrically-conductive, sputter-deposited ITO layer. The theory and use of blocking layers is described in more detail in U.S. Pat. No. 6,097,147 and U.S. Patent Application Publication No. 2003/

0230980, which are incorporated by reference in their entireties. Examples of injection layers are provided in U.S. Patent Application Publication No. 2004/0174116, which is incorporated by reference in its entirety. A description of protective layers may be found in U.S. Patent Application Publication No. 2004/0174116, which is incorporated by reference in its entirety.

[0054] FIG. 2 shows an inverted OLED **200**. The device includes a substrate **210**, a cathode **215**, an emissive layer **220**, a hole transport layer **225**, and an anode **230**. Device **200** may be fabricated by depositing the layers described, in order. Because the most common OLED configuration has a cathode disposed over the anode, and device **200** has cathode **215** disposed under anode **230**, device **200** may be referred to as an "inverted" OLED. Materials similar to those described with respect to device **100** may be used in the corresponding layers of device **200**. FIG. 2 provides one example of how some layers may be omitted from the structure of device **100**.

[0055] The simple layered structure illustrated in FIGS. 1 and 2 is provided by way of non-limiting example, and it is understood that embodiments of the invention may be used in connection with a wide variety of other structures. The specific materials and structures described are exemplary in nature, and other materials and structures may be used. Functional OLEDs may be achieved by combining the various layers described in different ways, or layers may be omitted entirely, based on design, performance, and cost factors. Other layers not specifically described may also be included. Materials other than those specifically described may be used. Although many of the examples provided herein describe various layers as comprising a single material, it is understood that combinations of materials, such as a mixture of host and dopant, or more generally a mixture, may be used. Also, the layers may have various sublayers. The names given to the various layers herein are not intended to be strictly limiting. For example, in device **200**, hole transport layer **225** transports holes and injects holes into emissive layer **220**, and may be described as a hole transport layer or a hole injection layer. In one embodiment, an OLED may be described as having an "organic layer" disposed between a cathode and an anode. This organic layer may comprise a single layer, or may further comprise multiple layers of different organic materials as described, for example, with respect to FIGS. 1 and 2.

[0056] Structures and materials not specifically described may also be used, such as OLEDs comprised of polymeric materials (PLEDs) such as disclosed in U.S. Pat. No. 5,247,190 to Friend et al., which is incorporated by reference in its entirety. By way of further example, OLEDs having a single organic layer may be used. OLEDs may be stacked, for example as described in U.S. Pat. No. 5,707,745 to Forrest et al., which is incorporated by reference in its entirety. The OLED structure may deviate from the simple layered structure illustrated in FIGS. 1 and 2. For example, the substrate may include an angled reflective surface to improve out-coupling, such as a mesa structure as described in U.S. Pat. No. 6,091,195 to Forrest et al., and/or a pit structure as described in U.S. Pat. No. 5,834,893 to Bulovic et al., which are incorporated by reference in their entireties.

[0057] Unless otherwise specified, any of the layers of the various embodiments may be deposited by any suitable method. For the organic layers, preferred methods include thermal evaporation, ink-jet, such as described in U.S. Pat. Nos. 6,013,982 and 6,087,196, which are incorporated by reference in their entireties, organic vapor phase deposition

(OVPD), such as described in U.S. Pat. No. 6,337,102 to Forrest et al., which is incorporated by reference in its entirety, and deposition by organic vapor jet printing (OVJP), such as described in U.S. patent application Ser. No. 10/233,470, which is incorporated by reference in its entirety. Other suitable deposition methods include spin coating and other solution based processes. Solution based processes are preferably carried out in nitrogen or an inert atmosphere. For the other layers, preferred methods include thermal evaporation. Preferred patterning methods include deposition through a mask, cold welding such as described in U.S. Pat. Nos. 6,294,398 and 6,468,819, which are incorporated by reference in their entireties, and patterning associated with some of the deposition methods such as ink jet and OVJD. Other methods may also be used. The materials to be deposited may be modified to make them compatible with a particular deposition method. For example, substituents such as alkyl and aryl groups, branched or unbranched, and preferably containing at least 3 carbons, may be used in small molecules to enhance their ability to undergo solution processing. Substituents having 20 carbons or more may be used, and 3-20 carbons is a preferred range. Materials with asymmetric structures may have better solution processibility than those having symmetric structures, because asymmetric materials may have a lower tendency to recrystallize. Dendrimer substituents may be used to enhance the ability of small molecules to undergo solution processing.

[0058] Devices fabricated in accordance with embodiments of the invention may be incorporated into a wide variety of consumer products, including flat panel displays, computer monitors, televisions, billboards, lights for interior or exterior illumination and/or signaling, heads up displays, fully transparent displays, flexible displays, laser printers, telephones, cell phones, personal digital assistants (PDAs), laptop computers, digital cameras, camcorders, viewfinders, micro-displays, vehicles, a large area wall, theater or stadium screen, or a sign. Various control mechanisms may be used to control devices fabricated in accordance with the present invention, including passive matrix and active matrix. Many of the devices are intended for use in a temperature range comfortable to humans, such as 18 degrees C. to 30 degrees C., and more preferably at room temperature (20-25 degrees C.).

[0059] The materials and structures described herein may have applications in devices other than OLEDs. For example, other optoelectronic devices such as organic solar cells and organic photodetectors may employ the materials and structures. More generally, organic devices, such as organic transistors, may employ the materials and structures.

[0060] The terms halo, halogen, alkyl, cycloalkyl, alkenyl, alkynyl, arylkyl, heterocyclic group, aryl, aromatic group, and heteroaryl are known to the art, and are defined in U.S. Pat. No. 7,279,704 at cols. 31-32, which are incorporated herein by reference.

[0061] A method of fabricating an organic light emitting device by solution depositing an organic layer comprising an organic electron donor and an organic electron acceptor, which forms a layer insoluble to a non-polar solvent, is provided. Preferably, the organic layer forms a hole injection layer (HIL) in the device. The HIL is a particularly important organic layer in an OLED, because it helps provide holes to the emissive material in the emissive layer.

[0062] For solution processed OLEDs, an organic layer must be resistant to the solvent used in the next organic layer.

Previously, there were only two methods available to provide an organic layer resistant to subsequent layers. First, an orthogonal solvent may be used, such as PEDOT/PSS in aqueous solution. Second, cross-linkable polymers may be used. In the second instance, the film becomes insoluble after the layer is treated to crosslink the polymers. (See, e.g., WO2008073440).

[0063] Here, a mixture of non-cross-linkable organic compounds forms a layer insoluble to a non-polar solvent used in a subsequent organic layer. As used herein, a “non-polar solvent” has a polarity index equal to or less than 3.5. The polarity index is defined in the Solvent Miscibility Table in the Appendix of the Phenomenex catalog (also see, <http://www.chemical-ecology.net/java/solvents.htm>). The insoluble organic layer includes an organic electron donor, e.g., a triarylamine derivative, and an organic electron acceptor, e.g., azatriphenylene. Especially preferred organic electron donors have an oxidation potential less than 0.6 V vs Fc^+/Fc . Organic electron acceptors have a first reduction potential high than -1.0 V vs Fc^+/Fc . Without being bound by theory, it is believed that the organic electron donor and the organic electron acceptor form an ionic charge transfer complex, thereby creating a layer insoluble to a non-polar solvent.

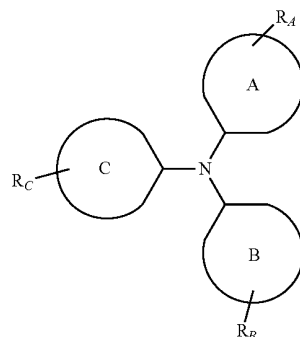
[0064] Vacuum thermal evaporation OLEDs containing triarylamine derivatives have been reported in the literature. (See, e.g., US2008107919A1, US2008124572A1, and U.S. Pat. No. 6,344,283B1). In particular, the use of p-doped triarylamine derivatives as HIL materials for vacuum thermal evaporation OLEDs has been reported. (See Walzer et al., *Chemical Review*, 2007, 107, 1233). Solution-processed OLEDs comprising an insoluble layer of triarylamine in combination with an inorganic electron donor, where the layer is embedded in metal oxide, have also been reported. (See Suzuki et al., *SID Digest*, 2007, 1840-1843). However, an organic layer containing a non-cross-linkable triarylamine derivative in combination with an organic electron acceptor has not been reported. The formation of a good organic layer film using these compounds was unexpected for several reasons. The properties of the compounds suggest that they would make poor films for a solution processed multilayer device. In particular, the crystallinity of triarylamine derivatives and the azatriphenylene suggests poor film formation. Further, these compounds have been traditionally used in OLEDs in which layers were deposited using VTE processing, a method very different from solution-processing.

[0065] Moreover, formation of an insoluble layer upon heating the triarylamine derivative and conductivity dopant composition was surprising. It would be expected that the film would have very poor solvent resistance, thus unsuitable for use in a solution processed multilayer device. If heated separately, the compounds would not become insoluble. Here, heating the organic layer comprising the organic electron donor, i.e., triarylamine derivative, and the organic electron acceptor, i.e., azatriphenylene, unexpectedly resulted in formation of a layer insoluble to a non-polar solvent. There are no prior reports of an insoluble organic layer comprising small molecule compounds that do not require cross-linking. Thus, there was no expectation that these small molecule materials would become insoluble when heated. The insoluble layer described herein is especially beneficial for fabrication of solution processed OLEDs.

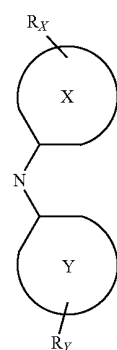
[0066] Further, devices comprising an organic layer containing the organic electron donor, i.e., triarylamine derivative, and the organic electron acceptor, i.e., azatriphenylene, may have improved properties, including longer lifetime, good reproducibility, lower operating voltage while maintaining luminous efficiency, and improved purification, as illustrated in FIG. 3.

[0067] A method of fabricating an organic light emitting device is provided. The method comprises providing an electrode, depositing a first organic layer in contact with the electrode by a solution process, and heating the first organic layer to form a layer that is insoluble in a non-polar solvent. Preferably, the electrode is an anode, and the first organic layer is deposited in contact with the anode.

[0068] The first organic layer comprises an organic electron acceptor and an organic electron donor having the formula:

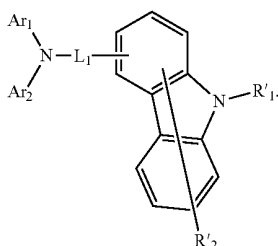


[0069] A, B, and C are 5 or 6 membered cyclic or heterocyclic rings. R_A , R_B , and R_C are independently selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl. R_A , R_B , and R_C are optionally fused to A, B, and C. At least two of R_A , R_B , and R_C contain the structure:



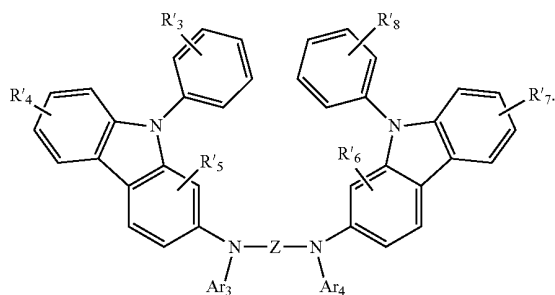
[0070] X and Y are independently 5 or 6 membered cyclic or heterocyclic rings. R_X and R_Y are independently selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl. R_X and R_Y are optionally fused to X and Y. R_X and R_Y are optionally connected to A and B.

[0071] In one aspect, the organic electron donor has the formula:



[0072] L_1 represents a substituted or unsubstituted arylene group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted fluorenylene group, or a substituted or unsubstituted heteroarylene group having 5 to 60 atoms forming a ring; Ar_1 and Ar_2 each independently represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring or a substituted or unsubstituted heteroaryl group having 5 to 60 atoms forming a ring; R'_1 represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring; R'_2 represents a hydrogen atom, a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted alkyl group having 1 to 50 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 50 carbon atoms, a substituted or unsubstituted aryloxy group having 6 to 50 atoms forming a ring, a substituted or unsubstituted arylthio group having 5 to 50 atoms forming a ring, a substituted or unsubstituted alkoxy carbonyl group having 2 to 50 carbon atoms, an amino group substituted by a substituted or unsubstituted aryl group having 6 to 50 carbon atoms forming the aromatic ring, a halogen atom, a cyano group, a nitro group, a hydroxyl group or a carboxyl group; with the proviso that neither Ar_1 nor Ar_2 contains a fluorene structure, and that the number of a carbazole structures in the aromatic amine derivative represented by the formula is 1 or 2.

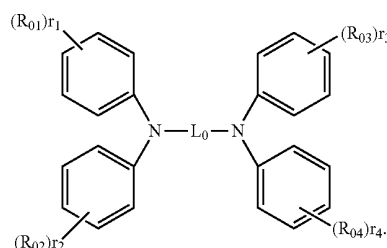
[0073] In another aspect, the organic electron donor has the formula:



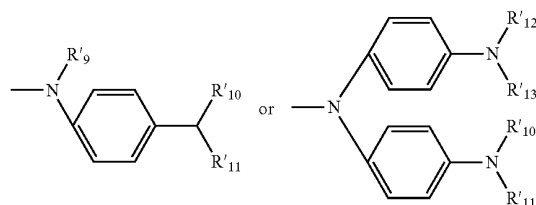
[0074] Z is selected from the group consisting of a substituted or unsubstituted C1-C30 alkylene group, a substituted or unsubstituted C2-C30 alkenylene group, a substituted or unsubstituted C6-C30 arylene group, a substituted or unsubstituted C2-C30 heteroarylene group, and a substituted or unsubstituted C2-C30 heterocyclic group; each of R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 is independently selected from the group consisting of a hydrogen atom, a substituted or unsubstituted C1-C30 alkyl group, a substituted or unsubstituted C1-C30

alkoxy group, a substituted or unsubstituted C6-C30 aryl group, a substituted or unsubstituted C6-C30 aryloxy group, a substituted or unsubstituted C2-C30 heterocyclic group, a substituted or unsubstituted C6-C30 condensed polycyclic group, a hydroxy group, a cyano group, and a substituted or unsubstituted amino group, and, alternatively, two or more adjacent groups among R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 can be connected to each other to form a saturated or unsaturated carbocycle; and wherein each of Ar_3 and Ar_4 are independently a substituted or unsubstituted C6-C30 aryl group or a substituted or unsubstituted C2-C30 heteroaryl group.

[0075] In yet another aspect, the organic electron donor has the formula:

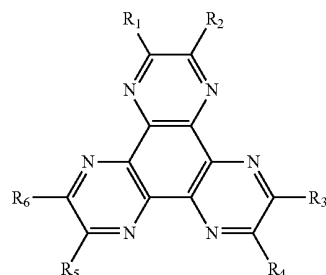


[0076] L_0 is any one of o-, p-, and m-phenylene groups which have two, three or four rings and which have a substituent with the proviso that when L_0 is a phenylene group having four rings, the phenylene group may have an unsubstituted or substituted aminophenyl group somewhere therein, and R_{01} , R_{02} , R_{03} and R_{04} are any one of the following groups:



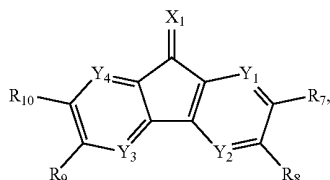
[0077] R'_9 , R'_{10} , R'_{11} , R'_{12} and R'_{13} are each a substituted or unsubstituted aryl group, and r_1 , r_2 , r_3 and r_4 are each an integer of 0 to 5 with the proviso that $r_1+r_2+r_3+r_4 \cong 1$.

[0078] In one aspect, the organic electron acceptor is selected from the group consisting of:

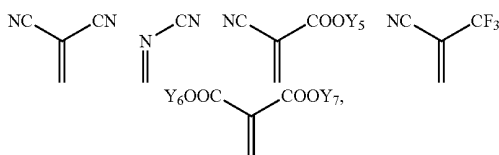


[0079] R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 are independently chosen from the group consisting of hydrogen, halogen, nitrile, nitro, sulfonyl, sulfoxide, sulfonamide, sulfonate, trifluoromethyl, ester, amide, straight-chain or branched C1-C12 alkoxy, straight-chain or branched C1-C12 alkyl, aromatic or non-

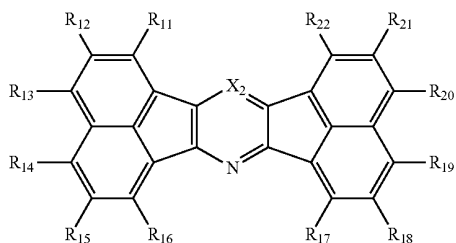
aromatic (substituted or unsubstituted) heterocyclic, substituted or unsubstituted aryl, mono- or di-(substituted or unsubstituted)aryl-amine, and (substituted or unsubstituted)alkyl-(substituted or unsubstituted)aryl-amine; or where R_1 and R_2 , R_3 and R_4 , and R_5 and R_6 combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted;



[0080] Y_1 to Y_4 are independently a carbon atom or a nitrogen atom. R_7 to R_{10} are independently a hydrogen atom, an alkyl group, a substituted or unsubstituted aryl group, a substituted or unsubstituted heterocycle, a halogen atom, a fluoroalkyl group or a cyano group. R_7 and R_8 , and R_9 and R_{10} are independently bonded to form a substituted or unsubstituted aromatic ring or a substituted or unsubstituted heterocycle. X_1 is selected from the group consisting of:



[0081] Y_5 to Y_7 are independently a hydrogen atom, a fluoroalkyl group, an alkyl group, an aryl group or a heterocyclic group; and Y_6 and Y_7 may form a ring;

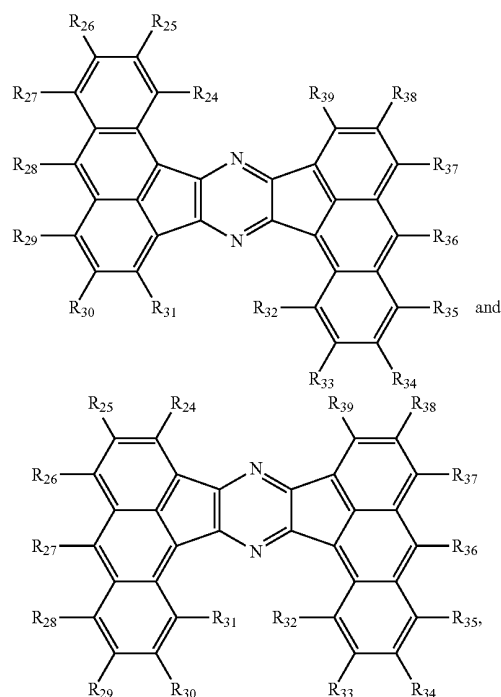


[0082] X_2 is

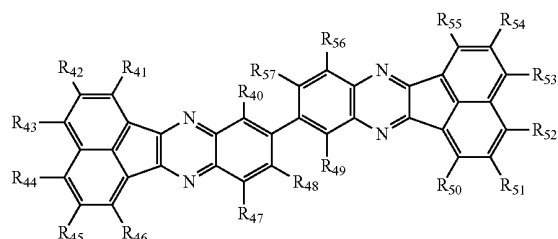


[0083] $C(R_{23})$ or N , R_{11} to R_{22} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{11} to R_{22} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{11} to

R_{23} , which are adjacent to one another, may be linked together to form a ring structure;

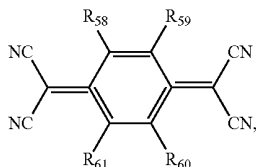


[0084] R_{24} to R_{39} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{24} to R_{39} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{24} to R_{39} which are adjacent to one another, may be linked together to form a ring structure;



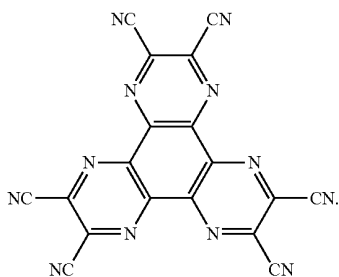
[0085] R_{40} to R_{57} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may

have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{40} to R_{57} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{40} to R_{57} which are adjacent to one another, may be linked together to form a ring structure; and



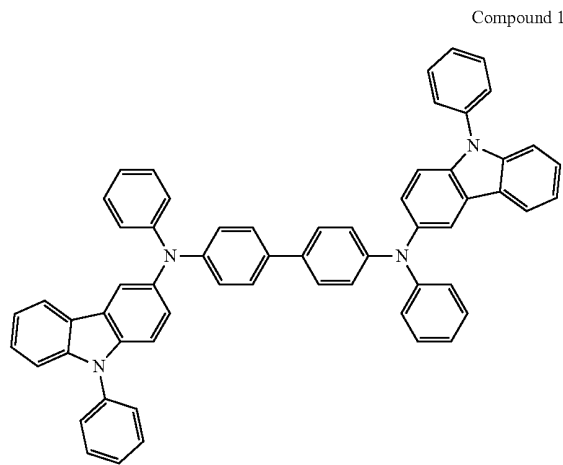
[0086] R_{58} - R_{61} independently represents hydrogen, fluorine, or substituents independently selected from nitrile ($-\text{CN}$), nitro ($-\text{NO}_2$), sulfonyl ($-\text{SO}_2\text{R}$), sulfoxide ($-\text{SOR}$), trifluoromethyl ($-\text{CF}_3$), ester ($-\text{CO-DR}$), amide ($-\text{CONHR}$ or $-\text{CO-NRR}'$), substituted or unsubstituted aryl, substituted or unsubstituted heteroaryl, or substituted or unsubstituted alkyl, where R and R' include substituted or unsubstituted alkyl or aryl; or R_{58} and R_{59} , or R_{60} and R_{61} , combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted.

[0087] Preferably, the organic electron acceptor is:



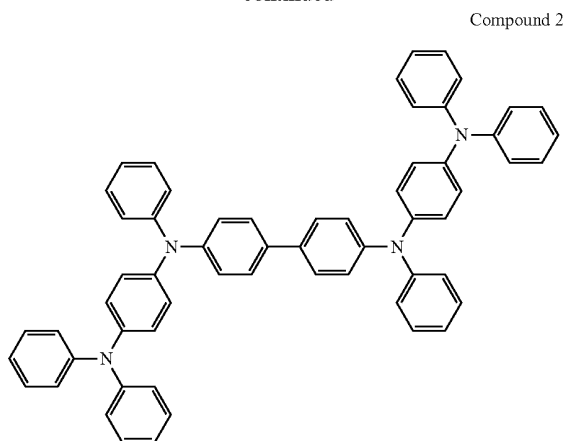
Dopant 1

[0088] Preferably, the organic electron donor is selected from the group consisting of:



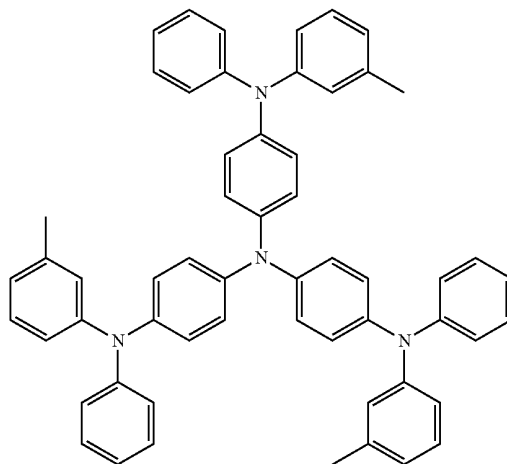
Compound 1

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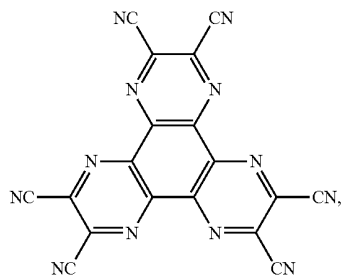


Compound 2

Compound 3



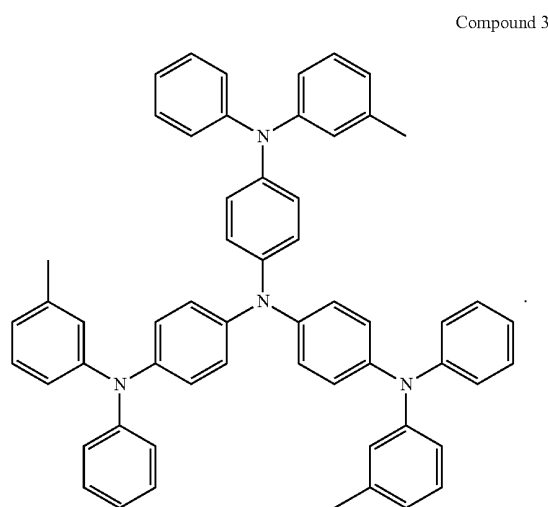
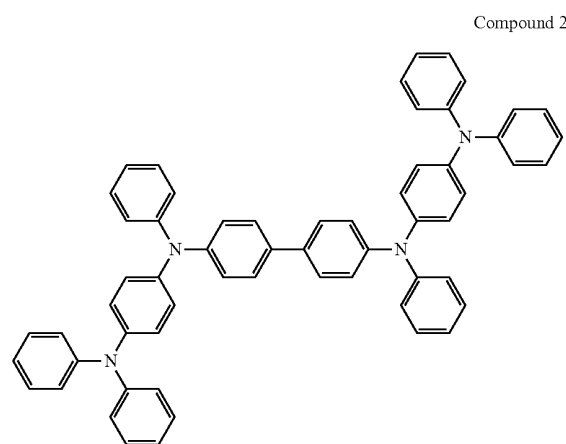
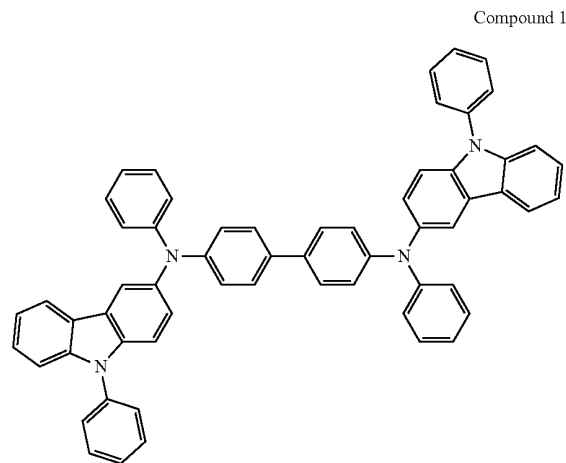
[0089] More preferably, the organic electron acceptor is:



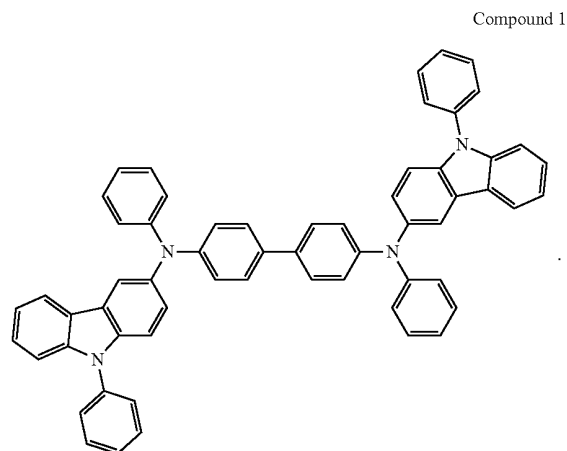
Dopant 1

and

the organic electron donor is selected from the group consisting of:



[0090] Most preferably, the organic electron acceptor is Dopant 1 and the organic electron donor is:



[0091] In one aspect, a second organic layer containing a non-polar solvent is deposited over the first organic layer, and the first organic layer is insoluble to the non-polar solvent in the second organic layer. Preferably, the first organic layer is a hole injection layer. Preferably, the second organic layer is a hole transporting layer, a hole blocking layer, an electron transporting layer, an electron injection layer, or an emissive layer.

[0092] Non-polar solvents, as used herein, have a polarity index equal to or less than 3.5. Examples of non-polar solvents include, without limitation, benzene, carbon tetrachloride, cyclohexane, 1,2-dichloroethane, dichloromethane, diethyl ether, heptane, hexane, methyl-t-butyl ether, pentane, di-iso-propyl ether, toluene, and xylene. Preferably, the non-polar solvent is toluene.

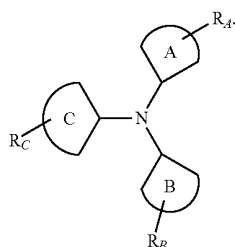
[0093] In one aspect, the solution process is spin coating or inkjet printing.

[0094] In another aspect, the organic electron acceptor and the organic electron donor are mixed at a mole ratio of 1:1 or 2:1. Without being bound by theory, it is believed that the high mole ratio of the organic electron acceptor provides for good formation of the ionic complex between the organic electron acceptor and the organic electron donor. In doped VTE HILs, only a few percent of electron acceptor, normally less than 5%, is required to achieve efficient electron injection from the anode and high conductivity. It might not be enough, however, to form an insoluble layer with low electron acceptor percentage. For example, when the mole ratio of donor to acceptor is 1:20, the majority of the electron donor does not react with the electron acceptor. Therefore, a much higher electron acceptor concentration (mole ratio) may be needed.

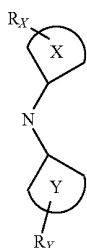
[0095] In yet another aspect, the insoluble organic layer forms when the composition is heated at a temperature no less than about 100° C. and no more than about 250° C. It is believed that the ionic complex formed between the organic electron acceptor and the organic electron donor forms more efficiently, solvent is better evaporated and materials do not breakdown within this temperature range.

[0096] Additionally, a first device is provided, the device comprising an organic light emitting device, which further comprises an anode; a cathode; and a first organic layer dis-

posed between the anode and the cathode. The first organic layer comprises an organic electron acceptor and an organic electron donor having the formula:



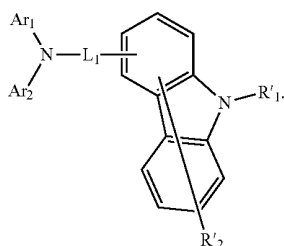
[0097] A, B, and C are 5 or 6 membered cyclic or heterocyclic rings. R_A , R_B , and R_C are independently selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl. R_A , R_B , and R_C are optionally fused to A, B, and C. At least two of R_A , R_B , and R_C contain the structure:



[0098] X and Y are independently 5 or 6 membered cyclic or heterocyclic rings. R_X and R_Y are independent selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl. R_X and R_Y are optionally fused to X and Y. R_X and R_Y are optionally connected to A and B. When the organic electron acceptor and the organic electron donor are heated, they form a layer that is insoluble in a non-polar solvent.

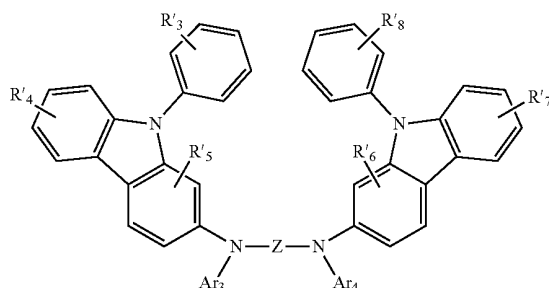
[0099] In one aspect, the first organic layer is deposited in contact with the anode.

[0100] In one aspect, the organic electron donor has the formula:



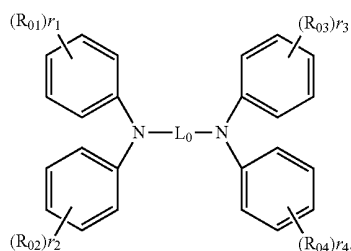
[0101] L_1 represents a substituted or unsubstituted arylene group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted fluorenylene group, or a substituted or unsubstituted heteroarylene group having 5 to 60 atoms forming a ring; Ar_1 and Ar_2 each independently represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring or a substituted or unsubstituted heteroaryl group having 5 to 60 atoms forming a ring; R'_1 represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring; R'_2 represents a hydrogen atom, a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted alkyl group having 1 to 50 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 50 carbon atoms, a substituted or unsubstituted aryloxy group having 6 to 50 atoms forming a ring, a substituted or unsubstituted arylthio group having 5 to 50 atoms forming a ring, a substituted or unsubstituted alkoxy carbonyl group having 2 to 50 carbon atoms, an amino group substituted by a substituted or unsubstituted aryl group having 6 to 50 carbon atoms forming the aromatic ring, a halogen atom, a cyano group, a nitro group, a hydroxyl group or a carboxyl group; with the proviso that neither Ar_1 nor Ar_2 contains a fluorene structure, and that the number of a carbazole structures in the aromatic amine derivative represented by the formula is 1 or 2.

[0102] In another aspect, the organic electron donor has the formula:

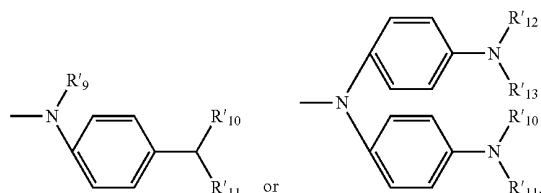


[0103] Z is selected from the group consisting of a substituted or unsubstituted C1-C30 alkylene group, a substituted or unsubstituted C2-C30 alkenylene group, a substituted or unsubstituted C6-C30 arylene group, a substituted or unsubstituted C2-C30 heteroarylene group, and a substituted or unsubstituted C2-C30 heterocyclic group; each of R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 is independently selected from the group consisting of a hydrogen atom, a substituted or unsubstituted C1-C30 alkyl group, a substituted or unsubstituted C1-C30 alkoxy group, a substituted or unsubstituted C6-C30 aryl group, a substituted or unsubstituted C6-C30 aryloxy group, a substituted or unsubstituted C2-C30 heterocyclic group, a substituted or unsubstituted C6-C30 condensed polycyclic group, a hydroxy group, a cyano group, and a substituted or unsubstituted amino group, and, alternatively, two or more adjacent groups among R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 can be connected to each other to form a saturated or unsaturated carbocycle; and wherein each of Ar_3 and Ar_4 are independently a substituted or unsubstituted C6-C30 aryl group or a substituted or unsubstituted C2-C30 heteroaryl group.

[0104] In yet another aspect, the organic electron donor has the formula:

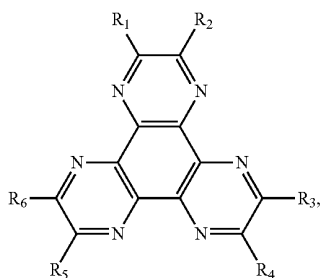


[0105] L_0 is any one of o-, p-, and m-phenylene groups which have two, three or four rings and which have a substituent with the proviso that when L_0 is a phenylene group having four rings, the phenylene group may have an unsubstituted or substituted aminophenyl group somewhere therein, and R_{01} , R_{02} , R_{03} and R_{04} are any one of the following groups:

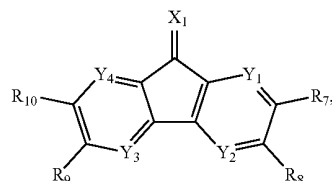


[0106] R'_9 , R'_{10} , R'_{11} , R'_{12} and R'_{13} are each a substituted or unsubstituted aryl group, and r_1 , r_2 , r_3 and r_4 are each an integer of 0 to 5 with the proviso that $r_1+r_2+r_3+r_4 \geq 1$.

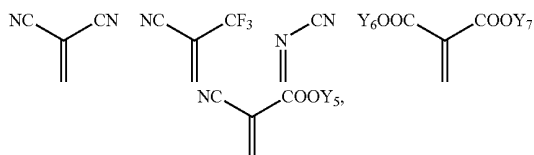
[0107] In one aspect, the organic electron acceptor is selected from the group consisting of:



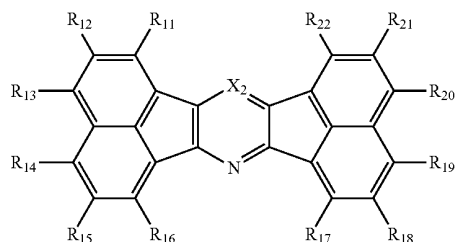
[0108] R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 are independently chosen from the group consisting of hydrogen, halogen, nitrile, nitro, sulfonyl, sulfoxide, sulfonamide, sulfonate, trifluoromethyl, ester, amide, straight-chain or branched C1-C12 alkoxy, straight-chain or branched C1-C12 alkyl, aromatic or non-aromatic (substituted or unsubstituted) heterocyclic, substituted or unsubstituted aryl, mono- or di-(substituted or unsubstituted)aryl-amine, and (substituted or unsubstituted)alkyl-(substituted or unsubstituted)aryl-amine; or where R_1 and R_2 , R_3 and R_4 , and R_5 and R_6 combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted;



[0109] Y_1 to Y_4 are independently a carbon atom or a nitrogen atom. R_7 to R_{10} are independently a hydrogen atom, an alkyl group, a substituted or unsubstituted aryl group, a substituted or unsubstituted heterocycle, a halogen atom, a fluoroalkyl group or a cyano group. R_7 and R_8 , and R_9 and R_{10} are independently bonded to form a substituted or unsubstituted aromatic ring or a substituted or unsubstituted heterocycle. X_1 is selected from the group consisting of:



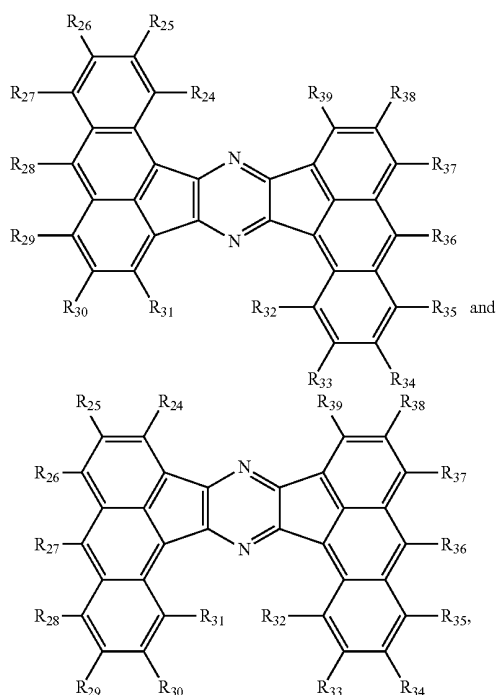
[0110] Y_5 to Y_7 are independently a hydrogen atom, a fluoroalkyl group, an alkyl group, an aryl group or a heterocyclic group; and Y_6 and Y_7 may form a ring;



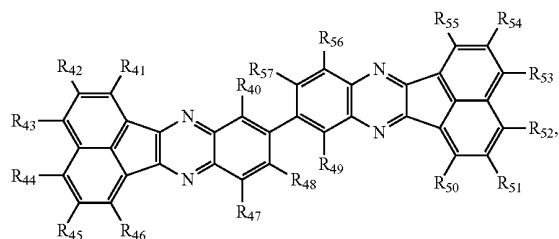
[0111] X_2 is



[0112] $C(R_{23})$ or N , R_{11} to R_{23} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{11} to R_{23} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{11} to R_{23} , which are adjacent to one another, may be linked together to form a ring structure;

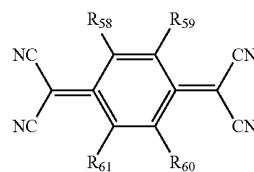


[0113] R_{24} to R_{39} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{24} to R_{39} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{24} to R_{39} which are adjacent to one another, may be linked together to form a ring structure;



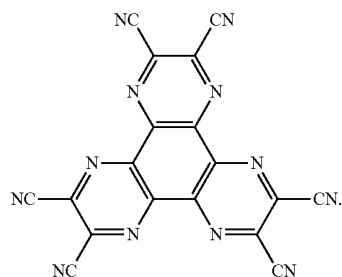
[0114] R_{40} to R_{57} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of

R_{40} to R_{57} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{40} to R_{57} which are adjacent to one another, may be linked together to form a ring structure; and



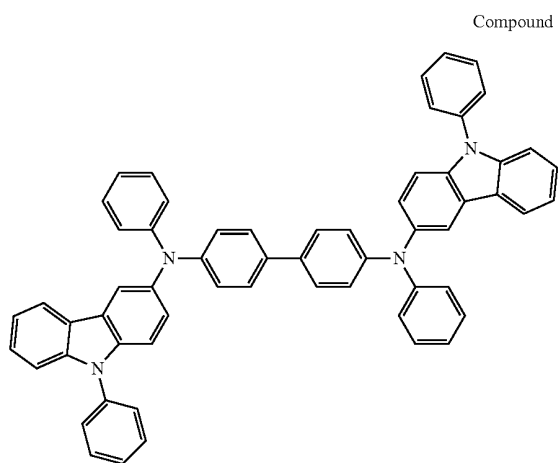
[0115] R_{58} - R_{61} independently represents hydrogen, fluorine, or substituents independently selected from nitrile ($-\text{CN}$), nitro ($-\text{NO}_2$), sulfonyl ($-\text{SO}_2\text{R}$), sulfoxide ($-\text{SOR}$), trifluoromethyl ($-\text{CF}_3$), ester ($-\text{CO-DR}$), amide ($-\text{CONHR}$ or $-\text{CO-NRR}'$), substituted or unsubstituted aryl, substituted or unsubstituted heteroaryl, or substituted or unsubstituted alkyl, where R and R' include substituted or unsubstituted alkyl or aryl; or R_{58} and R_{59} , or R_{60} and R_{61} , combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted.

[0116] Preferably, the organic electron acceptor has the formula:



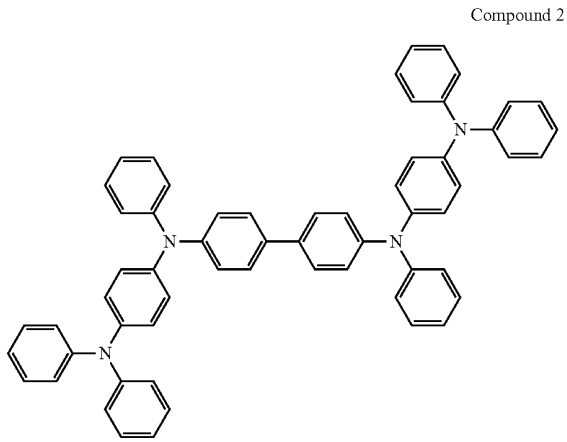
Dopant 1

[0117] Preferably, the organic electron donor is selected from the group consisting of:

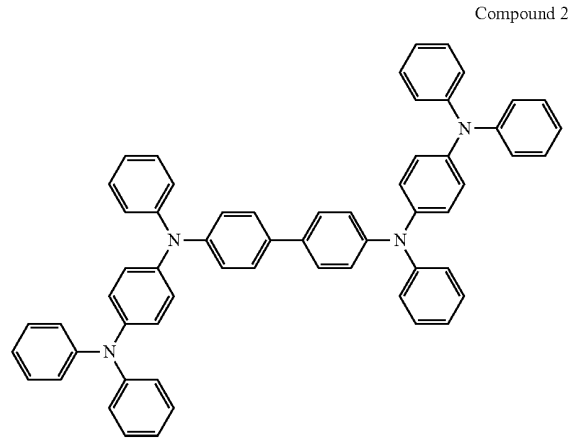


Compound 1

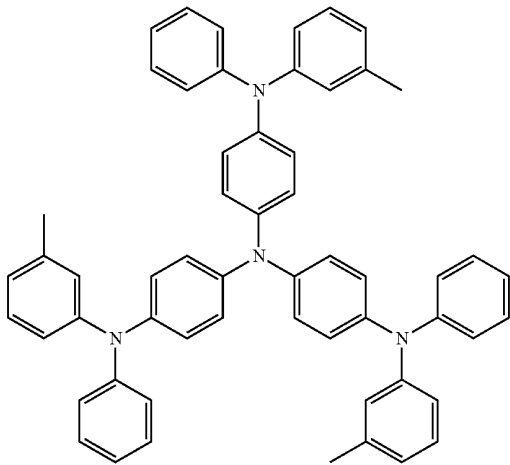
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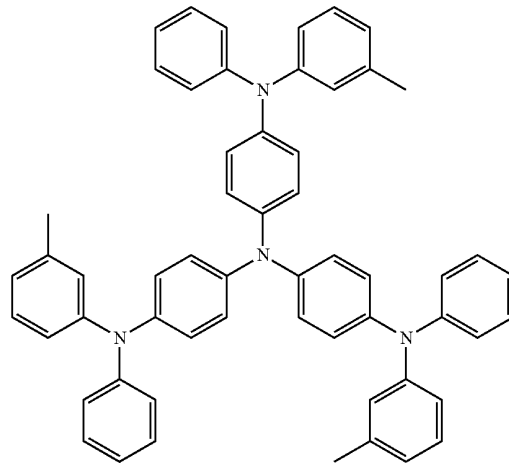
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Compound 3

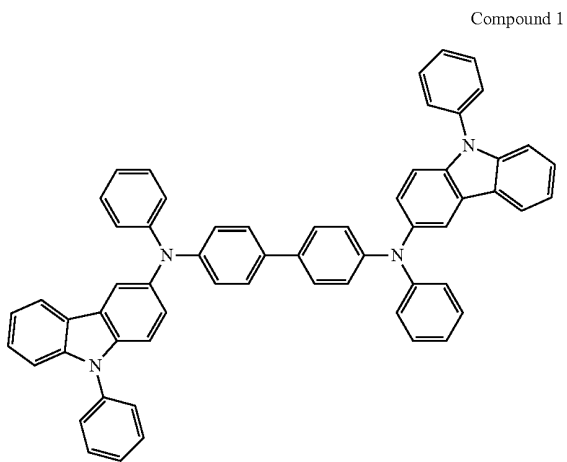


Compound 3

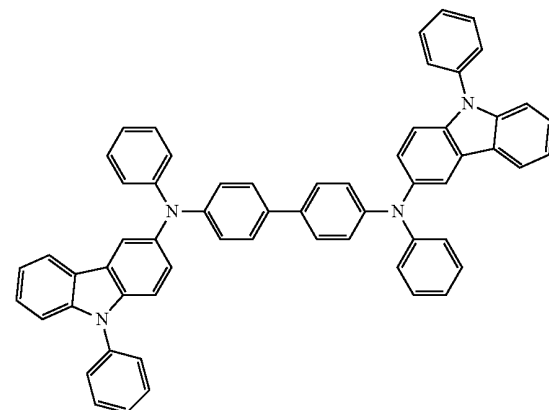


[0118] More preferably, the organic electron acceptor is Dopant 1 and the organic electron donor is selected from the group consisting of:

[0119] Most preferably, the organic electron donor has the formula:



Compound 1



[0120] In one aspect, the organic electron acceptor and the organic electron donor form a layer that is insoluble in a

non-polar solvent having a polarity index equal to or less than 3.5. Examples of non-polar solvents include, without limitation, benzene, carbon tetrachloride, cyclohexane, 1,2-dichloroethane, dichloromethane, di-ethyl ether, heptane, hexane, methyl-t-butyl ether, pentane, di-iso-propyl ether, toluene, and xylene. Preferably, the non-polar solvent is toluene.

[0121] In one aspect, the first device is a consumer product. In another aspect, the first device is an organic light emitting device.

[0122] In another aspect, the layer that is insoluble in a non-polar solvent forms when the organic electron acceptor and the organic electron donor are heated at a temperature no less than about 100° C. and no more than about 250° C. For reasons discussed above, it is believed that the ionic complex between the organic electron acceptor and the organic electron donor forms more efficiently within this temperature range.

[0123] In one aspect, the organic electron acceptor and the organic electron donor are mixed at a mole ratio of 1:1 or 2:1.

[0124] In another aspect, a second organic layer containing a non-polar solvent is deposited over the first organic layer, and the first organic layer is insoluble to the non-polar solvent contained in the second organic layer. Preferably, the first organic layer is a hole injection layer. In yet a further aspect,

the second organic layer is a hole transporting layer, a hole blocking layer, an electron transporting layer, an electron injection layer, or an emissive layer.

[0125] The materials described herein as useful for a particular layer in an organic light emitting device may be used in combination with a wide variety of other materials present in the device. For example, emissive dopants disclosed herein may be used in conjunction with a wide variety of hosts, transport layers, blocking layers, injection layers, electrodes and other layers that may be present. The materials described or referred to below are non-limiting examples of materials that may be useful in combination with the compounds disclosed herein, and one of skill in the art can readily consult the literature to identify other materials that may be useful in combination.

[0126] In addition to and/or in combination with the materials disclosed herein, many hole injection materials, hole transporting materials, host materials, dopant materials, exciton/hole blocking layer materials, electron transporting and electron injecting materials may be used in an OLED. Non-limiting examples of the materials that may be used in an OLED in combination with materials disclosed herein are listed in Table 1 below. Table 1 lists non-limiting classes of materials, non-limiting examples of compounds for each class, and references that disclose the materials.

TABLE 1

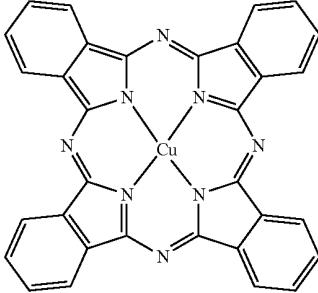
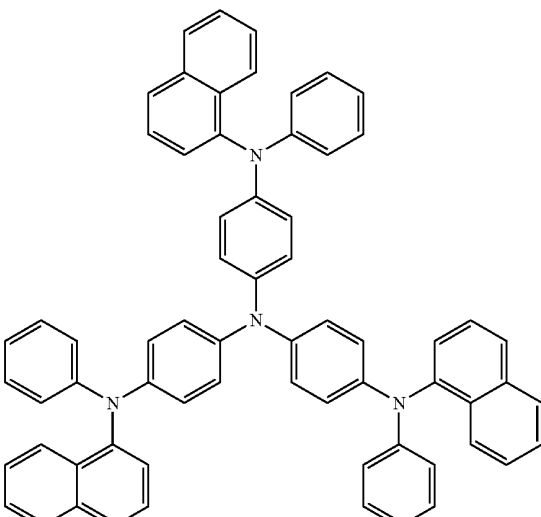
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
	Hole injection materials	
Phthalocyanine and porphyrin compounds		Appl. Phys. Lett. 69, 2160 (1996)
Starburst triarylamines		J. Lumin. 72-74, 985 (1997)

TABLE 1-continued

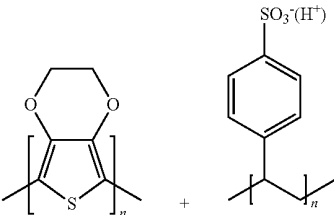
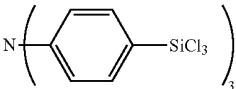
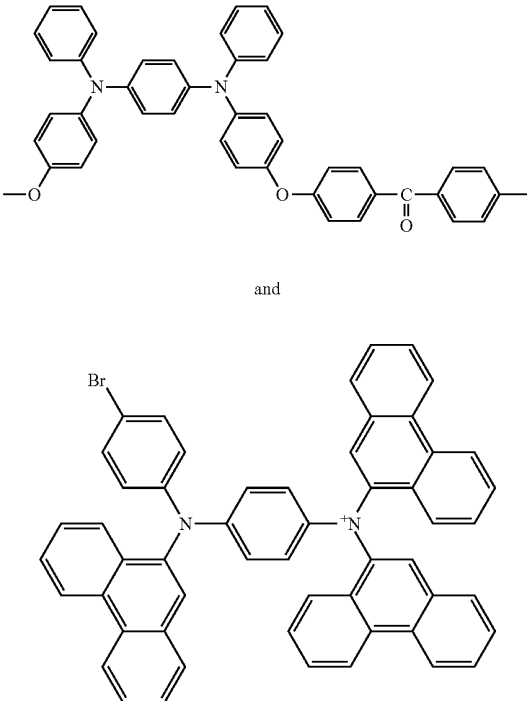
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
CF _x Fluorohydrocarbon polymer	$\text{-(CH}_2\text{F}_y\text{)-}_n$	Appl. Phys. Lett. 78, 673 (2001)
Conducting polymers (e.g., PEDOT:PSS, polyaniline, polythiophene)	 <p>The image shows two chemical structures. On the left is the structure of poly(2,5-dioxythiophene) (PEDOT), consisting of a thiophene ring with two oxygen atoms at the 2 and 5 positions, enclosed in brackets with a subscript 'n'. On the right is the structure of poly(styrene sulfonate) (PSS), consisting of a benzene ring with a sulfonate group (-SO₃⁻(H⁺)) at the para position, attached to a polymer backbone, also enclosed in brackets with a subscript 'n'. A plus sign is placed between the two structures.</p>	Synth. Met. 87, 171 (1997) WO2007002683
Phosphonic acid and silane SAMs	 <p>The image shows a chemical structure of a phosphonic acid and silane SAM. It consists of a benzene ring with a phosphonic acid group (-SiCl₃) at the para position, enclosed in brackets with a subscript '3'.</p>	US20030162053
Triarylamine or polythiophene polymers with conductivity dopants	 <p>The image shows two chemical structures. The top structure is a triarylamine polymer with a central benzene ring connected to two nitrogen atoms, each of which is bonded to two phenyl rings. The bottom structure is a polythiophene polymer with a central benzene ring connected to two nitrogen atoms, each of which is bonded to two phenyl rings. The two structures are separated by the word 'and'.</p>	EA01725079A1

TABLE 1-continued

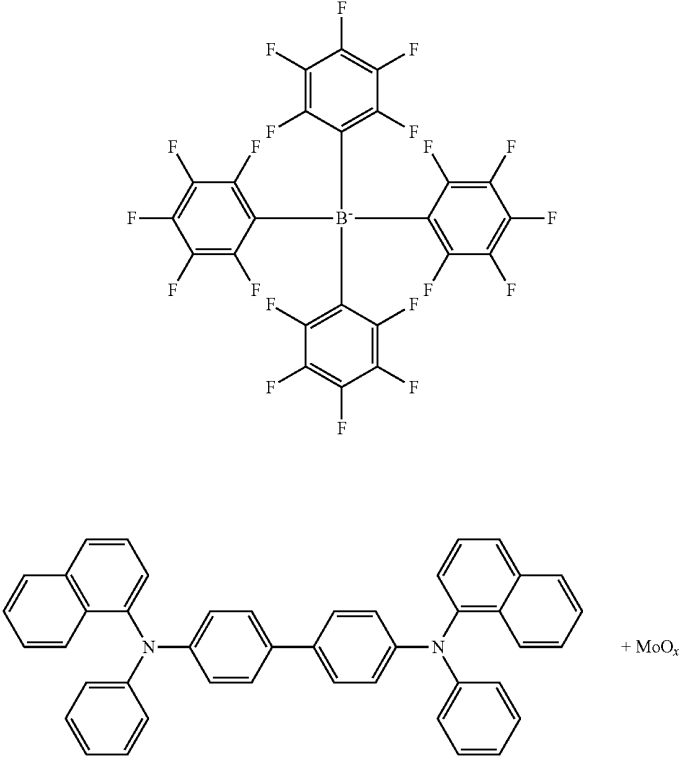
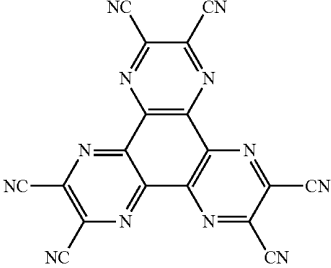
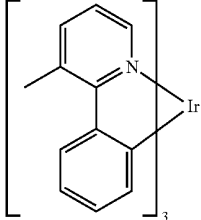
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Arylamines complexed with metal oxides such as molybdenum and tungsten oxides	 <p>The structure shows a central Boron atom (B) coordinated to four pentafluorophenyl rings. Below this, a chemical reaction is shown: a bis(arylamine) complex (two N-phenyl-1,2,3,4-tetrahydronaphthalenyl groups connected by a biphenyl bridge) reacts with MoO_x.</p>	SID Symposium Digest, 37, 923 (2006) WO2009018009
p-type semiconducting organic complexes	 <p>The structure is a porphyrin-like macrocycle with four nitrogen atoms at the corners. Each of the four meso-positions is substituted with a cyano group (CN).</p>	US20020158242
Metal organometallic complexes	 <p>The structure shows an Iridium (Ir) atom coordinated to three bipyridine-like ligands. The entire complex is enclosed in large square brackets with a subscript 3, indicating a trimeric complex.</p>	US20060240279

TABLE 1-continued

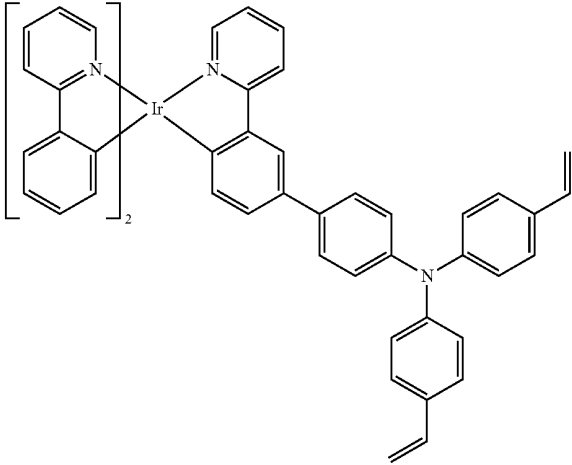
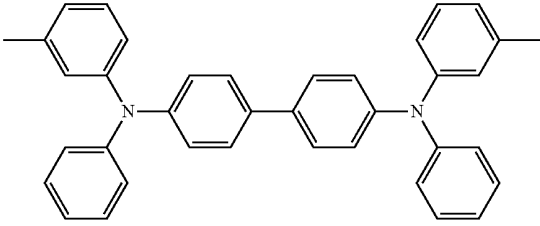
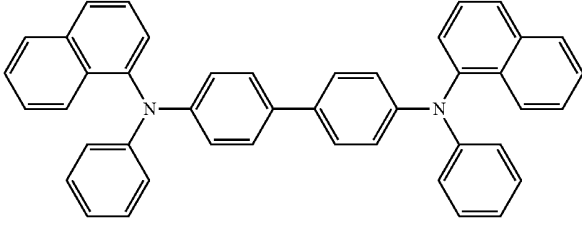
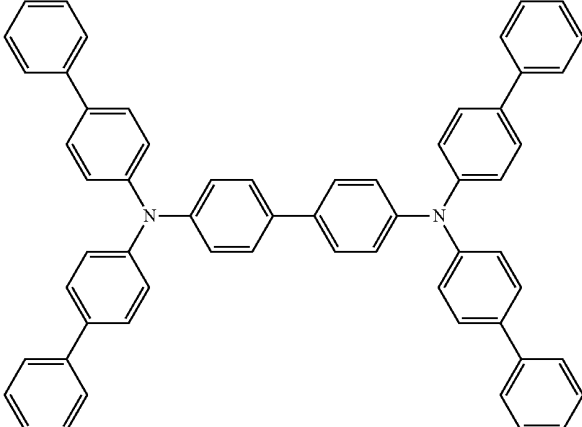
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Cross-linkable compounds		US20080220265
Hole transporting materials		
Triarylamines (e.g., TPD, α -NPD)		Appl. Phys. Lett. 51, 913 (1987)
		US5061569
		EP650955

TABLE 1-continued

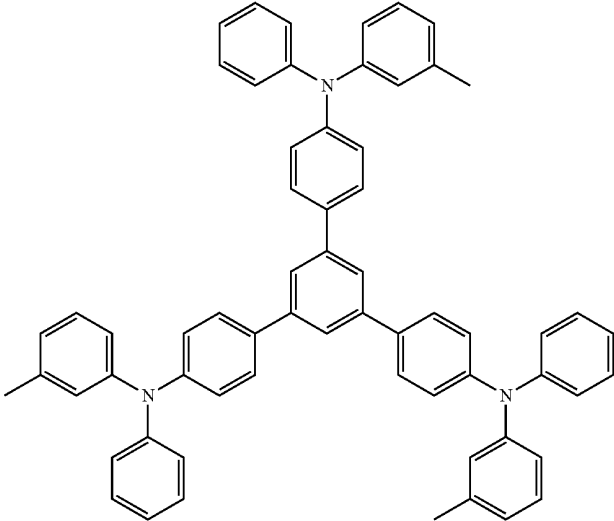
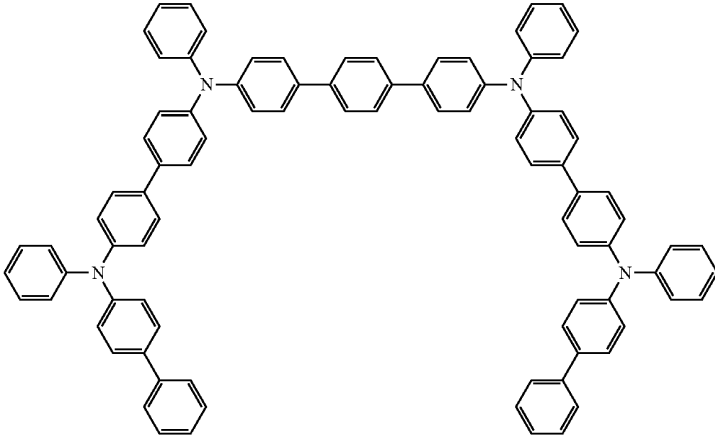
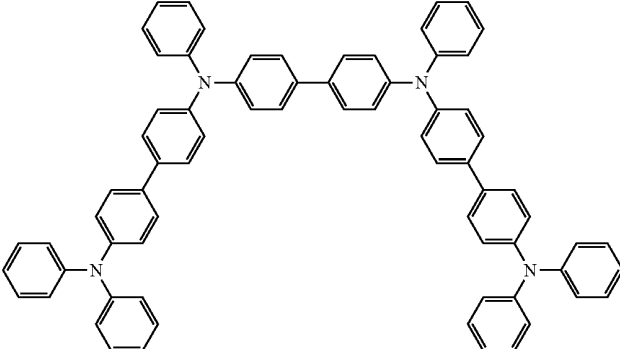
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		J. Mater. Chem. 3, 319 (1993)
		Appl. Phys. Lett. 90, 183503 (2007)
		Appl. Phys. Lett. 90, 183503 (2007)

TABLE 1-continued

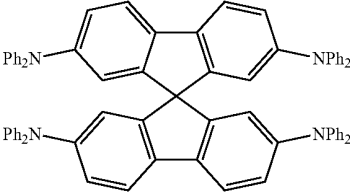
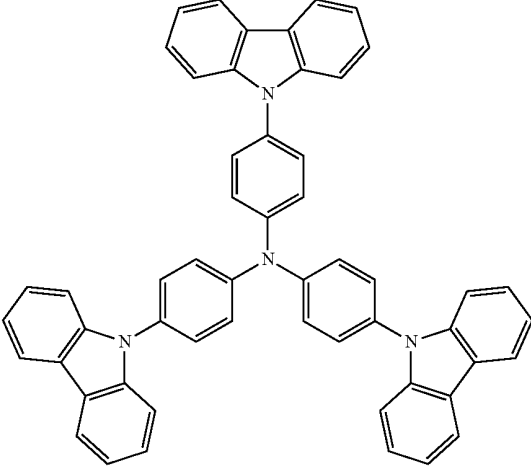
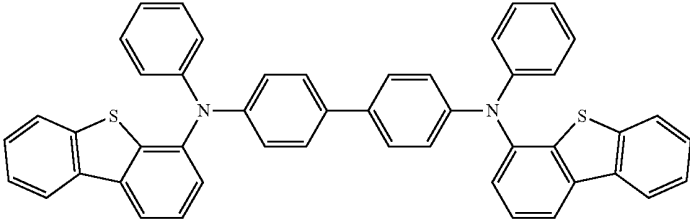
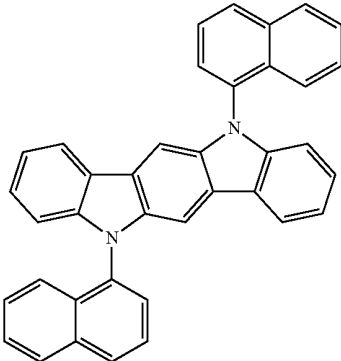
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Triarylamine on spirofluorene core		Synth. Met. 91, 209 (1997)
Arylamine carbazole compounds		Adv. Mater. 6, 677 (1994), US20080124572
Triarylamine with (di)benzothiophene/(di)benzofuran		US20070278938, US20080106190
Indolocarbazoles		Synth. Met. 111, 421 (2000)

TABLE 1-continued

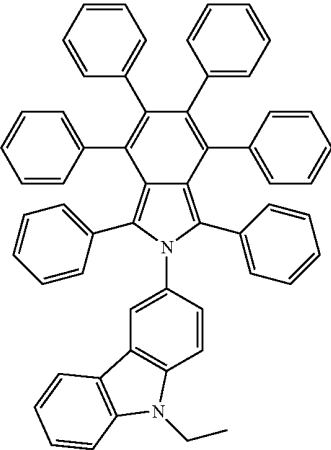
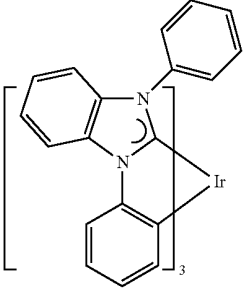
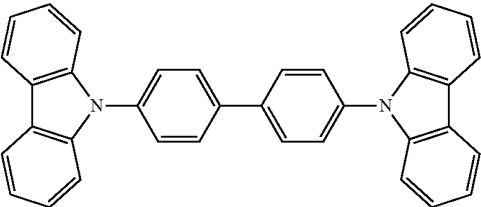
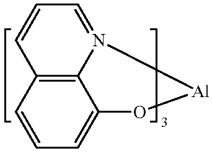
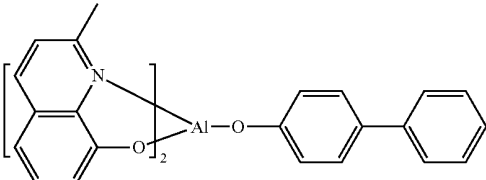
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Isoindole compounds		Chem. Mater. 15, 3148 (2003)
Metal carbene complexes		US20080018221
Phosphorescent OLED host materials Red hosts		
Arylcarbazoles		Appl. Phys. Lett. 78, 1622 (2001)
Metal 8-hydroxyquinolates (e.g., Alq ₃ , BAlq)		Nature 395, 151 (1998)
		US20060202194

TABLE 1-continued

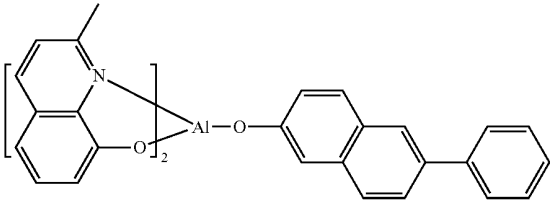
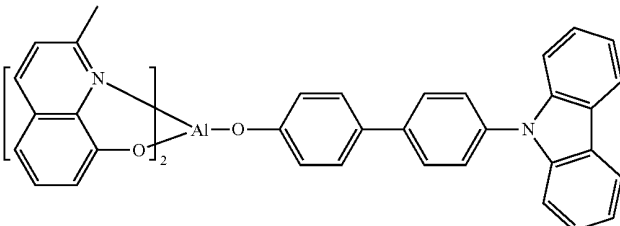
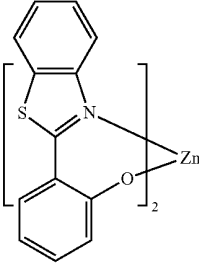
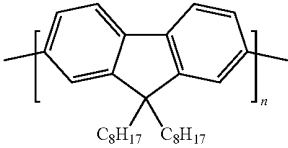
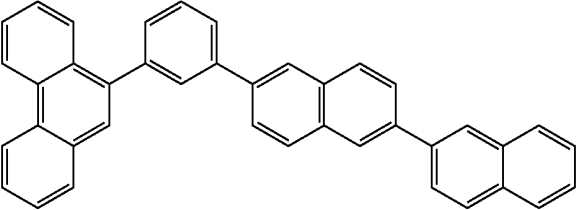
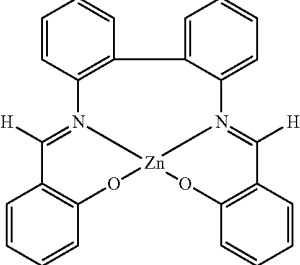
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		WO2005014551
		WO2006072002
Metal phenoxybenzothiazole compounds		Appl. Phys. Lett. 90, 123509 (2007)
Conjugated oligomers and polymers (e.g., polyfluorene)		Org. Electron. 1, 15 (2000)
Aromatic fused rings		WO2009066779, WO2009066778, WO2009063833, US20090045731, US20090045730, WO2009008311, US20090008605, US20090009065
Zinc complexes		WO2009062578

TABLE 1-continued

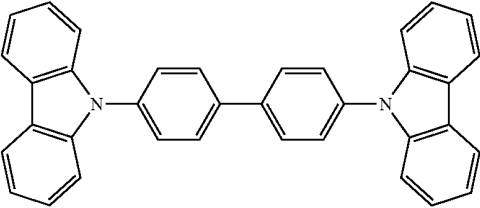
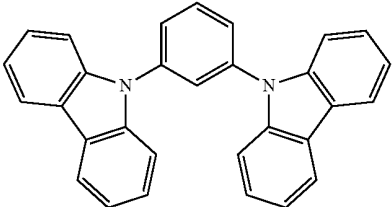
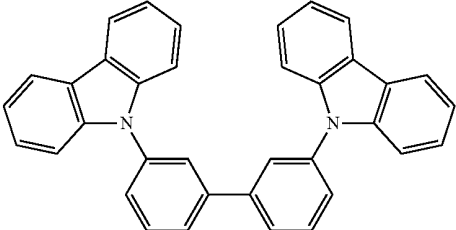
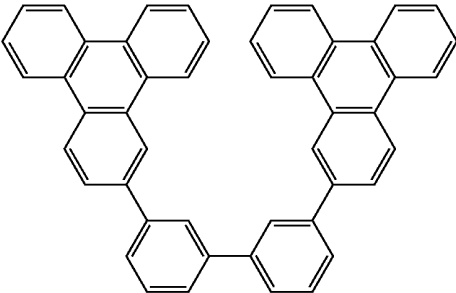
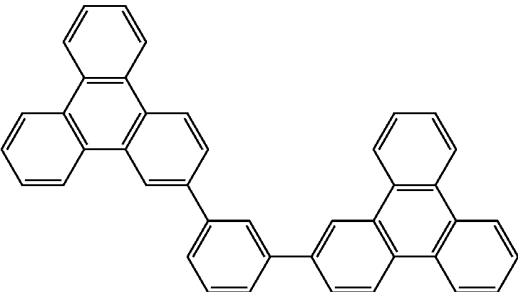
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
	Green hosts	
Arylcarbazoles		Appl. Phys. Lett. 78, 1622 (2001)
		US20030175553
		WO2001039234
Aryltriphenylene compounds		US20060280965
		US20060280965

TABLE 1-continued

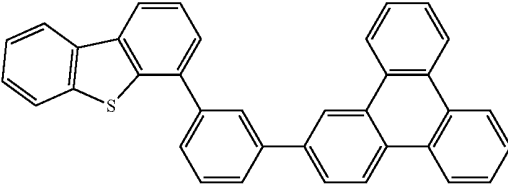
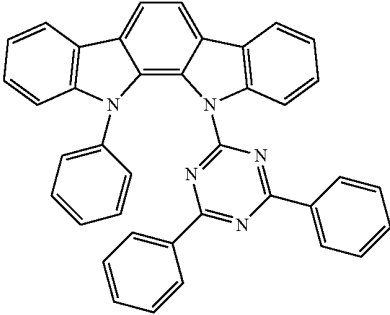
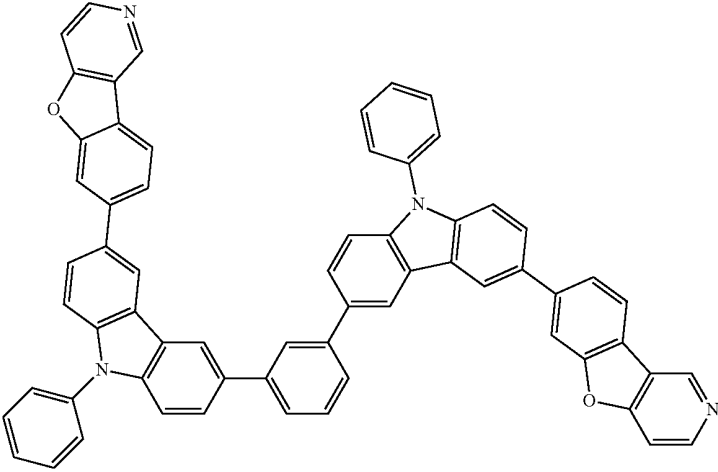
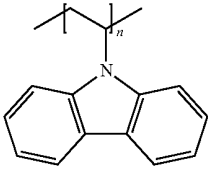
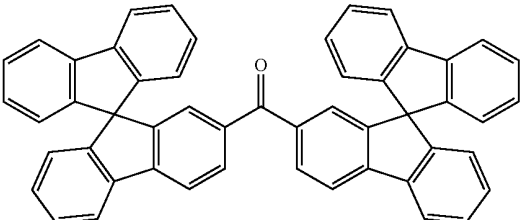
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Donor acceptor type molecules		WO2009021126
Aza-carbazole/DBT/DBF		WO2008056746
Polymers (e.g., PVK)		JP2008074939
Spirofluorene compounds		Appl. Phys. Lett. 77, 2280 (2000)
		WO2004093207

TABLE 1-continued

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Metal phenoxybenzoxazole compounds		WO2005089025
		WO2006132173
		JP200511610
Spirofluorene-carbazole compounds		JP2007254297
		JP2007254297

TABLE 1-continued

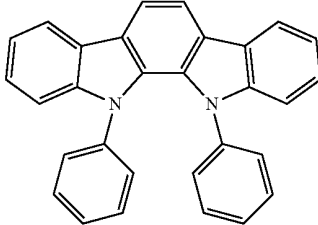
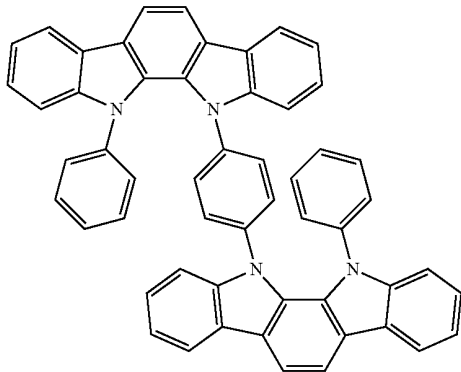
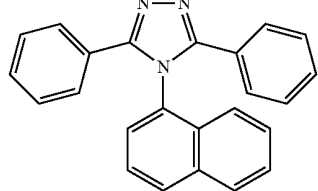
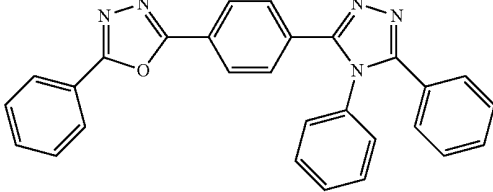
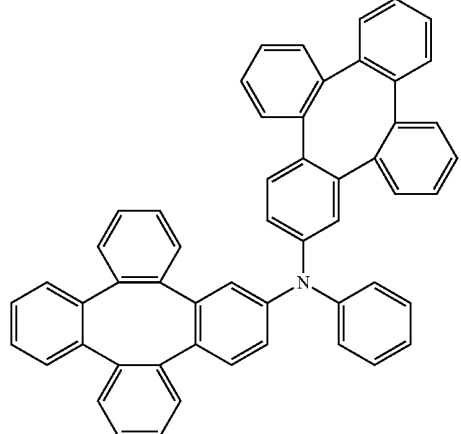
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Indolocarbazoles		WO2007063796
		WO2007063754
5-member ring electron deficient heterocycles (e.g., triazole, oxadiazole)		J. Appl. Phys. 90, 5048 (2001)
		WO2004107822
Tetraphenylene complexes		US20050112407

TABLE 1-continued

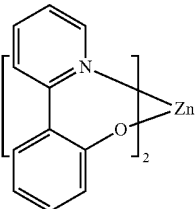
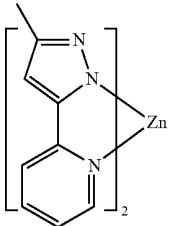
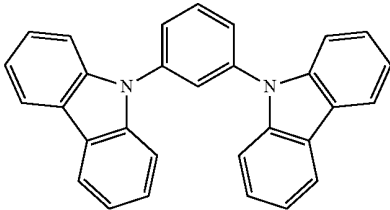
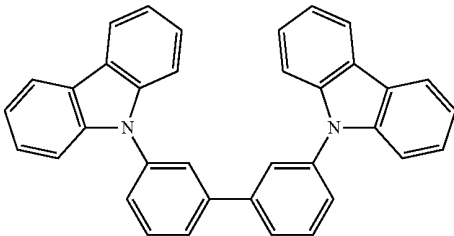
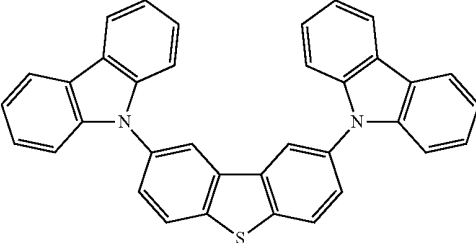
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Metal phenoxypyridine compounds		WO2005030900
Metal coordination complexes (e.g., Zn, Al with N N ligands)		US20040137268, US20040137267
Blue hosts		
Arylcarbazoles		Appl. Phys. Lett, 82, 2422 (2003)
		US20070190359
Dibenzothiophene/Dibenzo furan-carbazole compounds		WO2006114966, US20090167162

TABLE 1-continued

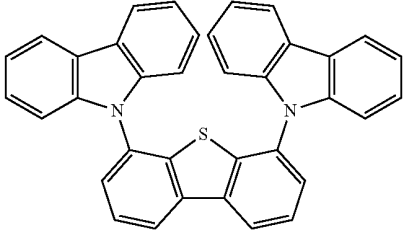
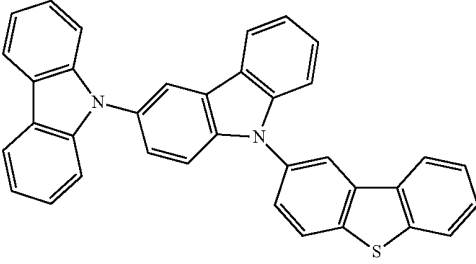
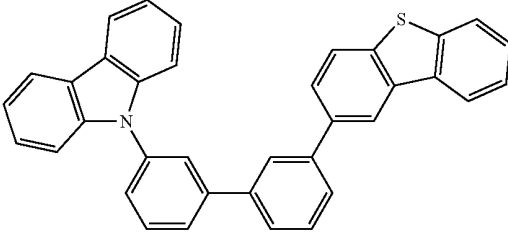
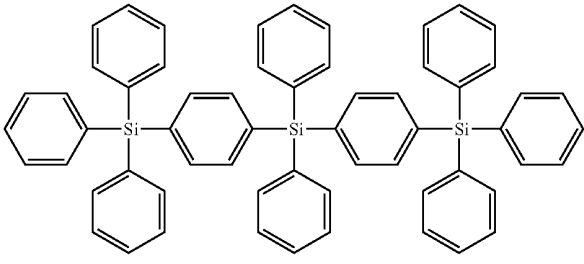
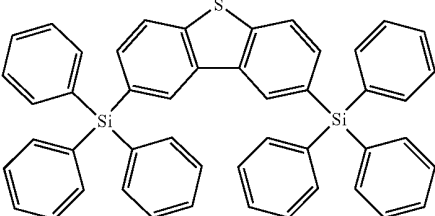
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		US20090167162
		WO2009086028
		US20090030202, US20090017330
Silicon aryl compounds		US20050238919
		WO2009003898

TABLE 1-continued

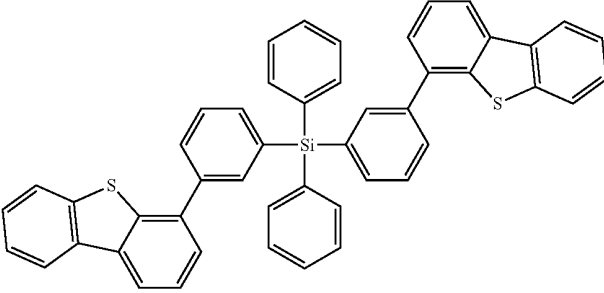
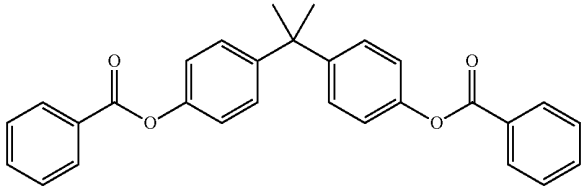
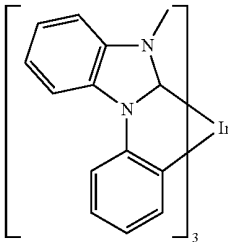
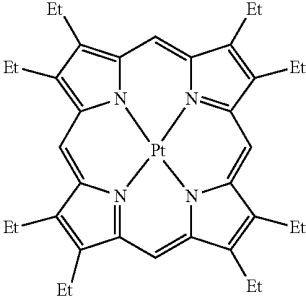
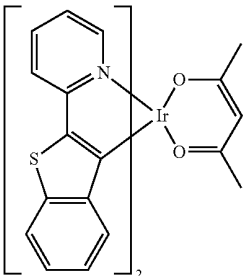
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Silicon/Germanium aryl compounds		EP2034538A
Aryl benzoyl ester		WO2006100298
High triplet metal organometallic complex		US7154114
Phosphorescent dopants Red dopants		
Heavy metal porphyrins (e.g., PtOEP)		Nature 395, 151 (1998)
Iridium(III) organometallic complexes		Appl. Phys. Lett. 78, 1622 (2001)

TABLE 1-continued

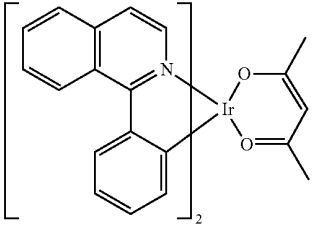
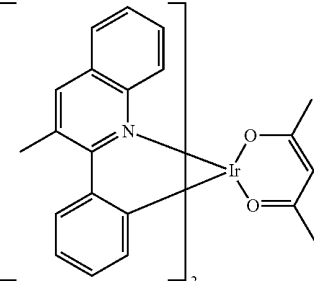
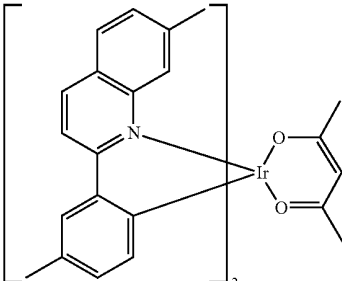
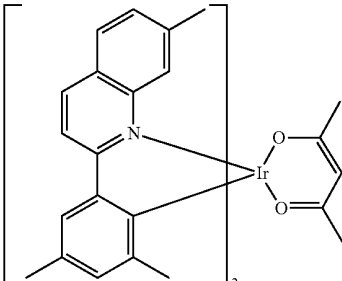
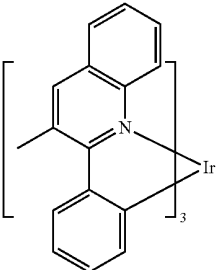
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		US2006835469
		US20060202194
		US20060202194
		US20070087321

TABLE 1-continued

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		US20070087321
		Adv. Mater. 19, 739 (2007)
		WO2009100991
		WO2008101842
Platinum(II) organometallic complexes		WO2003040257

TABLE 1-continued

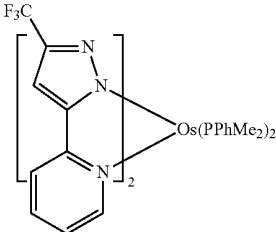
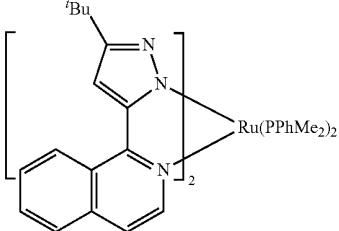
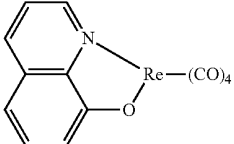
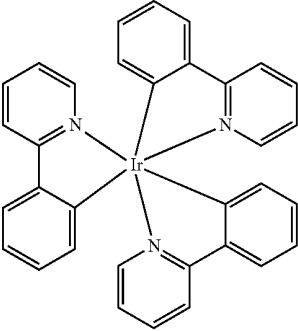
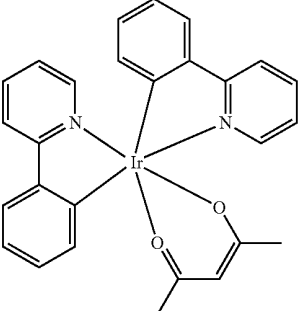
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Osmium(III) complexes		Chem. Mater. 17, 3532 (2005)
Ruthenium(II) complexes		Adv. Mater. 17, 1059 (2005)
Rhenium (I), (II), and (III) complexes		US20050244673
Green dopants		
Iridium(III) organometallic complexes		Inorg. Chem. 40, 1704 (2001)
	and its derivatives	
		US20020034656

TABLE 1-continued

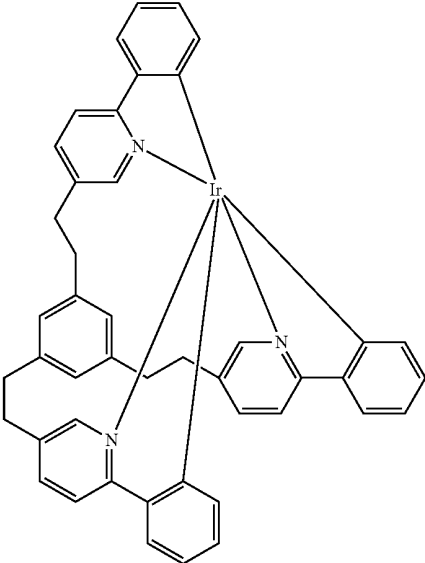
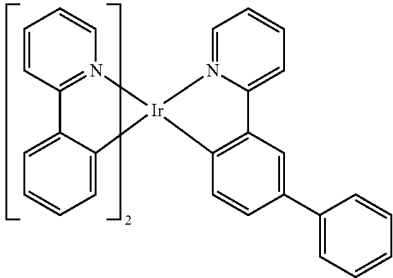
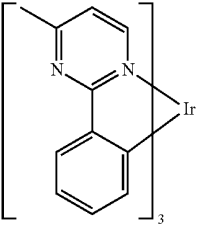
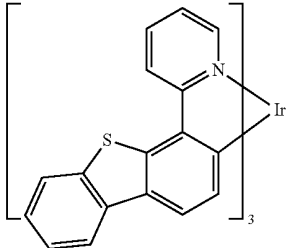
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		US20090039776
		US6921915

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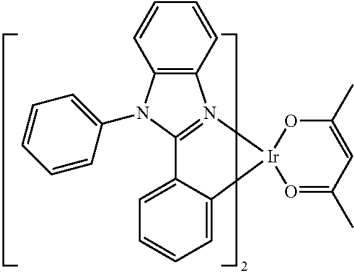
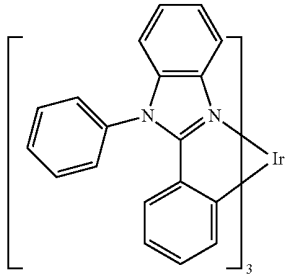
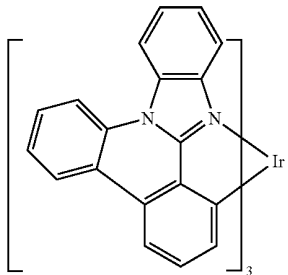
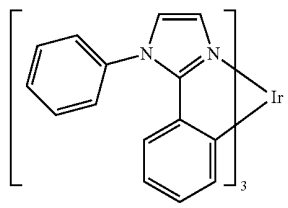
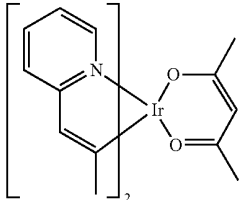
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		US6687266
		Chem. Mater. 16, 2480 (2004)
		US20070190359
		US 20060008670 JP2007123392
		Adv. Mater. 16, 2003 (2004)

TABLE 1-continued

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
	<p>The structure shows an iridium (Ir) center coordinated to a tricyclic ligand consisting of a benzene ring fused to a five-membered ring, which is further fused to another benzene ring. The Ir is also coordinated to a phenyl ring. The entire complex is enclosed in brackets with a subscript 3, indicating a trimeric species.</p>	Agnew. Chem. Int. Ed. 2006, 45, 7800
	<p>The structure shows an iridium (Ir) center coordinated to a tricyclic ligand similar to the first structure, but with an N-S group attached to the five-membered ring. The Ir is also coordinated to a phenyl ring. The entire complex is enclosed in brackets with a subscript 3.</p>	WO2009050290
	<p>The structure shows an iridium (Ir) center coordinated to a tricyclic ligand similar to the first structure, but with a sulfur atom (S) attached to the five-membered ring. The Ir is also coordinated to a phenyl ring. The entire complex is enclosed in brackets with a subscript 3.</p>	US20090165846
	<p>The structure shows an iridium (Ir) center coordinated to a tricyclic ligand similar to the first structure. The Ir is also coordinated to a chelating ligand consisting of a five-membered ring with two oxygen atoms and two methyl groups. The entire complex is enclosed in brackets with a subscript 2.</p>	US20080015355
Monomer for polymeric metal organometallic compounds	<p>The structure shows an iridium (Ir) center coordinated to a tricyclic ligand similar to the first structure. The Ir is also coordinated to a long chain ligand consisting of a five-membered ring with two oxygen atoms and two methyl groups, and a long alkyl chain ending in a vinyl group. The entire complex is enclosed in brackets with a subscript 2.</p>	US7250226, US7396598

TABLE 1-continued

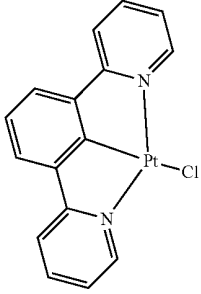
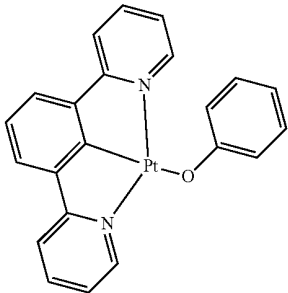
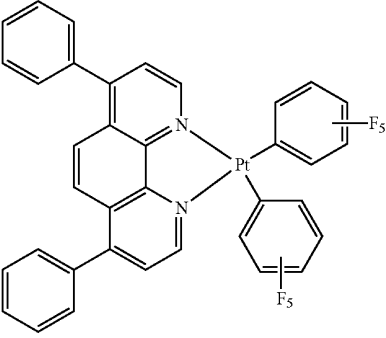
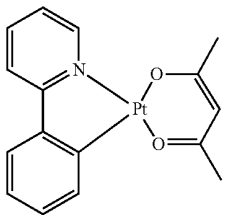
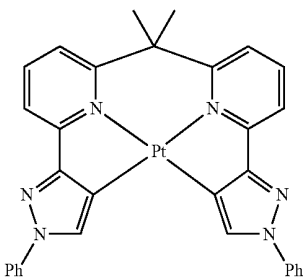
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Pt(II) organometallic complexes, including polydenated ligands		Appl. Phys. Lett. 86, 153505 (2005)
		Appl. Phys. Lett. 86, 153505 (2005)
		Chem. Lett. 34, 592 (2005)
		WO2002015645
		US20060263635

TABLE 1-continued

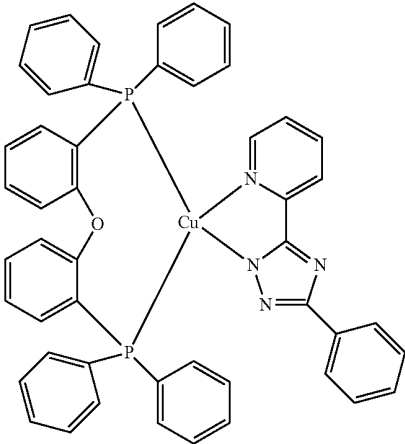
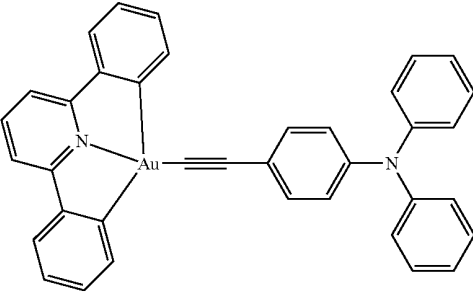
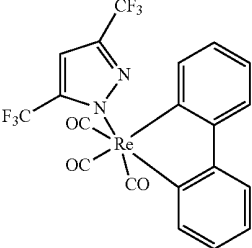
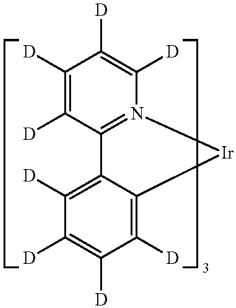
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Cu complexes		WO2009000673
Gold complexes		Chem. Commun. 2906 (2005)
Rhenium(III) complexes		Inorg. Chem. 42, 1248 (2003)
Deuterated organometallic complexes		US20030138657

TABLE 1-continued

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Organometallic complexes with two or more metal centers		US20030152802
		US7090928
	Blue dopants	
Iridium(III) organometallic complexes		WO2002002714
		WO2006009024

TABLE 1-continued

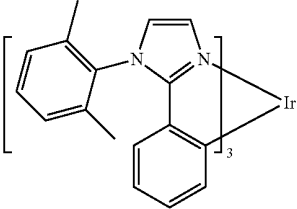
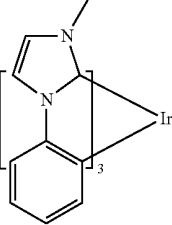
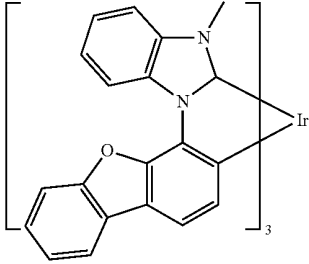
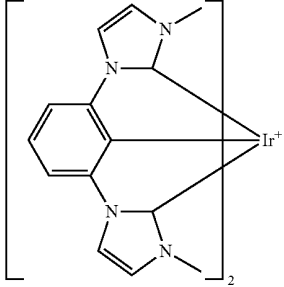
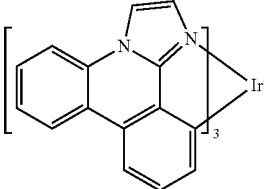
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		US20060251923
		US7393599, WO2006056418, US20050260441, WO2005019373
		US7534505
		US7445855
		US20070190359, US20080297033

TABLE 1-continued

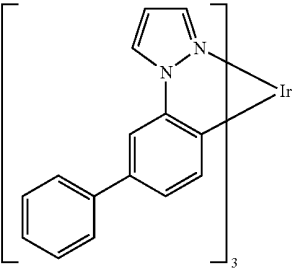
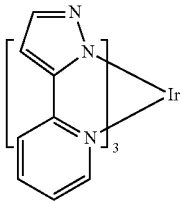
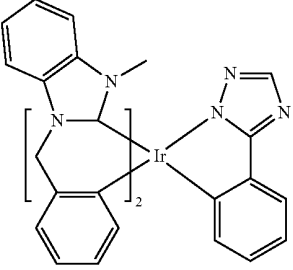
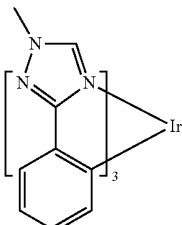
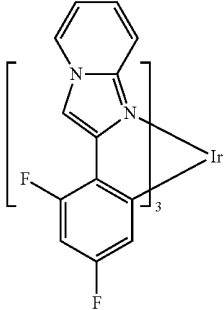
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
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		US20020134984
		Agnew. Chem. Int. Ed. 47, 1 (2008)
		Chem. Mater. 18, 5119 (2006)
		Inorg. Chem. 46, 4308 (2007)

TABLE 1-continued

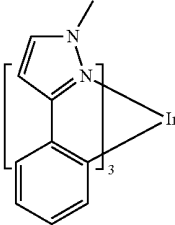
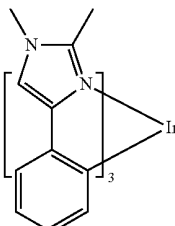
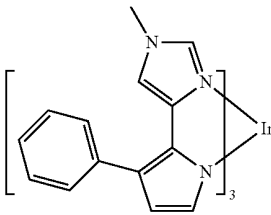
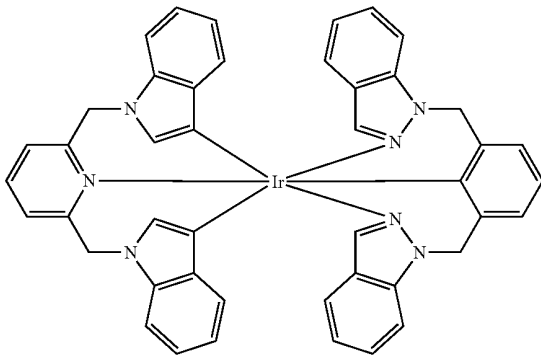
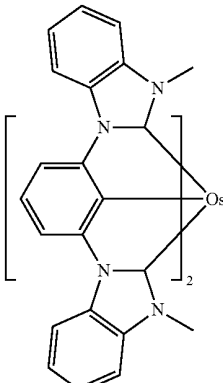
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		WO2005123873
		WO2005123873
		WO2007004380
		WO2006082742
Osmium(II) complexes		US7279704

TABLE 1-continued

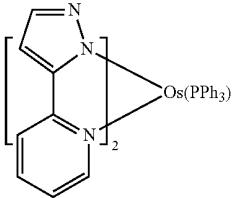
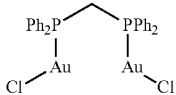
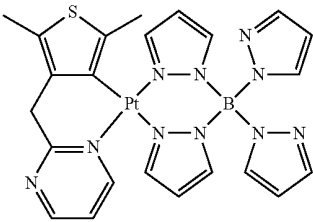
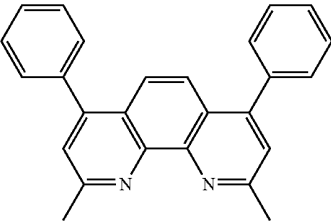
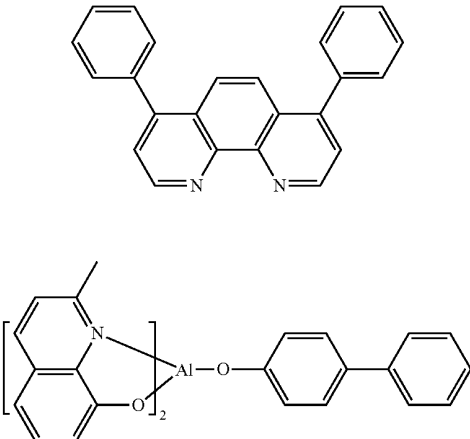
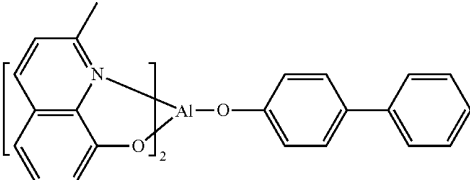
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Gold complexes		Organometallics 23, 3745 (2004)
Platinum(II) complexes		Appl. Phys. Lett. 74, 1361 (1999)
Platinum(II) complexes		WO2006098120, WO2006103874
Exciton/hole blocking layer materials		
Bathocuprine compounds (e.g., BCP, BPhen)		Appl. Phys. Lett. 75, 4 (1999)
Metal 8-hydroxyquinolates (e.g., BALq)		Appl. Phys. Lett. 79, 449 (2001)
Metal 8-hydroxyquinolates (e.g., BALq)		Appl. Phys. Lett. 81, 162 (2002)

TABLE 1-continued

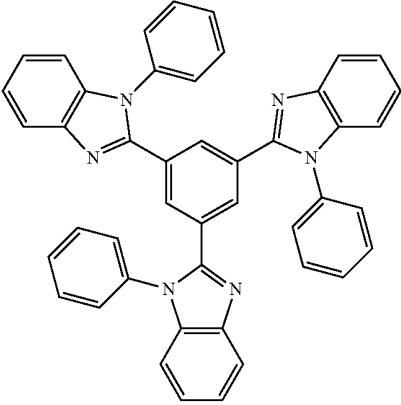
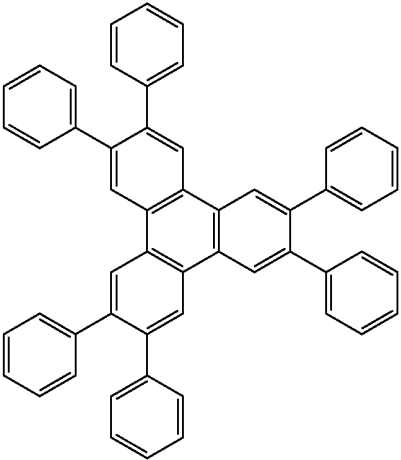
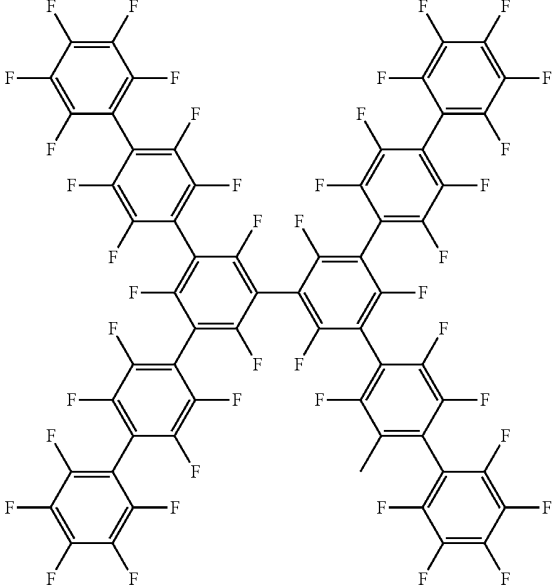
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
5-member ring electron deficient heterocycles such as triazole, oxadiazole, imidazole, benzoimidazole		Appl. Phys. Lett. 81, 162 (2002)
Triphenylene compounds		US20050025993
Fluorinated aromatic compounds		Appl. Phys. Lett. 79, 156 (2001)

TABLE 1-continued

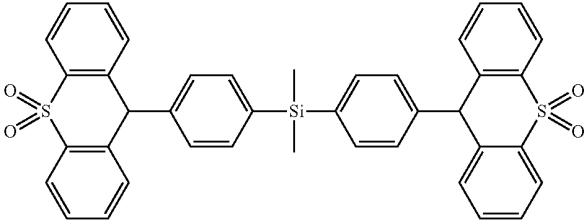
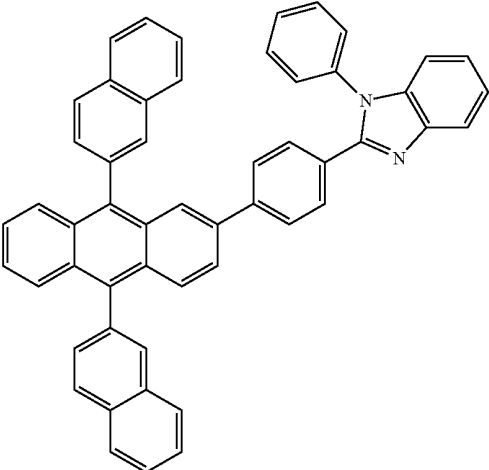
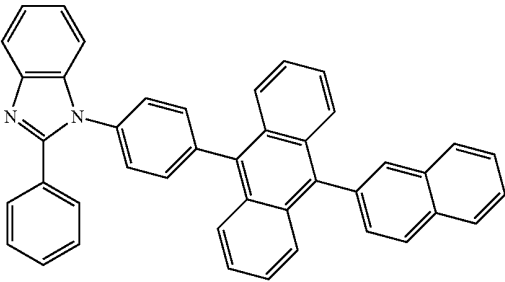
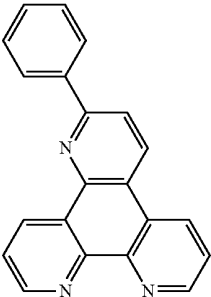
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Phenothiazine-S-oxide		WO2008132085
Electron transporting materials		
Anthracene-benzimidazole compounds		WO2003060956
		US20090179554
Aza triphenylene derivatives		US20090115316

TABLE 1-continued

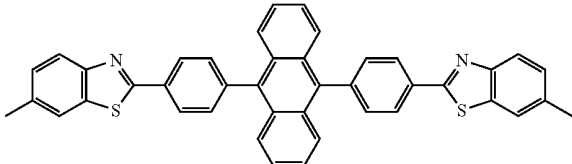
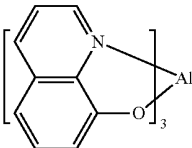
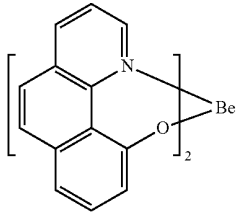
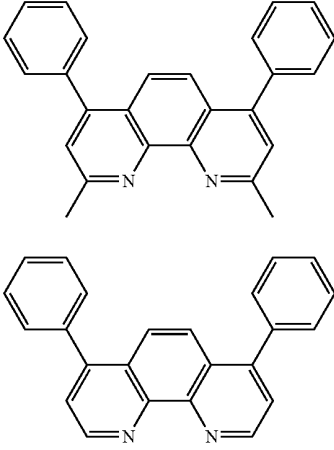
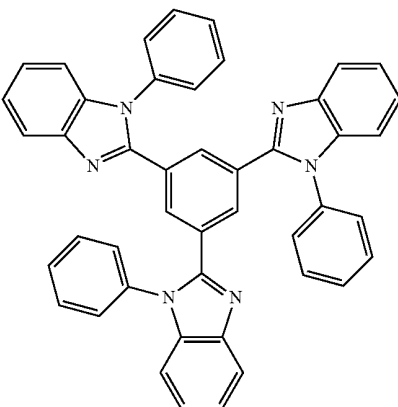
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Anthracene-benzothiazole compounds		Appl. Phys. Lett. 89, 063504 (2006)
Metal 8-hydroxyquinolates (e.g. Alq ₃ , Zr _q)		Appl. Phys. Lett. 51, 913 (1987) US7230107
Metal hydroxybenzoquinolates		Chem. Lett. 5, 905 (1993)
Bathocuprine compounds such as BCP, BPhen, etc		Appl. Phys. Lett. 91, 263503 (2007)
5-member ring electron deficient heterocycles (e.g. triazole, oxadiazole, imidazole, benzoimidazole)		Appl. Phys. Lett. 74, 865 (1999)

TABLE 1-continued

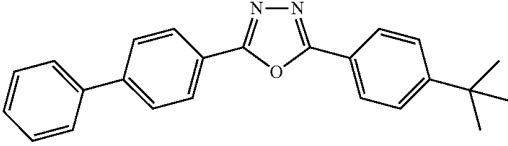
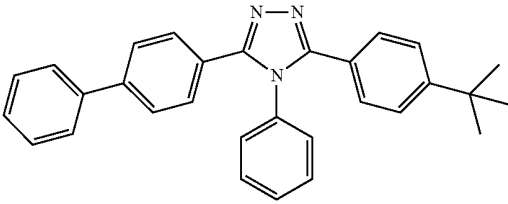
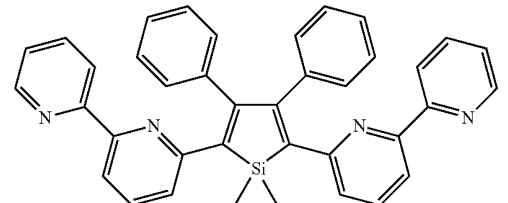
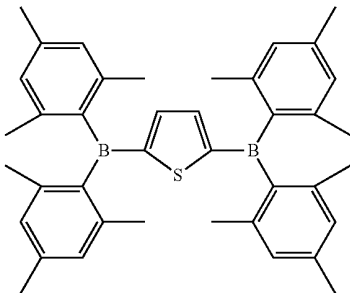
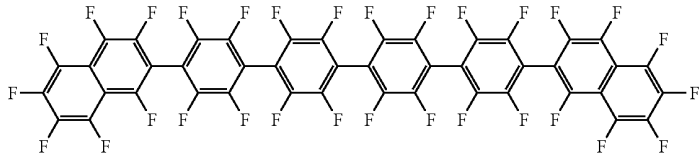
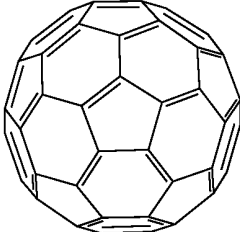
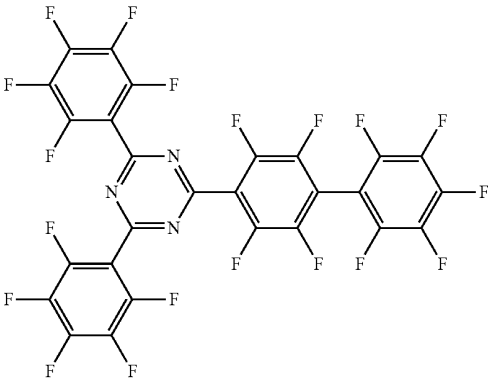
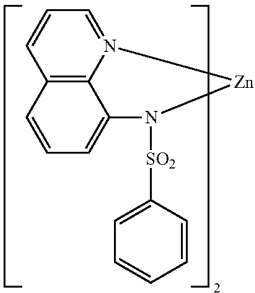
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		Appl. Phys. Lett. 55, 1489 (1989)
		Jpn. J. Apply. Phys. 32, L917 (1993)
Silole compounds		Org. Electron. 4, 113 (2003)
Arylborane compounds		J. Am. Chem. Soc. 120, 9714 (1998)
Fluorinated aromatic compounds		J. Am. Chem. Soc. 122, 1832 (2000)
Fullerene (e.g., C60)		US20090101870

TABLE 1-continued

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Triazine complexes		US20040036077
Zn (N ⁺ N ⁻) complexes		US6528187

EXPERIMENTAL

[0127] Several devices were fabricated as follows:

[0128] The hole injection layer (HIL) solutions were prepared by mixing the triarylamine derivative and conductivity dopant (mole ratio 1:1 or 2:1) in an organic solvent. Table 2 shows the composition of the HIL solutions. The HIL film was formed by spin coating the HIL solution at various speeds. The film was then baked at 250° C.

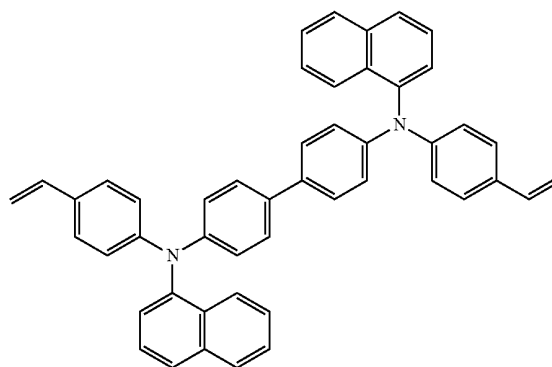
TABLE 2

	Organic electron acceptor	Organic electron donor	Mole ratio	Solvent	Total concentration (mg/mL)
HIL1	Compound 1	Dopant 1	1:1	Cyclohexanone	15
HIL2	Compound 2	Dopant 1	1:1	Cyclohexanone	15
HIL3	Compound 2	Dopant 1	2:1	Cyclohexanone	13

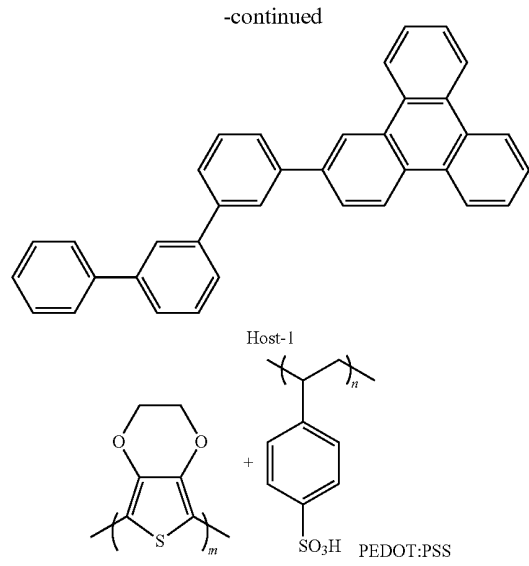
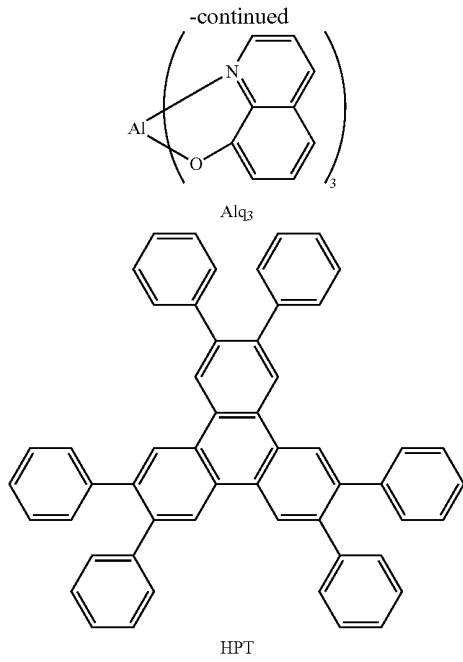
[0129] Green-emitting OLEDs were made using HIL1, HIL2, and HIL3 for the hole injection layer. To form the HIL, the solution was spin-coated at 2500 rpm for 60 seconds onto

a patterned indium tin oxide (ITO) electrode. The resulting film was baked for 30 minutes at 250° C.

[0130] As used herein, the following compounds have the following structures:



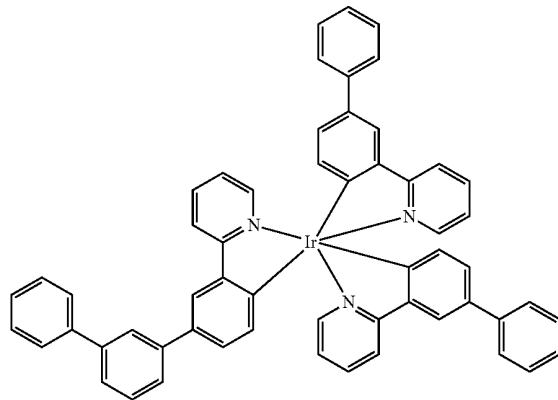
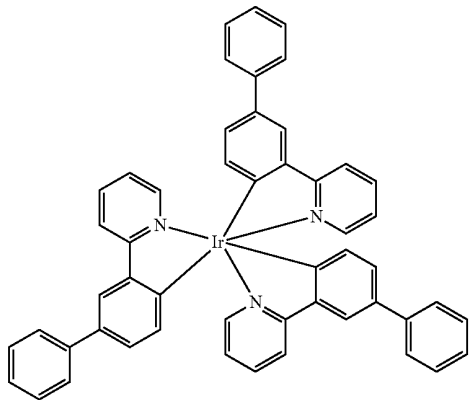
HTL-1



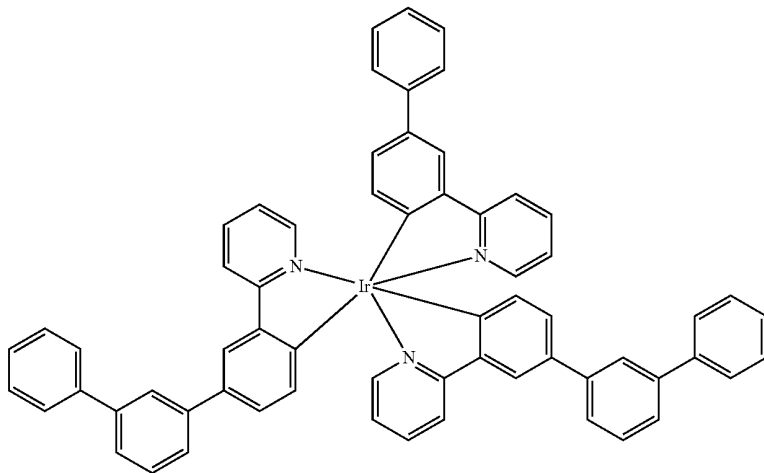
[0131] As used herein, Dopant 1 is a mixture of A, B, C, and D in a ratio of 1.9:18.0:46.7:32.8, wherein A, B, C, and D have the following structures:

(A)

(B)

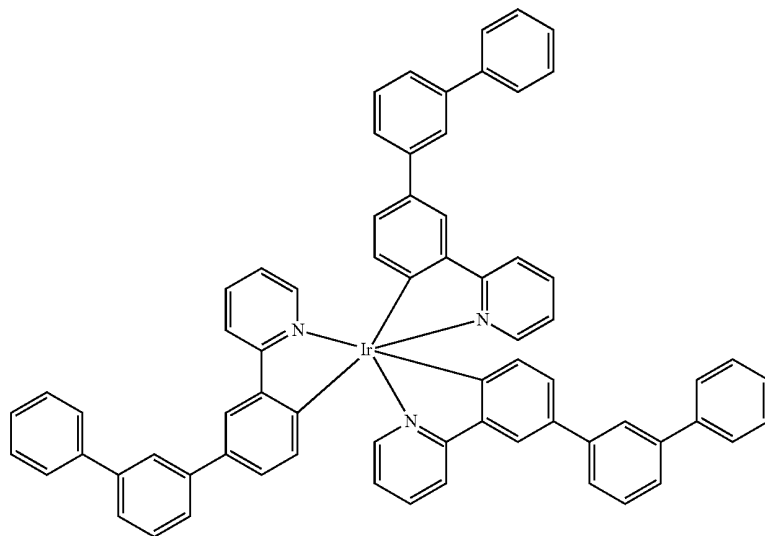


(C)



-continued

(D)



[0132] To check the insolubility, the HIL1 solution was spun-coated on the top of a Si-wafer, and the spin and baking conditions were same as on ITO. After baking, the HIL1 film was measured. Then, neat toluene solvent was spun on the top of HIL1 film to try wash-off the HIL1 film, which is the same as the hole transporting layer (HTL) spin-coating process used in device fabrication. The HIL1 film thickness was measured with 133 Å before washing, and 86 Å after toluene washing. About 60% of the film thickness was left after toluene washing.

[0133] A comparative green-emitting device was fabricated using PEDOT:PSS (Baytron, CH8000) as the HIL material. The PEDOT:PSS in an aqueous dispersion was spin-coated at 4000 rpm for 60 seconds onto a patterned indium tin oxide (ITO) electrode. The resulting film was baked for 5 minutes at 200° C.

[0134] On top of the HIL, a hole transporting layer (HTL) and then emissive layer (EML) were also formed by spin-coating. The HTL was made by spin-coating a 0.5 wt % solution of the hole transporting material HTL-1 in toluene at 4000 rpm for 60 seconds. The HTL film was baked at 200° C. for 30 minutes. After baking, the HTL became an insoluble film.

[0135] The EML was made using Host-1 as the host material and the green-emitting phosphorescent Dopant-1 as the emissive material. To form the EML, a toluene solution containing Host-1 and Dopant-1 (of total 0.75 wt %), with a Host-1:Dopant-1 weight ratio of 88:12, was spin-coated onto the insoluble HTL at 1000 rpm for 60 seconds, and then baked at 100° C. for 30 minutes.

[0136] The hole blocking layer (containing the compound HPT), the electron transport layer (containing Alq₃), the electron injection layer (containing LiF), and the aluminum electrode were sequentially vacuum deposited.

[0137] For performance testing, these green-emitting devices were operated under a constant DC current. FIG. 3 shows a plot of luminance intensity versus time for the devices. The lifetime LT₈₀ (as measured by the time elapsed

for decay of brightness to 80% of the initial level) were 9 h, 143 h, 87 h, and 131 h for the Comparative, HIL1, HIL2, and HIL3 devices, respectively. The devices with new HIL materials have much longer lifetime than the comparative PEDOT:PSS device.

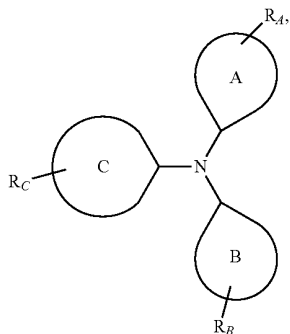
[0138] Table 3 summarizes the performance of the green-emitting devices. As seen in Table 3, the HIL1 device had similar performance in luminous efficiency (39 cd/A) and lower operating voltage (7.8 V) compared to Comparative device (42 cd/A, 8.1 V) at 4000 cd/m². However, HIL2 and HIL3 had lower efficiency and higher voltage than the Comparative device.

TABLE 3

	Comparative Device	HIL1 Device	HIL2 Device	HIL3 Device
Operating Voltage (V) @ 4000 cd/m ²	8.1	7.8	8.2	8.6
Luminous Efficiency (cd/A) @ 4000 cd/m ²	42	39	20	20
Lifetime LT ₈₀ (hours) from 4000 cd/m ²	9	143	87	131
Color Coordinate CIE 1931 (x, y)	(0.36, 0.60)	(0.33, 0.62)	(0.33, 0.63)	(0.32, 0.63)

[0139] It is understood that the various embodiments described herein are by way of example only, and are not intended to limit the scope of the invention. For example, many of the materials and structures described herein may be substituted with other materials and structures without deviating from the spirit of the invention. The present invention as claimed may therefore includes variations from the particular examples and preferred embodiments described herein, as will be apparent to one of skill in the art. It is understood that various theories as to why the invention works are not intended to be limiting.

1. A method of fabricating an organic light emitting device, the method comprising:
 providing an electrode;
 depositing a first organic layer in contact with the electrode by a solution process, wherein the first organic layer comprises an organic electron acceptor; and
 an organic electron donor having the formula:

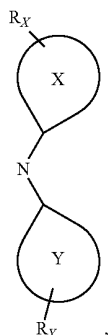


wherein A, B, and C are 5 or 6 membered cyclic or heterocyclic rings;

wherein R_A , R_B , and R_C are independent selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl; and

wherein R_A , R_B , and R_C are optionally fused to A, B, and C; and

wherein at least two of R_A , R_B , and R_C contain the structure:



wherein X and Y are independently 5 or 6 membered cyclic or heterocyclic rings;

wherein R_X and R_Y are independent selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl;

wherein R_X and R_Y are optionally fused to X and Y;

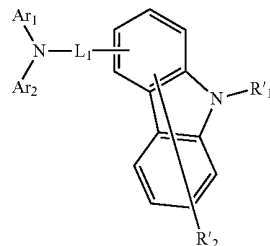
wherein R_X and R_Y are optionally connected to A and B; and

heating the first organic layer to form a layer that is insoluble in a non-polar solvent.

2. The method of claim 1, wherein the non-polar solvent is selected from the group consisting of benzene, carbon tetrachloride, cyclohexane, 1,2-dichloroethane, dichloromethane, di-ethyl ether, heptane, hexane, methyl-t-butyl ether, pentane, di-iso-propyl ether, toluene, and xylene.

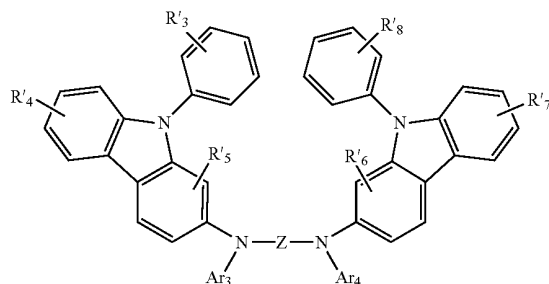
3. The method of claim 1, wherein the non-polar solvent is toluene.

4. The method of claim 1, wherein the organic electron donor has the formula:



wherein L_1 represents a substituted or unsubstituted arylene group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted fluorenylene group, or a substituted or unsubstituted heteroarylene group having 5 to 60 atoms forming a ring; Ar_1 and Ar_2 each independently represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring or a substituted or unsubstituted heteroaryl group having 5 to 60 atoms forming a ring; R'_1 represents a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring; R'_2 represents a hydrogen atom, a substituted or unsubstituted aryl group having 6 to 60 carbon atoms forming the aromatic ring, a substituted or unsubstituted alkyl group having 1 to 50 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 50 carbon atoms, a substituted or unsubstituted alkoxy group having 6 to 50 atoms forming a ring, a substituted or unsubstituted arylthio group having 5 to 50 atoms forming a ring, a substituted or unsubstituted alkoxy carbonyl group having 2 to 50 carbon atoms, an amino group substituted by a substituted or unsubstituted aryl group having 6 to 50 carbon atoms forming the aromatic ring, a halogen atom, a cyano group, a nitro group, a hydroxyl group or a carboxyl group; with the proviso that neither Ar_1 nor Ar_2 contains a fluorene structure, and that the number of a carbazole structures in the aromatic amine derivative represented by the formula is 1 or 2.

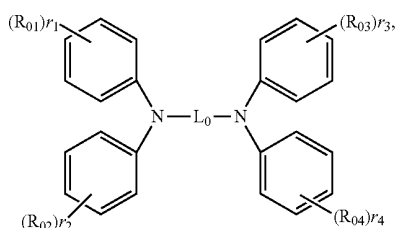
5. The method of claim 1, wherein the organic electron donor has the formula:



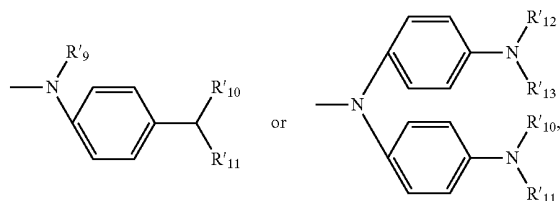
wherein Z is selected from the group consisting of a substituted or unsubstituted C1-C30 alkylene group, a substituted or unsubstituted C2-C30 alkenylene group, a substituted or unsubstituted C6-C30 arylene group, a substituted or unsubstituted C2-C30 heteroarylene group, and a substituted or unsubstituted C2-C30 heterocyclic group; each of R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 is

independently selected from the group consisting of a hydrogen atom, a substituted or unsubstituted C1-C30 alkyl group, a substituted or unsubstituted C1-C30 alkoxy group, a substituted or unsubstituted C6-C30 aryl group, a substituted or unsubstituted C6-C30 aryloxy group, a substituted or unsubstituted C2-C30 heterocyclic group, a substituted or unsubstituted C6-C30 condensed polycyclic group, a hydroxy group, a cyano group, and a substituted or unsubstituted amino group, and, alternatively, two or more adjacent groups among R'_3 , R'_4 , R'_5 , R'_6 , R'_7 , and R'_8 can be connected to each other to form a saturated or unsaturated carbocycle; and wherein each of Ar_3 and Ar_4 are independently a substituted or unsubstituted C6-C30 aryl group or a substituted or unsubstituted C2-C30 heteroaryl group.

6. The method of claim 1, wherein the organic electron donor has the formula:



wherein L_0 is any one of o-, p-, and m-phenylene groups which have two, three or four rings and which have a substituent with the proviso that when L_0 is a phenylene group having four rings, the phenylene group may have an unsubstituted or substituted aminophenyl group somewhere therein, and R_{01} , R_{02} , R_{03} and R_{04} are any one of the following groups:



wherein R'_9 , R'_{10} , R'_{11} , R'_{12} and R'_{13} are each a substituted or unsubstituted aryl group, and r_1 , r_2 , r_3 and r_4 are each an integer of 0 to 5 with the proviso that $r_1 + r_2 + r_3 + r_4 \geq 1$.

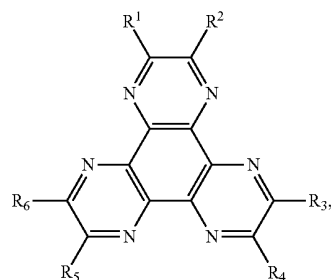
7. The method of claim 1, wherein the electrode is an anode, and the first organic layer is deposited in contact with the anode.

8. The method of claim 1, wherein a second organic layer containing a non-polar solvent is deposited over the first organic layer, and the first organic layer is insoluble to the non-polar solvent in the second organic layer.

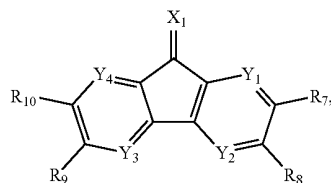
9. The method of claim 1, wherein the first organic layer is a hole injection layer.

10. The method of claim 1, wherein the second organic layer is a hole transporting layer, a hole blocking layer, an electron transporting layer, an electron injection layer, or an emissive layer.

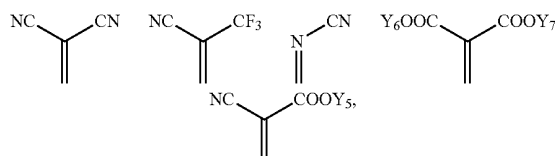
11. The method of claim 1, wherein the organic electron acceptor is selected from the group of compounds having the formulas:



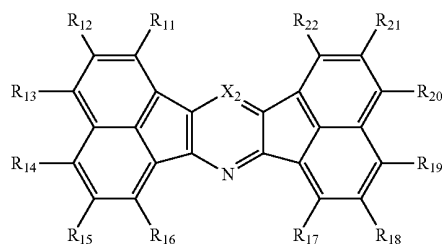
wherein R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 are independently chosen from the group consisting of hydrogen, halogen, nitrile, nitro, sulfonyl, sulfoxide, sulfonamide, sulfonate, trifluoromethyl, ester, amide, straight-chain or branched C1-C12 alkoxy, straight-chain or branched C1-C12 alkyl, aromatic or non-aromatic (substituted or unsubstituted) heterocyclic, substituted or unsubstituted aryl, mono- or di-(substituted or unsubstituted)aryl-amine, and (substituted or unsubstituted)alkyl-(substituted or unsubstituted)aryl-amine; or where R_1 and R_2 , R_3 and R_4 , and R_5 and R_6 combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted;



wherein Y_1 to Y_4 are independently a carbon atom or a nitrogen atom. R_7 to R_{10} are independently a hydrogen atom, an alkyl group, a substituted or unsubstituted aryl group, a substituted or unsubstituted heterocycle, a halogen atom, a fluoroalkyl group or a cyano group. R_7 and R_8 , and R_9 and R_{10} are independently bonded to form a substituted or unsubstituted aromatic ring or a substituted or unsubstituted heterocycle. X_1 is selected from the group consisting of:



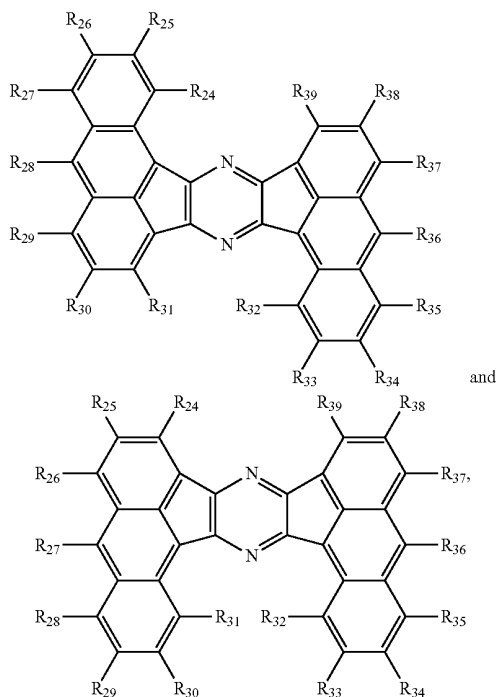
wherein Y_5 to Y_7 are independently a hydrogen atom, a fluoroalkyl group, an alkyl group, an aryl group or a heterocyclic group; and Y_6 and Y_7 may form a ring;



wherein X_2 is

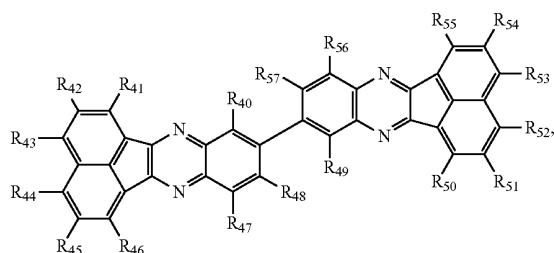


wherein C(R_{23}) or N, R_{11} to R_{23} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{11} to R_{23} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{11} to R_{23} , which are adjacent to one another, may be linked together to form a ring structure;

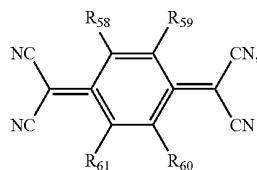


wherein R_{24} to R_{39} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{24} to R_{39} each represent a cyano group, a trifluoromethyl group or a

fluorine atom and that those of R_{24} to R_{39} which are adjacent to one another, may be linked together to form a ring structure;

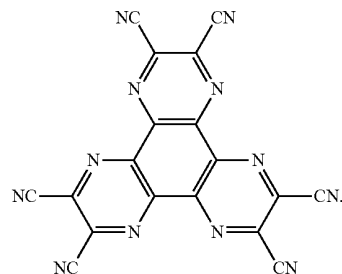


wherein R_{40} to R_{57} each independently represent a hydrogen atom, a substituted or unsubstituted alkyl group having 1 to 30 carbon atoms, a substituted or unsubstituted alkoxy group having 1 to 30 carbon atoms, a substituted or unsubstituted aryl group having 6 to 40 carbon atoms, a trialkylsilyl group wherein the alkyl group has 1 to 20 carbon atoms and may have a substituent, an aryloxy group wherein the aryl group has 6 to 40 carbon atoms and may have a substituent, a halogen atom, or a cyano group, provided that at least two of R_{40} to R_{57} each represent a cyano group, a trifluoromethyl group or a fluorine atom and that those of R_{40} to R_{57} which are adjacent to one another, may be linked together to form a ring structure; and



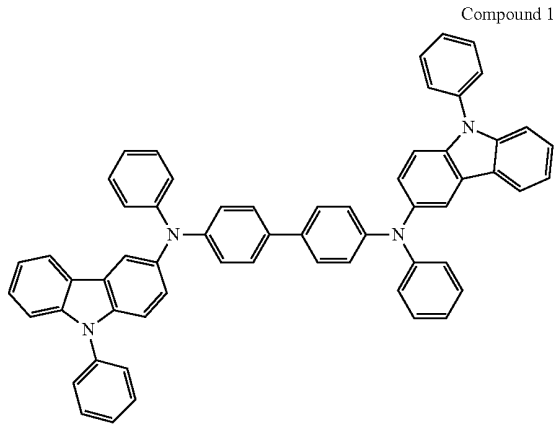
wherein R_{58} - R_{61} independently represents hydrogen, fluorine, or substituents independently selected from nitrile ($-\text{CN}$), nitro ($-\text{NO}_2$), sulfonyl ($-\text{SO}_2\text{R}$), sulfoxide ($-\text{SOR}$), trifluoromethyl ($-\text{CF}_3$), ester ($-\text{CO-DR}$), amide ($-\text{CONHR}$ or $-\text{CO-NRR}'$), substituted or unsubstituted aryl, substituted or unsubstituted heteroaryl, or substituted or unsubstituted alkyl, where R and R' include substituted or unsubstituted alkyl or aryl; or R_{58} and R_{59} , or R_{60} and R_{61} , combine form a ring structure including an aromatic ring, a heteroaromatic ring, or a non-aromatic ring, and each ring is substituted or unsubstituted.

12. The method of claim 1, wherein the organic electron acceptor is:

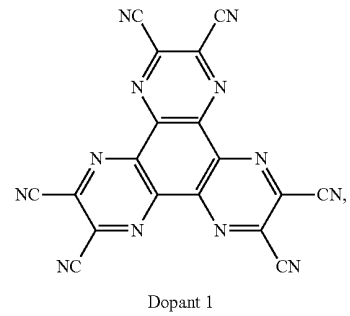


Dopant 1

13. The method of claim 1, wherein the organic electron donor is selected from the group consisting of:

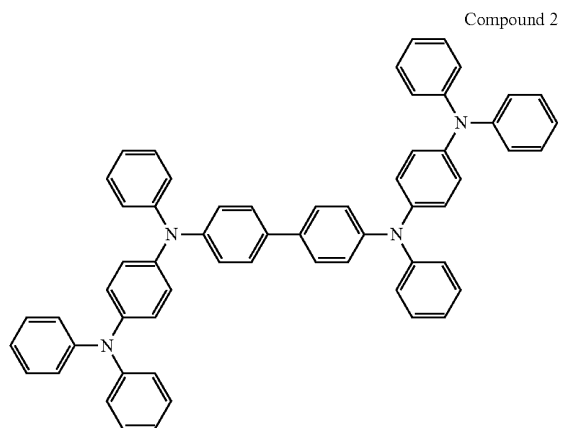
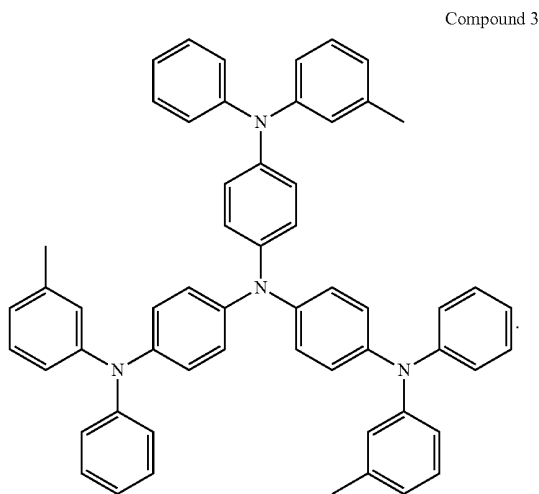
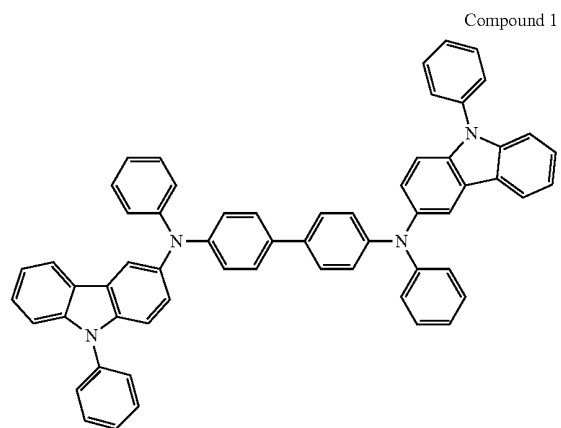
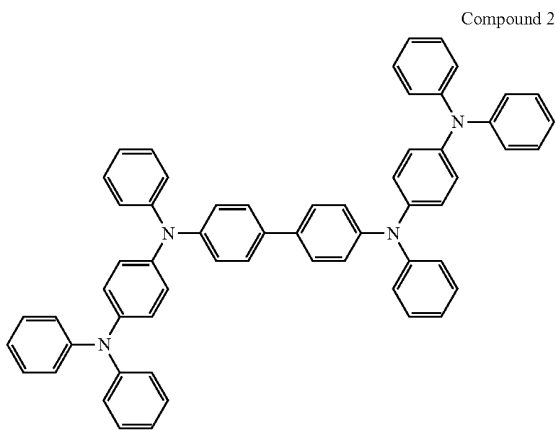


14. The method of claim 1, wherein the organic electron acceptor is:



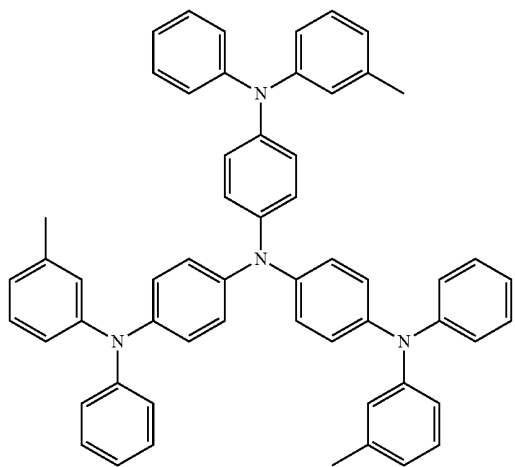
and

wherein the organic electron donor is selected from the group consisting of:



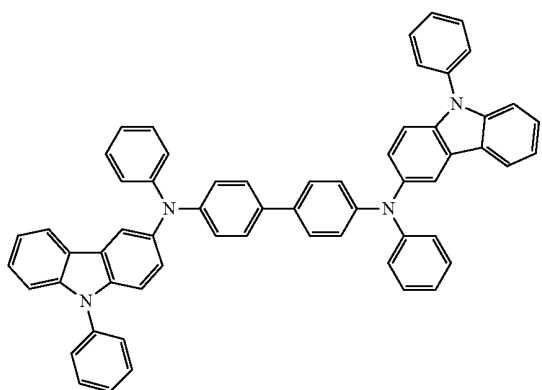
-continued

Compound 3



15. The method of claim 14, wherein the organic electron donor is:

Compound 1



16. The method of claim 1, wherein the solution process is spin coating or inkjet printing.

17. The method of claim 1, wherein the organic electron acceptor and the organic electron donor are mixed at a mole ratio of 1:1 or 2:1.

18. The device of claim 1, wherein the insoluble organic layer forms when the composition is heated at a temperature no less than about 100° C. and no more than about 250° C.

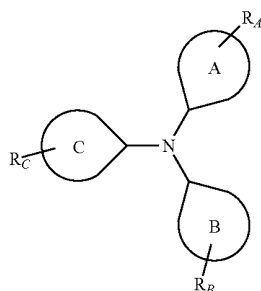
19. A first device comprising an organic light emitting device, further comprising:

an anode; and

a cathode; and

a first organic layer disposed between the anode and the cathode, wherein the first organic layer comprises an organic electron acceptor; and

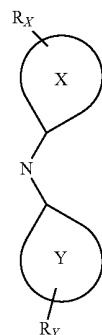
an organic electron donor having the formula:



wherein A, B, and C are 5 or 6 membered cyclic or heterocyclic rings;

wherein R_A , R_B , and R_C are independently selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl; and wherein R_A , R_B , and R_C are optionally fused to A, B, and C; and

wherein at least two of R_A , R_B , and R_C contain the structure:



wherein X and Y are independently 5 or 6 membered cyclic or heterocyclic rings;

wherein R_X and R_Y are independent selected from the group consisting of hydrogen, halogen, alkyl, alkoxy, amino, alkenyl, alkynyl, aryl and heteroaryl;

wherein R_X and R_Y are optionally fused to X and Y;

wherein R_X and R_Y are optionally connected to A and B; and

wherein the organic electron acceptor and the organic electron donor form an insoluble organic layer when the composition is heated.

20. The device of claim 19, wherein the organic electron acceptor and the organic electron donor form a layer that is insoluble in a non-polar solvent.

21.-37. (canceled)

* * * * *

专利名称(译)	可加工的掺杂三芳基胺空穴注入材料		
公开(公告)号	US20130112951A1	公开(公告)日	2013-05-09
申请号	US13/583539	申请日	2010-03-25
[标]申请(专利权)人(译)	夏传军 CHEON KWANG香港乐施会		
申请(专利权)人(译)	夏, 川军 CHEON, 乐施会KWANG		
当前申请(专利权)人(译)	通用显示器公司		
[标]发明人	XIA CHUANJUN CHEON KWANG OHK		
发明人	XIA, CHUANJUN CHEON, KWANG OHK		
IPC分类号	H01L51/00 H01L51/56		
CPC分类号	H01L51/0003 H01L51/56 H01L51/0026 H01L51/0037 H01L51/0054 H01L51/0059 H01L51/0061 H01L51/0072 H01L51/0081 H01L51/0085 H01L51/5052 H01L51/5088 H01L2251/308 H01L51/0062 H01L51/002		
其他公开文献	US8963132		
外部链接	Espacenet USPTO		

摘要(译)

提供了制造溶液处理的OLED的方法。该方法包括沉积包含有机电子受体和有机电子给体的混合物的有机层，以形成不溶于非极性溶剂的层。包含有机层的器件可以表现出改善的寿命并且具有较低的工作电压，同时保持良好的发光效率。

