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Title:

Production and Characterization of Vacuum Deposited Organic Light Emitting Diodes

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Keywords:

Thermally Activated Delayed Fluorescence, Organic Electronics, OLED, exciplex, thermal evaporation, ambipolar, Donor-Acceptor, patterning.

Short Abstract:

A protocol for the production of simple structured organic light-emitting diodes (OLEDs) is presented.

Long Abstract:

A method for producing simple and efficient thermally-activated delayed fluorescence organic light-emitting diodes (OLEDs) based on guest-host or exciplex donor-acceptor emitters is presented. With a step-by-step procedure, readers will be able to repeat and produce OLED devices based on simple organic emitters. A patterning procedure allowing the creation of personalized indium tin oxide (ITO) shape is shown. This is followed by the evaporation of all layers, encapsulation and characterization of each individual device. The end goal is to present a procedure that will give the opportunity to repeat the information presented in cited publication but also using different compounds and structures in order to prepare efficient OLEDs.

Introduction:

Organic electronics brings together all fields from chemistry to physics, going through materials science and engineering in order to improve the current technologies towards more efficient and more stable structures and devices. From this, organic light-emitting diodes (OLEDs) is a technology that has shown great improvements over the last few years, both in terms of efficiency and stability^{1,2}. Reports say that the OLED industry for displays may increase from the 16 billion dollars in 2016 to around 40 billion dollars by 2020 and more than 50 billion by 2026³. It is also finding its way into general lighting and head-mounted microdisplays for augmented-

reality⁴. Applications like organic sensors for biomedical applications is more of a futuristic application at the moment, given the requirements for both high luminance and stability⁵. This trend confirms the need for improved device structures that includes more efficient molecules at less expense of natural resources. A better understanding of the inherent processes of the materials used for OLEDs is also of great importance when designing these.

An OLED is a multi-layered organic stack sandwiched between two electrodes, at least one of the latter transparent. Each layer, designed accordingly to their highest occupied molecular orbital (HOMO) and lowest unoccupied molecular orbital (LUMO) and their intrinsic mobility, has a specific function (injection, blockage, and transport) in the overall device. The mechanism is based on opposite charge carriers (electrons and holes) travelling across the device where they meet in a specific layer, recombine to form excitons and from the deactivation of these excitons comes the emission of a photon⁶. This photon will be a characteristic of the layer where the deactivation is taking place⁷⁻⁹. So, pending molecular design strategies, different red, green and blue emitters can be synthesized and applied to the stack. Putting them together, white devices can also be produced^{10,11}. The emitting layer of an OLED stack is usually based on the guest-host (G-H) system where the guest is dispersed into the host to avoid quenching of light⁹ and by-side reactions¹².

There are several ways to push molecules to emit light, with thermally-activated delayed fluorescence (TADF) implemented more recently¹³⁻¹⁵. TADF allowed for the increase of the external efficiency of devices from 5% of a typical fluorescence emitter up to 30% by means of triplet harvesting through a small singlet-triplet energy-splitting in a process called reverse intersystem crossing (rISC). There are several ways to form efficient TADF-based OLEDs: one of the most common in literature is the G-H system where the emissive state is formed by a single molecule¹⁶⁻¹⁸. A second system uses an exciplex emitter formed between an electron donor (D) and an electron acceptor (A) molecules, which are simply called the donor-acceptor (D-A) system^{15,19-21}; A small range of TADF materials and devices have been reported, yielding very high external quantum yields¹⁴, reaching a values of, for example, 19% EQE²², clearly indicating that very efficient triplet harvesting is occurring and that 100% internal quantum efficiency is possible. In these TADF-based OLEDs, care must be taken when choosing the proper host material as the polarity of the environment can change the charge transfer (CT) state away from the local excited (LE) state, therefore, reducing the TADF mechanism. The procedure to be taken into account is similar to other fluorescent emitters²³. Such devices have relatively simple stack structures, typically 3 to 5 organic layers, and without the need of a *p-i-n* structure²⁴, resulting in ultra-low turn-on voltages of the order of 2.7 V and a maximum thickness of around 130 nm for all organic layers to guarantee a good charge balance.

Apart from the materials' properties, the production of multi-layered stacks can be either be based on vacuum thermal evaporation (VTE) or spin-coating, the former more frequent for small molecules. It requires precise control over the temperature, pressure, environment, rate, and thickness of each layer. For emitting G-H layers, the rates of co-evaporation have to be controlled for the desired ratios to be obtained. Also of extreme importance is the cleaning of

the substrates used for OLEDs which can result in non-working devices or uneven emissions throughout the emitting pixel²⁵.

Therefore, this article aims at all steps of preparation, production, and characterization of organic devices and intends to help new specialists on the careful protocol required for high efficiency and evenness of emission. It involves the use of DPTZ-DBTO₂ (2,8-Bis(10H-phenothiazin-10-yl)dibenzothiophene-S,S-dioxide) as emitting guest in a TADF G-H system^{16,26}. Similar methods can be also implemented for the formation of an exciplex based D-A systems using DtBuCz-DBTO₂ (2,8-Bis(3,6-di-tert-butyl-9H-carbazol-9-yl)dibenzothiophene-S,S-dioxide) in TAPC (4,4'-Cyclohexylidenebis[N,N-bis(4-methylphenyl)benzenamine])¹⁵, where the main difference in the procedure is the concentration ratio of the emissive layer but it significantly changes the nature of emission (single molecule CT emission vs exciplex CT emission). The G-H system described here has a single molecule CT emitter and involves the evaporation of 5 layers with 3 organic, and 2 inorganic materials. The device is composed of indium tin oxide (ITO) as the anode, 40 nm of *N,N'*-di(1-naphthyl)-*N,N'*-diphenyl-(1,1'-biphenyl)-4,4'-diamine (NPB) as the hole transport layer (HTL), and a total 20 nm of 4,4'-bis(*N*-carbazolyl)-1,1'-biphenyl (CBP) with 10% of DPTZ-DBTO₂ as the emitting layer based on the G-H system. 60 nm of 2,2',2''-(1,3,5-benzinetriyl)-tris(1-phenyl-1*H*-benzimidazole) (TPBi) is then used as the electron transport layer (ETL) and 1 nm of Lithium Fluoride (LiF) as electron injection layer (EIL). 100 nm of aluminum (Al) finalizes the device as a cathode. A diagram of the whole procedure can be found in Error! Reference source not found.. The thicknesses of organics were chosen to be similar to other devices used in the literature. The mobility of each layer must be carefully examined as to ensure good carrier balance inside the layer. The operation of LiF is based on a tunnelling effect, *i.e.*, carriers travel through the tunnels of a packed LiF, ensuring a better injection to the transport layers. This means thin layers (between 0.8 and 1.5 nm) are required²⁷. The layer of Al must be thick enough to prevent any oxidation (70 nm is a minimal requirement).

PROTOCOL:

CAUTION: The following procedure involves the use of different solvents, so proper care must be taken when using them. Please use fume and personal protective equipment (gloves, lab-coat). To ensure the quality of the devices evaporated, it is recommended that all the procedure is done in a clean environment (such as a clean room and/or a glovebox). The safety datasheets must be consulted before the use of each equipment/material.

1. ITO Patterning

1.1. Cover uniformly the Indium Tin Oxide (24 x 24 mm², ITO-coated glass substrates with a sheet resistance of 20 Ω/cm² and ITO thickness of 100 nm) substrate with a p-type photoresist using a pipette. Spin-coat it at rate 500 rpm for 5 s followed by 4000 rpm for 45 s.

1.2. Anneal the substrates on a hotplate for at least 5 min at 95 °C. This will ensure that all the remaining solvent evaporates producing a uniform film.

- 1.3. Place the mask with 4 mm stripes (or the desired pattern) on the resist-coated ITO substrate. Expose to an 8 W 365 nm UV lamp for 50 s.
- 1.4. Place the ITO substrate into the developer solution (1 part developer: 2 parts deionized (DI) water) for 60 s.
- 1.5. Carefully the substrate rinse for about 10 s with a wash bottle containing DI water, holding the substrate with tweezers. Dry the remaining water with an air gun.
- 1.6. Heat the ITO substrate on the hotplate at 95 °C for, at least, 15 min.
- 1.7. Remove the photoresist from the edges of the substrate and in-between the stripes using a cotton swab soaked with acetone.
- 1.8. Remove the ITO using a mixture of hydrochloric acid and nitric acid (20:1 v/v), leave it for 5 min at room temperature.
- 1.9. Rinse with DI water for 10 s and remove the rest of photoresist with acetone.

2. Substrate Cleaning

- 2.1. Take two patterned ITO substrates, rinse for about 10 s with acetone and wipe with a non-porous sheet of paper.
- 2.2. Using tweezers, fully submerge the substrates into a container with acetone. Put it into an ultrasonic bath (320 W, 37 kHz) for 15 min.
- 2.3. Now submerge the substrates into a container with isopropyl alcohol (IPA, 2-propanol). Put the container in the ultrasonic bath for another 15 min.
- 2.4. Remove the container from the ultrasonic bath and then the substrates from the IPA bath and dry with a nitrogen gun. Visually inspect the substrates to see if there are no solid residues or smudges. If not, repeat from point 2.1.
- 2.5. Open the flow in the oxygen tank to a rate of around 50 units. Use an oxygen plasma cleaner (100 W, 40 kHz) to clean the ITO substrates for 6 min at a 2.5 L/h oxygen flow being sure the ITO faces upward.
- 2.6. Remove the substrates from the plasma chamber and attach them to the substrate holder. Two masks will be used: (A) for the evaporation of all organic layers and (B) for the evaporation of aluminum (**Figure 1**). Place the substrates holder onto mask A.

3. Preparation of the Evaporation Chamber

3.1. Insert the substrate holder, mask A and mask B, into the evaporation chamber. Depending on the type of the evaporating system, place a substrate holder with mask A on the deposition shelf and mask B on shelf 1.

3.2. Add the organic powder of all different materials used for this device in different aluminum oxide crucibles making sure the surface is covered by it. In this case, add NPB, DPTZ-DBTO₂, CBP and TPBi to 4 different 10 mL aluminum oxide crucibles. Add LiF in one 5 mL crucible and aluminum (Al) pieces in a half-full 5 mL boron nitride high-temperature crucible.

3.3. Take into consideration the organic crucible position with respective Quartz Crystal Microbalance (QCM) sensor which will give the real value of thickness. For D-A and G-H system evaporations, the co-evaporation process needs to be done so to control the co-evaporation process, both DPTZ-DBTO₂ and CBP (TADF OLED) or DtBuCz-DBTO₂ and TAPC (Exciplex OLED) need to be controlled by different QCMs. In this case, the positions of the respective compounds are presented in **Figure 2**.

3.4. Close the chamber and initiate the vacuum procedure (also known as pumping down). Wait for the pressure $P < 1 \cdot 10^{-5}$ mbar to start the evaporation.

4. Evaporation of the Organic Layers

Note: For all organics, do not exceed the evaporation rate of 2 Å/s as this results in increased roughness and decreasing the uniformity of the layers. To a certain point, this may result in non-uniform emissions and even shorts.

4.1. Turn ON the water flow to provide sufficient cooling of the elements.

4.2. Turn ON the substrate rotation, at 10 rotations per min (rpm), to ensure the deposition of uniform layers.

4.3. Pre-heat the NPB crucible by switching-on the temperature controller of the system and open its' shutter. This can be done using the VTE software at the disposal of the user. Start the evaporation (open deposit shutter) when the rate stabilizes at around 1 Å/s. Evaporate a 40 nm thick layer, close the shutter, wait until the crucible cools down to start the next process.

4.4. In a similar fashion to point 4.3., preheat the CBP and DPTZ-DBTO₂ and open their shutters for co-evaporation. Depending on the final concentration of the layer, use different rates of compounds.

4.4.1. For the 10% emissive layer start the evaporation when the rate will stabilize around 2.0 Å/s for CBP and 0.22 Å/s for DPTZ-DBTO₂. Open the depositing shutter when the rate is achieved.

4.4.2. Evaporate 20 nm thickness layer containing 18 nm of CBP and 2 nm of DPTZ-DBTO₂, close the shutter, wait until the crucible cools down to start the next process.

4.5. Pre-heat the TPBi and open its shutter. Start the evaporation (open deposit shutter) when the rate stabilizes at around 1 Å/s. Evaporate 60 nm thickness layer, close the shutter, wait until the crucible cools down to start the next process.

4.6. Pre-heat the LiF, start the evaporation (open evaporation shutter) when the rate stabilizes at around 0.2 Å/s. Do not exceed the evaporation rate of 0.5 Å/s. Evaporate 1 nm thickness layer, close the shutter, wait until the crucible cools down to start next process.

4.7. Turn OFF the substrate rotation.

4.8. Replace the mask A on a substrate holder with mask B. If necessary, vent the evaporation chamber. If vented, the chamber must be pumped down before the continuation of the procedure.

4.9. Turn ON the substrate rotation, *i.e.*, 10 rpm.

4.10. Pre-heat the Al, start the evaporation (open deposit shutter) when the rate stabilizes at around 1 Å/s. Do not exceed the evaporation rate of 2 Å/s. Evaporate 100 nm thickness layer, close the shutter, wait until the crucible cools down.

4.11. Vent and open the chamber. Remove the substrate holder with deposited devices.

Note: Once evaporated, 4 pixels are obtained with two different sizes as shown in **Figure 1**: 2x4 and 4x4 cm². This ensures there is reproducibility when upscaling the devices. The level of defects can also be more visible in the bigger pixels¹¹.

5. OLED Encapsulation

Note: This section is not mandatory for the analysis of OLEDs though it is highly recommended. To secure their quality, it is also important that this section is done in a controlled environment.

5.1. Remove the substrates from the substrate holder. Place them on top of an encapsulation stage with the evaporated films facing forward.

5.2. Prepare the resin tube and dispersing tools. Screw a proper tip to one side of the tube, and a pressure gun to the other side of the tube.

5.3. Apply pressure with the gun to disperse the resin. Draw squares that involve all evaporated pixels (**Figure 2**).

5.4. Place an encapsulation glass on top of each square of resin.

5.5. UV-cure the substrates with the resin and encapsulation glass for as long as required by the resin manufacturer.

6. OLED Characterization

6.1. If necessary, clean the ITO stripes not covered by the encapsulation glass with a toothpick using acetone or IPA to remove any organic material deposited before connecting to the measuring unit. This will guarantee that a good ohmic contact between measuring system and electrodes is achieved.

6.2. Calibrate the OLED measurement according to the NIST standards using a pre-calibrated lamp.

6.3. Place the OLED in the integrating sphere, making sure the contacts are placed correctly (**Error! Reference source not found.**). Confirm that the anode (+) and cathode (-) are connected to the ITO and Al pads, respectively. Close to the integrating sphere.

6.4. Measure the I-V curve of the device and the obtained luminance and emission spectra at different voltages.

6.4.1. Apply a voltage between the two terminals and measure the current output. A luminance meter measures the brightness output.

6.4.2. Using a software and the correct pixel size, calculate the Current Density (J), External Quantum Efficiency (EQE), Power, Wall-plug efficiency, Luminous Flux, Luminous efficiency (η_p), Current Efficiency (η_L) Luminance (L) and Commission Internationale de L'Eclairage (CIE) coordinates. More information on these values can be found in reference¹⁵.

6.5. Plot J-V-L, EQE-J, η_p -V- η_L , EL- λ at different voltages and analyse the data. This can be done using a data processing software. For a better understanding, use the following table as a reference on the plotting.

Representative Results:

The data presented in **Error! Reference source not found.** is a good example of the different information one can get by the analysis of this type of OLEDs. From **Error! Reference source not found.a**, the turn-on voltage (voltage at which the detector starts detecting light on the device) can be determined. In this case, it is 4 V. Device degradation due to high voltages is seen when luminance decreases substantially (around 13 V). Degradation occurs when carriers injected into the device react with the organic layers resulting in the breaking of bonds and molecules. Also, electrical stress can be associated with device degradation. The maximum luminance of this device is around 17000 cd/m². From **Error! Reference source not found.b**, the maximum E.Q.E. (around 7%) and roll-off, a measure of the device electrical stability, are determined. The roll-off of a device is also defined as the drop in efficiency with the current flowing through it.

To compare the roll-off of different devices, the values of EQE at the standard luminance of 100 and 1000 cd/m² are usually given⁶. In this case, 6.1 and 5.5%, respectively which represents a drop of 9% and 20% of its maximum value. This represents a poor roll-off. Good values should be between 0 and 5% until high levels of luminance. The other values of efficiency are shown in Error! Reference source not found.c, as other means of comparison with similar types of devices. Finally, the EL is shown peaking at 573 nm, a typical green-yellow emission (inset of Error! Reference source not found.d). The EL at different voltages can help giving insights into optical stability *i.e.*, where the emission is taking place. In this case, as this seemingly does not change with the applied voltage, one can assume that the device is optically-stable. Checking the CIE coordinates (inset of **Figure 3b** with voltage is another way to measure the optical stability.

Figure 1: Diagram containing all steps represented in this protocol. All organic layers and LiF are evaporated using mask A. After metallization (evaporation of aluminium), two sets of devices can be produced using mask B: one with 2x4 cm² and another with 4x4 cm². The voltage will be applied between the ITO (anode: +) and aluminium (cathode: -) and a current will be measured. A cross-section of the device structure is also shown.

Figure 2: a) Diagram of the organic low temperature (black) and inorganic high-temperature sources (blue) to be placed in the vacuum chamber. Each material has to be put in the specified source with a specific heating number for the software as they were previously optimized for each material in question. b) QCM sensors arranged throughout the chamber.

Figure 3: a) J-V-L, b) EQE-J, c) η_P -V- η_L , d) EL- λ at different voltages for the device in this study. The CIE coordinates change with voltage is shown on the inset of b) while a photograph of the device is shown in the inset of d).

Table 1: Considered curves and related scale for the unification of the characterization of OLEDs.

Discussion:

The present protocol aims to present an effective tool for the patterning, production, encapsulation and characterization of OLEDs based on small molecular-weight TADF-emitting or exciplex-emitting layers. The organic vacuum thermal evaporation allows for the production of thin films (from a few Å to hundreds of nm) of both organic and inorganic materials and produce pathways for charge carriers to recombine from which light will be emitted. Although versatile, the device production is fairly limited to the evaporator *i.e.*, the number of organic and inorganic sources available or the possibility of more than one evaporation at the same time (co- and tri-evaporations are very common, particularly in TADF devices). More advanced systems may allow for the evaporation of more than 3 sources at the same time, which may be useful for applications such as white-OLEDs²⁸ for displays and general lighting. Nevertheless, a trade-off between the device complexity and its performance must be met. The multifunctionality of this evaporation procedure also allows doing different studies that go beyond this work. These include effects of layer thickness, dopant concentration, layer

functionality or even study the inherent mobilities of new layers. The fine control over the rates of single and co-evaporated layers is also crucial since it allows for the formation of uniform films with controlled precise ratios.

It is recommended that all steps of this protocol are done in a controlled environment and, more importantly for the encapsulation, inside a glovebox to avoid any ambient related degradation. Finally, an integrating sphere is most welcomed as it provides for a more detailed electrical and optical analysis. With this mind, all steps from theoretical introduction to production and characterization of TADF-based OLEDs were presented in this protocol highlighting all these different stages allowing the production of stable devices that, when encapsulated, can last for large periods of time.

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Disclosures:

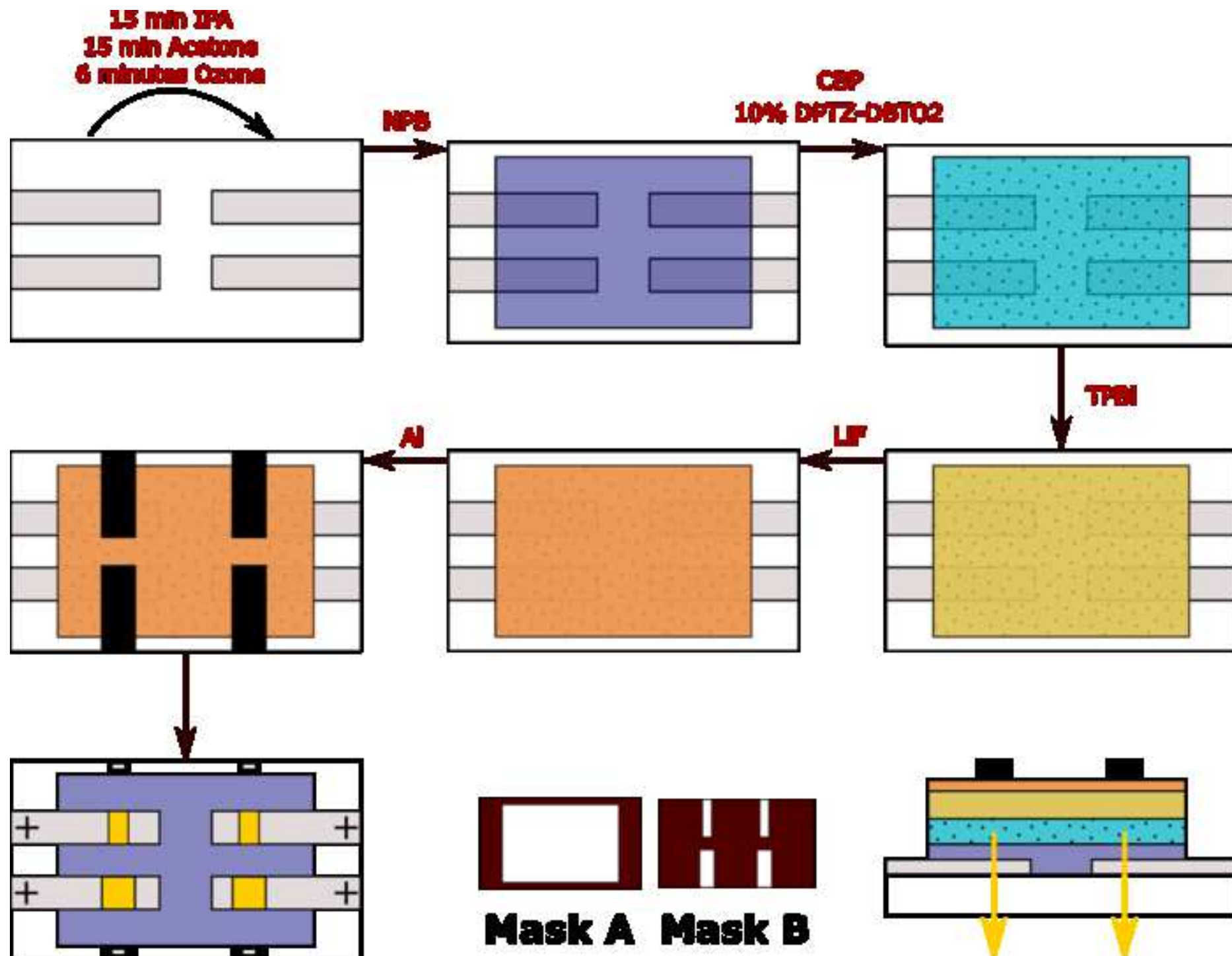
The authors have nothing to disclose.

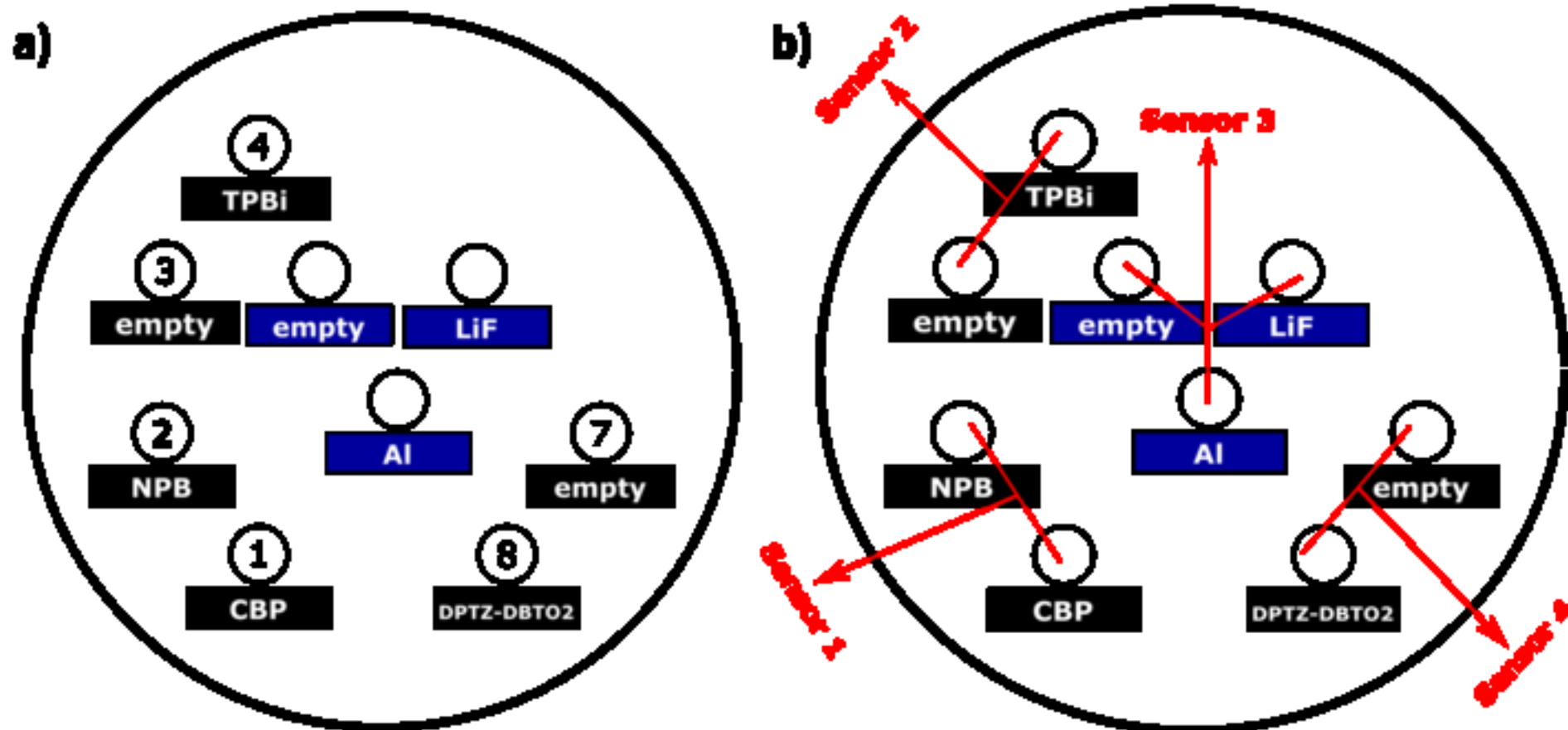
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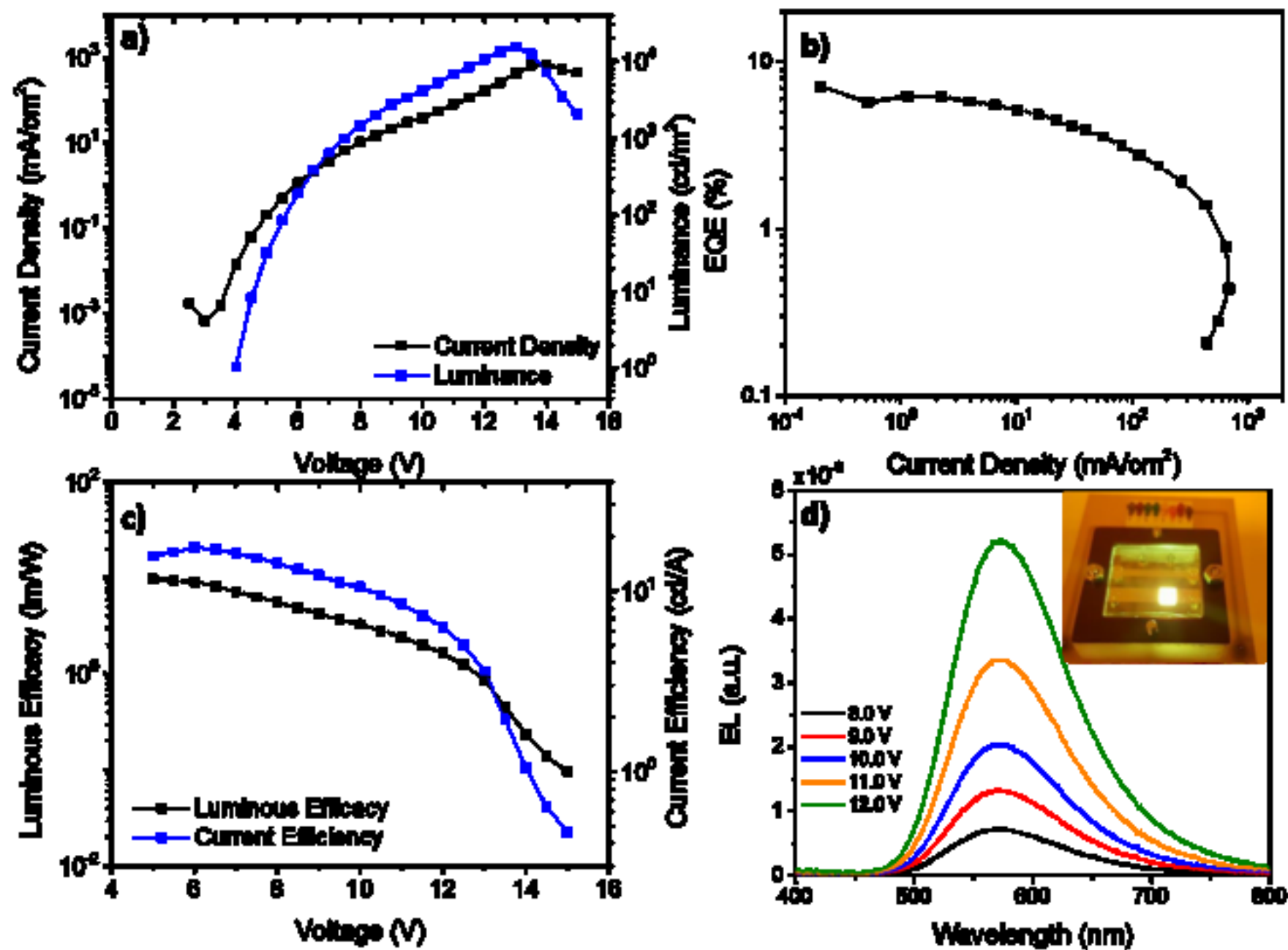
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Figure 1







Curve	x	Scale	y1	Scale	y2	Scale
J-V-L	V	linear	J	log	L	log
η_P -V- η_L			η_P	log	η_L	log
EQE-J	J	log	EQE	log		
EL- λ	λ	linear	EL	linear		

Name of Material/ Equipment	Short name	Company	Catalog Number	Comments/Description
N,N'-Di(1-naphthyl)-N,N'-diphenyl-(1,1'-biphenyl)-4,4'-diamine	NPB	Sigma Aldrich	556696	Sublimed grade
4,4'-Bis(N-carbazolyl)-1,1'-biphenyl	CBP	Sigma Aldrich	699195	
2,2',2''-(1,3,5-Benzinetriyl)-tris(1-phenyl-1-H-benzimidazole)	TPBi	Sigma Aldrich	806781	
Lithium Floride 99.995%	LiF	Sigma Aldrich	669431	Sublimed grade
Aluminum 99.999%	Al	Alfa Aesar	14445	
Acetone 99.9%	Acetone	Sigma Aldrich	439126	
Isopropyl alcohol 99.9 %	IPA	Sigma Aldrich	675431	
Photoresist		DOW Electronic Materials	Microposit S1813	
Developer		DOW Electronic Materials	Microposit 351	
Hydrochloric acid 37%	HCl	Sigma Aldrich	435570	
Nitric acid 70%	HNO3	Sigma Aldrich	258113	
Encapsulation resin		Delo	Kationbond GE680	
Encapsulation square glass 15x15mm		Agar	AGL46s15-4	
ITO		Naranjo Substrates	Custom made	

Title of Article:

Detailed method of formation and characterizing of OLEDs

Author(s):

Daniel de Sa Pereira, Andrew P. Monkman, Przemyslaw Data

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MS # (internal use):

Dear Editor,

We thank the referees for their constructive comments as we have addressed each point. Where appropriate, additions have been made to our revised manuscript to help clarify the points raised. Also, we have corrected all the issues described by the Editorial comments. In addition to the aforementioned corrections, the manuscript was proofread and properly revised. Signalled in blue are the parts we believe describe best the protocol so we suggest them to be filmed upon acceptance.

Yours sincerely,

Daniel de Sa Pereira, Prof. Andrew P. Monkman and Dr Przemyslaw Data

Editorial comments:

“1. Please take this opportunity to thoroughly proofread the manuscript to ensure that there are no spelling or grammar issues. The JoVE editor will not copy-edit your manuscript and any errors in the submitted revision may be present in the published version.”

The manuscript was proofread and all grammar/spelling issues fixed.

“2. Please respond to all previous Editorial’s comments.”

All editorial’s comments have been read and answered.

“3. Title: Please avoid using abbreviations in the Title.”

The abbreviation in the title was removed.

“4. Long Abstract: Please define all abbreviation before use. Please attention that in the final form, Long Abstract will be used as the Abstract. The Short Abstract will be used as Highlights of the manuscript for the databases.”

All abbreviations were defined.

“5. Please remove the embedded figure(s) and Table(s) from the manuscript. All figures should be uploaded separately to your Editorial Manager account. Each figure must be accompanied by a title and a description after the Representative Results of the manuscript text.”

All images and tables were removed from the manuscript.

“6. Please define all abbreviations before use.”

All abbreviations were corrected.

“7. Please highlight 2.75 pages or less of the Protocol (including headings and spacing) that identifies the essential steps of the protocol for the video, i.e., the steps that should be visualized

to tell the most cohesive story of the Protocol. Remember that non-highlighted Protocol steps will remain in the manuscript, and therefore will still be available to the reader.”

The areas necessary to be filmed are highlighted in blue.

“8. Please ensure that the highlighted steps form a cohesive narrative with a logical flow from one highlighted step to the next. Please highlight complete sentences (not parts of sentences). Please ensure that the highlighted part of the step includes at least one action that is written in imperative tense.”

It's corrected.

“9. Please include all relevant details that are required to perform the step in the highlighting. For example: If step 2.5 is highlighted for filming and the details of how to perform the step are given in steps 2.5.1 and 2.5.2, then the sub-steps where the details are provided must be highlighted.”

It's corrected.

“10. Please convert centrifuge speeds to centrifugal force (x g) instead of revolutions per minute (rpm).”

Given that the equipment we use (and most spinners used in spin-coating processes) do not show the centrifugal force in SI but in rpm, we believe that, for practical reasons, this should be kept in rpm. Therefore, no change was performed on this point.

11. Please use SI units, e.g. please use “ μL ”.

It was changed if that made sense from the practical point of view, e.g. rpm.

12. Please add more details to your protocol steps. Please ensure you answer the “how” question, i.e., how is the step performed? Alternatively, add references to published material specifying how to perform the protocol action.

It was checked and corrected.

“13. Protocol: 1.5: How? Please describe the step clearly or refer to an appropriate reference or protocol.”

This point was clarified and more information was added. It can now be read: “Carefully rinse for about 10 s the substrate with a wash bottle containing DI water, holding the substrate with tweezers. Dry the remaining water with an air gun”

14. Protocol: 2.2: What are the conditions of the ultrasonic bath? Which power is used? Frequency?

The information was added.

“15. Protocol: 2.4: Remove from “IPA bath” or “ultrasonic bath”? At the end of 2.3 it was still in a “ultrasonic bath”! Inspect how? Using what?”

Points 2.3 and 2.4 were clarified so it is not confusing with the terms. Both baths are to be used (substrates inside the IPA container and container inside US bath). It can now be read: “2.3. Now submerge the substrates into a container with Isopropyl alcohol (IPA, 2-propanol). Put the container in the ultrasonic bath for another 15 min.”

“2.4. Remove the container from the ultrasonic bath and then the substrates from the IPA bath and dry with a nitrogen gun. Visually inspect the substrates to see if there are no solid residues or smudges. If not, repeat from point 2.1.”

“16. Protocol: 4.10: “Pre-heat the Al” How?”

This is a software related tool. By pre-heating, we mean switch on the temperature controller of the system that allows for the Joule effect in the crucible. Therefore, because this was mentioned earlier, point 4.3. was revised and rewritten to “Pre-heat the NPB crucible, by switching on the temperature controller of the system and open its’ shutter. This can be done using the VTE software at the disposal of the user. Start the evaporation (open deposit shutter) when the rate stabilizes at around 1 Å/s. Evaporate 40 nm thickness layer, close the shutter, wait till the crucible will cool down to start next process.”

“17. Protocol: 5.3: How to run a pre-programmed recipe? Please explain it or refer to an appropriate reference or protocol.”

The automated part of the encapsulation was replaced with a manual encapsulation. This makes the procedure simpler to those who read it.

18. Please include at least one paragraph of text to explain the Representative Results in the context of the technique you have described, e.g., how do these results show the technique, suggestions about how to analyze the outcome, etc. The paragraph text should refer to all of the figures. Data from both successful and sub-optimal experiments can be included.

Such information’s are present.

19. Please discuss all figures in the Representative Results. However, for figures showing the experimental set-up, please reference them in the Protocol.

The information’s were added.

20. As we are a methods journal, please revise the Discussion to explicitly cover the following in detail in 3-6 paragraphs with citations:

a) Critical steps within the protocol

- b) Any modifications and troubleshooting of the technique
- c) Any limitations of the technique
- d) The significance with respect to existing methods
- e) Any future applications of the technique

I think we covered this information.

21. Please include a title and a description of each figure and/or table. All figures and/or tables showing data must include measurement definitions, scale bars, and error bars (if applicable). Please include all the Figure Legends together at the end of the Representative Results in the manuscript text.

It's added.

22. Please revise the table of the essential supplies, reagents, and equipment. The table should include the name, company, and catalogue number of all relevant materials in separate columns in an xls/xlsx file.

It's revised.

"23. Please indicate the track of any change in the text based on the reviewers' comments. For example, you respond to the second comment of Reviewer #2 as following;

A more complete point 4.3. was written with an explanation to why we need such low evaporation rates.

"4.3. Pre-heat the NPB, start the evaporation (open shutter) when the rate will stabilize around 1 Å/s, don't exceed the evaporation rate 2 Å/s as this results in increased roughness hence decreasing the uniformity of the layers. To a certain point, this may result in non-uniform emissions and even shorts. Evaporate 40 nm thickness layer, close the shutter, wait till the crucible will cool down to start next process."

We have looked for a new version of this point but it must have gotten lost. Nevertheless, point 4.3. was updated according to what is said in comment number 16.

Reviewers comments:

- Step 1.1: Please add more details on the ITO substrate used in your studies. What size?

It's added to step 1.1 24x24 mm² ITO substrates

- 1.3: Please add details on the mask used in your studies. How is the resin added?

The information about mask was added (mask with 4 mm stripes), information about resin is in the point 1.1

“2.2: Which tow substrates? Please mention the ultrasonic bath conditions and settings.”

Point 2.2. now contains the details at which the bath is done. It can be read “Using tweezers, fully submerge the substrates into a container with acetone. Put it into an ultrasonic bath (320 W, 37 kHz) for 15 min. Please ensure that the bath is at least 3/4 full of DI water to ensure a good spread of the ultrasounds.”

“2.5: Please add more details on how to clean using the oxygen plasma cleaner.”

More details have been added to point 2.5. It can be read “Open the flow in the oxygen tank to a rate of around 50 units. Use an oxygen plasma cleaner (100 W, 40 kHz) to clean the ITO substrates for 6 min at a 2.5 l/h oxygen flow being sure the ITO faces upward.”

“1.9: For how long?

It's added. 10s.

2.1: Please add more details. Wash for how long? Clean how?”

An estimated time has been added to this point.

“5.1: Encapsulate how? Please add details.

It's added.

5.2: Clean how?

It's added to the point 6.1

5.3: Please add details.”

As described in point 17 of the editorial comments, the automated part of the encapsulation was replaced with a manual encapsulation.

5.4: Please mention how to place the contacts correctly.

There is nothing to add here, square substrate fits square holder.

5.6: Please add details on how to measure the I-V curve and obtain the spectra.

It's described in point 6.4 and reference 15.

5.7: Please add more details on how to plot.”

To make this part simpler, figure 1 was updated and the connections to the voltage supplier were drawn on one of the pixels. Regarding the plotting procedure, we believe that point 6.5. clarifies everything that needs to be thought of (what to plot, axis, and scale).