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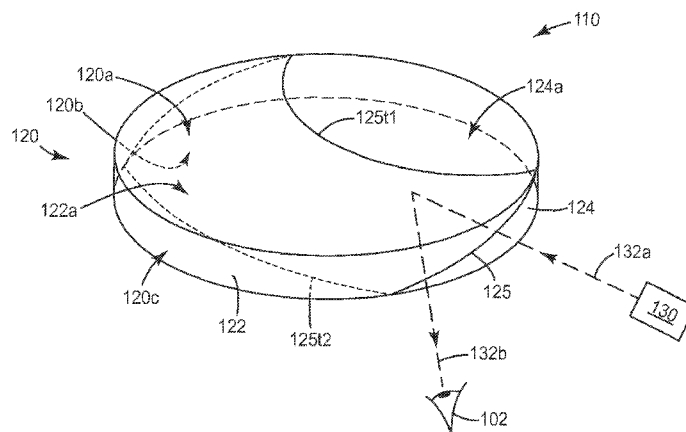


FIG. 1

(57) Abstract: A lens 120 is formed from at least two sections or bodies 122, 124 that are shaped to mate with each other, and a multilayer optical film 125 is sandwiched between these two sections. Smooth surfaces 121a, 124a of each section combine to provide a first optical surface 120 a of the lens, e.g., a concave, convex, or flat optical surface. The multilayer optical film includes a stack of polymer layers configured to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent. The multilayer optical film may thus be or comprise e.g. a reflective polarizer and/ or a narrow band or otherwise notched reflector. The multilayer optical film has an extended terminus 125t1 that separates the smooth surfaces of the two sections. Any edge defects such as cracks or delaminations that may exist along the extended terminus are characterized by an average defect distance of no more than 100 or 50 microns.



**LENS WITH EMBEDDED MULTILAYER OPTICAL FILM
FOR NEAR-EYE DISPLAY SYSTEMS**

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FIELD OF THE INVENTION

This invention relates generally to lenses and related optical components, with particular application to lenses that include a partially reflective element for purposes of beamsplitting. The invention also relates to associated articles, systems, and methods.

10

BACKGROUND

Optical beamsplitters are known. Some beamsplitters are made by cementing two prisms together with a reflective film in between. The reflective film typically extends between opposite edges of the beamsplitter. See e.g. U.S. Patent 7,329,006 (Aastuen et al.)

15 Lenses, including compound lenses in which two or more simple lenses are cemented together, are also known. U.S. Patent 5,654,827 (Reichert) discusses lenses in which the lens is divided into two parts by a beamsplitter.

Head-Up Displays or Head-Mounted Displays (collectively referred to herein as HUDs) can project an image that fills all or part of a user's field of view. Some HUDs use a combiner optic that integrates the projected image with the usual image of the external environment. In some cases, the HUD
20 is a Near-Eye Display (NED), which may have a form factor similar to that of eyeglasses. See e.g. U.S. Patent 6,353,503 (Spitzer et al.).

BRIEF SUMMARY

25 In Near Eye Displays and similar systems, the lens portion of the glasses desirably combines world and augmented (projected) views, provides high quality optical performance with a minimum of artifacts, and is also robust enough to withstand normal handling and usage typical for eyeglasses.

Multilayer optical films that include a stack of polymer layers configured to selectively reflect light by constructive or destructive interference have been used now for many years in a variety of applications in which high quality optical performance, with minimal artifacts, is required, such as in
30 backlit display applications for laptop computers. However, embedding such films into a lens to function as a beamsplitter, particularly where the beamsplitter is designed to be off-axis relative to the optical axis of the lens, and also where at least some of the polymer layers in the stack are birefringent, poses certain design challenges and is by no means a trivial undertaking. If the degree of misalignment between the optical axis of the lens and the orientation of the optical film is large enough, the optical film may meet or
35 intersect an optical surface of the lens. Such an intersection results in a bifurcation of the optical surface, with an edge of the multilayer optical film forming a line of separation between the two portions of the bifurcated optical surface. Polymer layers that are birefringent tend to be more brittle than those that are isotropic, and the edge of a multilayer optical film that contains birefringent polymer layers can therefore tend to have more breaks, cracks, and/or delaminations at such edge than an alternative film that contains

no birefringent layers. If present at the edge of the film, such breaks, cracks, and other edge defects have the potential to significantly diminish the optical performance of the lens, particularly since they are located at or near the optical surface of the lens, directly in the path of incident light rays and within the clear aperture of the optical system.

5 We have found that multilayer optical films containing birefringent polymer layers can be successfully embedded into lenses to provide a beamsplitting function that may be suitable for Near-Eye Displays and similar applications. If the degree of misalignment between the optical axis of the lens and the orientation of the multilayer optical film is such that an optical surface of the lens is bifurcated by the film, care can be taken to ensure that the edge of the multilayer optical film that forms a line of separation
10 between the portions of the bifurcated optical surface does not have excessive defects such as breaks, cracks, or delaminations, thus allowing for high quality optical performance of the lens. Ensuring that the film edge has minimal edge defects can also or alternatively enhance product robustness by reducing the chance of fracturing of the lens at the film edge (e.g. due to an edge delamination that spreads throughout the film) in the presence of stresses that may occur in the lens during product fabrication, installation, or
15 use.

Lenses are thus disclosed in which the lens is formed from at least two sections or bodies that are shaped to mate with each other, and a multilayer optical film is sandwiched between these two sections. Smooth surfaces of each section combine to provide a first optical surface of the lens, such as a concave, convex, or flat optical surface. The multilayer optical film includes a stack of polymer layers configured
20 to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent. The multilayer optical film may thus be or comprise e.g. a reflective polarizer and/or a narrow band or otherwise notched reflector. The multilayer optical film has an extended edge or terminus that separates the smooth surfaces of the two sections. Any edge defects such as cracks or delaminations that may exist along the extended terminus are characterized by an average defect distance
25 of no more than 100 or 50 microns.

We also describe herein, *inter alia*, lenses that have first and second opposed optical surfaces connected by a circumferential surface, such a lens also including a first and second lens section and a multilayer optical film embedded in the lens between the first and second lens sections. The first lens section has a first smooth surface and a side surface, and the second lens section has a first smooth
30 surface, a second smooth surface, and a side surface. The multilayer optical film includes a plurality of polymer layers configured to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent. The first optical surface of the lens includes the first smooth surface of the first lens section and the first smooth surface of the second lens section. The second optical surface includes the second smooth surface of the second lens section. The multilayer
35 optical film includes a first extended terminus that separates the first smooth surface of the first lens section from the first smooth surface of the second lens section.

The circumferential surface may include the side surface of the first lens section and the side surface of the second lens section. In some cases, the first optical surface may include the first extended

terminus. In some cases, the first extended terminus may be disposed in a first extended notch that separates the first smooth surface of the first lens section from the first smooth surface of the second lens section, and the first extended notch may be no more than 250 microns deep.

To the extent the multilayer optical film has any edge defects along the first extended terminus, such edge defects may be characterized by a first average defect distance of no more than 100 microns, or no more than 50 microns.

The first optical surface may be curved, and the first extended terminus may be arc-shaped. The first optical surface may instead be flat, and the first extended terminus may be straight.

The first lens section may also have a second smooth surface, and the second optical surface may include the second smooth surface of the first lens section and the second smooth surface of the second lens section, and the multilayer optical film may include a second extended terminus that separates the second smooth surface of the first lens section from the second smooth surface of the second lens section. In such cases, the second optical surface may also include the second extended terminus. The second extended terminus may alternatively be disposed in a second extended notch that separates the second smooth surface of the first lens section from the second smooth surface of the second lens section. To the extent the multilayer optical film may have any edge defects along the second extended terminus, such edge defects may be characterized by a second average defect distance of no more than 100 microns, or no more than 50 microns.

The multilayer optical film may be configured as a reflective polarizer for at least one visible wavelength of normally incident light. Additionally or alternatively, the multilayer optical film may be configured as a notch filter for at least one polarization state of normally incident light. In such cases, the multilayer optical film may also be configured as a reflective polarizer for at least one visible wavelength of normally incident light.

The lens may also include a protective coating that covers the first smooth surface of the first lens section, the first smooth surface of the second lens section, and the first extended terminus. The lens may also include an absorptive layer that covers the first optical surface or the second optical surface, and the absorptive layer may be or include an absorptive polarizer. The lens may also be bonded to a second lens to provide a compound lens. The lens may also be part of a system which also includes an imaging device disposed to direct imaging light towards the multilayer optical film. The multilayer optical film may be configured to selectively reflect visible light of a first characteristic and selectively transmit visible light of a second characteristic, and the imaging light may comprise the first characteristic. The first and second characteristics may be orthogonal first and second polarization states, respectively, and the lens may further include an absorptive polarizer configured to absorb light of the second polarization state. The system may be or include eyewear.

We also disclose optical components that have first and second opposed optical surfaces connected by a circumferential surface, such an optical component including a first section, a second section, and a multilayer optical film embedded in the optical component between the first and second sections. The first section may have a first smooth surface and a side surface, and the second section may

have a first smooth surface, a second smooth surface, and a side surface, and the second section may be shaped to mate with the first section. The multilayer optical film may include a plurality of polymer layers arranged to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent. The first optical surface may include the first smooth surface of the first section and the first smooth surface of the second section, and the second optical surface may include the second smooth surface of the second section, and the multilayer optical film may include a first extended terminus that separates the first smooth surface of the first section from the first smooth surface of the second section. In some cases, both the first and second optical surfaces may be flat.

We also disclose methods of making lenses, such methods including: providing a first optical body and a second optical body, the second optical body shaped to mate with the first optical body; providing a multilayer optical film, the multilayer optical film including a plurality of polymer layers configured to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent; bonding the first and second optical bodies together with the multilayer optical film sandwiched therebetween to form a compound optical body; forming a first optical surface in the compound optical body, the forming being carried out to give a first smooth surface to the first optical body and a second smooth surface to the second optical body, the first and second smooth surfaces being portions of the first optical surface, the optical body also having, or made to have, a second optical surface opposite the first optical surface, and a circumferential surface that connects the first and second optical surfaces; and terminating the multilayer optical film along an extended terminus that separates the first smooth surface from the second smooth surface.

The terminating may be carried out to avoid edge defects in the multilayer optical film along the extended terminus, with any such edge defects being characterized by a first average defect distance of no more than 100 microns, or no more than 50 microns. The terminating may include polishing an end of the multilayer optical film, and the forming may include polishing the first and second optical bodies.

Related methods, systems, and articles are also discussed.

These and other aspects of the present application will be apparent from the detailed description below. In no event, however, should the above summaries be construed as limitations on the claimed subject matter, which subject matter is defined solely by the attached claims, as may be amended during prosecution.

BRIEF DESCRIPTION OF DRAWINGS

FIG. 1 is a schematic perspective view of system that includes a lens having an embedded multilayer optical film;

FIGS. 2A and 2B are schematic top views of eyewear that incorporates lenses having embedded multilayer optical films, and imaging devices;

FIG. 3 is a schematic side or sectional view of a portion of a multilayer optical film;

FIGS. 4A, 4B, and 4C are idealized, hypothetical graphs of reflectivity versus wavelength for various possible embodiments of the multilayer optical film;

FIGS. 5A through 5C are schematic side or sectional views of systems in which an imaging device injects imaging light into a lens having an embedded multilayer optical film;

FIG. 6 is a schematic side or sectional view of another system in which an imaging device injects imaging light into a lens having an embedded multilayer optical film;

5 FIGS. 7 and 8 are schematic side or sectional views of more lenses having embedded multilayer optical films;

FIG. 9 is a schematic side or sectional view of a compound lens in which one of the component lenses has an embedded multilayer optical film;

10 FIG. 10 is a schematic front view of a lens having an embedded multilayer optical film, the multilayer optical film having an extended terminus disposed at or near an optical surface of the lens;

FIGS. 11 and 12 are schematic front views of lenses having alternative circumferential shapes;

FIGS. 13, 14, and 15 are schematic sectional views of portions of lenses in which a multilayer optical film is sandwiched between two lens sections, and a terminus of the multilayer optical film is disposed at or near a curved optical surface of the lens;

15 FIG. 16 is a schematic plan or sectional view of a multilayer optical film with various idealized edge defects along the extended terminus of the film; and

FIGS. 17A through 17C are schematic side or sectional views showing how a multilayer optical film can be combined with two optical bodies to fabricate a lens having an embedded multilayer optical film.

20 In the figures, like reference numerals designate like elements.

DETAILED DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

As mentioned above, we have developed lenses in which the lens is formed from at least two sections or bodies that are shaped to mate with each other, and a multilayer optical film is sandwiched
25 between these two sections. The multilayer optical film is partially transmissive and partially reflective in order to give the lens a beamsplitting capability. The partial transmission and reflection may be primarily a function of polarization state of normally incident light (as with a broadband reflective polarizer), or may be primarily a function of optical wavelength (as with a notched filter), or may be a combination of these, and/or in combination with other characteristics. The multilayer optical film is oriented within the
30 lens such that an edge or terminus of the film intersects an optical surface of the lens. The terminus separates smooth surfaces of each of the two lens sections, such smooth surfaces in combination providing an optical surface of the lens. Any edge defects such as cracks or delaminations that may exist along the film terminus may be characterized by an average defect distance of no more than 100 or 50 microns.

35 Turning to FIG. 1, we see there a schematic view of a system **110** that includes a lens **120** having an embedded multilayer optical film **125**. The system **110** may, for example, be or include a Head-Up Display, a Head-Mounted Display, or a Near-Eye Display. The film **125** provides the lens **120** with a beamsplitting capability such that an observer can view (via light transmitted completely through the lens

120) objects that reside on the opposite side of the lens, which we refer to as a world view, and can also view (via light reflected by the film **125** and transmitted at least partially through the lens **120**) images generated by an imaging device **130**, which we refer to as a projected view. The eye **102** shown in the figure represents one eye of the observer. Arrow **132a** represents light emitted by the imaging device **130**, and arrow **132b** represents light from the imaging device **130** which has been reflected by the multilayer optical film **125**.

The lens **120** has a first optical surface **120a**, and a second optical surface **120b** opposed to the first optical surface **120a**. In the depicted embodiment, each of these optical surfaces has a circular aperture and a circular periphery. The first optical surface **120a** faces away from the observer and towards objects that are remote from the observer, while the second optical surface **120b** faces towards the observer and away from remote objects. The optical surfaces **120a**, **120b** are predominantly smooth so that light can be refracted at their surfaces in a predictable fashion with little or no surface scattering. The surfaces **120a**, **120b** are assumed to be exposed to air or vacuum, but in other cases they may be exposed to a different light-transmissive medium, or they may be overcoated, and in some cases cemented to other optical components as discussed further below. In order to qualify as a lens, at least one of the optical surfaces **120a**, **120b** is curved, e.g., convex or concave, rather than flat. The curvature may be spherical, i.e., it may have a constant radius of curvature over substantially the entire optical surface, or it may be aspherical, with a radius of curvature that changes over the optical surface, usually in a gradual and continuous fashion. The curvature provides the lens **120** with a non-zero optical power, e.g. a positive optical power in the case of a converging lens or a negative optical power in the case of a diverging lens, unless both optical surfaces have the same curvature, in which case the lens **120** may have a zero optical power and may be neither converging nor diverging. Whether spherical or aspherical, an optical surface of the lens **120** which is curved typically has a rotational symmetry about an axis, e.g., an axis that coincides with an optical axis of the lens **120**.

The first and second optical surfaces **120a**, **120b** are connected to each other by a circumferential surface **120c**. In the depicted embodiment, the circumferential surface **120c** is the ring-shaped side surface of the lens **120**.

From a mechanical construction standpoint, the lens **120** is made up of a first lens section **122**, a second lens section **124**, and a multilayer optical film **125**. The sections **122**, **124** are sized and shaped to mate with each other, but the film **125** is interposed between their mating surfaces. The sections are bonded to each other through the film **125**, e.g. by use of an optically clear adhesive, an optical cement, or by other suitable means. The film **125** may also be designed so that, when it is heated, the outer layers thereof can melt without melting or destroying the interior microlayers (discussed below) that provide the film with its partial reflectivity, and the melted outer layers can then bond the film **125** to the lens sections **122**, **124**. The film **125** may, for example, have optically thick outer skin layers made of a polymer material whose melting temperature, softening temperature, and/or glass transition temperature is lower than that of the microlayers in the film, and/or lower than the clearing temperature of the film **125**, where the clearing temperature refers to the temperature at which the film **125** significantly and irreversibly

changes its reflectivity due to excessive heat exposure. The film **125** is thus sandwiched between the first and second lens sections and embedded in the lens, except for the outermost edges of the film **125** which may be exposed to the outside environment.

The first and second lens sections each have a smooth surface which forms part of the first optical surface **120a**. That is, the first lens section **122** has a smooth surface **122a**, and the second lens section **124** has a smooth surface **124a**. These smooth surfaces **122a**, **124a** are not randomly or arbitrarily shaped or oriented with respect to each other; rather, they are coordinated with each other to follow a same contour shape, such shape being the shape of the first optical surface **120a**, e.g., concave with a given curvature or curvature distribution, or convex with a given curvature or curvature distribution, or flat. Inspection of FIG. 1 reveals that the smooth surfaces **122a**, **124a** do not actually meet or touch each other, but, due to the presence of the multilayer optical film **125** between the lens sections **122**, **124**, are separated by an extended terminus or edge **125t1** of the film **125**. The extended terminus resides at or near the first optical surface **120a**, within the clear aperture of the lens **120** and directly in the path of incident light rays. This is a consequence of the optical film **125** being oriented at a substantial oblique angle relative to the optical axis of the lens **120**. For purposes of FIG. 1, the film **125** is assumed to be planar (or approximately planar) and the first optical surface **120a** is assumed to be convex, which results in the extended terminus **125t1** being arc-shaped when viewed along the optical axis of the lens **120**.

The lens sections **122**, **124** may be made of any suitable light-transmissive optical material, for example, an optically clear polymer such as a polycarbonate, an acrylate such as polymethylmethacrylate (PMMA), a cyclic polyolefin copolymer and/or a cyclic polyolefin polymer, or a silicone, or an optical glass or ceramic such as a soda lime glass, a borosilicate glass, silica, or sapphire. Typically, the sections **122**, **124** are composed of the same or similar optical material, and have the same or similar refractive index. In some cases, however, the sections **122**, **124** be composed of substantially different optical materials and may have substantially different refractive indices, or substantially the same refractive indices with some material combinations. The refractive index of each section is typically isotropic rather than birefringent.

The multilayer optical film **125** includes a plurality of polymer layers whose optical thicknesses are small enough, whose refractive indices are different enough along at least one axis, and whose arrangement into one or more stacks or packets of layers, is such that they cooperate with each other to selectively reflect light by constructive or destructive interference. The selective reflection allows some light, e.g., visible light from the imaging device **130**, to be reflected so the user can perceive the projected view, while simultaneously allowing other light, e.g. a complementary spectrum or complementary polarization state of visible light from remote objects on the opposite side of the lens, to be transmitted so the user can perceive the world view. More description of suitable multilayer optical films is provided further below, but it is also worth noting that at least some, and in some cases all or substantially all, of the polymer layers within the one or more stacks or packets of layers are birefringent. Such birefringence is typically the result of stretching or otherwise orienting a layered extrudate after casting, in one or both in-plane directions of the film.

The multilayer optical film **125** terminates at or near the outer boundaries or surfaces of the lens **120**. Due to the film's skewed or tilted orientation with respect to the lens **120** or its optical axis, the film **125** terminates at an edge or terminus **125t1** at the first optical surface **120a**. The terminus **125t1** separates the smooth surface **122a** from the smooth surface **124a**. At the second optical surface **120b**, the film **125** may also terminate at an edge or terminus **125t2**. The terminus **125t2** separates another smooth surface of the section **122** from another smooth surface of the section **124**. The terminuses **125t1**, **125t2**, or at least large portions thereof, lie well within the active areas or apertures of the respective optical surfaces **120a**, **120b**, and because of this they have the potential to substantially distort or otherwise degrade the optical performance of the lens **120**. Any defects along the film terminus (referred to herein as edge defects), such as film breaks, film cracks, or film delaminations, can refract or otherwise redirect light to propagate in directions that differ from the direction that would be imparted by the undistorted or undisturbed optical surface, thus distorting or degrading optical performance, e.g. introducing an extended line of distortion in the world view as seen through the lens **120**. Because of the sensitivity of the lens **120** to edge defects of the multilayer optical film, the film **125** may be cut, polished, and/or otherwise processed in such a way as to reduce the number of such edge defects, and to ensure the defects, if any, are physically small enough to keep any optical degradation or distortion to a manageable level. This aspect of the multilayer optical film **125** is also discussed further below.

The imaging device **130** may be or comprise an OLED display, a transmissive liquid crystal display, a reflective LC display (such as, for example, a Liquid Crystal on Silicon (LCoS) display), or a scanned laser device. The device **130** and the multilayer optical film **125** may be designed or selected so that they have matching or substantially matching optical characteristics to enhance system efficiency, i.e., so that the film **125** provides a high reflectivity of light from the device **130** while also providing a high transmission of light from remote objects. Thus, the device **130** may emit polarized light, and the film **125** may then be tailored to have a high reflectivity for that polarization state and a low reflectivity (and high transmission) for light of the orthogonal polarization state. Alternatively or in addition, the device **130** may emit light selectively in one or more narrow bands (e.g., it may emit light in only one narrow band, such as in the red, green, or blue region of the spectrum, or it may emit light in two or three such narrow bands that do not substantially overlap), and the film may then be tailored to have a high reflectivity only in the narrow band or bands being emitted by the device **130**.

Lenses and imaging devices such as those of FIG. 1 can be incorporated into Near-Eye Displays or similar optical systems as discussed above. An example of such a system is shown schematically in FIGS. 2A and 2B. There, eyewear **210** incorporates a left lens **220** and a right lens **240**, which may be the same as or similar to lens **120** of FIG. 1. The eyewear **210** provides a Near-Eye Display (projected view) while also allowing the user to see remote objects in a world view. The lenses **220**, **240** are held in place in front of a user's eyes **202**, **203**, respectively, by an eyewear frame **212**. The frame **212** may also provide a mounting structure for left and right imaging devices **230**, **250** respectively, which can be energized to direct imaging light toward the left and right lenses, respectively, the imaging light being reflected by the associated multilayer optical film to provide projected views to the left and right eyes.

The eyewear **210** is shown in the context of a Cartesian x-y-z coordinate system, where the user's eyes are assumed to lie along an axis parallel to the x-axis, and the lenses are assumed to be oriented such that their optical axes each extend parallel to the z-axis.

Each lens has first and second opposed optical surfaces connected by a circumferential surface.

5 Thus, left lens **220** has first and second opposed optical surfaces **220a**, **220b**, respectively, connected by a circumferential surface **220c**, and right lens **240** has first and second opposed optical surfaces **240a**, **240b**, respectively, connected by a circumferential surface **240c**. The curvatures of the optical surfaces, together with the refractive indices of the lens materials, determine the optical powers of the lenses. Each lens is also assumed to have an optical axis, see axes **221**, **241** for the lenses **220**, **240** respectively, about
10 which the optical surfaces of the lens may have rotational symmetry.

Each lens **220**, **240** comprises an embedded multilayer optical film that operates as a beamsplitter, as discussed in connection with lens **120**. Each lens also has a 2-part construction, having two distinct lens sections shaped to mate with each other, with the multilayer optical film embedded in between. Thus, lens **220** is made up of a first lens section **222**, a second lens section **224**, and a multilayer
15 optical film **225**. The sections **222**, **224** are sized and shaped to mate with each other, but the film **225** is interposed between their mating surfaces, and the sections are bonded to each other through the film **225**. Lens **240** is likewise made up of a first lens section **242**, a second lens section **244**, and a multilayer optical film **245**. The sections **242**, **244** are sized and shaped to mate with each other, but the film **245** is interposed between their mating surfaces, and the sections are bonded to each other through the film **245**.
20 Due to the off-axis placement of the imaging devices, the multilayer optical films **225**, **245** are skewed or tilted with respect to the optical axes of their respective lenses in order to direct the imaging light appropriately to the respective eye of the user. In the figure, a normal (orthogonal) axis **225x** is perpendicular to the plane of the multilayer optical film **225**, and a normal (orthogonal) axis **245x** is perpendicular to the plane of the multilayer optical film **245**. These axes are tilted relative to the optical
25 axis of their respective lens as shown in the figure.

Regarding the left lens **220**, the first and second lens sections **222**, **224** have smooth outer surfaces that are shaped and configured to collectively follow a same contour shape, such shape being the shape of the first optical surface **220a**. In this embodiment, the first optical surface **220a** is convex. Due to the amount of tilt between the normal axis **225x** and the lens optical axis **221**, the multilayer optical
30 film **225** has an extended terminus **225t1** which resides at or near the first optical surface **220a**, and separates the smooth outer surfaces of the lens sections **222**, **224**. The first and second lens sections **222**, **224** also have smooth inner surfaces that are shaped and configured to collectively follow a same contour shape, such shape being the shape of the second optical surface **220b**. In this embodiment, the second optical surface **220b** is concave. The multilayer optical film **225** has an extended terminus **225t2** which
35 resides at or near the second optical surface **220b**, and separates the smooth inner surfaces of the lens sections **222**, **224**. The second optical surface **220b** may have the same curvature as the first optical surface **220a** or a different curvature; if they are the same, the lens **220** may have zero optical power.

The right lens **240** may have a construction which is an exact or approximate mirror image of the left lens **220**. If they are approximate mirror images of each other, they may have different optical powers and different curvatures of their respective optical surfaces, just as the lenses in conventional eyeglasses often have different optical powers to make up for differences in the optical prescription of the user's left and right eyes.

Thus, the first and second lens sections **242**, **244** of the right lens **240** have smooth outer surfaces that are shaped and configured to collectively follow a same contour shape, such shape being the shape of the first optical surface **240a**. In this embodiment, the first optical surface **240a** is convex. The multilayer optical film **245** has an extended terminus **245t1** which resides at or near the first optical surface **240a**, and separates the smooth outer surfaces of the lens sections **242**, **244**. The first and second lens sections **242**, **244** also have smooth inner surfaces that are shaped and configured to collectively follow a same contour shape, such shape being the shape of the second optical surface **240b**. In this embodiment, the second optical surface **240b** is concave. The multilayer optical film **245** has an extended terminus **245t2** which resides at or near the second optical surface **240b**, and separates the smooth inner surfaces of the lens sections **242**, **244**. The second optical surface **240b** may have the same curvature as the first optical surface **240a** or a different curvature; if they are the same curvature, the lens **240** may have zero optical power.

The imaging devices **230**, **250** may be the same as or similar to the imaging device **130** discussed previously to maximize or enhance system efficiency. They may be tailored or selected to match or substantially match optical characteristics, such as polarization and/or wavelength characteristics, of their respective multilayer optical films **225**, **245**, as discussed above.

The eyewear **210** is shown in the context of light that provides the user with a world view (FIG. 2A) and light that provides the user with a projected view (FIG. 2B). In FIG. 2A, light **204a** from a remote object impinges on the left lens **220**, striking the first optical surface **220a**. Some of this light passes through the lens, exiting the second optical surface **220b** and entering the eye **202** as light **204b**. At least some of the light that passes through the lens **220** is transmitted by the multilayer optical film **225**, but at least some may not pass through the film **225** but instead may completely avoid the film **225** yet pass through the lens **220** by following a path that leads from the first optical surface **220a** to the second optical surface **220b** without traversing the film **225**. Note that some of the light **204a** may undergo Fresnel reflection at the first optical surface **220a**, and some may be reflected, rather than transmitted, by the multilayer optical film **225**. The right lens **240** may operate similarly to the left lens **220**. Thus, light **205a** from the remote object impinges on the right lens **240**, striking the first optical surface **240a**. Some of this light passes through the lens, exiting the second optical surface **240b** and entering the eye **203** as light **205b**. At least some of the light that passes through the lens **240** is transmitted by the multilayer optical film **245**, but at least some may not pass through the film **245** but instead may completely avoid the film **245** yet pass through the lens **240** by following a path that leads from the first optical surface **240a** to the second optical surface **240b** without traversing the film **245**.

Some of the light **205a** may undergo Fresnel reflection at the first optical surface **240a**, and some may be reflected, rather than transmitted, by the multilayer optical film **245**.

In FIG. 2B, the eyewear **210** is shown in the context of light that provides the user with a projected view, which is superimposed on the world view. Here, the imaging devices **230**, **250** are energized and controlled to emit imaging light **232a**, **252a** respectively, towards the lenses **220**, **240**, respectively. At least some of this light enters the lens through the second optical surface (see surfaces **220b** and **240b**) and is reflected by the multilayer optical film (film **225** and film **245**) without reaching the first optical surface (see surfaces **220a** and **240a**), whereupon the light exits the lens through the second optical surface (see surfaces **220b** and **240b**) and enters the eye (see eye **202** and eye **203**) as light **232b** and **252b**, respectively.

As mentioned above, the embedded multilayer optical film in the disclosed lenses includes a plurality of polymer layers whose optical thicknesses are small enough, whose refractive indices are different enough along at least one axis, and whose arrangement into one or more stacks or packets of layers, is such that they cooperate with each other to selectively reflect light by constructive or destructive interference. Information on suitable or potentially suitable multilayer optical films can be found in: U.S. Patent 5,486,949 (Schrenk et al.) "Birefringent Interference Polarizer"; U.S. Patent 5,882,774 (Jonza et al.) "Optical Film"; U.S. Patent 6,045,894 (Jonza et al.) "Clear to Colored Security Film"; U.S. Patent 6,179,948 (Merrill et al.) "Optical Film and Process for Manufacture Thereof"; U.S. Patent 6,531,230 (Weber et al.) "Color Shifting Film"; U.S. Patent 6,939,499 (Merrill et al.) "Processes and Apparatus for Making Transversely Drawn Films with Substantially Uniaxial Character"; U.S. Patent 7,256,936 (Hebrink et al.) "Optical Polarizing Films with Designed Color Shifts"; U.S. Patent 7,316,558 (Merrill et al.) "Devices for Stretching Polymer Films"; PCT Publication WO 2008/144136 A1 (Nevitt et al.) "Lamp-Hiding Assembly for a Direct Lit Backlight"; PCT Publication WO 2008/144656 A2 (Weber et al.) "Backlight and Display System Using Same". For convenience, we summarize in connection with FIGS. 3 and 4 some relevant aspects of suitable multilayer optical films that may be useful in the disclosed lenses.

Figure 3 shows a schematic view of a typical multilayer optical film **325** in relation to its own Cartesian x' - y' - z' coordinate system, where the film **325** extends parallel to the x' - and y' -axes, and the z' -axis is perpendicular to the film and its constituent layers, and parallel to a thickness axis of the film. The film **325** need not be entirely flat, but may be curved or otherwise shaped to deviate from a plane, and even in those cases arbitrarily small portions or regions of the film can be associated with a local Cartesian coordinate system as shown.

The multilayer optical film **325** is partially reflective and partially light transmissive. In general, of course, transmission (T) plus reflection (R) plus absorption (A) equals one hundred percent, or $T + R + A = 100\%$. In exemplary embodiments, the film **325** is composed entirely of materials that have a low absorption over the wavelength spectrum of interest, e.g., over the visible spectrum. In such cases, the reflection and transmission over that spectral range take on a complementary relationship because $T + R = 100\% - A$, and since A is small, $T + R \approx 100\%$. For such films, high reflectivity (e.g. at a given

wavelength or for a given polarization state) is associated with low transmission, and low reflectivity is associated with high transmission.

Multilayer optical films include individual layers having different refractive indices so that some light is reflected at interfaces between adjacent layers. These layers, sometimes referred to as “microlayers”, are sufficiently thin so that light reflected at a plurality of the interfaces undergoes constructive or destructive interference to give the multilayer optical film the desired reflective or transmissive properties. For multilayer optical films designed to reflect light at ultraviolet, visible, or near-infrared wavelengths, each microlayer generally has an optical thickness (a physical thickness multiplied by refractive index) of less than about 1 μm . However, thicker layers can also be included, such as skin layers at the outer surfaces of the multilayer optical film, or protective boundary layers (PBLs) disposed within the multilayer optical film to separate coherent groupings (known as “stacks” or “packets”) of microlayers. In FIG. 3, the microlayers are labeled “A” or “B”, the “A” layers being composed of one material and the “B” layers being composed of a different material, these layers being stacked in an alternating arrangement to form optical repeat units or unit cells ORU 1, ORU 2, ... ORU 6 as shown. Typically, a multilayer optical film composed entirely of polymeric materials would include many more than 6 optical repeat units if high reflectivities are desired. The substantially thicker layer at the bottom of the figure can represent an outer skin layer, or a PBL that separates the stack of microlayers shown in the figure from another stack or packet of microlayers (not shown). If desired, two or more separate multilayer optical films can be laminated together, e.g. with one or more thick adhesive layers, or using pressure, heat, or other methods to form a laminate or composite film.

With regard to adjacent microlayers within a stack of the multilayer optical film, we refer to the refractive indices of one of the microlayers (e.g. the “A” layers in FIG. 3) for light polarized along principal x' -, y' -, and z' -axes such as those shown in FIG. 3 as n_{1x} , n_{1y} , and n_{1z} , respectively. We refer to the refractive indices of the adjacent microlayer (e.g. the “B” layers in FIG. 3) along the same axes as n_{2x} , n_{2y} , n_{2z} , respectively. A layer of the multilayer optical film **325**, or any material, is considered to be “birefringent” if the material has an anisotropic dielectric tensor over a wavelength range of interest, e.g., a selected wavelength or band in the UV, visible, and/or infrared portions of the spectrum. Stated differently, a material or layer is considered to be “birefringent” if the principal refractive indices of the material (e.g., n_{1x} , n_{1y} , n_{1z}) are not all the same. At least some of the microlayers in at least one packet of the multilayer optical film **325** are birefringent, and in some cases, all or substantially all of the microlayers in the film **325** or in a packet thereof may be birefringent. With regard to any two adjacent microlayers in a packet (either or both of which may or may not be birefringent), we refer to differences in their respective refractive indices as Δn_x ($= n_{1x} - n_{2x}$) along the x' -direction, Δn_y ($= n_{1y} - n_{2y}$) along the y' -direction, and Δn_z ($= n_{1z} - n_{2z}$) along the z' -direction. The nature of these refractive index differences, in combination with the number of microlayers in the film (or in a given stack of the film) and their thickness distribution, controls the reflective and transmissive characteristics of the film (or of the given stack of the film) in a given zone.

For example, if adjacent microlayers have a large refractive index mismatch along one in-plane direction (Δn_x large) and a small refractive index mismatch along the orthogonal in-plane direction ($\Delta n_y \approx 0$), the film or packet may behave as a reflective polarizer for normally incident light. Alternatively, if adjacent microlayers have a large refractive index mismatch along both in-plane axes (Δn_x large and Δn_y large), the film or packet may behave as an on-axis mirror. The optical wavelength band(s) over which the reflective polarizer or mirror reflects normally incident light is tailored by tailoring the layer thickness gradient of the microlayer stack. For obliquely incident light, the reflectivity of each interface between adjacent microlayers is influenced by the refractive indices of the microlayers along the z' -axis, i.e., along the thickness axis of the film **325**. By appropriate materials selection of the microlayers, adjacent microlayers can be made to exhibit a refractive index match ($\Delta n_z \approx 0$) or mismatch (Δn_z large) along the z -axis, and the mismatch Δn_z may in some cases be of the same polarity or sign as the in-plane refractive index mismatch(es), while in other cases the mismatch Δn_z may be of the opposite polarity or sign as the in-plane refractive index mismatch(es). Such tailoring of Δn_z plays a key role in whether the reflectivity of the p-polarized component of obliquely incident light increases, decreases, or remains the same with increasing incidence angle.

In some cases, the microlayers can have thicknesses and refractive index values corresponding to a $\frac{1}{4}$ -wave stack, i.e., arranged in optical repeat units each having two adjacent microlayers of equal optical thickness (f-ratio = 50%, the f-ratio being the ratio of the optical thickness of a constituent layer "A" to the optical thickness of the complete optical repeat unit), such optical repeat unit being effective to reflect by constructive interference light whose wavelength λ is twice the overall optical thickness of the optical repeat unit. In other cases, the optical thickness of the microlayers in an optical repeat unit may be different from each other, whereby the f-ratio is greater than or less than 50%. In the embodiment of FIG. 3, the "A" layers are depicted for generality as being thinner than the "B" layers. Each depicted optical repeat unit (ORU 1, ORU 2, etc.) has an optical thickness (OT_1 , OT_2 , etc.) equal to the sum of the optical thicknesses of its constituent "A" and "B" layer, and each optical repeat unit reflects light whose wavelength λ is twice its overall optical thickness.

In some embodiments, the optical thicknesses of the optical repeat units in a layer stack may all be equal to each other, to provide a narrow reflection band of high reflectivity centered at a wavelength equal to twice the optical thickness of each optical repeat unit. A depiction of this is shown in the idealized graph of FIG. 4A, where curve **402** is a reflectivity spectrum of a multilayer optical film or microlayer packet thereof, the spectrum having a strong, narrow reflection band **402a** in the green region of the visible wavelength spectrum. The reflection spectrum of a film containing three such packets, that differ in average layer thickness, is shown in FIG. 4B, where the curve **404** is an idealized reflectivity spectrum having strong, narrow reflection bands in the red (band **404c**), green (band **404b**), and blue (band **404a**) region of the visible spectrum.

In other embodiments, the optical thicknesses of the optical repeat units may differ according to a thickness gradient along the z -axis or thickness direction of the film, whereby the optical thickness of the

optical repeat units increases, decreases, or follows some other functional relationship as one progresses from one side of the stack (e.g. the top) to the other side of the stack (e.g. the bottom). Such thickness gradients can be used to provide a widened reflection band to provide substantially spectrally flat transmission and reflection of light over the extended wavelength band of interest, and also over all angles of interest. A depiction of this is shown in the idealized graph of FIG. 4C, where curve **406** extends broadly over the visible wavelength spectrum. In a variation of this approach, the layer thickness profile may be tailored to provide high reflectivity over a broad range of wavelengths but a low reflectivity, and high transmission, in one or more narrow transmission bands, e.g. in the red, green, and/or blue regions of the visible spectrum. Multilayer optical films that provide one or more such narrow transmission bands, or one or more narrow reflection bands (see FIGS. 4A and 4B), are referred to herein as notched reflectors or notched filters.

The spectral reflectivity characteristics described in the foregoing paragraphs, including those shown in FIGS. 4A through 4C, may be a feature of a multilayer optical film that reflects all polarizations, or of a multilayer optical film that reflects one polarization state and transmits the orthogonal polarization state. For example, a notched filter may be substantially polarization insensitive, reflecting two orthogonal polarization states within the reflection band(s) at normal incidence or at a design angle of incidence, or it may be polarization sensitive, reflecting only one polarization state and transmitting the orthogonal polarization state within the reflection band(s).

Thickness gradients tailored to sharpen the band edges at the wavelength transition between high reflection and high transmission can also be used, as discussed in U.S. Patent 6,157,490 (Wheatley et al.) "Optical Film With Sharpened Bandedge". For polymeric multilayer optical films, reflection bands can be designed to have sharpened band edges as well as "flat top" reflection bands, in which the reflection properties are essentially constant across the wavelength range of application. Other layer arrangements, such as multilayer optical films having 2-microlayer optical repeat units whose f-ratio is different from 50%, or films whose optical repeat units include more than two microlayers, are also contemplated. These alternative optical repeat unit designs can be configured to reduce or to excite certain higher-order reflections, which may be useful if the desired reflection band resides in or extends to near infrared wavelengths. *See, e.g.,* U.S. Patents 5,103,337 (Schrenk et al.) "Infrared Reflective Optical Interference Film", 5,360,659 (Arends et al.) "Two Component Infrared Reflecting Film", 6,207,260 (Wheatley et al.) "Multicomponent Optical Body", and 7,019,905 (Weber) "Multi-layer Reflector With Suppression of High Order Reflections".

Exemplary multilayer optical films **325** are composed of polymer materials and may be fabricated using coextruding, casting, and orienting processes. Reference is made to U.S. Patent 5,882,774 (Jonza et al.) "Optical Film", U.S. Patent 6,179,948 (Merrill et al.) "Optical Film and Process for Manufacture Thereof", and 6,783,349 (Neavin et al.) "Apparatus for Making Multilayer Optical Films". The multilayer optical film may be formed by coextrusion of the polymers as described in any of the aforementioned references. The polymers of the various layers are preferably chosen to have similar rheological properties, e.g., melt viscosities, so that they can be co-extruded without significant flow

disturbances. Extrusion conditions are chosen to adequately feed, melt, mix, and pump the respective polymers as feed streams or melt streams in a continuous and stable manner. Temperatures used to form and maintain each of the melt streams may be chosen to be within a range that avoids freezing, crystallization, or unduly high pressure drops at the low end of the temperature range, and that avoids material degradation at the high end of the range.

In brief summary, the fabrication method may comprise: (a) providing at least a first and a second stream of resin corresponding to the first and second polymers to be used in the finished film; (b) dividing the first and the second streams into a plurality of layers using a suitable feedblock, such as one that comprises: (i) a gradient plate comprising first and second flow channels, where the first channel has a cross-sectional area that changes from a first position to a second position along the flow channel, (ii) a feeder tube plate having a first plurality of conduits in fluid communication with the first flow channel and a second plurality of conduits in fluid communication with the second flow channel, each conduit feeding its own respective slot die, each conduit having a first end and a second end, the first end of the conduits being in fluid communication with the flow channels, and the second end of the conduits being in fluid communication with the slot die, and (iii) optionally, an axial rod heater located proximal to said conduits; (c) passing the composite stream through an extrusion die to form a multilayer web in which each layer is generally parallel to the major surface of adjacent layers; and (d) casting the multilayer web onto a chill roll, sometimes referred to as a casting wheel or casting drum, to form a cast multilayer film. This cast film may have the same number of layers as the finished film, but the layers of the cast film are typically much thicker than those of the finished film. Furthermore, the layers of the cast film are typically all isotropic.

Many alternative methods of fabricating the cast multilayer web can also be used. One such alternative method that also utilizes polymer coextrusion is described in U.S. Patent 5,389,324 (Lewis et al.).

After cooling, the multilayer web can be drawn or stretched to produce the near-finished multilayer optical film, details of which can be found in the references cited above. The drawing or stretching accomplishes two goals: it thins the layers to their desired final thicknesses, and it orients the layers such that at least some of the layers become birefringent. The orientation or stretching can be accomplished along the cross-web direction (e.g. via a tenter), along the down-web direction (e.g. via a length orienter), or any combination thereof, whether simultaneously or sequentially. If stretched along only one direction, the stretch can be "unconstrained" (wherein the film is allowed to dimensionally relax in the in-plane direction perpendicular to the stretch direction) or "constrained" (wherein the film is constrained and thus not allowed to dimensionally relax in the in-plane direction perpendicular to the stretch direction). If stretched along both in-plane directions, the stretch can be symmetric, i.e., equal along the orthogonal in-plane directions, or asymmetric. Alternatively, the film may be stretched in a batch process. In any case, subsequent or concurrent draw reduction, stress or strain equilibration, heat setting, and other processing operations can also be applied to the film.

The multilayer optical film **325** can also include additional layers and coatings, and other additives, selected for their optical, mechanical, and/or chemical properties. For example, a UV absorbing layer can be added at one or both major outer surfaces of the film. *See, e.g.,* U.S. Patent 6,368,699 (Gilbert et al.).

5 The selective reflection provided by the multilayer optical film **325** allows some light, e.g., visible light from the imaging device, to be reflected so the user can perceive the projected view, while simultaneously allowing other light, e.g. a complementary spectrum or complementary polarization state of visible light from remote objects on the opposite side of the lens, to be transmitted so the user can perceive the world view.

10 The lenses and systems described herein can have a variety of configurations and features. Figures 5A through 15 schematically depict some of these configurations and features.

Figures 5A through 5C depict various systems in which an imaging device injects imaging light into a lens having an embedded multilayer optical film. In these figures, two imaging devices are shown to illustrate different possible placements or orientations of the imaging device relative to the lens.

15 Design aspects of the lenses may be the same as or similar to the lens **120** of FIG. 1, except as noted, and design aspects of the imaging devices may be the same as or similar to the imaging device **130** of FIG. 1, except as noted.

In FIG. 5A, a system **510a** includes a lens **520** and imaging devices **530**, **534**. The lens **520** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has first and second opposed optical surfaces **520a**, **520b**, and a circumferential surface **520c** that connects the optical surfaces. The lens **520** also includes a first lens section **522**, a second lens section **524**, and a multilayer optical film **525**. The film **525** is sandwiched between mating surfaces of the lens sections **522**, **524**, which may attach to each other through the film **525**. The first lens section **522** has first and second smooth surfaces **522a**, **522b**, and the second lens section **524** has first and second smooth surfaces **524a**, **524b**. The first optical surface **520a** of the lens is convex and includes the first smooth surfaces **522a**, **524a**. The second optical surface **520b** of the lens is also convex and includes the second smooth surfaces **522b**, **524b**. The multilayer optical film **525** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **525** intersects both the first optical surface **520a** and the second optical surface **520b**. At the first optical surface, the film **525** terminates along an extended terminus **525t1**, which separates the first smooth surface **522a** from the first smooth surface **524a**. At the second optical surface, the film **525** terminates along an extended terminus **525t2**, which separates the second smooth surface **522b** from the second smooth surface **524b**. The imaging device may be positioned to inject imaging light into the lens through the first optical surface **520a** (see imaging device **530**), or it may be positioned to inject imaging light through the circumferential surface **520c** (see imaging device **534**). In either case, the multilayer optical film **525** reflects some of the imaging light out through the first optical surface **520a** to an eye of the user.

In FIG. 5B, a system **510b** includes a lens **540** and imaging devices **550**, **554**. The lens **540** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has first and second opposed optical surfaces **540a**, **540b**, and a circumferential surface **540c** that connects the optical surfaces. The lens **540** also includes a first lens section **542**, a second lens section **544**, and a multilayer optical film **545**. The film **545** is sandwiched between mating surfaces of the lens sections **542**, **544**, which may attach to each other through the film **545**. The first lens section **542** has a first smooth surface **542a**, and the second lens section **544** has first and second smooth surfaces **544a**, **544b**. The first optical surface **540a** of the lens is convex and includes the first smooth surfaces **542a**, **544a**. The second optical surface **540b** of the lens is also convex and coincides with the second smooth surface **544b**. The multilayer optical film **545** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **545** intersects the first optical surface **540a** and the circumferential surface **540c**, but not the second optical surface **540b**. At the first optical surface, the film **545** terminates along an extended terminus **545t1**, which separates the first smooth surface **542a** from the first smooth surface **544a**. The imaging device may be positioned to inject imaging light into the lens through the first optical surface **540a** (see imaging device **550**), or it may be positioned to inject imaging light through the circumferential surface **540c** (see imaging device **554**). In either case, the multilayer optical film **545** reflects some of the imaging light out through the first optical surface **540a** to an eye of the user.

In FIG. 5C, a system **510c** includes a lens **560** and imaging devices **570**, **574**. The lens **560** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has first and second opposed optical surfaces **560a**, **560b**, and a circumferential surface **560c** that connects the optical surfaces. The lens **560** also includes a first lens section **562**, a second lens section **564**, and a multilayer optical film **565**. The film **565** is sandwiched between mating surfaces of the lens sections **562**, **564**, which may attach to each other through the film **565**. The first lens section **562** has first and second smooth surfaces **562a**, **562b**, and the second lens section **524** has a second smooth surface **564b**. The first optical surface **560a** of the lens is convex and coincides with the first smooth surface **562a**. The second optical surface **560b** of the lens is also convex and includes the second smooth surfaces **562b**, **564b**. The multilayer optical film **565** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **565** intersects both the second optical surface **560b** and the circumferential surface **560c**, but not the first optical surface **560a**. At the second optical surface, the film **565** terminates along an extended terminus **565t2**, which separates the second smooth surface **562b** from the second smooth surface **564b**. The imaging device may be positioned to inject imaging light into the lens through the first optical surface **560a** (see imaging device **570**), or it may be positioned to inject imaging light through the circumferential surface **560c** (see imaging device **574**). In either case, the multilayer optical film **565** reflects some of the imaging light out through the first optical surface **560a** to an eye of the user.

Figure 6 depicts a system which uses a folded optical path for the imaging light. In this figure, a system **610a** includes a lens **620** and imaging devices **630**, **634**. The lens **620** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has first and second opposed optical surfaces **620a**, **620b**, and a circumferential surface **620c** that connects the optical surfaces. The lens **620** also includes a first lens section **622**, a second lens section **624**, and a multilayer optical film **625**. The film **625** is sandwiched between mating surfaces of the lens sections **622**, **624**, which may attach to each other through the film **625**. The first lens section **622** has first and second smooth surfaces **622a**, **622b**, and the second lens section **624** has first and second smooth surfaces **624a**, **624b**. The first optical surface **620a** of the lens is convex and includes the first smooth surfaces **622a**, **624a**. The second optical surface **620b** of the lens is also convex and includes the second smooth surfaces **622b**, **624b**. The multilayer optical film **625** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **625** intersects both the first optical surface **620a** and the second optical surface **620b**. At the first optical surface, the film **625** terminates along an extended terminus **625t1**, which separates the first smooth surface **622a** from the first smooth surface **624a**. At the second optical surface, the film **625** terminates along an extended terminus **625t2**, which separates the second smooth surface **622b** from the second smooth surface **624b**. The imaging device may be positioned to inject imaging light into the lens through the second optical surface **620b** (see imaging device **630**), or it may be positioned to inject imaging light through the circumferential surface **620c** (see imaging device **634**). In either case, the multilayer optical film **625** is oriented to reflect some of the imaging light to the second optical surface **620b** where it is partially reflected, then partially transmitted back through the film **625**, and exits the lens **620** through the first optical surface **620a** to an eye of the user. If desired, a partial reflector such as a thin partially transparent metal layer, a dielectric layer having a different refractive index than the surrounding media, and/or a partially reflective dielectric stack comprising multiple layers of high and low refractive index materials, can be disposed on at least a part of the second optical surface **620b** to increase the reflectivity of the imaging light while also allowing light from remote objects to pass through the lens **620**.

Figures 7 through 9 show still more lens configurations. In FIG. 7, a lens **720** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has first and second opposed optical surfaces **720a**, **720b**, and a circumferential surface **720c** that connects the optical surfaces. The lens **720** also includes a first lens section **722**, a second lens section **724**, and a multilayer optical film **725**. The film **725** is sandwiched between mating surfaces of the lens sections **722**, **724**, which may attach to each other through the film **725**. The first lens section **722** has first and second smooth surfaces **722a**, **722b**, and the second lens section **724** has first and second smooth surfaces **724a**, **724b**. The first optical surface **720a** of the lens is flat and includes the first smooth surfaces **722a**, **724a**. The second optical surface **720b** of the lens is convex and includes the second smooth surfaces **722b**, **724b**. The multilayer optical film **725** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z

coordinate system. The amount of tilt or rotation is such that the film **725** intersects both the first optical surface **720a** and the second optical surface **720b**. At the first optical surface, the film **725** terminates along an extended terminus **725t1**, which separates the first smooth surface **722a** from the first smooth surface **724a**. At the second optical surface, the film **725** terminates along an extended terminus **725t2**, which separates the second smooth surface **722b** from the second smooth surface **724b**. An imaging device (not shown) may be positioned to inject imaging light into the lens through the first optical surface **720a**, or it may be positioned to inject imaging light through the circumferential surface **720c**. In either case, the multilayer optical film **725** reflects some of the imaging light out through the first optical surface **720a** to an eye of the user.

In FIG. 8, a lens **820** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has first and second opposed optical surfaces **820a**, **820b**, and a circumferential surface **820c** that connects the optical surfaces. The lens **820** also includes a first lens section **822**, a second lens section **824**, and a multilayer optical film **825**. The film **825** is sandwiched between mating surfaces of the lens sections **822**, **824**, which may attach to each other through the film **825**. The first lens section **822** has first and second smooth surfaces **822a**, **822b**, and the second lens section **824** has first and second smooth surfaces **824a**, **824b**. The first optical surface **820a** of the lens is flat and includes the first smooth surfaces **822a**, **824a**. The second optical surface **820b** of the lens is concave and includes the second smooth surfaces **822b**, **824b**. The multilayer optical film **825** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **825** intersects both the first optical surface **820a** and the second optical surface **820b**. At the first optical surface, the film **825** terminates along an extended terminus **825t1**, which separates the first smooth surface **822a** from the first smooth surface **824a**. At the second optical surface, the film **825** terminates along an extended terminus **825t2**, which separates the second smooth surface **822b** from the second smooth surface **824b**. An imaging device (not shown) may be positioned to inject imaging light into the lens through the first optical surface **820a**, or it may be positioned to inject imaging light through the circumferential surface **820c**. In either case, the multilayer optical film **825** reflects some of the imaging light out through the first optical surface **820a** to an eye of the user.

In FIG. 9, a compound lens **900** includes a lens **920** cemented or otherwise joined to another lens **940**. The lens **920**, as well as the compound lens **900** and the other lens **940**, has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens **920** has first and second opposed optical surfaces **920a**, **920b**, and a circumferential surface **920c** that connects the optical surfaces. (Similarly, the lens **940** has first and second opposed optical surfaces **940a**, **940b**, and a circumferential surface **940c** that connects the optical surfaces. The first optical surface **940a** of the lens **940** is shaped to mate with the second optical surface **920b** of the lens **920**.) The lens **920** includes a first lens section **922**, a second lens section **924**, and a multilayer optical film **925**. The film **925** is sandwiched between mating surfaces of the lens sections **922**, **924**, which may attach to each other through the film **925**. The first lens section **922** has first and second smooth surfaces **922a**, **922b**, and the second lens section **924** has first and second

smooth surfaces **924a**, **924b**. The first optical surface **920a** of the lens **920** is flat and includes the first smooth surfaces **922a**, **924a**. The second optical surface **920b** of the lens **920** is convex and includes the second smooth surfaces **922b**, **924b**. The multilayer optical film **925** partially reflects and partially transmits light as described above, and lies in the $x'-y'$ plane of an $x'-y'-z'$ Cartesian coordinate system which is rotated or tilted relative to the $x-y-z$ coordinate system. The amount of tilt or rotation is such that the film **925** intersects both the first optical surface **920a** and the second optical surface **920b**. At the first optical surface, the film **925** terminates along an extended terminus **925t1**, which separates the first smooth surface **922a** from the first smooth surface **924a**. At the second optical surface, the film **925** terminates along an extended terminus **925t2**, which separates the second smooth surface **922b** from the second smooth surface **924b**. An imaging device (not shown) may be positioned to inject imaging light into the lens through the first optical surface **920a**, or it may be positioned to inject imaging light through the circumferential surface **920c**. In either case, the multilayer optical film **925** reflects some of the imaging light out through the first optical surface **920a** to an eye of the user.

Figures 10 through 12 depict front or plan views of representative lenses so that different possible shapes of the extended terminus of the multilayer optical film, as well as the outer periphery or circumference of the lens, can be better seen and discussed. In FIG. 10, a lens **1020** may be the same as or similar to lenses discussed elsewhere herein. The lens **1020** has an optical axis parallel to the z -axis of an $x-y-z$ Cartesian coordinate system. The lens **1020** has a first optical surface **1020a**, an opposed second optical surface, and a circumferential surface **1020c** that connects the optical surfaces. The circumferential surface **1020c** is substantially circular. The lens **1020** includes a first lens section, a second lens section, and a multilayer optical film sandwiched between mating surfaces of the lens sections. The first lens section has a first smooth surface **1022a**, and the second lens section also has a first smooth surface **1024a**. The first optical surface **1020a** includes the first smooth surfaces **1022a**, **1024a**. The multilayer optical film partially reflects and partially transmits light as described above, and lies in a plane that is rotated or tilted relative to the $x-y$ plane. The amount of tilt or rotation is such that the film intersects at least the first optical surface **1020a**. At the first optical surface, the film terminates along an extended terminus, which separates the first smooth surface **1022a** from the first smooth surface **1024a**. The shape and appearance of the extended terminus depends on the shape of the multilayer optical film, e.g., whether it is flat and planar or curved or otherwise non-flat, and on the shape of the first optical surface **1020a**, e.g. whether it is flat, concave, or convex. Three alternative extended terminuses are shown in the figure for the case where the multilayer optical film is flat: arc-shaped extended terminus **1025t1'** is for a case where the first optical surface **1020a** is concave, straight extended terminus **1025t1''** is for a case where the first optical surface **1020a** is flat, and arc-shaped extended terminus **1025t1'''** is for a case where the first optical surface **1020a** is convex. In cases where the shape of the multilayer optical film deviates from a flat plane, the plan view shape of the extended terminus will deviate from those depicted in FIG. 10.

Figure 11 depicts a lens **1120** that may be the same as or similar to that of FIG. 10, except that the outer periphery or circumference of the lens is substantially square or rectangular. Thus, the lens **1120**

has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens **1120** also has a first optical surface **1120a**, an opposed second optical surface, and a circumferential surface **1120c** that connects the optical surfaces. The circumferential surface **1120c** is substantially square in shape. The lens **1120** includes a first lens section, a second lens section, and a multilayer optical film sandwiched between mating surfaces of the lens sections. The first lens section has a first smooth surface **1122a**, and the second lens section also has a first smooth surface **1124a**. The first optical surface **1120a** includes the first smooth surfaces **1122a**, **1124a**. The multilayer optical film partially reflects and partially transmits light as described above, and lies in a plane that is rotated or tilted relative to the x-y plane. The amount of tilt or rotation is such that the film intersects at least the first optical surface **1120a**. At the first optical surface, the film terminates along an extended terminus, which separates the first smooth surface **1122a** from the first smooth surface **1124a**. The shape and appearance of the extended terminus depends on the shape of the multilayer optical film, e.g., whether it is flat and planar or curved or otherwise non-flat, and on the shape of the first optical surface **1120a**, e.g. whether it is flat, concave, or convex. Three alternative extended terminuses are shown in the figure for the case where the multilayer optical film is flat: arc-shaped extended terminus **1125t1'** is for a case where the first optical surface **1120a** is concave, straight extended terminus **1125t1''** is for a case where the first optical surface **1120a** is flat, and arc-shaped extended terminus **1125t1'''** is for a case where the first optical surface **1120a** is convex. In cases where the shape of the multilayer optical film deviates from a flat plane, the plan view shape of the extended terminus will deviate from those depicted in FIG. 11.

Figure 12 depicts a lens **1220** that may be the same as or similar to that of FIGS. 10 and 11, except that the outer periphery or circumference of the lens is substantially octagonal. Thus, the lens **1220** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens **1220** also has a first optical surface **1220a**, an opposed second optical surface, and a circumferential surface **1220c** that connects the optical surfaces. The circumferential surface **1220c** is substantially octagonal in shape. The lens **1220** includes a first lens section, a second lens section, and a multilayer optical film sandwiched between mating surfaces of the lens sections. The first lens section has a first smooth surface **1222a**, and the second lens section also has a first smooth surface **1224a**. The first optical surface **1220a** includes the first smooth surfaces **1222a**, **1224a**. The multilayer optical film partially reflects and partially transmits light as described above, and lies in a plane that is rotated or tilted relative to the x-y plane. The amount of tilt or rotation is such that the film intersects at least the first optical surface **1220a**. At the first optical surface, the film terminates along an extended terminus, which separates the first smooth surface **1222a** from the first smooth surface **1224a**. The shape and appearance of the extended terminus depends on the shape of the multilayer optical film, e.g., whether it is flat and planar or curved or otherwise non-flat, and on the shape of the first optical surface **1220a**, e.g. whether it is flat, concave, or convex. Three alternative extended terminuses are shown in the figure for the case where the multilayer optical film is flat: arc-shaped extended terminus **1225t1'** is for a case where the first optical surface **1220a** is concave, straight extended terminus **1225t1''** is for a case where the first optical surface **1220a** is flat, and arc-shaped extended terminus **1225t1'''** is for a case where the first optical surface **1220a** is convex. In cases

where the shape of the multilayer optical film deviates from a flat plane, the plan view shape of the extended terminus will deviate from those depicted in FIG. 12.

Figures 13 through 15 are schematic sectional views which are enlarged or magnified to show details of the optical surface of the lens in the vicinity of the extended terminus of the embedded
5 multilayer optical film. The optical surface of the lens is shown as convex, but it may alternatively be flat, or concave. In FIG. 13, a lens **1320** may be the same as or similar to lenses discussed elsewhere herein. The lens **1320** has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has a first optical surface **1320a** connected to an opposed second optical surface by a circumferential surface. The lens **1320** also includes a first lens section **1322**, a second lens section **1324**,
10 and a multilayer optical film **1325**. The film **1325** is sandwiched between mating surfaces of the lens sections **1322**, **1324**. The first lens section **1322** has a first smooth surface **1322a**, and the second lens section **1324** has a first smooth surface **1324a**. The first optical surface **1320a** of the lens is convex and includes the first smooth surfaces **1322a**, **1324a**. The multilayer optical film **1325** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate
15 system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **1325** intersects at least the first optical surface **1320a**. At the first optical surface, the film **1325** terminates along an extended terminus **1325t1**, which separates the first smooth surface **1322a** from the first smooth surface **1324a**.

The edge or terminus **1325t1** of the multilayer optical film **1325** may be cut and mechanically
20 polished to form a smooth surface disposed to be in substantial registration with the smooth surfaces **1322a**, **1324a**, such that the terminus **1325t1** also forms part of the optical surface **1320a**. The cutting and polishing is carried out carefully to avoid damaging the edge of the film **1325**, thus reducing the chance that breaks, cracks, delaminations, or other edge defects may form at or near the terminus of the film.

In FIG. 14, a lens **1420** may be the same as or similar to the lens of FIG. 13, except that the
25 terminus of the multilayer optical film lies in a notch or groove near the optical surface. The lens **1420** thus has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has a first optical surface **1420a** connected to an opposed second optical surface by a circumferential surface. The lens **1420** also includes a first lens section **1422**, a second lens section **1424**, and a multilayer optical film
30 **1425**. The film **1425** is sandwiched between mating surfaces of the lens sections **1422**, **1424**. The first lens section **1422** has a first smooth surface **1422a**, and the second lens section **1424** has a first smooth surface **1424a**. The first optical surface **1420a** of the lens is convex and includes the first smooth surfaces **1422a**, **1424a**. The multilayer optical film **1425** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted
35 relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **1425** intersects at least the first optical surface **1420a**. Near the first optical surface, the film **1425** terminates along an extended terminus **1425t1**, which lies in an extended notch or groove **1426** and separates the first smooth surface **1422a** from the first smooth surface **1424a**. The notch **1426** is typically no more than 250

microns deep, or no more than 100 microns deep, and may have a width in a range from 100 to 250 microns, but these values should be understood to be illustrative and not unduly limiting. To reduce mechanical stresses at the film terminus, the notch **1426** may be filled with a tough, clear filler material **1427** such as a hard coat material or other suitable polymer or other solid material. To reduce optical artifacts associated with the notch **1426**, the filler material **1427** may have a refractive index that matches or substantially matches the refractive index of the lens sections **1422**, **1424**. An outer surface of the filler material **1427** may be smooth and shaped to be in substantial registration with the smooth surfaces **1422a**, **1424a**, such that the outer surface of the filler material **1427** also forms part of the optical surface **1420a**. Even though the filler material **1427** is provided in the notch **1426**, it is still desirable to process the multilayer optical film **1425** to avoid damaging the edge of the film, thus reducing the chance that breaks, cracks, delaminations, or other edge defects may form at or near the terminus of the film.

In FIG. 15, a lens **1520** may be the same as or similar to the lens of FIG. 13, except that a protective coating is provided over the optical surface of the lens. The lens **1520** thus has an optical axis parallel to the z-axis of an x-y-z Cartesian coordinate system. The lens has a first optical surface **1520a** connected to an opposed second optical surface by a circumferential surface. The lens **1520** also includes a first lens section **1522**, a second lens section **1524**, and a multilayer optical film **1525**. The film **1525** is sandwiched between mating surfaces of the lens sections **1522**, **1524**. The first lens section **1522** has a first smooth surface **1522a**, and the second lens section **1524** has a first smooth surface **1524a**. The first optical surface **1520a** of the lens is convex and includes the first smooth surfaces **1522a**, **1524a**. The multilayer optical film **1525** partially reflects and partially transmits light as described above, and lies in the x'-y' plane of an x'-y'-z' Cartesian coordinate system which is rotated or tilted relative to the x-y-z coordinate system. The amount of tilt or rotation is such that the film **1525** intersects at least the first optical surface **1520a**. At the first optical surface, the film **1525** terminates along an extended terminus **1525t1**, which separates the first smooth surface **1522a** from the first smooth surface **1524a**. The edge or terminus **1525t1** of the multilayer optical film **1525** may be cut and mechanically polished to form a smooth surface disposed to be in substantial registration with the smooth surfaces **1522a**, **1524a**, such that the terminus **1525t1** also forms part of the optical surface **1520a**. The cutting and polishing is carried out carefully to avoid damaging the edge of the film **1525**, thus reducing the chance that breaks, cracks, delaminations, or other edge defects may form at or near the terminus of the film. A protective coating **1528**, such as a hard coat or other suitable polymer or other solid material, is provided over the terminus **1525t1** as well as the smooth surfaces **1522a**, **1524a**. If the coating **1528** is applied to the optical surface **1520a** as a liquid and then cured into a solid layer, it may penetrate into any breaks, cracks, delaminations, or other edge defects that may be present at the terminus **1525t1**, and may thus at least partially repair such edge defects from an optical performance standpoint.

A schematic, magnified view of a portion of a multilayer optical film in the vicinity of its extended edge or terminus is shown in FIG. 16. In that figure, a multilayer optical film **1625** may be the same as or similar to other optical films discussed herein. The film **1625** has been cut, polished, and/or otherwise processed to have an extended terminus **1625t1**, this terminus desirably being situated at or

near an optical surface of a lens. The film **1625** is assumed to lie in an $x'-y'$ plane of a Cartesian $x'-y'-z'$ coordinate system, which coordinate system is rotated or tilted relative to a coordinate system aligned with the optical axis of the lens. Several idealized edge defects **1625-1**, **1625-2**, **1625-3**, and **1625-4** are shown in the figure, which defects may be or include breaks, cracks, or delaminations of the multilayer optical film **1625**. Each defect can be characterized by a defect distance, which is measured in the plane of the film **1625**, perpendicular to the terminus **1625t1**. Thus, edge defect **1625-1** is characterized by a defect distance **D1**, edge defect **1625-2** is characterized by a defect distance **D2**, edge defect **1625-3** is characterized by a defect distance **D3**, and edge defect **1625-4** is characterized by a defect distance **D4**. These defect distances can be averaged together to provide an average defect distance for the terminus **1625t1** or a portion thereof. In order to ensure high quality optical performance of the lens within which the film **1625** is embedded, the average defect distance for the terminus **1625t1** is controlled to be no more than 100 microns, or no more than 50 microns.

Schematic drawings that show one way of combining a multilayer optical film with two optical bodies to fabricate a lens, such as any of the lenses discussed herein, are provided by FIGS. 17A through 17C. The manufacturing technique illustrated by these figures should not be construed to be unduly limiting, but illustrative. In FIG. 17A, a first optical body **1722**, a second optical body **1724**, and a multilayer optical film **1725** are provided. The bodies **1722**, **1724** have mating surfaces **1722c**, **1724c**, respectively. In FIG. 17B, a compound optical body is formed by bonding the bodies **1722**, **1724** together with the multilayer optical film **1725** sandwiched therebetween. Light transmissive bonding layers **1727**, **1729**, which may be or comprise an optically clear optical adhesive, optical cement, or similar material, may also be included to ensure a strong bond and robust construction. The compound optical body may then be cut and polished or otherwise formed along surfaces of interest **S1** and **S2**, the surfaces **S1** and **S2** being shaped to provide opposed optical surfaces of a desired lens. As shown in FIG. 17C, the forming of the optical surfaces is carried out to give a smooth surface **1722a'** to the first optical body (which is now labeled **1722'** to distinguish it from the original, uncut body **1722**), and a smooth surface **1724a'** to the second optical body (which is now labeled **1724'** to distinguish it from the original, uncut body **1724**). These smooth surfaces **1722a'**, **1724a'** are portions of a first optical surface **1720a** of the lens **1720** that is produced as a result of the bonding and forming. The forming may also provide the first optical body **1722'** with a smooth surface **1722b'** and the second optical body **1724'** with a smooth surface **1724b'**, and these smooth surfaces **1722b'**, **1724b'** may be portions of a second optical surface **1720b** of the lens **1720**. A circumferential surface **1720c** may connect the first and second optical surfaces. As part of the forming, the multilayer optical film **1725** may also be terminated at or near the optical surfaces **1720a**, **1720b** to provide extended terminuses **1725t1**, **1725t2**, respectively, the terminus **1725t1** separating the smooth surface **1722a'** from the smooth surface **1724a'**, and the terminus **1725t2** separating the smooth surface **1722b'** from the smooth surface **1724b'**. The film **1725** is terminated in such a way as to avoid edge defects in the multilayer optical film **1725** along the extended terminuses, with any such edge defects being characterized by an average defect distance of no more than 100 microns, or no more than 50 microns.

Numerous modifications can be made to the foregoing teachings. In one such modification, the disclosed designs and techniques can also be applied to optical components other than lenses. Such other optical components may be the same as or similar to any of the disclosed lenses having embedded multilayer optical films, except that both of the opposed optical surfaces can be made to be flat, i.e.,
5 neither of the opposed optical surfaces are curved. Such an optical component may include a first section having a first smooth surface and a side surface, a second section having a first smooth surface, a second smooth surface, and a side surface, the second section shaped to mate with the first section, and a multilayer optical film embedded in the optical component between the first and second sections. The first optical surface of the component may comprise the first smooth surface of the first section and the
10 first smooth surface of the second section, and the second optical surface of the component may comprise the second smooth surface of the second section. The multilayer optical film may comprise a first extended terminus that separates the first smooth surface of the first section from the first smooth surface of the second section. Such optical components may in some cases be used as beamsplitting windows and combined with one or more imaging devices in eyewear that may be suitable for Near-Eye Displays
15 and similar applications.

Unless otherwise indicated, all numbers expressing quantities, measurement of properties, and so forth used in the specification and claims are to be understood as being modified by the term “about”. Accordingly, unless indicated to the contrary, the numerical parameters set forth in the specification and
20 claims are approximations that can vary depending on the desired properties sought to be obtained by those skilled in the art utilizing the teachings of the present application. Not as an attempt to limit the application of the doctrine of equivalents to the scope of the claims, each numerical parameter should at least be construed in light of the number of reported significant digits and by applying ordinary rounding techniques. Notwithstanding that the numerical ranges and parameters setting forth the broad scope of
25 the invention are approximations, to the extent any numerical values are set forth in specific examples described herein, they are reported as precisely as reasonably possible. Any numerical value, however, may well contain errors associated with testing or measurement limitations.

Various modifications and alterations of this invention will be apparent to those skilled in the art without departing from the spirit and scope of this invention, and it should be understood that this
30 invention is not limited to the illustrative embodiments set forth herein. The reader should assume that features of one disclosed embodiment can also be applied to all other disclosed embodiments unless otherwise indicated. All U.S. patents, patent application publications, and other patent and non-patent documents referred to herein are incorporated by reference, to the extent they do not contradict the foregoing disclosure.

35 This application discloses a variety of items relating to lenses and related optical components having a partially reflective element. These include, but are not limited to, the numbered items below.

Item 1 is a lens having first and second opposed optical surfaces connected by a circumferential surface, the lens comprising:

a first lens section having a first smooth surface and a side surface;

a second lens section having a first smooth surface, a second smooth surface, and a side surface; and

5 a multilayer optical film embedded in the lens between the first and second lens sections, the multilayer optical film comprising a plurality of polymer layers configured to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent;

10 wherein the first optical surface comprises the first smooth surface of the first lens section and the first smooth surface of the second lens section;

wherein the second optical surface comprises the second smooth surface of the second lens section; and

15 wherein the multilayer optical film comprises a first extended terminus that separates the first smooth surface of the first lens section from the first smooth surface of the second lens section.

Item 2 is the lens of item 1, wherein the circumferential surface comprises the side surface of the first lens section and the side surface of the second lens section.

20 Item 3 is the lens of any previous item, wherein the first optical surface also comprises the first extended terminus.

Item 4 is the lens of item 1 or item 2, wherein the first extended terminus is disposed in a first extended notch that separates the first smooth surface of the first lens section from the first smooth surface of the second lens section.

25 Item 5 is the lens of item 4, wherein the first extended notch is no more than 250 microns deep.

30 Item 6 is the lens of any previous item, wherein to the extent the multilayer optical film has any edge defects along the first extended terminus, such edge defects are characterized by a first average defect distance of no more than 100 microns.

Item 7 is the lens of item 6, wherein the first average defect distance is no more than 50 microns.

35 Item 8 is the lens of any previous item, wherein the first optical surface is curved, and the first extended terminus is arc-shaped.

Item 9 is the lens of any of items 1-7, wherein the first optical surface is flat, and the first extended terminus is straight.

Item 10 is the lens of any previous item, wherein the first lens section also has a second smooth surface, wherein the second optical surface comprises the second smooth surface of the first lens section and the second smooth surface of the second lens section, and wherein the multilayer optical film comprises a
5 second extended terminus that separates the second smooth surface of the first lens section from the second smooth surface of the second lens section.

Item 11 is the lens of item 10, wherein the second optical surface also comprises the second extended terminus.

10 Item 12 is the lens of item 10, wherein the second extended terminus is disposed in a second extended notch that separates the second smooth surface of the first lens section from the second smooth surface of the second lens section.

15 Item 13 is the lens of any of items 10-12, wherein to the extent the multilayer optical film has any edge defects along the second extended terminus, such edge defects are characterized by a second average defect distance of no more than 100 microns.

Item 14 is the lens of item 13, wherein the second average defect distance is no more than 50 microns.

20 Item 15 is the lens of any previous item, wherein, for at least one visible wavelength of normally incident light, or at another design angle of incidence, the multilayer optical film is configured as a reflective polarizer.

25 Item 16 is the lens of any previous item, wherein, for at least one polarization state of normally incident light, or at another design angle of incidence, the multilayer optical film is configured as a notch filter.

Item 17 is the lens of item 16, wherein, for at least one visible wavelength of normally incident light, or at another design angle of incidence, the multilayer optical film is configured as a reflective polarizer.

30 Item 18 is the lens of any previous item, further comprising a protective coating that covers the first smooth surface of the first lens section, the first smooth surface of the second lens section, and the first extended terminus.

35 Item 19 is the lens of any previous item, further comprising an absorptive layer that covers the first optical surface or the second optical surface.

Item 20 is the lens of item 19, wherein the absorptive layer comprises an absorptive polarizer.

Item 21 is a compound lens, comprising:

- the lens of any previous item; and
- a second lens bonded to the lens of any previous item.

5

Item 22 is a system, comprising:

- the lens of any previous item; and
- an imaging device disposed to direct imaging light towards the multilayer optical film.

10 Item 23 is the system of item 22, wherein the multilayer optical film is configured to selectively reflect visible light of a first characteristic and selectively transmit visible light of a second characteristic, and wherein the imaging light comprises the first characteristic.

Item 24 is the system of item 23, wherein the first and second characteristics are orthogonal first and
15 second polarization states, respectively, and wherein the lens further comprises an absorptive polarizer configured to absorb light of the second polarization state.

Item 25 is the system of any of items 22-24, wherein the system comprises eyewear.

20 Item 26 is an optical component having first and second opposed optical surfaces connected by a circumferential surface, the optical component comprising:

- a first section having a first smooth surface and a side surface;
- a second section having a first smooth surface, a second smooth surface, and a side surface, the
second section shaped to mate with the first section; and

25 a multilayer optical film embedded in the optical component between the first and second sections, the multilayer optical film comprising a plurality of polymer layers arranged to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent;

30 wherein the first optical surface comprises the first smooth surface of the first section and the first smooth surface of the second section;

wherein the second optical surface comprises the second smooth surface of the second section; and

wherein the multilayer optical film comprises a first extended terminus that separates the first smooth surface of the first section from the first smooth surface of the second section.

35 Item 27 is the optical component of item 26, wherein both the first and second optical surfaces are flat.

Item 28 is a method of making a lens, comprising:

providing a first optical body and a second optical body, the second optical body shaped to mate with the first optical body;

providing a multilayer optical film, the multilayer optical film comprising a plurality of polymer layers configured to selectively reflect light by constructive or destructive interference, at least
5 some of the polymer layers being birefringent;

bonding the first and second optical bodies together with the multilayer optical film sandwiched therebetween to form a compound optical body;

forming a first optical surface in the compound optical body, the forming being carried out to give a first smooth surface to the first optical body and a second smooth surface to the second optical
10 body, the first and second smooth surfaces being portions of the first optical surface, the optical body also having, or made to have, a second optical surface opposite the first optical surface, and a circumferential surface that connects the first and second optical surfaces; and

terminating the multilayer optical film along an extended terminus that separates the first smooth surface from the second smooth surface.

15

Item 29 is the method of item 28, wherein the terminating is carried out to avoid edge defects in the multilayer optical film along the extended terminus, with any such edge defects being characterized by a first average defect distance of no more than 100 microns.

20

Item 30 is the method of item 29, wherein the terminating comprises polishing an end of the multilayer optical film, and wherein the forming comprises polishing the first and second optical bodies.

Item 31 is the method of any of items 28-30, further comprising:

25

forming an extended notch in the first optical surface such that the extended terminus is disposed in the extended notch.

Item 32 is the method of any of items 28-31, further comprising:

forming a protective coating over all, or substantially all, or a portion of, the first optical surface.

CLAIMS

1. A lens having first and second opposed optical surfaces connected by a circumferential surface, the
5 lens comprising:
a first lens section having a first smooth surface and a side surface;
a second lens section having a first smooth surface, a second smooth surface, and a side surface; and
a multilayer optical film embedded in the lens between the first and second lens sections, the
10 multilayer optical film comprising a plurality of polymer layers configured to selectively reflect
light by constructive or destructive interference, at least some of the polymer layers being
birefringent;
wherein the first optical surface comprises the first smooth surface of the first lens section and the
first smooth surface of the second lens section;
wherein the second optical surface comprises the second smooth surface of the second lens section;
15 and
wherein the multilayer optical film comprises a first extended terminus that separates the first smooth
surface of the first lens section from the first smooth surface of the second lens section.
2. The lens of claim 1, wherein the circumferential surface comprises the side surface of the first lens
20 section and the side surface of the second lens section.
3. The lens of claim 1, wherein the first optical surface also comprises the first extended terminus.
4. The lens of claim 1, wherein the first extended terminus is disposed in a first extended notch that
25 separates the first smooth surface of the first lens section from the first smooth surface of the second lens
section.
5. The lens of claim 1, wherein the first lens section also has a second smooth surface, wherein the
second optical surface comprises the second smooth surface of the first lens section and the second
30 smooth surface of the second lens section, and wherein the multilayer optical film comprises a second
extended terminus that separates the second smooth surface of the first lens section from the second
smooth surface of the second lens section.
6. The lens of claim 5, wherein the second extended terminus is disposed in a second extended notch that
35 separates the second smooth surface of the first lens section from the second smooth surface of the second
lens section.

7. The lens of claim 1, wherein, for at least one visible wavelength of normally incident light, the multilayer optical film is configured as a reflective polarizer.
8. A system, comprising:
- 5 the lens of claim 1; and
- an imaging device disposed to direct imaging light towards the multilayer optical film.
9. The system of claim 8, wherein the system comprises eyewear.
- 10 10. An optical component having first and second opposed optical surfaces connected by a circumferential surface, the optical component comprising:
- a first section having a first smooth surface and a side surface;
- a second section having a first smooth surface, a second smooth surface, and a side surface, the second section shaped to mate with the first section; and
- 15 a multilayer optical film embedded in the optical component between the first and second sections, the multilayer optical film comprising a plurality of polymer layers arranged to selectively reflect light by constructive or destructive interference, at least some of the polymer layers being birefringent;
- wherein the first optical surface comprises the first smooth surface of the first section and the first
- 20 smooth surface of the second section;
- wherein the second optical surface comprises the second smooth surface of the second section; and
- wherein the multilayer optical film comprises a first extended terminus that separates the first smooth surface of the first section from the first smooth surface of the second section.

25

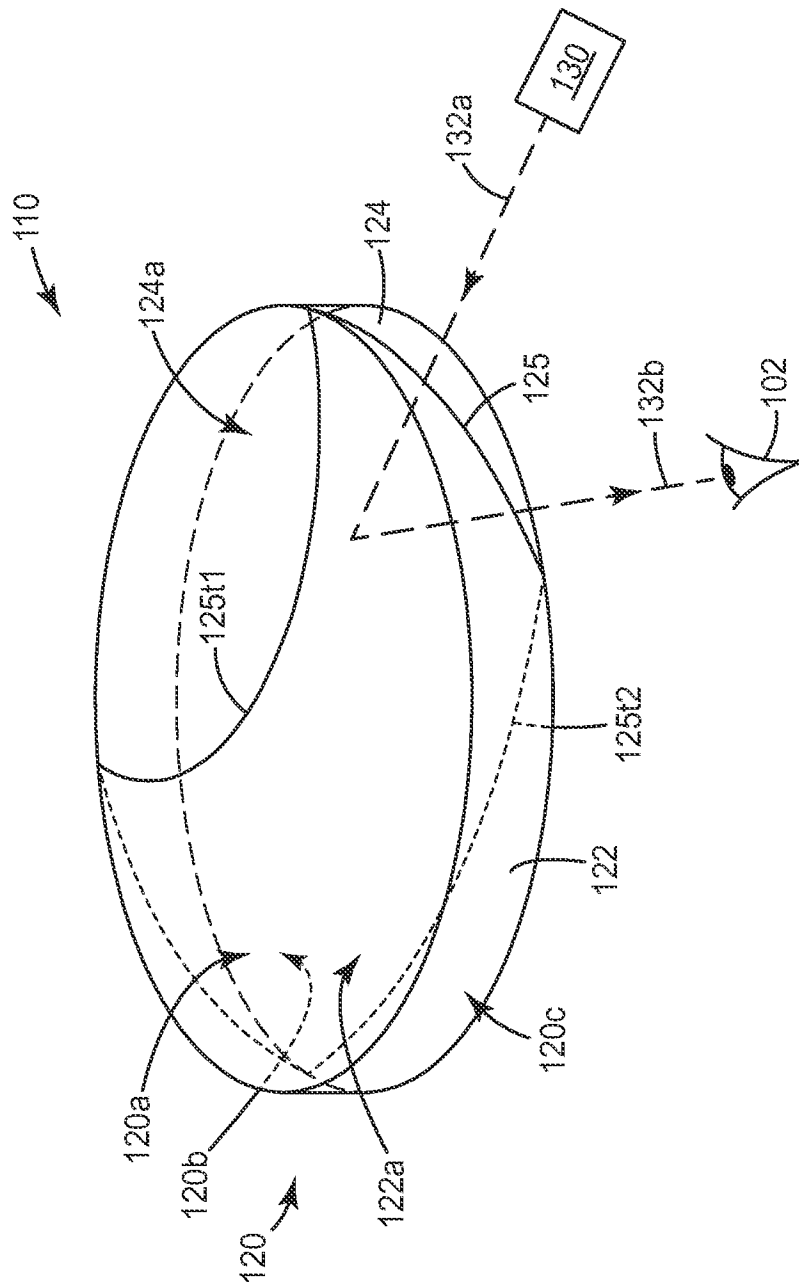


FIG. 1

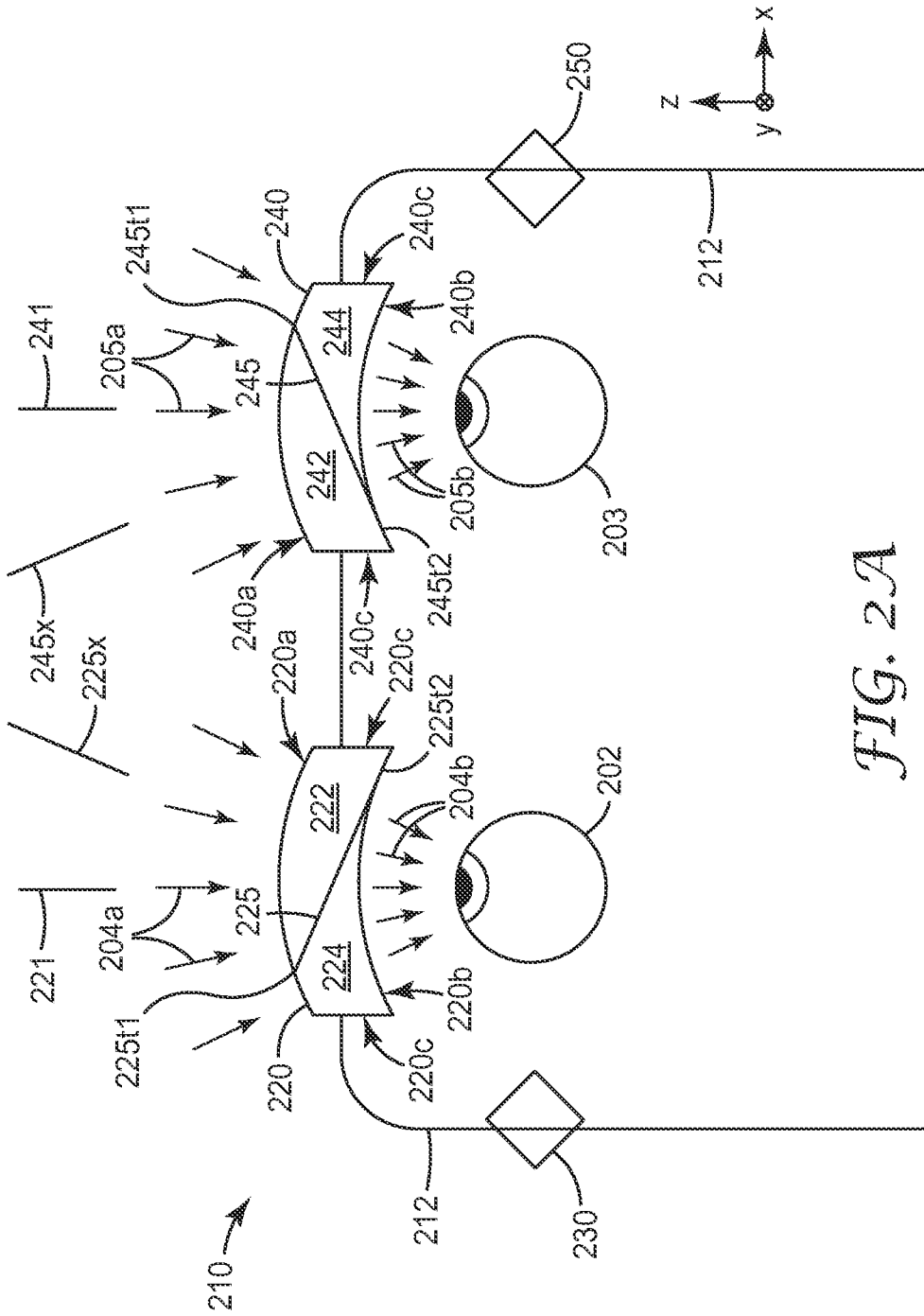


FIG. 2A

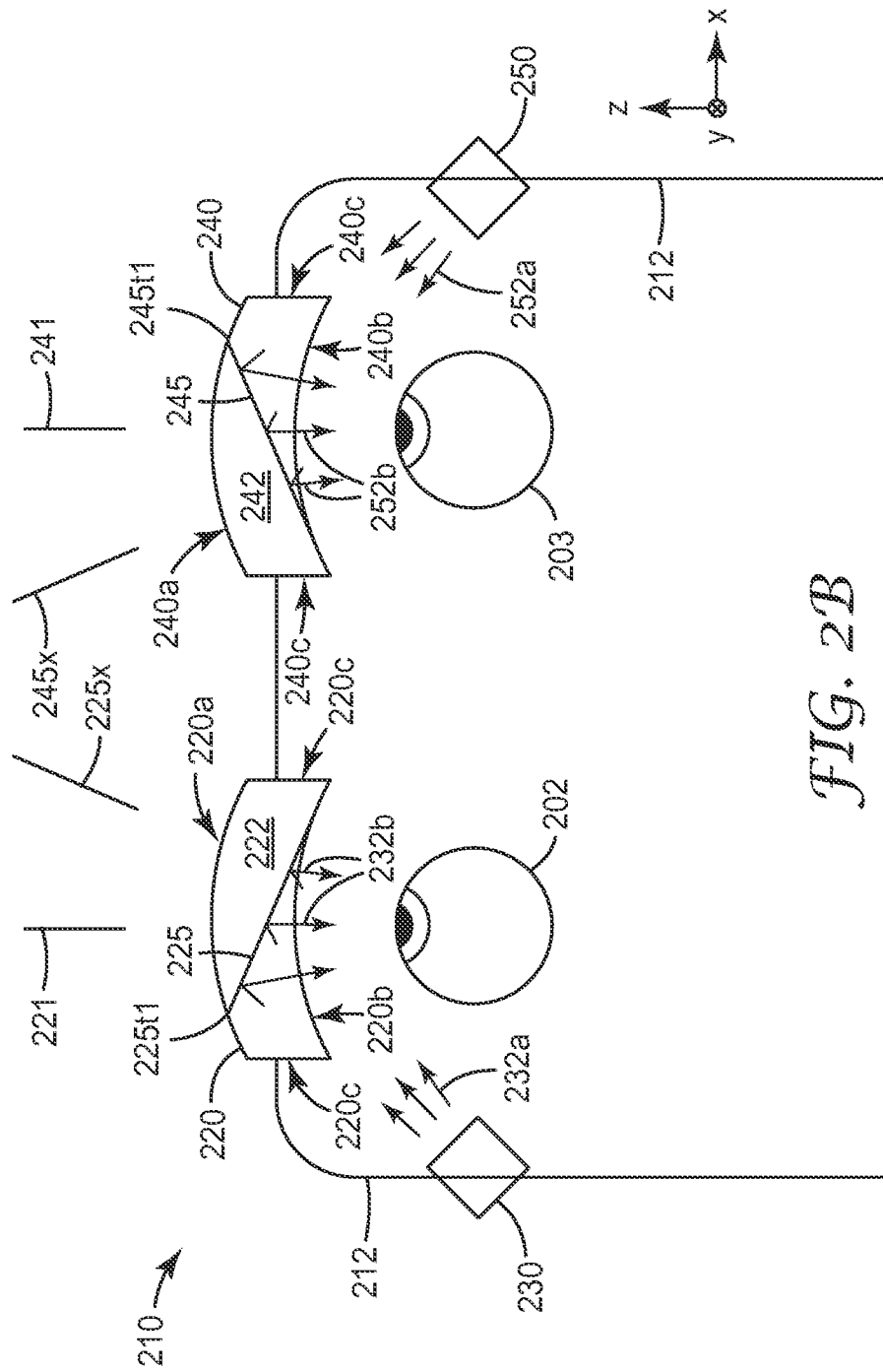


FIG. 2B

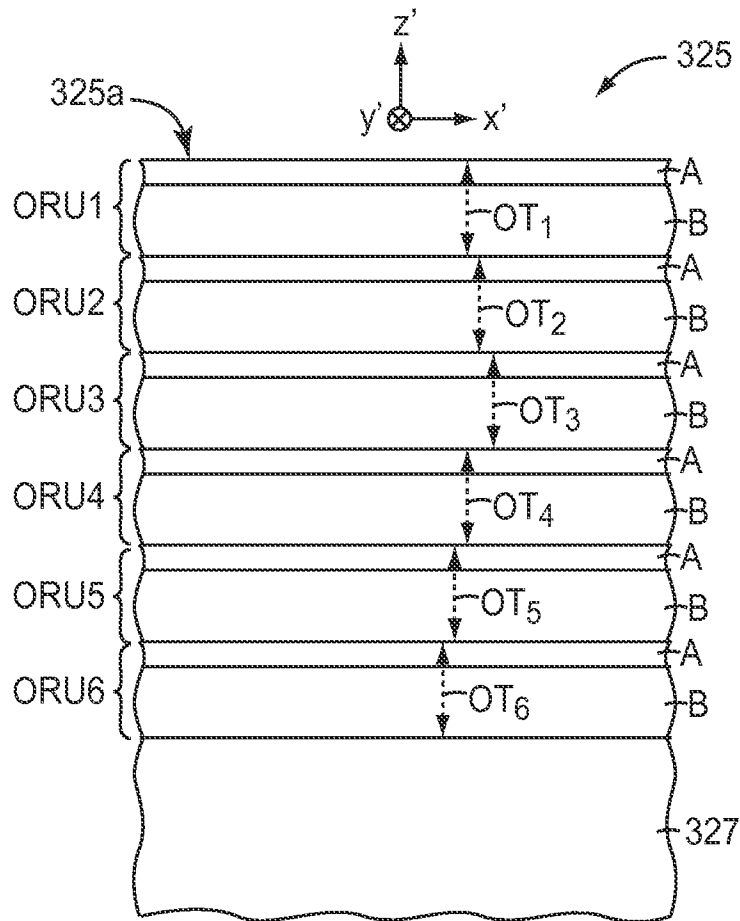


FIG. 3

5/11

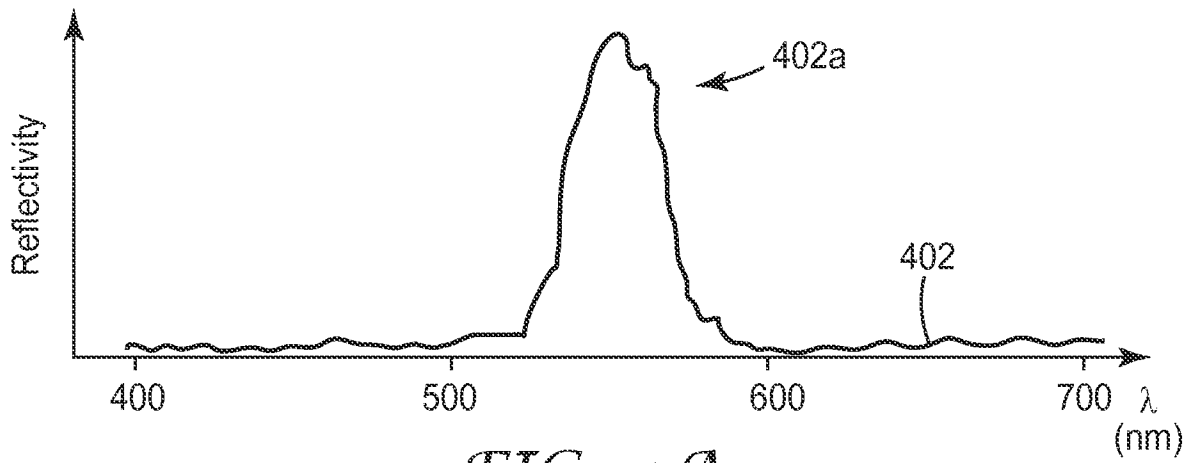


FIG. 4A

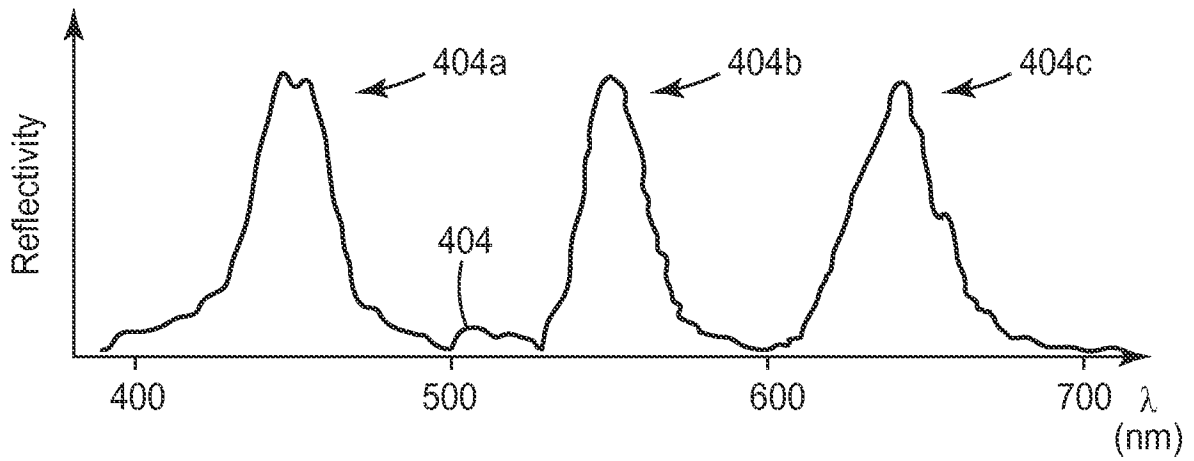


FIG. 4B

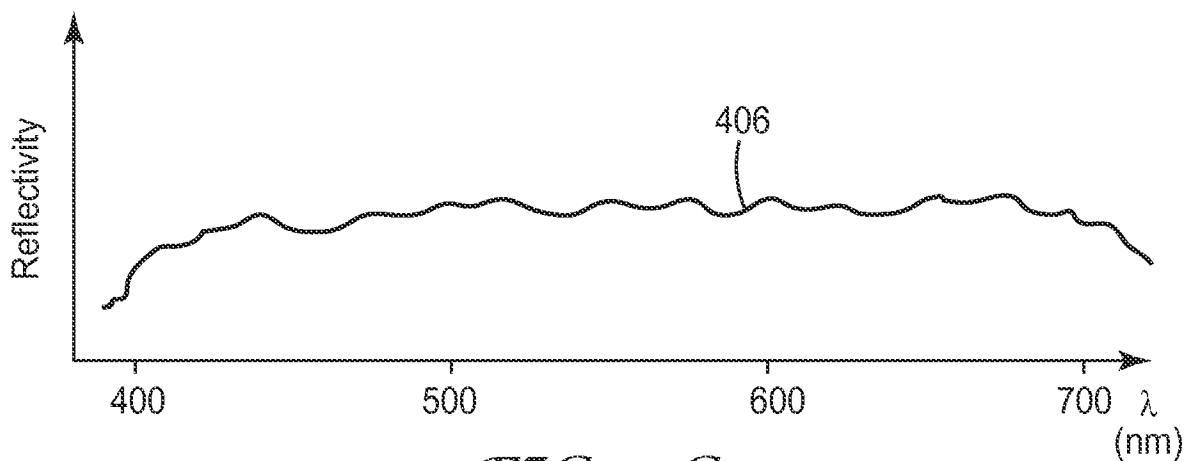


FIG. 4C

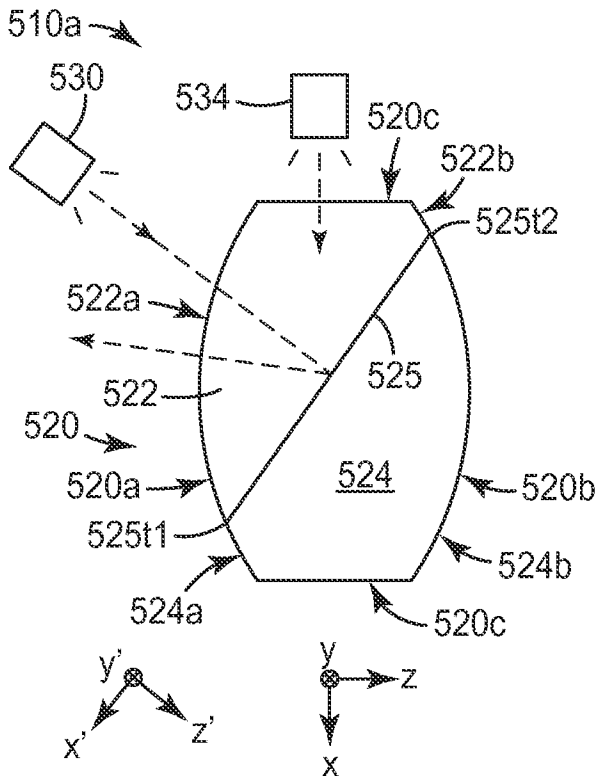


FIG. 5A

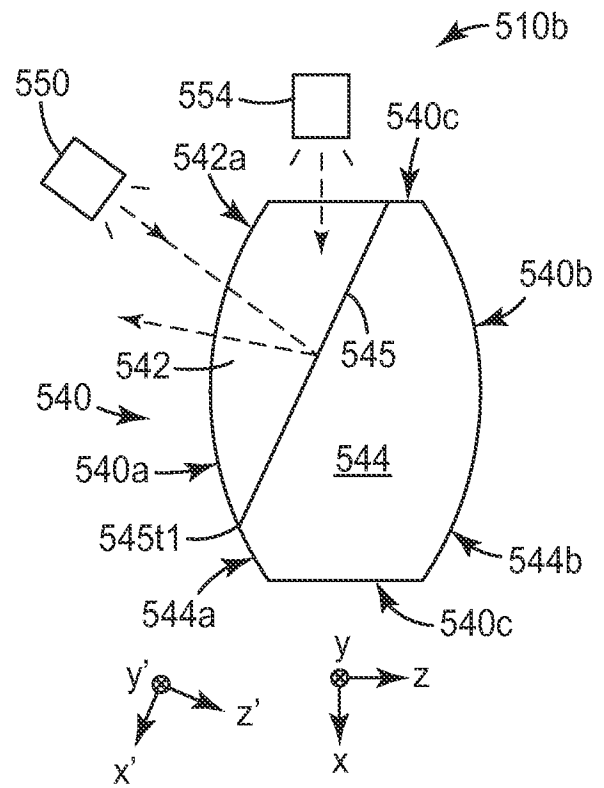


FIG. 5B

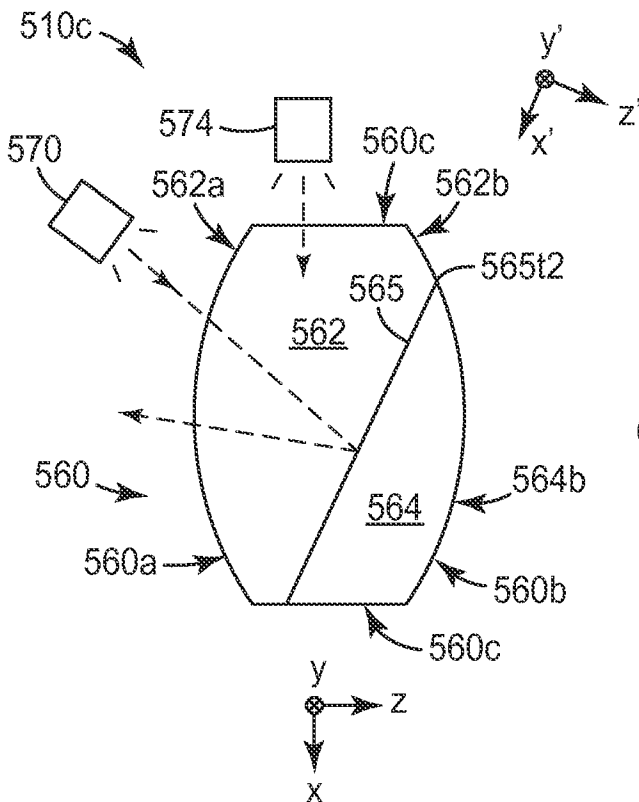


FIG. 5C

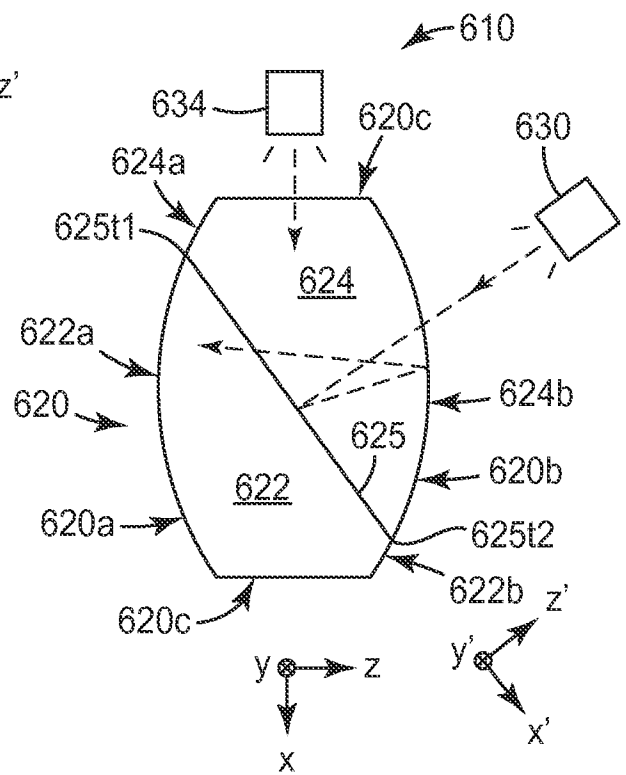


FIG. 6

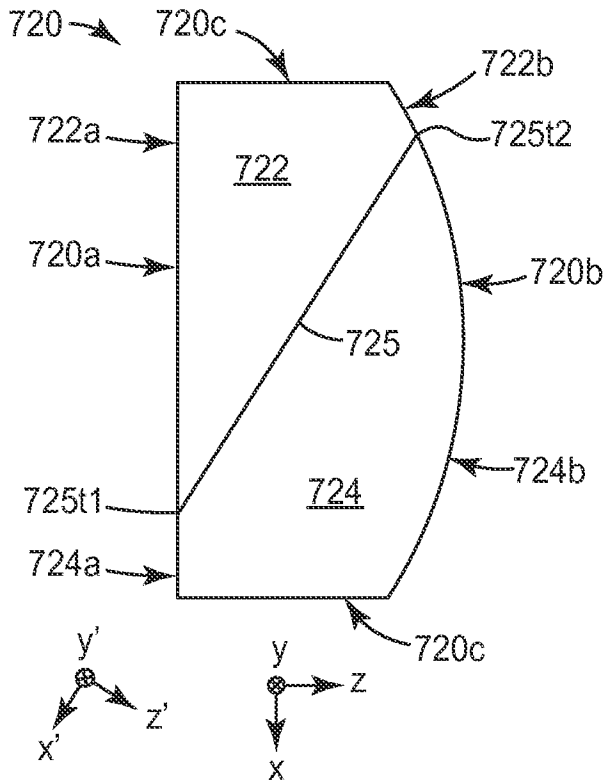


FIG. 7

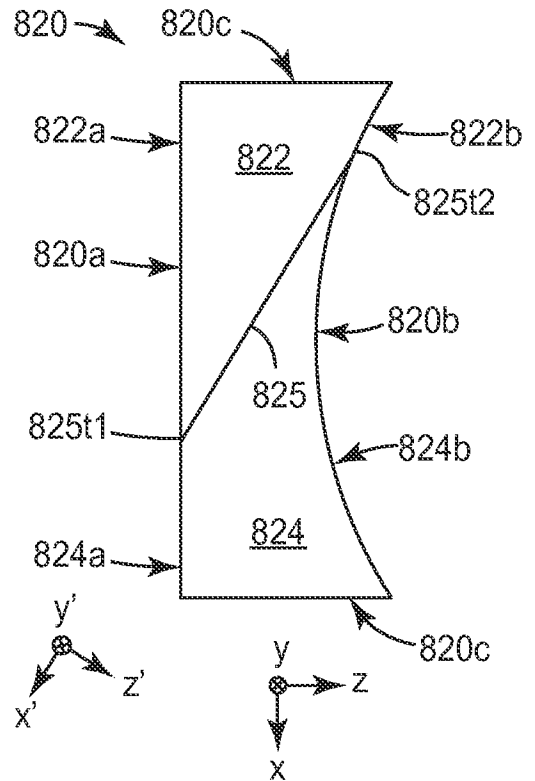


FIG. 8

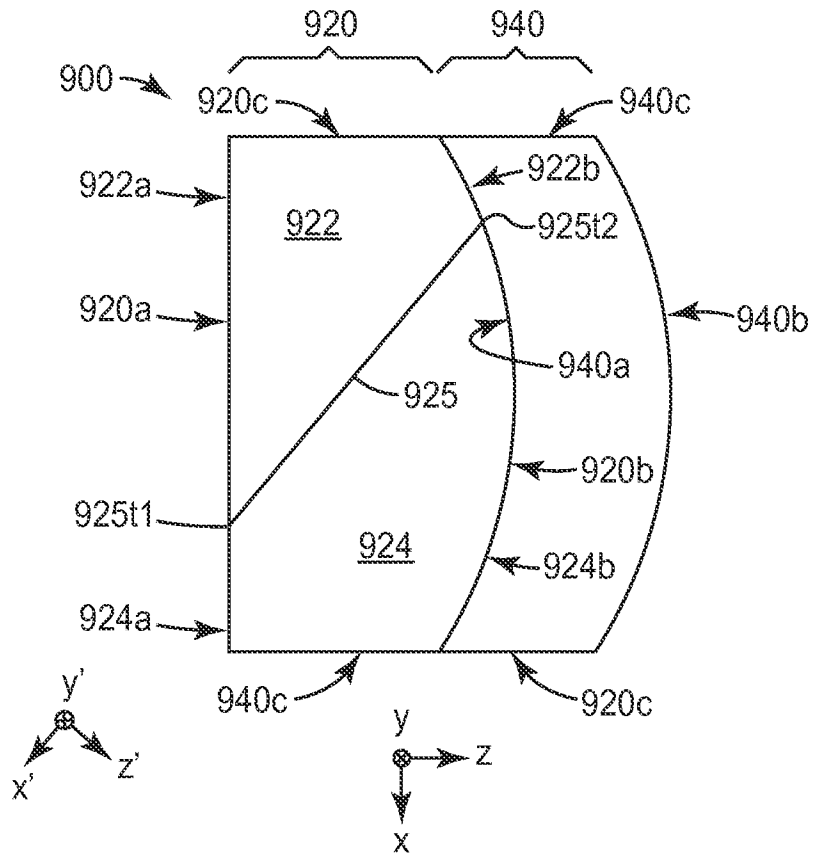


FIG. 9

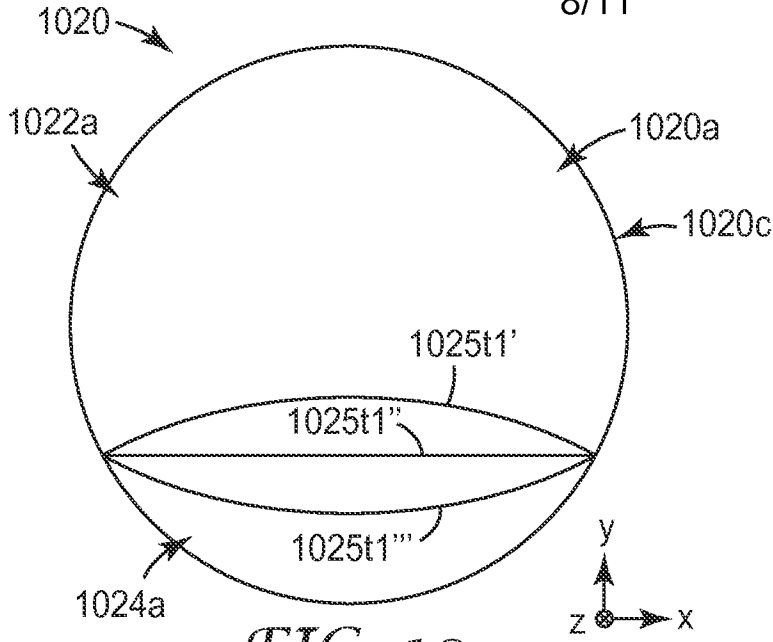


FIG. 10

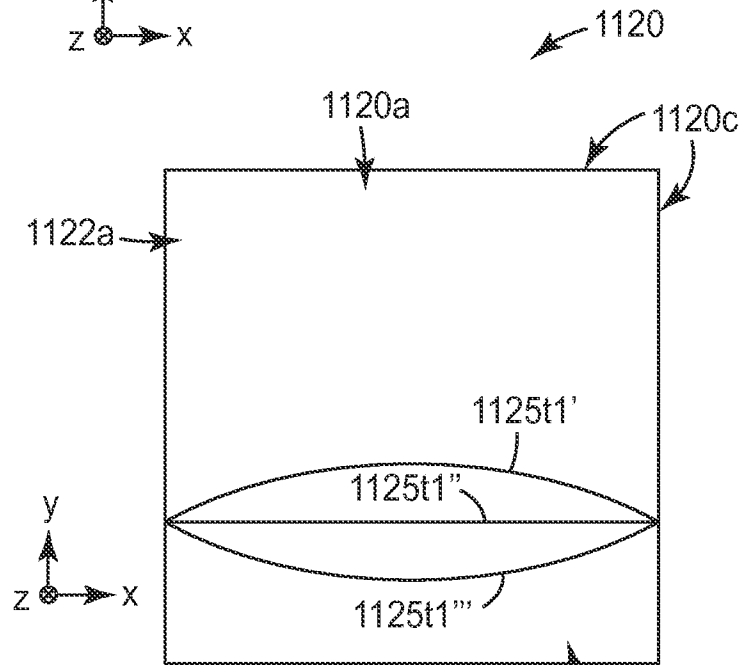


FIG. 11

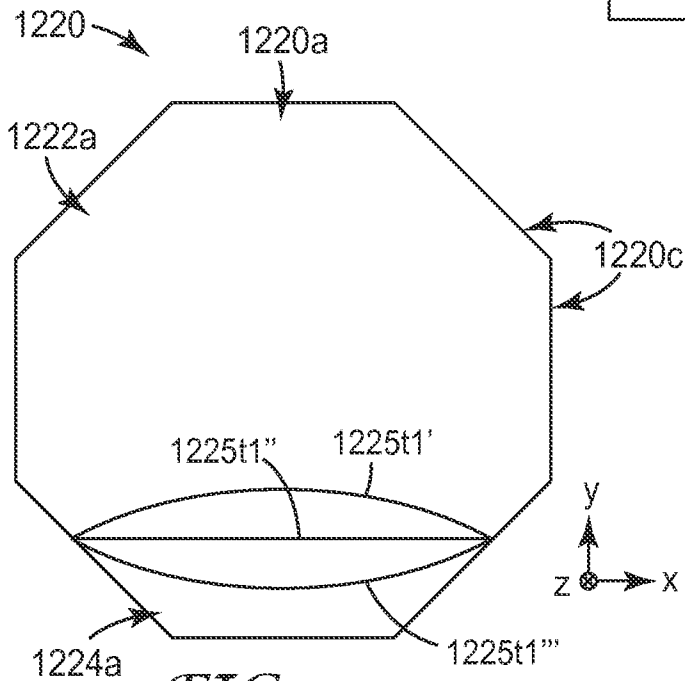


FIG. 12

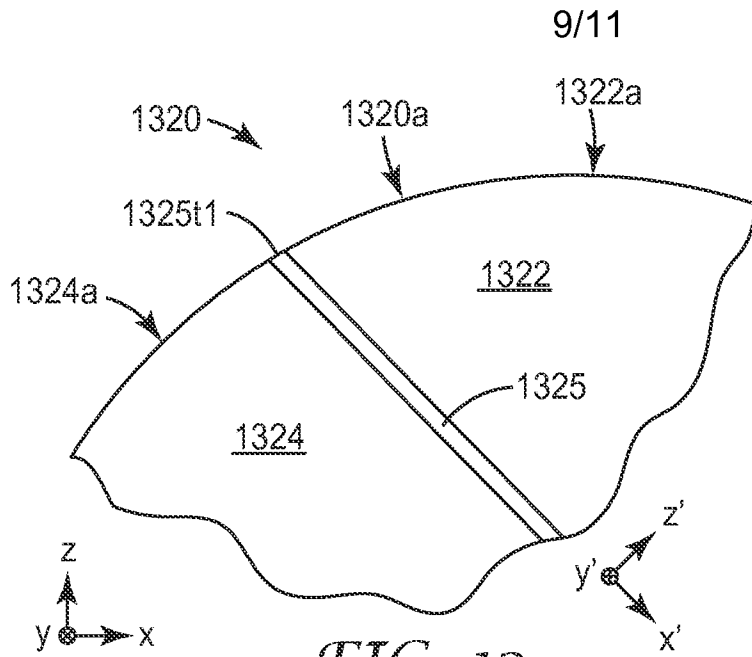


FIG. 13

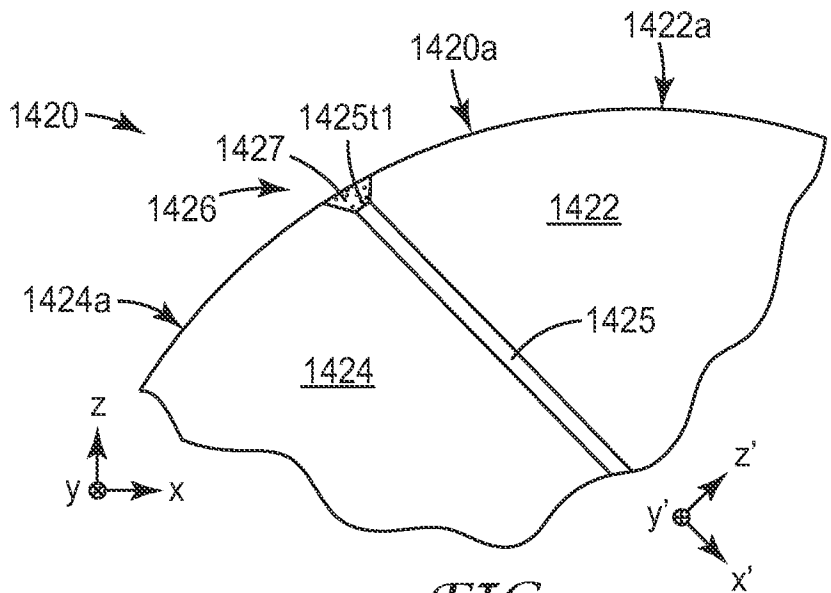


FIG. 14

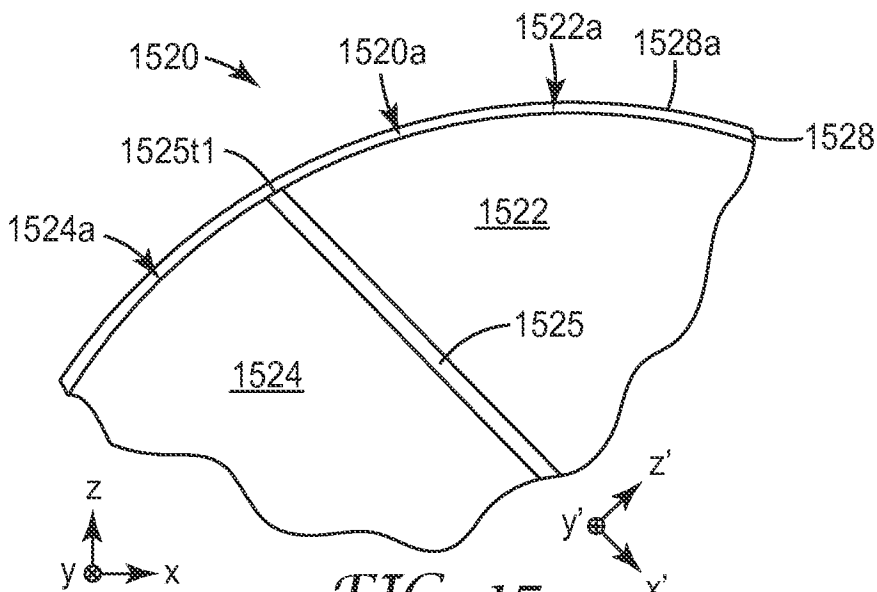


FIG. 15

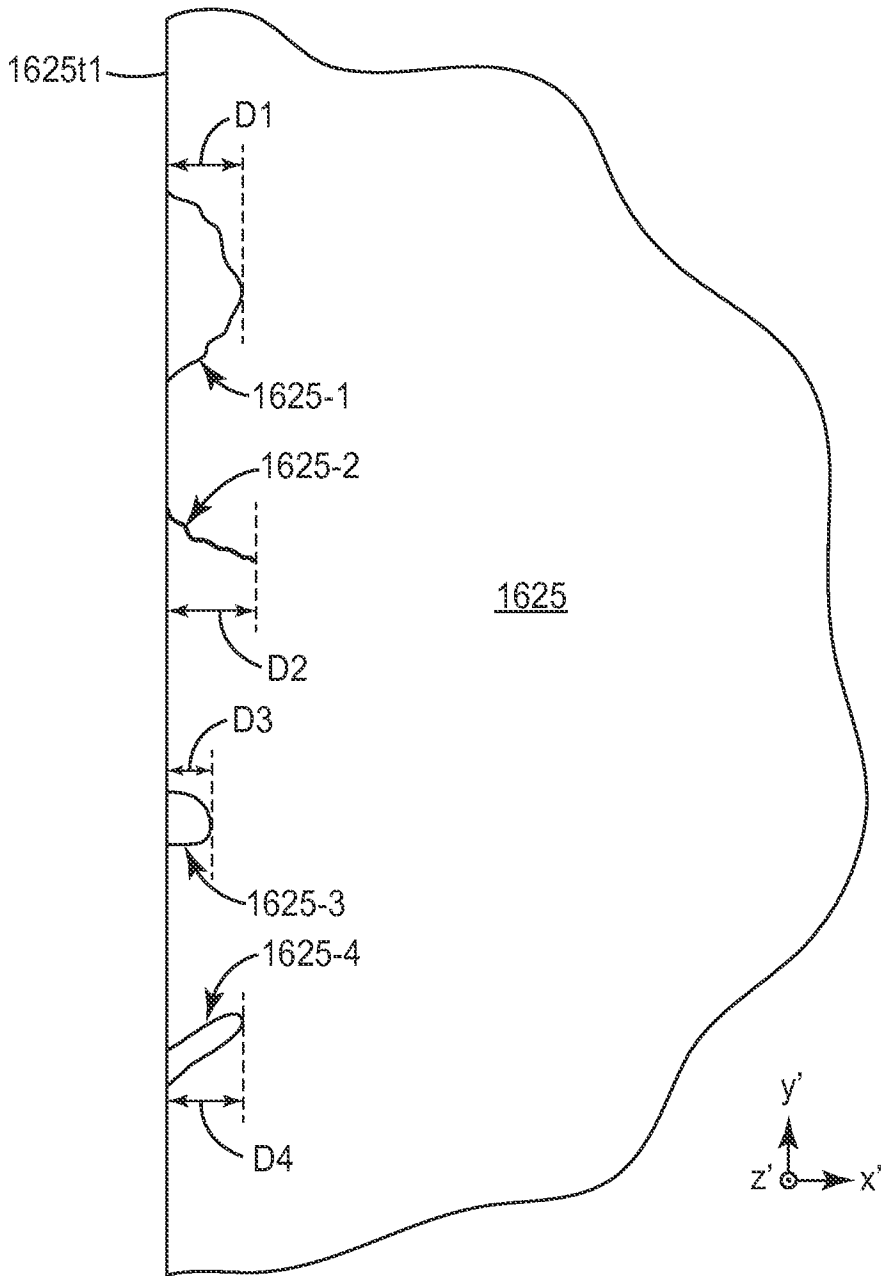


FIG. 16

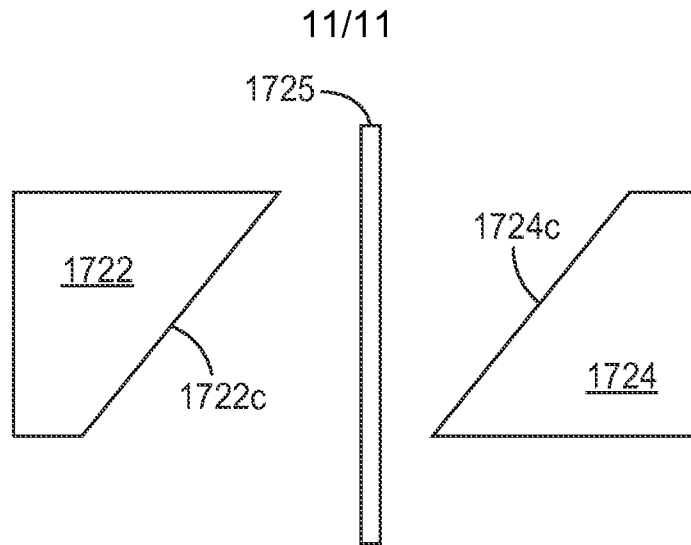


FIG. 17A

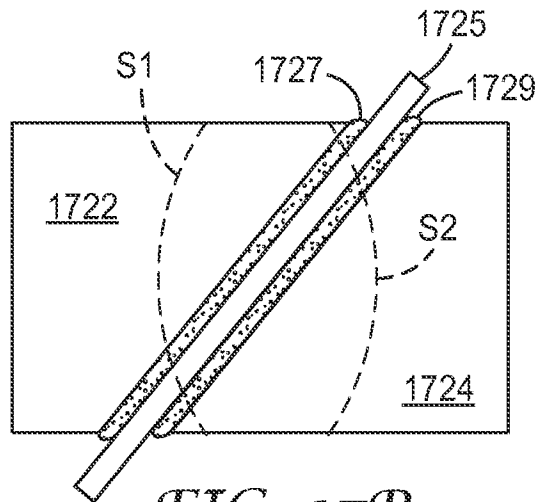


FIG. 17B

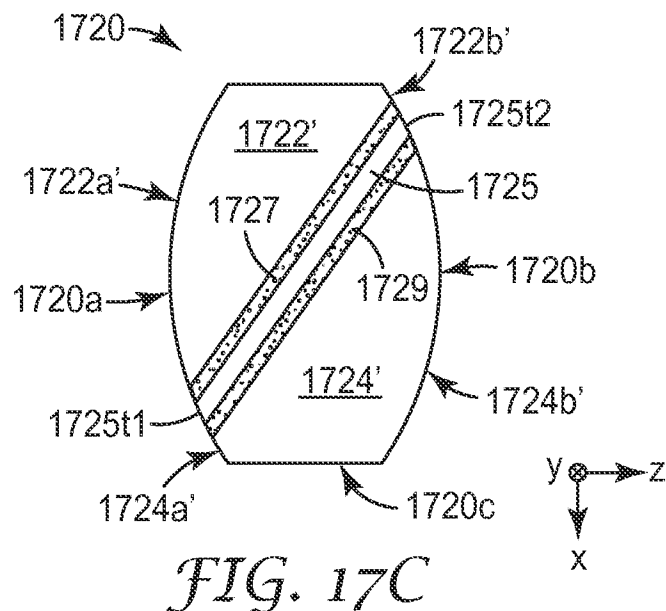


FIG. 17C

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2014/070791

A. CLASSIFICATION OF SUBJECT MATTER
 INV. G02B5/30 G02B27/10 G02B27/28 G02B27/01 G02C7/14
 ADD.
 According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
 Minimum documentation searched (classification system followed by classification symbols)
 G02B G02C
 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
 EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 5 654 827 A (REICHERT ABRAHAM [IL]) 5 August 1997 (1997-08-05) cited in the application figure 1 -----	1-10
Y	US 2013/010360 A1 (OUDERKIRK ANDREW J [US] ET AL) 10 January 2013 (2013-01-10) paragraphs [0037] - [0039], [0048] - [0050]; figures 1,4 -----	1-10
Y	US 3 680 946 A (BELLOWS ALFRED H) 1 August 1972 (1972-08-01) figures 1,2 -----	1,10

Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents :

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- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
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- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
- "&" document member of the same patent family

Date of the actual completion of the international search

24 February 2015

Date of mailing of the international search report

10/03/2015

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Authorized officer

Rödig, Christoph

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2014/070791

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 5654827	A	05-08-1997	NONE

US 2013010360	A1	10-01-2013	CN 102754012 A 24-10-2012
			EP 2521937 A2 14-11-2012
			TW 201137395 A 01-11-2011
			US 2013010360 A1 10-01-2013
			WO 2011084911 A2 14-07-2011

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