

# US Patent & Trademark Office

## Patent Public Search | Text View

---

United States Patent Application Publication

20250255094

Kind Code

A1

Publication Date

August 07, 2025

Inventor(s)

IWATA; NOBORU et al.

---

### ELECTROLUMINESCENT ELEMENT AND ELECTROLUMINESCENT DEVICE

---

#### Abstract

An electroluminescent element including an anode, a cathode, and a light-emitting layer provided between the anode and the cathode, in which the electroluminescent element further includes an electron transport layer including n-type semiconductor particles and a first insulating polymer, and a hole transport layer including p-type semiconductor particles, the electron transport layer is provided between the cathode and the light-emitting layer, the hole transport layer is provided between the anode and the light-emitting layer, and a volume proportion of the n-type semiconductor particles in the electron transport layer is smaller than a volume proportion of the p-type semiconductor particles in the hole transport layer.

---

**Inventors:** IWATA; NOBORU (Sakai City, JP), UTSUMI; HISAYUKI (Sakai City, JP), UETA; YOSHIHIRO (Sakai City, JP)

**Applicant:** Sharp Kabushiki Kaisha (Sakai City, JP)

**Family ID:** 75165657

**Appl. No.:** 19/086688

**Filed:** March 21, 2025

#### Related U.S. Application Data

parent US continuation 17642794 20220314 parent-grant-document US 12284861 WO  
continuation PCT/JP2019/037968 20190926 child US 19086688

---

#### Publication Classification

**Int. Cl.:** H10K50/16 (20230101); H10K50/115 (20230101); H10K50/125 (20230101);  
H10K50/15 (20230101)

## Background/Summary

CROSS-REFERENCE TO RELATED APPLICATION [0001] The present application is a continuation application of U.S. patent application Ser. No. 17/642,794, filed on Mar. 14, 2022, which is the National Stage of International Application No. PCT/JP2019/037968, filed on Sep. 26, 2019, the content of which is hereby incorporated by reference into this application.

### TECHNICAL FIELD

[0002] The disclosure relates to an electroluminescent element and an electroluminescent device including a plurality of electroluminescent elements.

### BACKGROUND ART

[0003] In recent years, various display devices have been developed. Particularly, a display device including an Organic Light Emitting Diode (OLED) and a display device including an inorganic light emitting diode or a Quantum dot Light Emitting Diode (QLED) have drawn a great deal of attention because the devices are capable of achieving lower power consumption, smaller thickness, higher picture quality, and the like.

[0004] PTLs 1 to 3 disclose an electroluminescent element, such as an OLED or a QLED, which includes an electron transport layer including semiconductor nanoparticles (for example, metal oxide nanoparticles) or a hole transport layer.

[0005] FIG. 9 is a diagram illustrating schematic configurations of known electroluminescent elements **101**, **102**, **103**, and **104** disclosed in PTLs 1 to 3.

[0006] The electroluminescent element **101** disclosed in PTL 1 illustrated in (a) of FIG. 9 has a structure in which an anode (anode electrode) **112**, a hole transport layer **113**, a light-emitting layer **114**, a nanoparticle layer **115**, and a cathode (cathode electrode) **116** are layered on a substrate **111** in this order from the substrate **111** side. In addition, the nanoparticle layer **115** is formed by applying a material in which nanoparticles of barium titanate are dispersed in a xylene solution as metal oxide nanoparticles (electron transport material) on the light-emitting layer **114** by a spraying method. PTL 1 discloses that electron injection into the light-emitting layer **114** is efficiently performed by providing the nanoparticle layer **115** between the light-emitting layer **114** and the cathode **116** (cathode electrode) in this manner.

[0007] The electroluminescent element **102** disclosed in PTL 1 illustrated in (b) of FIG. 9 has a structure in which the anode (anode electrode) **112**, the hole transport layer **113**, the light-emitting layer **114**, a nanoparticle-containing film **117**, and the cathode (cathode electrode) **116** are layered on the substrate **111** in this order from the substrate **111** side. In addition, the nanoparticle-containing film **117** is formed by applying a solution, which is obtained by dissolving and/or dispersing a mixture in xylene, onto the light-emitting layer **114** by a spraying method, the mixture containing polystyrene, which is a binder resin, and barium titanate at a weight ratio of 3:1 (polystyrene: barium titanate=3:1). In addition, it is disclosed that an electron transport material may be mixed into the binder resin, and a material having an ability to transport electrons is suitable as the binder resin. PTL 1 discloses that electron injection into the light-emitting layer **114** is efficiently performed by providing the nanoparticle-containing film **117** between the light-emitting layer **114** and the cathode (cathode electrode) **116** in this manner.

[0008] The electroluminescent element **103** disclosed in PTL 2 illustrated in (c) of FIG. 9 has a structure in which an anode (anode electrode) **122**, a hole injection layer **123**, a hole transport layer

**124**, a light-emitting layer **125**, an electron transport layer **126**, an electron injection layer **127**, and a cathode (cathode electrode) **128** are layered on the substrate **121** in this order from a substrate **121** side. In addition, the hole transport layer **124** contains semiconductor nanoparticles **129**, and the surface of the hole transport layer **124** has an uneven structure. According to PTL 2, it is disclosed that the hole transport layer **124** contains the semiconductor nanoparticles **129** in this manner, and thus it is possible to improve the hole transport property. In addition, the surface of the hole transport layer **124** has an uneven structure, and thus it is possible to efficiently perform hole injection due to electric field concentration at the interface having irregularities.

[0009] The electroluminescent element **104** disclosed in PTL 3 illustrated in (d) of FIG. **9** has a structure in which an anode (anode electrode) **132**, an organic functional layer **150**, and a cathode (cathode electrode) **138** are layered on a flexible support substrate **131** in this order from the flexible support substrate **131** side. The organic functional layer **150** includes a hole injection layer **133**, a hole transport layer **134**, a light-emitting layer **135**, an electron transport layer **136**, and an electron injection layer **137**. The hole injection layer **133**, the hole transport layer **134**, the light-emitting layer **135**, the electron transport layer **136**, and the electron injection layer **137** are layered in this order from the anode (anode electrode) **132** side. In addition, the anode (anode electrode) **132**, the organic functional layer **150**, and the cathode (cathode electrode) **138** on the flexible support substrate **131** are sealed by a flexible sealing member **140** via a sealing adhesive **139**. In addition, the electron transport layer **136** includes an electron transport material and semiconductor nanoparticles **141**. PTL 3 discloses that the electron transport layer **136** includes the electron transport material and the semiconductor nanoparticles **141** in this manner, and thus a decrease in light emission luminance and an increase in a startup voltage are suppressed even when the thickness of the light-emitting layer **135** or the electron transport layer **136** is increased.

## CITATION LIST

### Patent Literature

[0010] PTL 1: WO 2009/084273 A1 (published Jul. 9, 2009) [0011] PTL 2: WO 2012/029750 A1 (published Mar. 8, 2012) [0012] PTL 3: JP 2015-128191 A (published Jul. 9, 2015)

## SUMMARY

### Technical Problem

[0013] However, the electroluminescent element **101** disclosed in PTL 1 illustrated in (a) of FIG. **9** includes the nanoparticle layer **115** without the balance between the number of holes and the number of electrons which are injected into the light-emitting layer **114** being considered at all. Thus, a state of having an excess number of electrons compared with those originally present in the light-emitting layer **114** is caused, and it is not possible to realize efficient light emission with well-balanced holes and electrons in the light-emitting layer **114**.

[0014] Further, in the case of the electroluminescent element **102** disclosed in PTL 1 illustrated in (b) of FIG. **9**, it is disclosed that the nanoparticle-containing film **117** uses a mixture of polystyrene, which is a binder resin, and barium titanate at a weight ratio of 3:1 (polystyrene:barium titanate=3:1). However, the balance between the number of holes and the number of electrons which are injected into the light-emitting layer **114** is not considered at all, and thus there is no description regarding what level of hole transport property is required for the hole transport layer **113** with respect to the electron transport property of the nanoparticle-containing film **117**. Further, in the case of the electroluminescent element **102** disclosed in PTL 1, it is disclosed that an electron transport material may be mixed into the binder resin, and a material having an electron transport property is suitable as the binder resin. Thus, similarly to the electroluminescent element **101** described above, a state of having an excess number of electrons compared with those originally present in the light-emitting layer **114** is caused, and it is not possible to realize efficient light emission with well-balanced holes and electrons in the light-emitting layer **114**.

[0015] In addition, in the case of the electroluminescent element **103** disclosed in PTL 2 illustrated in (c) of FIG. **9**, it is disclosed that the hole transport layer **124** contains the semiconductor

nanoparticles **129**. However, the balance between the number of holes and the number of electrons which are injected into the light-emitting layer **125** is not considered at all, and thus there is no description regarding what level of electron transport property is required for the electron transport layer **126** with respect to the hole transport property of the hole transport layer **124** containing the semiconductor nanoparticles **129**. Further, there is no description about using an insulating polymer in the electron transport layer **126** to reduce the electron transport property. Thus, it is not possible to realize efficient light emission with well-balanced holes and electrons in the light-emitting layer **125**.

[0016] Further, the electroluminescent element **104** disclosed in PTL 3 illustrated in (d) of FIG. **9** includes the electron transport layer **136** including the electron transport material and the semiconductor nanoparticles **141** without considering the balance between the number of holes and the number of electrons which are injected into the light-emitting layer **135** at all. Thus, a state of having an excess number of electrons compared with those originally present in the light-emitting layer **135** is caused, and it is not possible to realize efficient light emission with well-balanced holes and electrons in the light-emitting layer **135**.

[0017] An aspect of the disclosure has been made in view of the above-mentioned issue, and an object of the disclosure is to provide an electroluminescent element in which efficient light emission is realized with well-balanced holes and electrons in a light-emitting layer, and an electroluminescent device including a plurality of electroluminescent elements.

#### Solution to Problem

[0018] In order to solve the problem described above, an aspect of an electroluminescent element of the disclosure is an electroluminescent element including an anode, a cathode, and a light-emitting layer provided between the anode and the cathode, in which the electroluminescent element further includes an electron transport layer including n-type semiconductor particles and a first insulating polymer, and a hole transport layer including p-type semiconductor particles, the electron transport layer is provided between the cathode and the light-emitting layer, the hole transport layer is provided between the anode and the light-emitting layer, and a volume proportion of the n-type semiconductor particles in the electron transport layer is smaller than a volume proportion of the p-type semiconductor particles in the hole transport layer.

[0019] In order to solve the problem described above, an aspect of an electroluminescent device of the disclosure includes the electroluminescent element.

[0020] In order to solve the problem described above, an aspect of an electroluminescent device of the disclosure is an electroluminescent device including a first electroluminescent element and a second electroluminescent element, in which the first electroluminescent element includes a first anode, a first cathode, a first light-emitting layer provided between the first anode and the first cathode, a first hole transport layer including first p-type semiconductor particles, the first hole transport layer being provided between the first anode and the first light-emitting layer, and a first electron transport layer including first n-type semiconductor particles and a first insulating polymer, the first electron transport layer being provided between the first cathode and the first light-emitting layer, a volume proportion of the first n-type semiconductor particles in the first electron transport layer is smaller than a volume proportion of the first p-type semiconductor particles in the first hole transport layer, the second electroluminescent element includes a second anode, a second cathode, a second light-emitting layer having a shorter light emission wavelength than the first light-emitting layer, the second light-emitting layer being provided between the second anode and the second cathode, a second hole transport layer including second p-type semiconductor particles, the second hole transport layer being provided between the second anode and the second light-emitting layer, and a second electron transport layer including second n-type semiconductor particles and a third insulating polymer, the second electron transport layer being provided between the second cathode and the second light-emitting layer, a volume proportion of the second n-type semiconductor particles in the second electron transport layer is smaller than a

volume proportion of the second p-type semiconductor particles in the second hole transport layer, and a volume proportion of the second n-type semiconductor particles in the second electron transport layer is larger than a volume proportion of the first n-type semiconductor particles in the first electron transport layer.

#### Advantageous Effects of Disclosure

[0021] According to an aspect of the disclosure, it is possible to provide an electroluminescent element in which efficient light emission is realized with well-balanced holes and electrons in a light-emitting layer, and an electroluminescent device including a plurality of electroluminescent elements.

---

## Description

### BRIEF DESCRIPTION OF DRAWINGS

[0022] FIG. 1 is a diagram illustrating a schematic configuration of an electroluminescent element according to a first embodiment.

[0023] FIG. 2 is an energy band diagram of the electroluminescent element illustrated in FIG. 1.

[0024] FIG. 3 is a diagram illustrating a schematic configuration of a display device including the electroluminescent element illustrated in FIG. 1.

[0025] FIG. 4 is a diagram illustrating a modification example of the electroluminescent element illustrated in FIG. 1.

[0026] FIG. 5 is a diagram illustrating a relationship between voltage and current density for each volume proportion of a first insulating polymer in an electron transport layer provided in the electroluminescent element illustrated in FIG. 1.

[0027] FIG. 6 is a diagram illustrating a schematic configuration of a display device including an electroluminescent element according to a second embodiment.

[0028] FIG. 7 is a diagram illustrating a schematic configuration of an electroluminescent element according to a third embodiment.

[0029] FIG. 8 is a diagram illustrating a schematic configuration of an electroluminescent element according to a fourth embodiment.

[0030] FIG. 9 is a diagram illustrating schematic configurations of known electroluminescent elements disclosed in PTLs 1 to 3.

### DESCRIPTION OF EMBODIMENTS

[0031] Embodiments of the disclosure will be described with reference to FIGS. 1 to 8 as follows. Hereinafter, for convenience of explanation, components having the same functions as those described in a specific embodiment have the same reference signs appended thereto, and descriptions thereof may be omitted.

[0032] In the following embodiments of the disclosure, an example of a display device will be described as an electroluminescent device including a plurality of electroluminescent elements and a control circuit that controls light emission of each of the plurality of electroluminescent elements. However, the disclosure is not limited thereto, and examples thereof may include an illumination device including a plurality of electroluminescent elements and a control circuit controlling light emission of each of the plurality of electroluminescent elements, and the like.

#### First Embodiment

[0033] A first embodiment of the disclosure will be described with reference to FIGS. 1 to 5.

[0034] FIG. 1 is a diagram illustrating a schematic configuration of an electroluminescent element XR according to a first embodiment.

[0035] FIG. 2 is an energy band diagram of the electroluminescent element XR illustrated in FIG. 1.

[0036] The electroluminescent element XR illustrated in FIG. 1 includes an anode (anode

electrode) **22**, a cathode (cathode electrode) **25**, and a light-emitting layer **24** (first light-emitting layer) **R** including quantum dots provided between the anode (first anode) **22** and the cathode (first cathode) **25**. Here, a case where the electroluminescent element includes the light-emitting layer **24R** that emits light in a red wavelength region is described as an example. However, the disclosure is not limited thereto, and the wavelength region of emitted light is not particularly limited, and may be, for example, a light-emitting layer that emits light in a green wavelength region or may be a light-emitting layer that emits light in a blue wavelength region. Note that, in the present embodiment, a Quantum dot Light Emitting Diode (QLED) that includes a light-emitting layer including quantum dots is described as an example of an electroluminescent element. However, the disclosure is not limited thereto, and the electroluminescent element may be an Organic Light Emitting Diode (OLED) including a light-emitting layer that does not include quantum dots, an inorganic light emitting diode, or the like as long as the electroluminescent element emits light by electrons and holes being inserted thereinto.

[0037] As illustrated in FIG. **1**, the electroluminescent element **XR** further includes an electron transport layer (first electron transport layer) **33** including n-type semiconductor particles (first n-type semiconductor particles) **36** and a first insulating polymer **37**, and a hole transport layer (first hole transport layer) **30** including p-type semiconductor particles (first p-type semiconductor particles) **34**. Note that, in the present embodiment, a case where the hole transport layer including p-type semiconductor particles **34** and the second insulating polymer **35** is used as the hole transport layer **30** including the p-type semiconductor particles **34** is described as an example. However, the disclosure is not limited thereto, and a hole transport layer including only the p-type semiconductor particles **34** may be used as the hole transport layer **30** including the p-type semiconductor particles **34**.

[0038] The electron transport layer **33** is provided between the cathode **25** and the light-emitting layer **24R**, and the hole transport layer **30** is provided between the anode **22** and the light-emitting layer **24R**. Further, in the electroluminescent element **XR**, a volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is smaller than a volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30**.

[0039] The volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** can be obtained by (the entire volume of the n-type semiconductor particles **36**/the entire volume of the electron transport layer **33**) $\times$ 100%, and the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** can be obtained by (the entire volume of the p-type semiconductor particles **34**/the entire volume of the hole transport layer **30**) $\times$ 100%.

[0040] Note that, in the present embodiment, a case where inorganic nanoparticles consisting of, for example, zinc oxide (for example, ZnO) which are electron-transporting inorganic nanoparticles, are used as the n-type semiconductor particles **36** is described as an example. However, the disclosure is not limited thereto, and any one of, for example, inorganic nanoparticles consisting of titanium oxide (for example, TiO<sub>2</sub>), inorganic nanoparticles consisting of indium oxide (for example, In<sub>2</sub>O<sub>3</sub>), inorganic nanoparticles consisting of gallium oxide (for example, Ga<sub>2</sub>O<sub>3</sub>), inorganic nanoparticles consisting of tin oxide (for example, SnO<sub>2</sub>), inorganic nanoparticles consisting of zinc sulfide (for example, ZnS), inorganic nanoparticles consisting of zinc telluride (for example, ZnTe), inorganic nanoparticles consisting of vanadium oxide (for example, V<sub>2</sub>O<sub>5</sub>), inorganic nanoparticles consisting of molybdenum oxide (for example, MoO<sub>3</sub>), inorganic nanoparticles consisting of tungsten oxide (for example, WO<sub>3</sub>), and inorganic nanoparticles consisting of gallium nitride (for example, GaN) may be used as long as the inorganic nanoparticles are electron-transporting inorganic nanoparticles. Further, as the n-type semiconductor particles **36**, for example, inorganic nanoparticles consisting of a mixture containing two or more types among zinc oxide, titanium oxide, indium oxide, gallium oxide, tin oxide, zinc sulfide, zinc telluride, vanadium oxide, molybdenum oxide, tungsten oxide, and gallium nitride may be used. Further, a plurality of types among, for example, inorganic

nanoparticles consisting of zinc oxide, inorganic nanoparticles consisting of titanium oxide, inorganic nanoparticles consisting of indium oxide, inorganic nanoparticles consisting of gallium oxide, inorganic nanoparticles consisting of tin oxide, inorganic nanoparticles consisting of zinc sulfide, inorganic nanoparticles consisting of zinc telluride, inorganic nanoparticles consisting of vanadium oxide, inorganic nanoparticles consisting of molybdenum oxide, inorganic nanoparticles consisting of tungsten oxide, and inorganic nanoparticles consisting of gallium nitride may be used. [0041] Note that, although the particle size of the n-type semiconductor particles **36** in the electron transport layer **33** is not particularly limited, the particle size is preferably equal to or greater than 1 nm from the viewpoint of suppressing aggregation of particles, and the particle size is preferably equal to or less than 30 nm from the viewpoint of reducing the surface roughness of the electron transport layer **33** and the surface roughness of the electroluminescent element XR. Thus, in the present embodiment, inorganic nanoparticles consisting of zinc oxide (for example, ZnO) having a particle size of 12 nm are used as the n-type semiconductor particles **36**.

[0042] Further, the particle size of the n-type semiconductor particles **36** is preferably equal to or greater than 1 nm and equal to or less than 10 nm from the viewpoint of expressing a quantum size effect, improving electron injection efficiency, and obtaining an effect of blocking holes which are counter carriers.

[0043] In addition, as the first insulating polymer **37** of the electron transport layer **33**, for example, polyvinyl alcohol (PVA), polystyrene (PS), polyacrylate, polyvinyl pyrrolidone (PVP), carboxymethylcellulose (CMC), polymethylmethacrylate (PMMA), polysilsesquioxane (PSQ), polydimethylsiloxane (PDMS), and the like can be used. In the present embodiment, polyvinyl pyrrolidone (PVP) is used as the first insulating polymer **37** of the electron transport layer **33**.

[0044] Note that the mixing ratio of the first insulating polymer **37** in the electron transport layer **33**, that is, the volume proportion of the first insulating polymer **37** in the electron transport layer **33** is preferably equal to or greater than 30% and equal to or less than 80%, and more preferably equal to or greater than 10% and equal to or less than 60%.

[0045] Further, the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** of the electroluminescent element XR including the light-emitting layer **24R**, which includes quantum dots having a red light emission wavelength and emits light in a red wavelength region, is preferably equal to or greater than 5% and equal to or less than 65%.

[0046] As illustrated in FIG. 2, a lower end of a conduction band of the light-emitting layer **24R** that includes quantum dots having a red light emission wavelength and emits light in a red wavelength region is located relatively close to a lower end of a conduction band of the electron transport layer (ETL) **33**, and thus the injection of electrons **39** from the electron transport layer (ETL) **33** to the light-emitting layer **24R** occurs relatively easily. Thus, in the electroluminescent element XR provided with the light-emitting layer **24R**, it is preferable that the n-type semiconductor particles **36** that contribute to an improvement in the electron transport property be included in the electron transport layer **33** at a volume proportion of equal to or greater than 5% and equal to or less than 65%. Note that the reason for this will be described below.

[0047] Note that the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** or the volume proportion of the first insulating polymer **37** in the electron transport layer **33** can also be determined from the particle size of the n-type semiconductor particles **36** and the area ratio of the first insulating polymer **37** filling a void portion, for example, by checking an electron microscopy image of the cross section of the electroluminescent element XR.

[0048] The thickness (film thickness) of the electron transport layer **33** is preferably larger than the particle size of the n-type semiconductor particles **36**, and the n-type semiconductor particles **36** are preferably formed such that there are two or more layers thereof in the thickness (film thickness) direction of the electron transport layer **33**. Thereby, it is possible to reduce the surface roughness of the electron transport layer **33** and increase the uniformity of electron injection in a film surface

direction of the electron transport layer **33**. The thickness (film thickness) of the electron transport layer **33** is preferably equal to or greater than 10 nm and equal to or less than 200 nm.

[0049] Note that, in the present embodiment, a case where inorganic nanoparticles consisting of, for example, nickel oxide (for example, NiO) which are hole-transporting inorganic nanoparticles are used as the p-type semiconductor particles **34** is described as an example. However, the disclosure is not limited thereto, and any one of, for example, inorganic nanoparticles consisting of copper oxide (for example, CuO), inorganic nanoparticles consisting of chromium oxide (for example, Cr.sub.2O.sub.3), inorganic nanoparticles consisting of lithium nickelate (for example, LiNiO.sub.2), inorganic nanoparticles consisting of nickel acid lanthanum (for example, LaNiO.sub.3), and inorganic nanoparticles consisting of gallium nitride (for example, GaN) may be used as long as the inorganic nanoparticles are hole-transporting inorganic nanoparticles. Further, as the p-type semiconductor particles **34**, for example, inorganic nanoparticles consisting of a mixture containing two or more types among nickel oxide, copper oxide, chromium oxide, lithium nickelate, lanthanum nickelate, and gallium nitride may be used. Further, as the p-type semiconductor particles **34**, a plurality of types among, for example, inorganic nanoparticles consisting of nickel oxide, inorganic nanoparticles consisting of copper oxide, inorganic nanoparticles consisting of chromium oxide, inorganic nanoparticles consisting of lithium nickelate, inorganic nanoparticles consisting of lanthanum nickelate, and inorganic nanoparticles consisting of gallium nitride may be used.

[0050] Note that, although the particle size of the p-type semiconductor particles **34** in the hole transport layer **30** is not particularly limited, the particle size is preferably equal to or greater than 1 nm from the viewpoint of suppressing aggregation of particles, and the particle size is preferably equal to or less than 30 nm from the viewpoint of reducing the surface roughness of the hole transport layer **30** and the surface roughness of the electroluminescent element XR. Thus, in the present embodiment, inorganic nanoparticles consisting of nickel oxide (for example, NiO) having a particle size of 12 nm are used as the p-type semiconductor particles **34**.

[0051] Further, the particle size of the p-type semiconductor particles **34** is preferably equal to or greater than 1 nm and equal to or less than 10 nm from the viewpoint of expressing a quantum size effect, improving hole injection efficiency, and obtaining an effect of blocking electrons which are counter carriers.

[0052] In addition, similarly to the case of the first insulating polymer **37** of the electron transport layer **33**, as the second insulating polymer **35** of the hole transport layer **30**, for example, polyvinyl alcohol (PVA), polystyrene (PS), polyacrylate, polyvinyl pyrrolidone (PVP), carboxymethylcellulose (CMC), polymethylmethacrylate (PMMA), polysilsesquioxane (PSQ), polydimethylsiloxane (PDMS), and the like can be used. In the present embodiment, similarly to the case of the first insulating polymer **37** of the electron transport layer **33**, polyvinyl pyrrolidone (PVP) is used as the second insulating polymer **35** of the hole transport layer **30**. However, the disclosure is not limited thereto, and the second insulating polymer **35** of the hole transport layer **30** may be an insulating polymer of a type different from the first insulating polymer **37** of the electron transport layer **33**.

[0053] Note that, in the electroluminescent element XR provided with the light-emitting layer **24R**, the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** is greater than the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33**, and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is preferably equal to or greater than 5% and equal to or less than 65%. Thus, the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** is preferably equal to or greater than 80% and equal to or less than 99.99%. That is, the difference between the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is preferably equal to or greater than 20%.



[0054] Note that the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** or the volume proportion of the second insulating polymer **35** in the hole transport layer **30** can also be determined from the particle size of the p-type semiconductor particles **34** and the area ratio of the second insulating polymer **35** filling a void portion, for example, by checking an electron microscopy image of the cross section of the electroluminescent element XR.

[0055] The thickness (film thickness) of the hole transport layer **30** is preferably larger than the particle size of the p-type semiconductor particles **34**, and the p-type semiconductor particles **34** are preferably formed such that there are two or more layers thereof in the thickness (film thickness) direction of the hole transport layer **30**. Thereby, it is possible to reduce the surface roughness of the hole transport layer **30** and increase the uniformity of hole injection in the film surface direction of the hole transport layer **30**. The thickness (film thickness) of the hole transport layer **30** is preferably equal to or greater than 10 nm and equal to or less than 200 nm.

[0056] As illustrated in FIG. 2, in the electroluminescent element XR, an injection barrier of the electrons **39**, which is a difference between the lower end of the conduction band of the electron transport layer (ETL) **33** and the lower end of the conduction band of the light-emitting layer **24R**, is smaller than an injection barrier of holes **38**, which is a difference between an upper end of a valence band of the hole transport layer (HTL) **30** and an upper end of a valence band of the light-emitting layer **24R**, and thus the light-emitting layer **24R** is originally in a state of having an excessive number of the electrons **39**. Consequently, in the electroluminescent element XR, the state of having an excessive number of the electrons **39** in the light-emitting layer **24R** is improved by setting the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** to be higher than the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33**, reducing the amount of electrons **39** injected into the light-emitting layer **24R**, and increasing the amount of the holes **38** injected into the light-emitting layer **24R**. In this manner, it is possible to improve the light emission characteristics of the electroluminescent element XR by improving the balance between the number of holes **38** and the number of electrons **39** in the light-emitting layer **24R**, that is, by improving the carrier balance.

[0057] In addition, the difference between the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is preferably equal to or greater than 20% for the following reason. This is because, in a case where a difference between the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is less than 20%, a carrier balance is improved, but the quantum dots of the light-emitting layer **24R** are still in a state of having an excessive number of the electrons **39**, and there is also a concern that the holes **38** and the electrons **39** that have not been injected into the quantum dots of the light-emitting layer **24R** may be recombined and emit light outside the quantum dots of the light-emitting layer **24R**, which may result in a reduction in emission color purity when the holes **38** and the electrons **39** are recombined and emit light outside the quantum dots of the light-emitting layer **24R** in this manner.

[0058] Note that, in a case where the difference between the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is less than 20% even in the case of an electroluminescent element including a light-emitting layer that does not include quantum dots, the carrier balance is improved, but the light-emitting layer that does not include quantum dots is still in a state of having an excessive number of the electrons **39**, and thus the difference between the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer **33** is preferably equal to or greater than 20%.

[0059] Further, in the hole transport layer **30** provided in the electroluminescent element XR, the p-

type semiconductor particles **34** and the second insulating polymer **35** are mixed, and thus an area where the second insulating polymer **35** and first quantum dots of the light-emitting layer **24R** are in contact with each other is increased, as compared with a case where the p-type semiconductor particles **34** are used independently as a hole transport layer at an interface with the light-emitting layer **24R** including the first quantum dots. Thus, the hole transport layer **30** can suppress deactivation of excitons due to the p-type semiconductor particles **34** directly contacting the first quantum dots of the light-emitting layer **24R**, and also functions as a blocking layer of electrons which are counter carriers.

[0060] Note that even in the case of an electroluminescent element including a light-emitting layer that does not include quantum dots, the hole transport layer **30** is configured such that the p-type semiconductor particles **34** and the second insulating polymer **35** are mixed, and thus an area where the second insulating polymer **35** and the light-emitting layer that does not include quantum dots are in contact with each other is increased, as compared with a case where the p-type semiconductor particles **34** are used independently as a hole transport layer at an interface with the light-emitting layer that does not include quantum dots. Thus, the hole transport layer **30** can suppress deactivation of excitons due to the p-type semiconductor particles **34** directly contacting the light-emitting layer that does not include quantum dots, and also functions as a blocking layer of electrons which are counter carriers.

[0061] Similarly, in the electron transport layer **33** provided in the electroluminescent element XR, the n-type semiconductor particles **36** and the first insulating polymer **37** are mixed, and thus an area where the first insulating polymer **37** and the first quantum dots of the light-emitting layer **24R** are in contact with each other is increased, as compared with a case where the n-type semiconductor particles **36** are used independently as an electron transport layer at an interface with the light-emitting layer **24R** including quantum dots. Thus, the electron transport layer **33** can suppress deactivation of excitons due to the n-type semiconductor particles **36** directly contacting the first quantum dots of the light-emitting layer **24R**, and also functions as a blocking layer of holes which are counter carriers.

[0062] Note that even in the case of an electroluminescent element including a light-emitting layer that does not include quantum dots, the electron transport layer **33** is configured such that the n-type semiconductor particles **36** and the first insulating polymer **37** are mixed, and thus an area where the first insulating polymer **37** and the light-emitting layer that does not include quantum dots are in contact with each other is increased, as compared with a case where the n-type semiconductor particles **36** are used independently as an electron transport layer at an interface with the light-emitting layer that does not include quantum dots. Thus, the electron transport layer **33** can suppress deactivation of excitons due to the n-type semiconductor particles **36** directly contacting the light-emitting layer that does not include quantum dots, and also functions as a blocking layer of holes which are counter carriers.

[0063] In the manufacture of the electroluminescent element XR described above, for example, the hole transport layer **30** may be applied and formed by mixing the p-type semiconductor particles **34** and the second insulating polymer **35** and dissolving the mixture in a solvent at a desired ratio, the light-emitting layer **24R** including the first quantum dots may be applied and formed by mixing quantum dots and a polymer material (conductive material or/and non-conductive material) and dissolving the mixture in a solvent at a desired ratio, and the electron transport layer **33** may be applied and formed by mixing the n-type semiconductor particles **36** and the first insulating polymer **37** and dissolving the mixture in a solvent at a desired ratio. As the solvent, it is preferable to apply a solvent capable of dissolving the first insulating polymer **37**, the polymer material (conductive material and/or non-conductive material), or the second insulating polymer **35**. For example, water, methanol, ethanol, acetone, ethylene glycol, DMSO, trichloroethylene, and the like can be applied as polar solvents, and benzene, toluene, xylene, n-hexane, cyclohexane, and the like can be applied as non-polar solvents.

[0064] In addition, an application formation method of each of the hole transport layer **30**, the light-emitting layer **24R** including the first quantum dots, and the electron transport layer **33** is not particularly limited, but an application formation method such as spin coating, dip coating, spraying, ink jet, slit coating, or screen printing can be used.

[0065] As described above, in the manufacture of the electroluminescent element XR, a series of processes for forming the hole transport layer **30**, the light-emitting layer **24R** including the first quantum dots, and the electron transport layer **33** can be performed as an application process, and the electroluminescent element XR can be manufactured using a relatively simple manufacturing device and a manufacturing process.

[0066] In addition, the hole transport layer **30**, the light-emitting layer **24R** including the first quantum dots, and the electron transport layer **33** which are provided in the electroluminescent element XR manufactured in this manner are all mixed with a polymer material, and thus the surface roughness of each layer is reduced, as compared with a case where the electroluminescent element XR is formed by a single body of the p-type semiconductor particles **34**, the quantum dots, or the n-type semiconductor particles **36**. Further, the flatness of the light-emitting layer **24R**, including the first quantum dots, which is formed on the hole transport layer **30** is improved. As a result, an effect of improving the surface uniformity of carrier injection and improving light emission characteristics is obtained.

[0067] In the present embodiment, a case where the anode **22** and the hole transport layer (HTL) **30** are directly in contact with each other has been described as an example. However, the disclosure is not limited thereto, and a hole injection layer (HIL) for injecting holes may be further provided between the anode **22** and the hole transport layer (HTL) **30**. The hole injection layer (HIL) may be an organic material, an inorganic material, nanoparticles, or a layer in which nanoparticles are dispersed in various types of polymer materials.

[0068] FIG. **3** is a diagram illustrating a schematic configuration of a display device (electroluminescent device) **1** including the electroluminescent element XR illustrated in FIG. **1**.

[0069] As illustrated in FIG. **3**, a resin layer **12**, a barrier layer **3**, a TFT layer **4**, electroluminescent elements XR, XG, and XB, and a sealing layer **6** are layered on one surface of a substrate **10** in the display device **1**. Note that, in the present specification, a direction from the substrate **10** to the electroluminescent elements XR, XG, and XB in FIG. **3** is referred to as an “upward direction”, and a direction from the electroluminescent elements XR, XG, and XB to the substrate **10** is referred to as a “downward direction”. In other words, a “lower layer” means a layer that is formed in a process prior to that of a comparison layer, and an “upper layer” means a layer that is formed in a process after that of a comparison layer. That is, relatively speaking, a layer closer to the substrate **10** is a lower layer, and a layer farther from the substrate **10** is an upper layer.

[0070] Examples of the material of the substrate **10** include polyethylene terephthalate (PET), a glass substrate, and the like, but the material is not limited thereto. In the present embodiment, in order for the display device **1** to be a flexible display device, PET is used as the material of the substrate **10**, but in a case where the display device **1** is a non-flexible display device, a glass substrate or the like may be used.

[0071] Examples of the material of the resin layer **12** include a polyimide resin, an epoxy resin, and a polyamide resin, but are not limited thereto. In the present embodiment, the display device **1** is made as a flexible display device by irradiating the resin layer **12** with laser light through a support substrate (not illustrated) to reduce the bonding strength between the support substrate (not illustrated) and the resin layer **12**, peeling (laser lift off (LLO) process) the support substrate (not illustrated) from the resin layer **12**, and adhering the substrate **10** formed of PET to the surface of the resin layer **12** where the support substrate (not illustrated) was peeled off. However, in a case where the display device **1** is formed as a non-flexible display device or in a case where the display device **1** is formed as a flexible display device by a method other than the LLO process, the resin layer **12** is not necessary.

[0072] The barrier layer **3** is a layer that prevents moisture or impurities from reaching the TFT layer **4** or the electroluminescent elements XR, XG, and XB when the display device **1** is being used, and can be constituted by a silicon oxide film, a silicon nitride film, or a silicon oxynitride film, or by a layered film thereof, for example, formed by CVD.

[0073] The TFT layer **4** includes a semiconductor film **15**, an inorganic insulating film **16** (gate insulating film) above the semiconductor film **15**, a gate electrode GE above the inorganic insulating film **16**, an inorganic insulating film **18** above the gate electrode GE, a capacitance wiring line CE above the inorganic insulating film **18**, an inorganic insulating film **20** above the capacitance wiring line CE, a source-drain wiring line SH including a source-drain electrode above the inorganic insulating film **20**, and a flattening film **21** above the source-drain wiring line SH.

[0074] A thin film transistor element Tr (TFT element) as an active element is configured to include the semiconductor film **15**, the inorganic insulating film **16** (gate insulating film), the gate electrode GE, the inorganic insulating film **18**, the inorganic insulating film **20**, and the source-drain wiring line SH.

[0075] The semiconductor film **15** is formed of, for example, low-temperature polysilicon (LTPS) or an oxide semiconductor. Note that FIG. **1** illustrates the TFT that has a top gate structure including the semiconductor film **15** as a channel, but the TFT may have a bottom gate structure.

[0076] The gate electrode GE, the capacitance electrode CE, the source-drain wiring line SH, and the like are formed of, for example, a single film or a layered film of metal containing at least one of aluminum (Al), tungsten (W), molybdenum (Mo), tantalum (Ta), chromium (Cr), titanium (Ti), or copper (Cu).

[0077] The inorganic insulating films **16**, **18**, and **20** may be constituted by, for example, a silicon oxide (SiO<sub>x</sub>) film, a silicon nitride (SiN<sub>x</sub>) film, a silicon oxynitride film, or a layered film thereof, formed by CVD.

[0078] The flattening film (interlayer insulating film) **21** may be formed of, for example, a coatable photosensitive organic material such as a polyimide resin or an acrylic resin.

[0079] FIGS. **1** and **2** illustrate only a schematic configuration of the electroluminescent element XR including the light-emitting layer **24R** that emits light in a red wavelength region among the electroluminescent elements XR, XG, and XB included in the display device **1** as an example. However, as illustrated in FIG. **3**, the display device **1** also includes the electroluminescent element XG (second electroluminescent element) and the electroluminescent element (third electroluminescent element) XB in addition to the electroluminescent element (first electroluminescent element) XR. The electroluminescent element XR has already been described above, and thus the electroluminescent element XG and the electroluminescent element XB will be specifically described here.

[0080] The electroluminescent element XG illustrated in FIG. **3** includes an anode (anode electrode) **22**, a cathode (cathode electrode) **25**, and a light-emitting layer (second light-emitting layer) **24G** including second quantum dots having a green light emission wavelength between the anode (second anode) **22** and the cathode (second cathode) **25**. Further, the electroluminescent element XG includes an electron transport layer **31** including n-type semiconductor particles (second n-type semiconductor particles) **36** and a first insulating polymer (third insulating polymer) **37**, and a hole transport layer (second hole transport layer) **30** including p-type semiconductor particles (second p-type semiconductor particles) **34**. The electron transport layer **31** is provided between the cathode **25** and the light-emitting layer **24G**, and the hole transport layer **30** is provided between the anode **22** and the light-emitting layer **24G**. Note that, in the electroluminescent element XG, a volume proportion of the n-type semiconductor particles **36** in the electron transport layer (second electron transport layer) **31** is smaller than a volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30**.

[0081] In addition, the electroluminescent element XB illustrated in FIG. **3** includes an anode (anode electrode) **22**, a cathode (cathode electrode) **25**, and a light-emitting layer (third light-

emitting layer) **24B** including third quantum dots having a blue light emission wavelength between the anode (third anode) **22** and the cathode (third cathode) **25**. Further, the electroluminescent element XB includes an electron transport layer **32** including n-type semiconductor particles (third n-type semiconductor particles) **36** and a first insulating polymer (fourth insulating polymer) **37**, and a hole transport layer (third hole transport layer) **30** including p-type semiconductor particles (third p-type semiconductor particles) **34**. The electron transport layer **32** is provided between the cathode **25** and the light-emitting layer **24G**, and the hole transport layer **30** is provided between the anode **22** and the light-emitting layer **24G**. Note that, in the electroluminescent element XB, a volume proportion of the n-type semiconductor particles **36** in the electron transport layer (third electron transport layer) **32** is smaller than a volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30**.

[0082] In the present embodiment, a case where the hole transport layer including the p-type semiconductor particles **34** and the second insulating polymer **35** is used as the hole transport layer **30** including the p-type semiconductor particles **34** is described as an example. However, the disclosure is not limited thereto, and a hole transport layer including only the p-type semiconductor particles **34** may be used as the hole transport layer **30** including the p-type semiconductor particles **34**.

[0083] In the present embodiment, similarly to the n-type semiconductor particles **36** included in the electron transport layer **33** provided in the electroluminescent element XR described above, a case where inorganic nanoparticles consisting of, for example, zinc oxide (for example, ZnO), which are electron-transporting inorganic nanoparticles, are used as the n-type semiconductor particles **36** included in the electron transport layer **31** provided in the electroluminescent element XG and the n-type semiconductor particles **36** included in the electron transport layer **32** provided in the electroluminescent element XB is described as an example. However, the disclosure is not limited thereto, and other materials that have already been described in the case of the electron transport layer **33** provided in the electroluminescent element XR may be used.

[0084] Further, in the present embodiment, a case where the n-type semiconductor particles **36** included in the electron transport layer **31**, the electron transport layer **32**, and the electron transport layer **33** consist of the same material is described as an example. However, the disclosure is not limited thereto, and for example, different materials may be used for the n-type semiconductor particles **36** included in the electron transport layer **31**, the electron transport layer **32**, and the electron transport layer **33**. In addition, for example, two layers may be formed using the same material, and the remaining one layer may be formed using a material different from those of the two layers.

[0085] In the present embodiment, similarly to the first insulating polymer **37** included in the electron transport layer **33** provided in the electroluminescent element XR described above, a case where polyvinyl pyrrolidone (PVP) is used as the first insulating polymer **37** included in the electron transport layer **31** provided in the electroluminescent element XG and the first insulating polymer **37** included in the electron transport layer **32** provided in the electroluminescent element XB is described as an example. However, the disclosure is not limited thereto, and other materials that have already been described in the case of the electron transport layer **33** provided in the electroluminescent element XR may be used.

[0086] Further, in the present embodiment, a case where the first insulating polymers **37** included in the electron transport layer **31**, the electron transport layer **32**, and the electron transport layer **33** are formed of the same material is described as an example. However, the disclosure is not limited thereto, and for example, different materials may be used for the first insulating polymers **37** included in the electron transport layer **31**, the electron transport layer **32**, and the electron transport layer **33**. In addition, for example, two layers may be formed using the same material, and the remaining one layer may be formed using a material different from those of the two layers.

[0087] In the present embodiment, similarly to the p-type semiconductor particles **34** included in

the hole transport layer **30** provided in the electroluminescent element XR described above, a case where inorganic nanoparticles consisting of, for example, nickel oxide (for example, NiO), which are hole-transporting inorganic nanoparticles, are used as the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XG and the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XB is described as an example. However, the disclosure is not limited thereto, and other materials that have already been described in the case of the hole transport layer **30** provided in the electroluminescent element XR may be used.

[0088] Further, in the present embodiment, a case where the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XR, the hole transport layer **30** provided in the electroluminescent element XG, and the hole transport layer **30** provided in the electroluminescent element XB consist of the same material is described as an example. However, the disclosure is not limited thereto, and for example, different materials may be used for the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XR, the hole transport layer **30** provided in the electroluminescent element XG, and the hole transport layer **30** provided in the electroluminescent element XB. In addition, for example, two layers may be formed using the same material, and the remaining one layer may be formed using a material different from those of the two layers.

[0089] In the present embodiment, similarly to the second insulating polymer **35** included in the hole transport layer **30** provided in the electroluminescent element XR, a case where polyvinyl pyrrolidone (PVP) is used as the second insulating polymer **35** included in the hole transport layer **30** provided in the electroluminescent element XG and the second insulating polymer **35** included in the hole transport layer **30** provided in the electroluminescent element XB is described as an example. However, the disclosure is not limited thereto, and other materials that have already been described in the case of the hole transport layer **30** provided in the electroluminescent element XR may be used.

[0090] Further, in the present embodiment, a case where the second insulating polymers **35** included in the hole transport layer **30** provided in the electroluminescent element XR, the hole transport layer **30** provided in the electroluminescent element XG, and the hole transport layer **30** provided in the electroluminescent element XB consist of the same material is described as an example. However, the disclosure is not limited thereto, and for example, different materials may be used for the second insulating polymer **35** included in the hole transport layer **30** provided in the electroluminescent element XR, the hole transport layer **30** provided in the electroluminescent element XG, and the hole transport layer **30** provided in the electroluminescent element XB. In addition, for example, two layers may be formed using the same material, and the remaining one layer may be formed using a material different from those of the two layers.

[0091] Note that, in the display device **1** illustrated in FIG. **3**, each of the hole transport layer **30** provided in the electroluminescent element XR, the hole transport layer **30** provided in the electroluminescent element XG, and the hole transport layer **30** provided in the electroluminescent element XB is formed to have an island shape. However, the disclosure is not limited thereto, and, as in a second embodiment to be described later, the hole transport layer **30** provided in the electroluminescent element XR, the hole transport layer **30** provided in the electroluminescent element XG, and the hole transport layer **30** provided in the electroluminescent element XB may be formed as one common layer.

[0092] Note that a lower end of a conduction band of each of the light-emitting layer **24B** including the third quantum dots having a blue light emission wavelength and the light-emitting layer **24G** including the second quantum dots having a green light emission wavelength is positioned to be higher than the lower end of the conduction band of the light-emitting layer **24R** including the first quantum dots having a red light emission wavelength illustrated in FIG. **2**, that is, above the lower end of the conduction band of the light-emitting layer **24R** in FIG. **2**. In particular, a lower end of a

conduction band of the light-emitting layer **24B** including quantum dots having a blue light emission wavelength is positioned to be higher than the lower end of the conduction band of the light-emitting layer **24G** including the second quantum dots having a green light emission wavelength and is positioned above the lower end of the conduction band of the light-emitting layer **24G** in FIG. 2.

[0093] Thus, an injection barrier of the electrons **39**, which is a difference between the lower end of the conduction band of the electron transport layer (ETL) **32** and the lower end of the conduction band of the light-emitting layer **24B** in the electroluminescent element XB, and an injection barrier of the electrons **39**, which is a difference between the lower end of the conduction band of the electron transport layer (ETL) **31** and the lower end of the conduction band of the light-emitting layer **24G** in the electroluminescent element XG, are larger than an injection barrier of the electrons **39**, which is a difference between the lower end of the conduction band of the electron transport layer (ETL) **33** and the lower end of the conduction band of the light-emitting layer **24R** in the electroluminescent element XR illustrated in FIG. 2. In addition, an injection barrier of the electrons **39**, which is a difference between the lower end of the conduction band of the electron transport layer (ETL) **32** and the lower end of the conduction band of the light-emitting layer **24B**, in the electroluminescent element XB is larger than an injection barrier of the electrons **39**, which is a difference between the lower end of the conduction band of the electron transport layer (ETL) **31** and the lower end of the conduction band of the light-emitting layer **24G** in the electroluminescent element XG.

[0094] Note that the characteristics described above are also applied as they are to a light-emitting layer having a red light emission wavelength that does not include quantum dots, a light-emitting layer having a green light emission wavelength that does not include quantum dots, and a light-emitting layer having a blue light emission wavelength that does not include quantum dots.

[0095] For this reason, in the display device **1**, each of a volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **31** of the electroluminescent element XG and a volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **32** of the electroluminescent element XB is set to be higher than a volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **33** of the electroluminescent element XR. Further, the volume proportion of n-type semiconductor particles **36** in the electron transport layer (ETL) **32** of the electroluminescent element XB is set to be higher than the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **31** of electroluminescent element XG.

[0096] Specifically, within a range satisfying the relationship of the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **32** of the electroluminescent element XB>the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **31** of the electroluminescent element XG>the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **33** of the electroluminescent element XR, the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **33** of the electroluminescent element XR is preferably equal to or greater than 5% and equal to or less than 65%, the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **31** of the electroluminescent element XG is preferably equal to or greater than 30% and equal to or less than 90%, and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **32** of the electroluminescent element XB is preferably equal to or greater than 40% and equal to or less than 95%.

[0097] Further, each of the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **33** of the electroluminescent element XR, the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **31** of the electroluminescent element XG, and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **32** of the electroluminescent element XB is determined

within a range in which each of the volume proportions is smaller than the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** (equal to or greater than 80% and equal to or less than 99.99% in the present embodiment).

[0098] Note that, in each of the electroluminescent element XR, the electroluminescent element XG, and the electroluminescent element XB, the difference between the volume proportion of the p-type semiconductor particles **34** in the hole transport layer **30** (equal to or greater than 80% and equal to or less than 99.99% in the present embodiment) and each of the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **31**, the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **32**, and the volume proportion of the n-type semiconductor particles **36** in the electron transport layer (ETL) **33** is preferably equal to or greater than 20%.

[0099] FIG. 5 is a diagram illustrating the relationship between voltage and current density for each volume proportion of the first insulating polymer **37** in the electron transport layer **33** provided in the electroluminescent element XR illustrated in FIG. 1.

[0100] Results illustrated in FIG. 5 are results of current densities measured while changing an applied voltage for each sample manufactured as follows.

[0101] Each of a 0% sample electroluminescent element, a 10% sample electroluminescent element, a 30% sample electroluminescent element, a 50% sample electroluminescent element, and a 60% sample electroluminescent element is a sample electroluminescent element in which PEDOT:PSS/PVK, which is a hole transport layer, the light-emitting layer **24R** including the first quantum dots, an electron transport layer including inorganic nanoparticles having an average particle size of 12 nm consisting of zinc oxide (for example, ZnO) as the n-type semiconductor particles **36** and polyvinyl pyrrolidone (PVP) as the first insulating polymer **37** at a predetermined ratio, and Al as the cathode **25** are layered on Indium Tin Oxide (ITO) as the anode **22** in this order. The 0% sample electroluminescent element is a sample electroluminescent element in which the volume proportion of the first insulating polymer **37** in the electron transport layer is 0% (the volume proportion of the n-type semiconductor particles **36** in the electron transport layer is 100%). The 10% sample electroluminescent element is a sample electroluminescent element in which the volume proportion of the first insulating polymer **37** in the electron transport layer is 10% (the volume proportion of the n-type semiconductor particles **36** in the electron transport layer is 90%). The 30% sample electroluminescent element is a sample electroluminescent element in which the volume proportion of the first insulating polymer **37** in the electron transport layer is 30% (the volume proportion of the n-type semiconductor particles **36** in the electron transport layer is 70%). The 50% sample electroluminescent element is a sample electroluminescent element in which the volume proportion of the first insulating polymer **37** in the electron transport layer is 50% (the volume proportion of the n-type semiconductor particles **36** in the electron transport layer is 50%). The 60% sample electroluminescent element is a sample electroluminescent element in which the volume proportion of the first insulating polymer **37** in the electron transport layer is 60% (the volume proportion of the n-type semiconductor particles **36** in the electron transport layer is 40%).

[0102] As illustrated in FIG. 5, even in any case of the 10% sample electroluminescent element, the 30% sample electroluminescent element, the 50% sample electroluminescent element, and the 60% sample electroluminescent element, it can be understood that the values of the current densities in the same voltage value are reduced, and the injection of electrons into the electroluminescent element is less likely to be performed, as compared with the 0% sample electroluminescent element in which the electron transport layer is formed of only zinc oxide as the n-type semiconductor particles **36**.

[0103] Further, in each of the 10% sample electroluminescent element, the 30% sample electroluminescent element, the 50% sample electroluminescent element, and the 60% sample electroluminescent element, it can be understood that the degree of decrease in the value of the



current density in the same voltage value increases as the volume proportion of the first insulating polymer **37** increases.

[0104] In this manner, the amount of electrons injected into the light-emitting layer including quantum dots can be appropriately controlled by appropriately changing the volume proportion of the n-type semiconductor particles **36** and the volume proportion of the first insulating polymer **37** in the electron transport layer.

[0105] Although not illustrated in the drawing, similarly to the case of the electron transport layer, the amount of holes injected into the light-emitting layer including quantum dots can be appropriately controlled by appropriately changing the volume proportion of the p-type semiconductor particles **34** and the volume proportion of the second insulating polymer **35** in the hole transport layer.

[0106] The light-emitting layer **24R**, the light-emitting layer **24G**, and the light-emitting layer **24B** illustrated in FIG. **3** are light-emitting layers including a quantum dot (nanoparticle) phosphor. Hereinafter, “phosphor” is omitted for the sake of simplicity and is simply referred to as quantum dots (nanoparticles). As the specific material of the quantum dots (nanoparticles), for example, any of CdSe/CdS, CdSe/ZnS, InP/ZnS, and CIGS/ZnS can be used, and the particle size of the quantum dots (nanoparticles) may be approximately from 3 nm to 10 nm. Note that, in order to make the light-emitting layer **24R**, the light-emitting layer **24G**, and the light-emitting layer **24B** have different center wavelengths of emitted light, the light-emitting layers may have different particle sizes of quantum dots (nanoparticles), or quantum dots (nanoparticles) of different types may be used.

[0107] As illustrated in FIG. **3**, each of the electroluminescent element XR, the electroluminescent element XG, and the electroluminescent element XB is a subpixel SP of the display device **1**, and for example, one electroluminescent element XR, one electroluminescent element XG, and one electroluminescent element XB may constitute one pixel of the display device **1**.

[0108] As illustrated in FIG. **3**, a bank **23** that covers the edge of the anode **22** can be formed of a coatable photosensitive organic material such as a polyimide resin or an acrylic resin.

[0109] In the present embodiment, a case where the anode **22**, the hole transport layer (HTL) **30**, the light-emitting layers **24R**, **24G**, and **24B**, and the electron transport layers (ETL) **31**, **32**, and **33**, except for the cathode **25** formed as a solid-like common layer, are formed in island shapes for each subpixel SP has been described as an example, but the disclosure is not limited thereto. For example, in a case where the cathode **25** is formed in an island shape, and the island-shaped cathode **25** is individually controlled and operated by a thin film transistor element or the like, the anode **22** may be formed as a solid-like common layer. Further, as will be described below, the hole transport layer (HTL) **30** may be formed as a solid-like common layer. Note that, in this case, the bank **23** need not be provided.

[0110] At least one of the anode **22** or the cathode **25** is formed of a light-transmissive material. Note that any one of the anode **22** and the cathode **25** may be formed of a light-reflective material. In a case where the display device **1** is formed as a top-emitting display device, the cathode **25** being an upper layer is formed of a light-transmissive material, and the anode **22** being a lower layer is formed of a light-reflective material. In a case where the display device **1** is a bottom-emitting display device, the cathode **25** being an upper layer is formed of a light-reflective material, and the anode **22** being a lower layer is formed of a light-transmissive material. Note that, in a case where the order of layering from the anode **22** to the cathode **25** is reversed, the display device **1** can be formed as a top-emitting display device by the anode **22**, being an upper layer, being formed of a light-transmissive material and the cathode **25**, being a lower layer, being formed of a light-reflective material, or can be formed as a bottom-emitting display device by the anode **22**, being an upper layer, being formed of a light-reflective material and the cathode **25**, being a lower layer, being formed of a light-transmissive material.

[0111] As the light-transmissive material, for example, a transparent conductive film material can

be used. Specifically, for example, Indium Tin Oxide (ITO), Indium Zinc Oxide (IZO), ZnO, aluminum-doped zinc oxide (AZO), boron-doped zinc oxide (BZO), or the like can be used. These materials have a high transmittance of visible light, and thus light emission efficiency is improved. [0112] As the light-reflective material, a material having a high reflectivity of visible light is preferably used, and for example, a metal material can be used. Specifically, for example, Al, Cu, Au, Ag, or the like can be used. These materials have a high reflectivity of visible light, and thus light emission efficiency is improved.

[0113] In addition, either one of the anode **22** or the cathode **25** may be formed as a layered body including a light-transmissive material and a light-reflective material to form an electrode having light reflectivity.

[0114] Note that, in the present embodiment, the display device **1** is formed as a top-emitting type display device, and thus the cathode **25** being an upper layer is formed of a light-transmissive material, and the anode **22** being a lower layer is formed of a light-reflective material.

[0115] Note that the particle size of the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XG and the particle size of the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XB are preferably equal to or greater than 1 nm and equal to or less than 30 nm, respectively, similar to the particle size of the p-type semiconductor particles **34** included in the hole transport layer **30** provided in the electroluminescent element XR.

[0116] In addition, the thickness (film thickness) of each of the hole transport layer **30** provided in the electroluminescent element XG and the hole transport layer **30** provided in the electroluminescent element XB is preferably equal to or greater than 10 nm and equal to or less than 200 nm, similar to the hole transport layer **30** provided in the electroluminescent element XR.

[0117] In addition, the particle size of the n-type semiconductor particles **36** included in the electron transport layer **31** provided in the electroluminescent element XG and the particle size of the n-type semiconductor particles **36** included in the electron transport layer **32** provided in the electroluminescent element XB are preferably equal to or greater than 1 nm and equal to or less than 30 nm, similar to the particle size of the n-type semiconductor particles **36** included in the electron transport layer **33** provided in the electroluminescent element XR.

[0118] In addition, the thickness (film thickness) of each of the electron transport layer **31** provided in the electroluminescent element XG and the electron transport layer **32** provided in the electroluminescent element XB is preferably 10 nm or more and 200 nm or less, similar to the electron transport layer **33** provided in the electroluminescent element XR.

[0119] As described above, in the display device **1**, it is possible to improve light emission characteristics of the electroluminescent elements XR, XG, and XB by improving a carrier balance in each of the electroluminescent element XR, the electroluminescent element XG, and the electroluminescent element XB. Thus, it is possible to realize the display device **1** that realizes efficient light emission with well-balanced holes and electrons in the light-emitting layer.

[0120] In the present embodiment, since the display device is described as an example of an electroluminescent device, a case where the display device **1** includes the electroluminescent element XR including the light-emitting layer **24R** including the first quantum dots having a red light emission wavelength, the electroluminescent element XG including the light-emitting layer **24G** including the second quantum dots having a green light emission wavelength, and the electroluminescent element XB including the light-emitting layer **24B** including the third quantum dots having a blue light emission wavelength has been described as an example. However, for example, in a case where the electroluminescent device is an illumination device or the like, one or more electroluminescent elements of only one color type including a light-emitting layer including quantum dots having a light emission wavelength of any one color may be provided, or one or more first electroluminescent elements including a first light-emitting layer including first quantum dots and one or more second electroluminescent elements including a second light-emitting layer

including second quantum dots having a shorter light emission wavelength than the first quantum dots may be provided.

[0121] FIG. 4 is a diagram illustrating a schematic configuration of an electroluminescent element XR' which is a modification example of the electroluminescent element XR illustrated in FIG. 1.

[0122] In the electroluminescent element XR illustrated in FIG. 1, aggregation of inorganic nanoparticles is suppressed by using inorganic nanoparticles consisting of zinc oxide (for example, ZnO) having a particle size of 12 nm as the p-type semiconductor particles 34 included in the hole transport layer 30.

[0123] Similarly to the hole transport layer 30 provided in the electroluminescent element XR illustrated in FIG. 1, a hole transport layer 30' provided in the electroluminescent element XR' illustrated in FIG. 4 includes inorganic nanoparticles consisting of zinc oxide (for example, ZnO) as the p-type semiconductor particles 34 and polyvinyl pyrrolidone (PVP) as the second insulating polymer 35. A difference from the hole transport layer 30 provided in the electroluminescent element XR illustrated in FIG. 1 is that the particle size of the inorganic nanoparticles consisting of zinc oxide (for example, ZnO) is less than 1 nm. Specifically, the inorganic nanoparticles consisting of zinc oxide (for example, ZnO) as the p-type semiconductor particles 34 included in the hole transport layer 30' provided in the electroluminescent element XR' illustrated in FIG. 4 have an average particle size of 0.5 nm. Note that a volume proportion of the inorganic nanoparticles (average particle size of 0.5 nm) consisting of zinc oxide (for example, ZnO) as the p-type semiconductor particles 34 in the hole transport layer 30' is set to be a volume proportion of the inorganic nanoparticles (average particle size of 12 nm) consisting of zinc oxide (for example, ZnO) as the p-type semiconductor particles 34 in the hole transport layer 30 provided in the electroluminescent element XR illustrated in FIG. 1.

[0124] As illustrated in FIG. 4, aggregation of inorganic nanoparticles (average particle size of 0.5 nm) consisting of zinc oxide (for example, ZnO) occurs in the hole transport layer 30'. However, similarly to the electroluminescent element XR illustrated in FIG. 1, it is possible to improve a balance, that is, a carrier balance between the number of holes 38 and the number of electrons 39 in the light-emitting layer 24R and to improve light emission characteristics also in the electroluminescent element XR'.

## Second Embodiment

[0125] Next, a second embodiment of the disclosure will be described with reference to FIG. 6. A display device 1' including electroluminescent elements XR'', XG'', and XB'' of the present embodiment is different from that in the first embodiment in that a hole transport layer 30 provided in the electroluminescent element (first electroluminescent element) XR'', a hole transport layer 30 provided in the electroluminescent element (second electroluminescent element) XG'', and a hole transport layer 30 provided in the electroluminescent element (third electroluminescent element) XB'' are formed as one common layer, and a cathode 25 provided in the electroluminescent element XR'', a cathode 25 provided in the electroluminescent element XG'', and a cathode 25 provided in the electroluminescent element XB'' are formed in an island shape. For convenience of description, members having the same functions as those illustrated in the drawings in the first embodiment are denoted by the same reference numerals and signs, and descriptions thereof will be omitted.

[0126] FIG. 6 is a diagram illustrating a schematic configuration of the display device 1' including the electroluminescent elements XR'', XG'', and XB'' according to the second embodiment.

[0127] As illustrated in FIG. 6, in the display device 1' including the electroluminescent elements XR'', XG'', and XB'', the hole transport layer 30 provided in the electroluminescent element XR'', the hole transport layer 30 provided in the electroluminescent element XG'', and the hole transport layer 30 provided in the electroluminescent element XB'' are formed as one common layer. Thus, a patterning process for forming the hole transport layer 30 in an island shape, and the like can be omitted, and thus it is advantageous in terms of the manufacturing process. Further, by forming the hole transport layer 30 as a single common layer, the step of forming the bank 23 covering the edge

of the anode **22** illustrated in FIG. **3** and the like can be omitted, and thus, it is advantageous in terms of the manufacturing process.

[0128] In addition, as illustrated in FIG. **6**, in the display device **1'** including the electroluminescent elements XR'', XG'', and XB'', the cathode **25** provided in the electroluminescent element XR'', the cathode **25** provided in the electroluminescent element XG'', and the cathode **25** provided in the electroluminescent element XB'' are formed in an island shape.

[0129] As described above, in the display device **1'**, it is possible to improve light emission characteristics of the electroluminescent elements XR'', XG'', and XB'' by improving a carrier balance in each of the electroluminescent element XR'', the electroluminescent element XG'', and the electroluminescent element XB''. Thus, it is possible to realize the display device **1'** that realizes efficient light emission with well-balanced holes and electrons in the light-emitting layer.

#### Third Embodiment

[0130] Next, a third embodiment of the disclosure will be described with reference to FIG. **7**. An electroluminescent element XR''' of the present embodiment is different from that in the first embodiment in that the order of layering from an anode **22** to a cathode **25** is reversed. For convenience of description, members having the same functions as those illustrated in the drawings in the first embodiment are denoted by the same reference numerals and signs, and descriptions thereof will be omitted.

[0131] FIG. **7** is a diagram illustrating a schematic configuration of the electroluminescent element XR''' according the third embodiment.

[0132] As illustrated in FIG. **7**, in the electroluminescent element XR''', the order of layering from the anode **22** to the cathode **25** is reversed with respect to that of the electroluminescent element XR illustrated in FIG. **1**. That is, first, the cathode **25** is formed, an electron transport layer **33** is formed on the cathode **25**, a light-emitting layer **24R** including first quantum dots is formed on the electron transport layer **33**, a hole transport layer **30** is formed on the light-emitting layer **24R**, and the anode **22** is formed on the hole transport layer **30**. In such a case, even when the anode **22** is formed using a vacuum film forming method such as sputtering, because the hole transport layer **30** includes a second insulating polymer **35**, it is possible to obtain the electroluminescent element XR''' having satisfactory light emission characteristics without imparting plasma damage to the light-emitting layer **24R** including the first quantum dots.

[0133] Further, since the electron transport layer **33** includes a first insulating polymer **37**, the flatness of the light-emitting layer **24R** including the first quantum dots formed on the electron transport layer **33** is improved. As a result, an effect of improving the surface uniformity of carrier injection and improving light emission characteristics is obtained.

#### Fourth Embodiment

[0134] Next, a fourth embodiment of the disclosure will be described on the basis of FIG. **8**. An electroluminescent element XR''' of the present embodiment is different from that in the first embodiment in that an insulating layer **41** is provided between a light-emitting layer **24R** and a hole transport layer **30**, and an insulating layer **42** is provided between the light-emitting layer **24R** and an electron transport layer **33**. For convenience of description, members having the same functions as those illustrated in the drawings in the first embodiment are denoted by the same reference numerals and signs, and descriptions thereof will be omitted.

[0135] FIG. **8** is a diagram illustrating a schematic configuration of the electroluminescent element XR''' according to the fourth embodiment.

[0136] As illustrated in FIG. **8**, the electroluminescent element XR''' includes the insulating layer **41** provided between the light-emitting layer **24R** and the hole transport layer **30**, and the insulating layer **42** provided between the light-emitting layer **24R** and the electron transport layer **33**.

[0137] The insulating layer **41** and the insulating layer **42** are both layers that do not include p-type semiconductor particles **34** and n-type semiconductor particles **36**. The type of insulating layer **41** and the type of insulating layer **42** are not particularly limited as long as the insulating layer **41** and

the insulating layer **42** do not include the p-type semiconductor particles **34** and the n-type semiconductor particles **36**. However, the insulating layers may be, for example, polymers having conductivity, may be insulating layers formed of an inorganic oxide, or may be layers formed of an inorganic nitride.

[0138] Note that, by providing the insulating layer **41** and the insulating layer **42**, the insulating layer **41** and the insulating layer **42** function as blocking layers that prevent the p-type semiconductor particles **34** and the n-type semiconductor particles **36** from directly touching the light-emitting layer **24R** including the first quantum dots, prevent excitons generated by the light-emitting layer **24R** including the first quantum dots from being trapped due to defect levels of the p-type semiconductor particles **34** and the n-type semiconductor particles **36**, or the like, and inhibit holes injected from the hole transport layer **30** and electrons injected from the electron transport layer **33** from passing through electrodes on opposite sides.

[0139] The insulating layer **41** and the insulating layer **42** may be formed using the same material as that of the first insulating polymer **37** or the second insulating polymer **35** described above in the first embodiment. In addition, the insulating layer **41** and the insulating layer **42** may be inorganic insulators formed of any one of aluminum oxide, magnesium oxide, silicon oxide, aluminum nitride, zirconium oxide, and hafnium oxide, and may be inorganic insulators formed of mixtures of two or more of aluminum oxide, magnesium oxide, silicon oxide, aluminum nitride, zirconium oxide, and hafnium oxide.

[0140] Additionally, the film thickness of each of the insulating layer **41** and the insulating layer **42** is preferably equal to or greater than 1 nm and equal to or less than 10 nm from the perspective of preventing the p-type semiconductor particles **34** and the n-type semiconductor particles **36** from contacting the light-emitting layer **24R** including the first quantum dots and allowing carrier injection into the light-emitting layer **24R** including the first quantum dots by tunneling.

[0141] Note that, in the present embodiment, a case where the insulating layer **41** is provided between the light-emitting layer **24R** and the hole transport layer **30**, and the insulating layer **42** is provided between the light-emitting layer **24R** and the electron transport layer **33** has been described as an example. However, the disclosure is not limited thereto, and the insulating layer **41** may be provided only between the light-emitting layer **24R** and the hole transport layer **30**, and the insulating layer **42** may be provided only between the light-emitting layer **24R** and the electron transport layer **33**.

## Appendix

[0142] The disclosure is not limited to the embodiments described above, and various modifications may be made within the scope of the claims. Embodiments obtained by appropriately combining technical approaches disclosed in the different embodiments also fall within the technical scope of the disclosure. Further, novel technical features can be formed by combining the technical approaches disclosed in each of the embodiments.

## INDUSTRIAL APPLICABILITY

[0143] The disclosure can be utilized in electroluminescent elements and electroluminescent devices.

## Claims

**1.** An electroluminescent element comprising: an anode; a cathode; and a light-emitting layer provided between the anode and the cathode, wherein the electroluminescent element further includes an electron transport layer including n-type semiconductor particles and a first polymer, and a hole transport layer including p-type semiconductor particles, the electron transport layer is provided between the cathode and the light-emitting layer, the hole transport layer is provided between the anode and the light-emitting layer, a volume proportion of the n-type semiconductor particles in the electron transport layer is smaller than a volume proportion of the p-type

semiconductor particles in the hole transport layer, and the volume proportion of the p-type semiconductor particles in the hole transport layer is equal to or greater than 80% and equal to or less than 99.9%.

2. The electroluminescent element according to claim 1, wherein the hole transport layer further includes a second polymer.

3. An electroluminescent element comprising: an anode; a cathode; and a light-emitting layer provided between the anode and the cathode, wherein the electroluminescent element further includes an electron transport layer including n-type semiconductor particles and a first polymer, and a hole transport layer including p-type semiconductor particles, the electron transport layer is provided between the cathode and the light-emitting layer, the hole transport layer is provided between the anode and the light-emitting layer, a volume proportion of the n-type semiconductor particles in the electron transport layer is smaller than a volume proportion of the p-type semiconductor particles in the hole transport layer, the light-emitting layer has a red light emission wavelength, and the volume proportion of the n-type semiconductor particles in the electron transport layer is equal to or greater than 5% and equal to or less than 65%.

4. The electroluminescent element according to claim 1, wherein the light-emitting layer has a green light emission wavelength, and the volume proportion of the n-type semiconductor particles in the electron transport layer is equal to or greater than 30% and equal to or less than 90%.

5. The electroluminescent element according to claim 1, wherein the light-emitting layer has a blue light emission wavelength, and the volume proportion of the n-type semiconductor particles in the electron transport layer is equal to or greater than 40% and equal to or less than 95%.

6. The electroluminescent element according to claim 4, wherein a difference between the volume proportion of the p-type semiconductor particles in the hole transport layer and the volume proportion of the n-type semiconductor particles in the electron transport layer is equal to or greater than 20%.

7. The electroluminescent element according to claim 1, wherein a film thickness of the hole transport layer is equal to or greater than 10 nm and equal to or less than 200 nm.

8. The electroluminescent element according to claim 1, wherein a particle size of the n-type semiconductor particles is equal to or greater than 1 nm and equal to or less than 30 nm.

9. The electroluminescent element according to claim 1, wherein a particle size of the p-type semiconductor particles is equal to or greater than 1 nm and equal to or less than 30 nm.

10. An electroluminescent device comprising: a first electroluminescent element; and a second electroluminescent element, wherein the first electroluminescent element includes a first anode, a first cathode, a first light-emitting layer provided between the first anode and the first cathode, a first hole transport layer including first p-type semiconductor particles, the first hole transport layer being provided between the first anode and the first light-emitting layer, and a first electron transport layer including first n-type semiconductor particles and a first polymer, the first electron transport layer being provided between the first cathode and the first light-emitting layer, a volume proportion of the first n-type semiconductor particles in the first electron transport layer is smaller than a volume proportion of the first p-type semiconductor particles in the first hole transport layer, the second electroluminescent element includes a second anode, a second cathode, a second light-emitting layer having a shorter light emission wavelength than the first light-emitting layer, the second light-emitting layer being provided between the second anode and the second cathode, a second hole transport layer including second p-type semiconductor particles, the second hole transport layer being provided between the second anode and the second light-emitting layer, and a second electron transport layer including second n-type semiconductor particles and a third polymer, the second electron transport layer being provided between the second cathode and the second light-emitting layer, a volume proportion of the second n-type semiconductor particles in the second electron transport layer is smaller than a volume proportion of the second p-type semiconductor particles in the second hole transport layer, and a volume proportion of the second

n-type semiconductor particles in the second electron transport layer is larger than the volume proportion of the first n-type semiconductor particles in the first electron transport layer.

**11.** The electroluminescent device according to claim 10, wherein the first p-type semiconductor particles and the second p-type semiconductor particles are the same material, the volume proportion of the first p-type semiconductor particles in the first hole transport layer and the volume proportion of the second p-type semiconductor particles in the second hole transport layer are the same, and the first hole transport layer and the second hole transport layer are formed of the same material as a single layer.

**12.** The electroluminescent device according to claim 10, wherein the first n-type semiconductor particles and the second n-type semiconductor particles are the same material, and the first polymer and the third polymer are the same material.

**13.** The electroluminescent device according to claim 10, wherein a thickness of the first hole transport layer is equal to or greater than 10 nm and equal to or less than 200 nm, and a thickness of the second hole transport layer is equal to or greater than 10 nm and equal to or less than 200 nm.

**14.** The electroluminescent device according to claim 10, wherein a particle size of the first n-type semiconductor particles is equal to or greater than 1 nm and equal to or less than 30 nm, and a particle size of the second n-type semiconductor particles is equal to or greater than 1 nm and equal to or less than 30 nm.

**15.** The electroluminescent device according to claim 10, wherein a particle size of the first p-type semiconductor particles is equal to or greater than 1 nm and equal to or less than 30 nm, and a particle size of the second p-type semiconductor particles is equal to or greater than 1 nm and equal to or less than 30 nm.

**16.** The electroluminescent device according to claim 10, wherein an insulating layer is provided at least one of between the first light-emitting layer and the first hole transport layer, between the first light-emitting layer and the first electron transport layer, between the second light-emitting layer and the second hole transport layer, or between the second light-emitting layer and the second electron transport layer.

**17.** The electroluminescent device according to claim 10, further comprising: a third electroluminescent element, wherein the third electroluminescent element includes a third anode, a third cathode, a third light-emitting layer having a shorter light emission wavelength than the second light-emitting layer, the third light-emitting layer being provided between the third anode and the third cathode, a third hole transport layer including third p-type semiconductor particles, the third hole transport layer being provided between the third anode and the third light-emitting layer, and a third electron transport layer including third n-type semiconductor particles and a fourth polymer, the third electron transport layer being provided between the third cathode and the third light-emitting layer, a volume proportion of the third n-type semiconductor particles in the third electron transport layer is smaller than a volume proportion of the third p-type semiconductor particles in the third hole transport layer, and the volume proportion of the third n-type semiconductor particles in the third electron transport layer is larger than the volume proportion of the second n-type semiconductor particles in the second electron transport layer.

**18.** The electroluminescent device according to claim 10, wherein the first light-emitting layer includes first quantum dots, the second light-emitting layer includes second quantum dots, and the second quantum dots have a shorter light emission wavelength than the first quantum dots.

**19.** The electroluminescent device according to claim 17, wherein the first light-emitting layer includes first quantum dots, the second light-emitting layer includes second quantum dots, the third light-emitting layer includes third quantum dots, the second quantum dots have a shorter light emission wavelength than the first quantum dots, and the third quantum dot have a shorter light emission wavelength than the second quantum dots.

---