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(54) **OPTICAL STACK**

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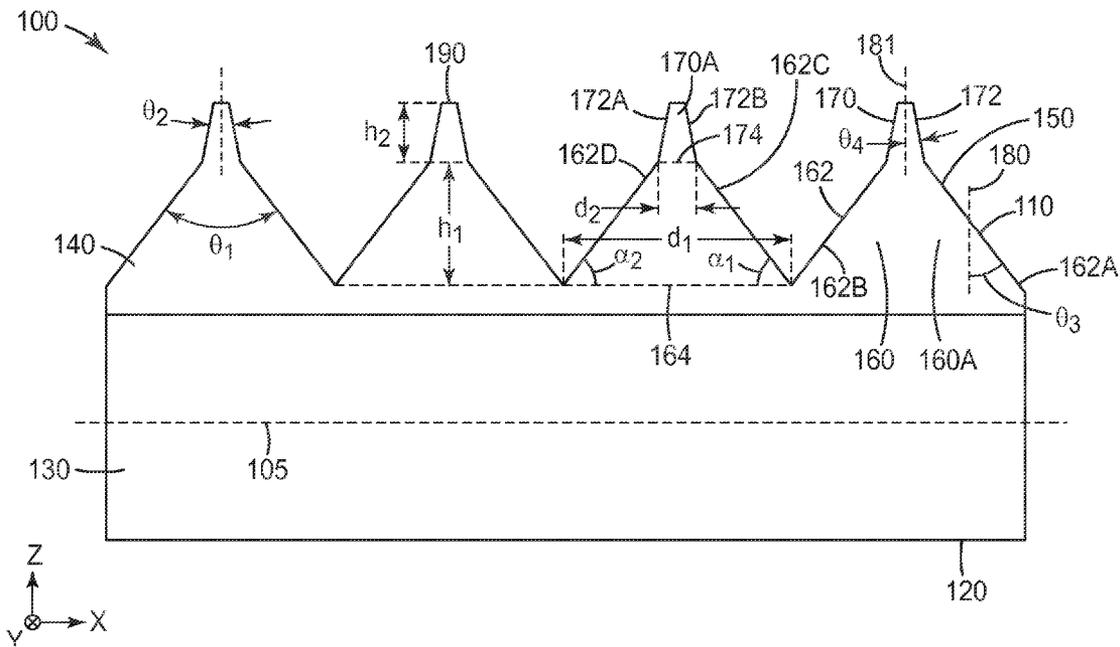
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G02B 5/30 (2006.01)
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(57) **ABSTRACT**
Optical stack is disclosed. The optical stack includes a light redirecting film that includes a first structured major surface that includes a plurality of unitary discrete structures. The optical stack also includes an optical adhesive layer that is disposed on the light directing film. At least portions of at least some unitary discrete structures in the plurality of unitary discrete structures penetrate into the optical adhesive layer. At least portions of at least some unitary discrete structures in the plurality of unitary discrete structures do not penetrate into the optical adhesive layer. The peel strength of the light redirecting film and the optical adhesive layer is greater than about 30 grams/inch. The average effective transmission of the optical stack is not less or is less than by no more than about 10% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer.

Related U.S. Application Data

(60) Provisional application No. 61/323,163, filed on Apr. 12, 2010, provisional application No. 61/323,128, filed on Apr. 12, 2010, provisional application No. 61/323,147, filed on Apr. 12, 2010.



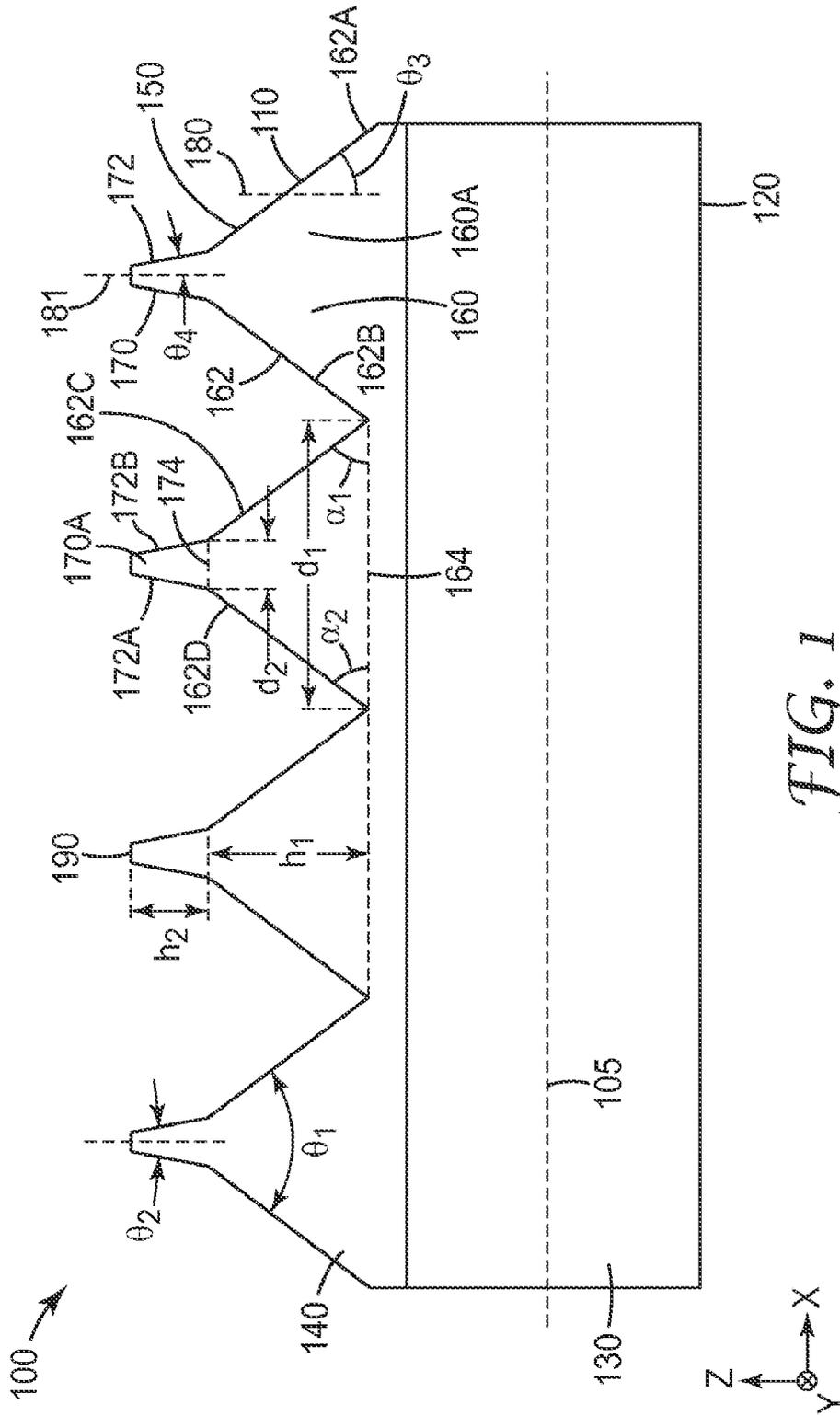
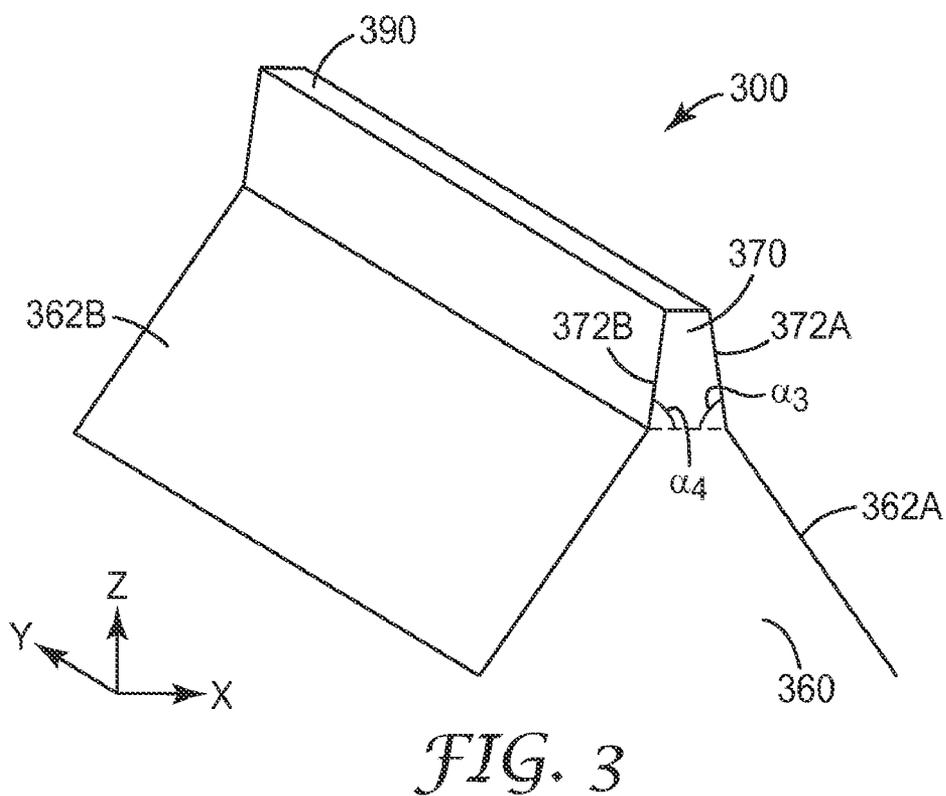
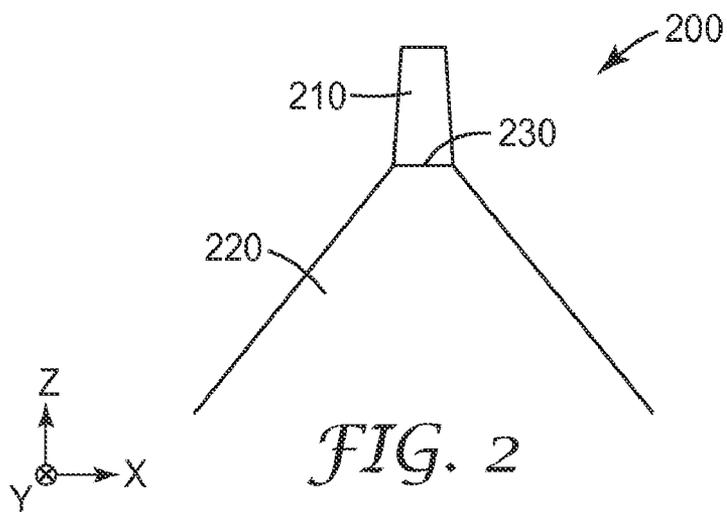


FIG. 1



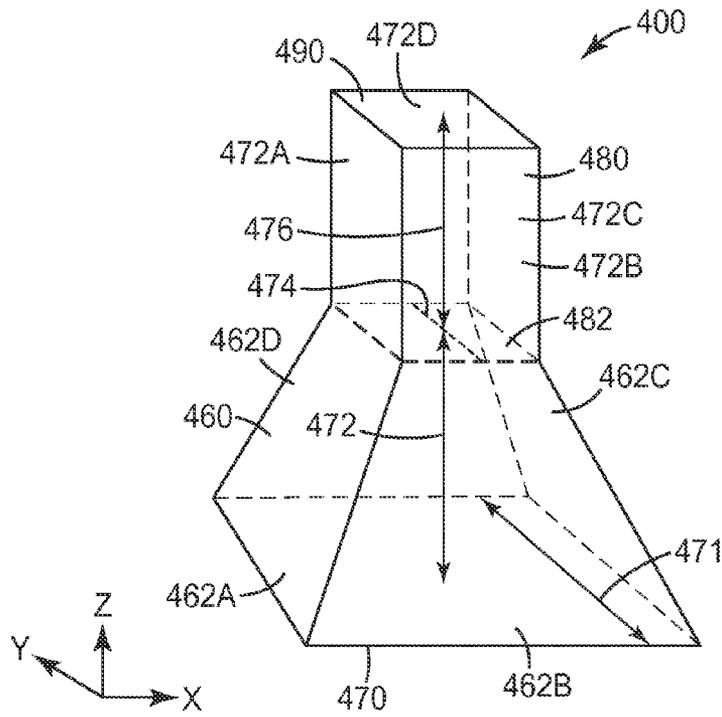


FIG. 4

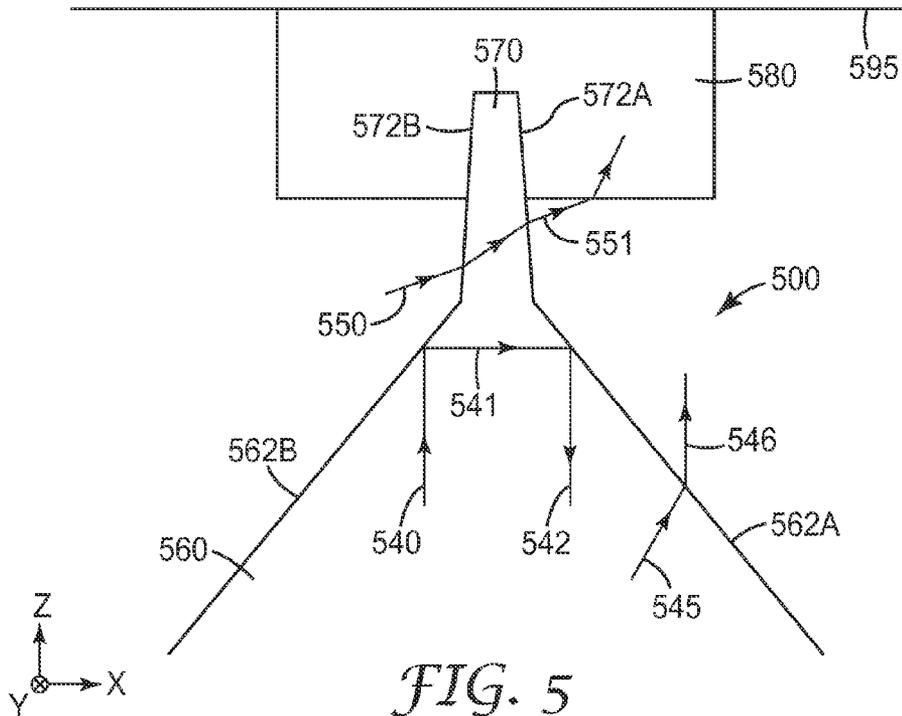


FIG. 5

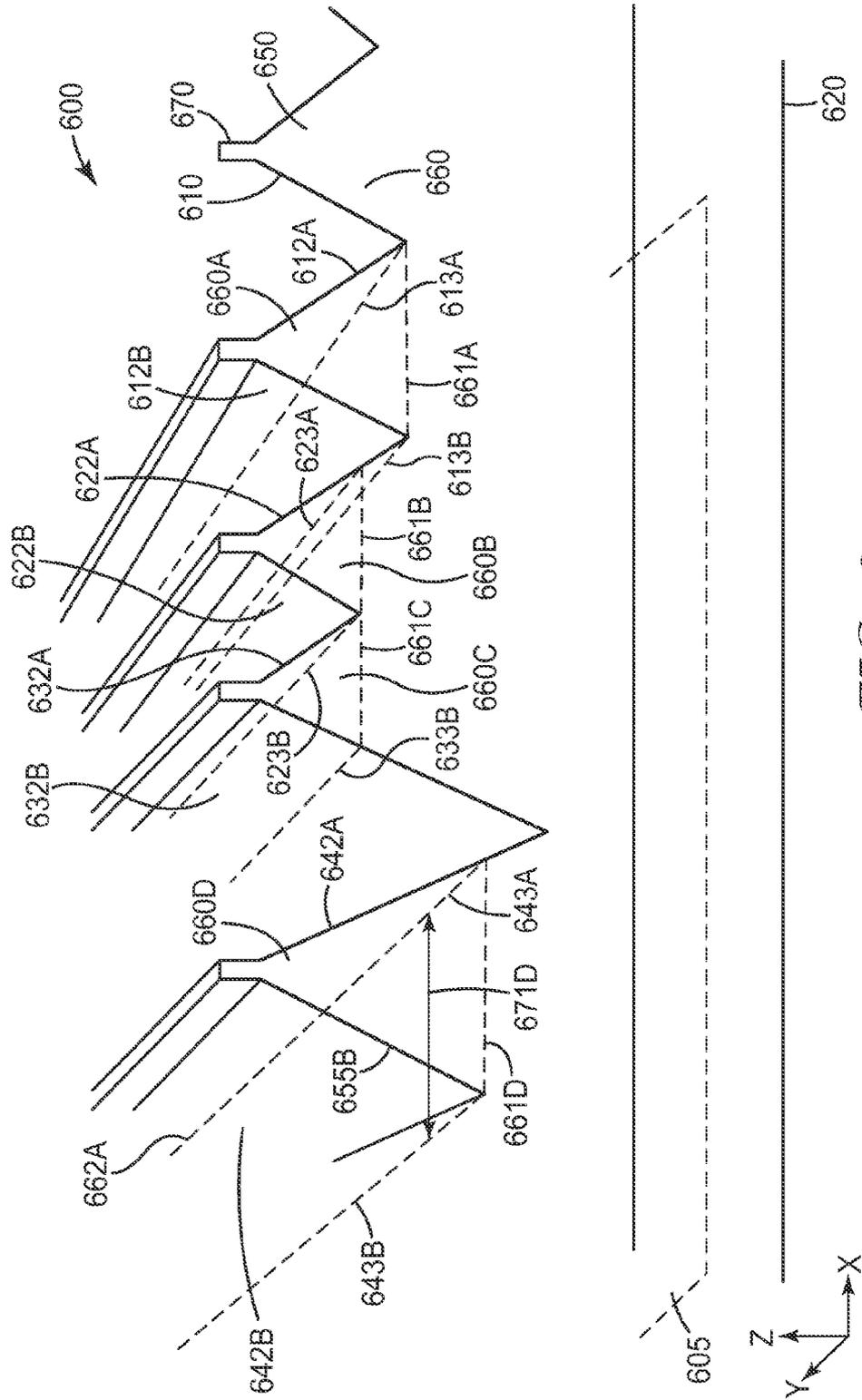


FIG. 6

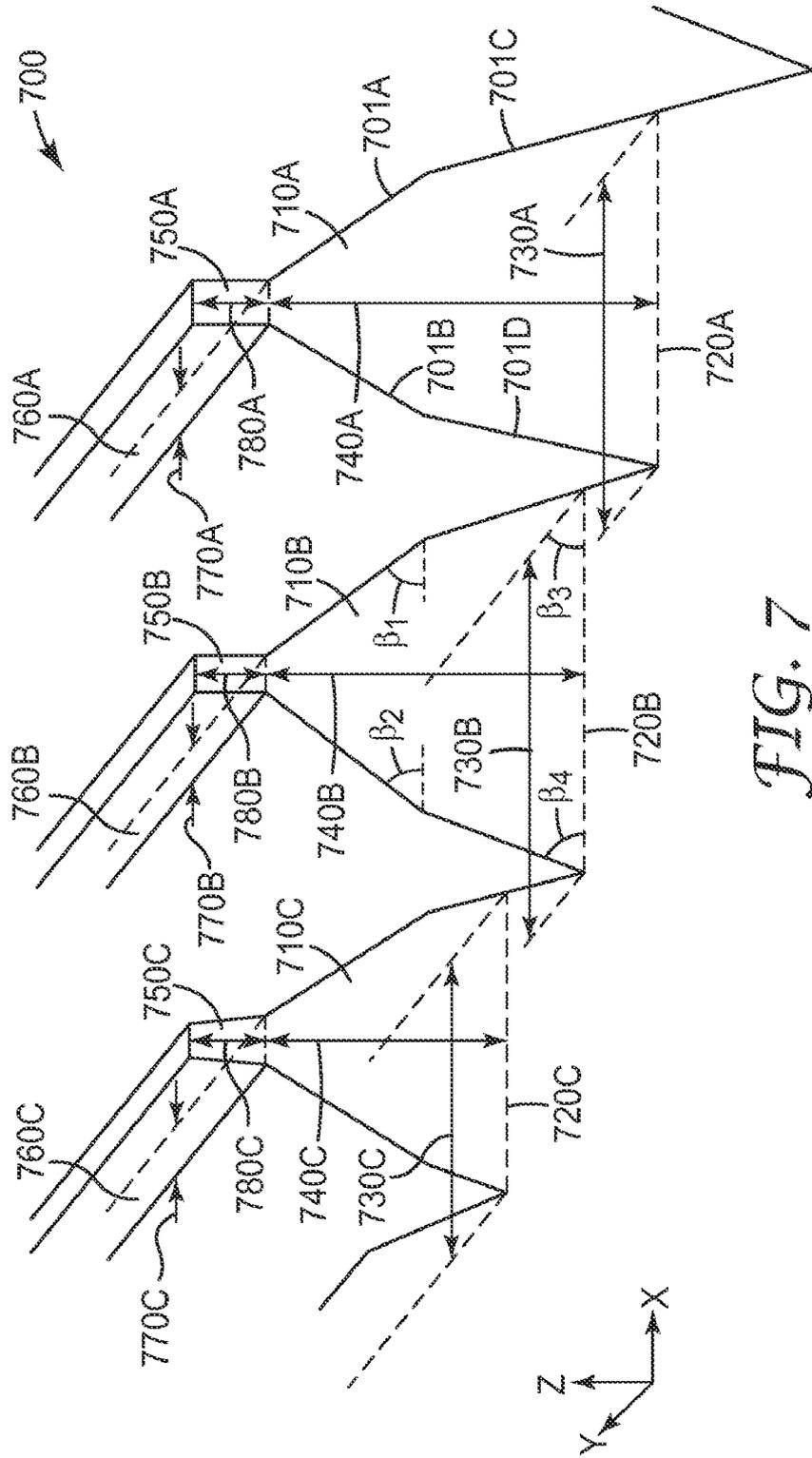
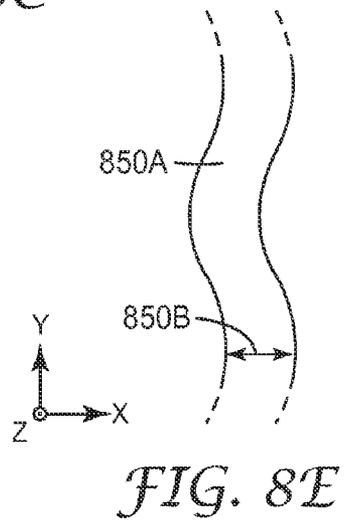
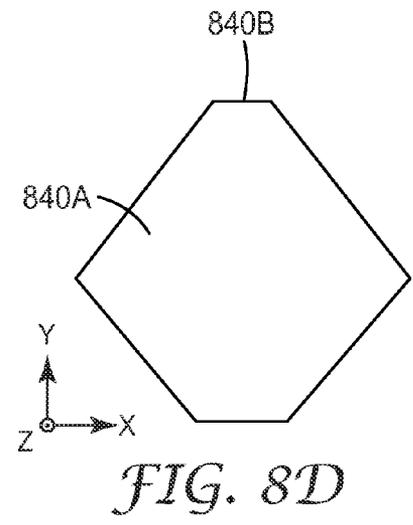
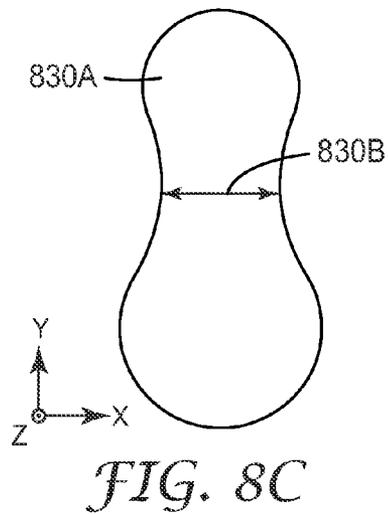
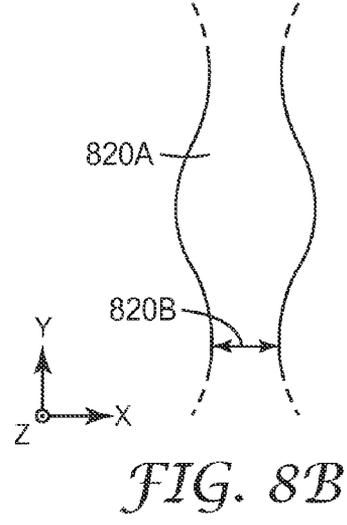
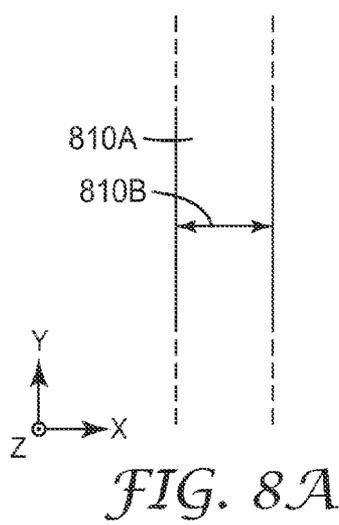


FIG. 7



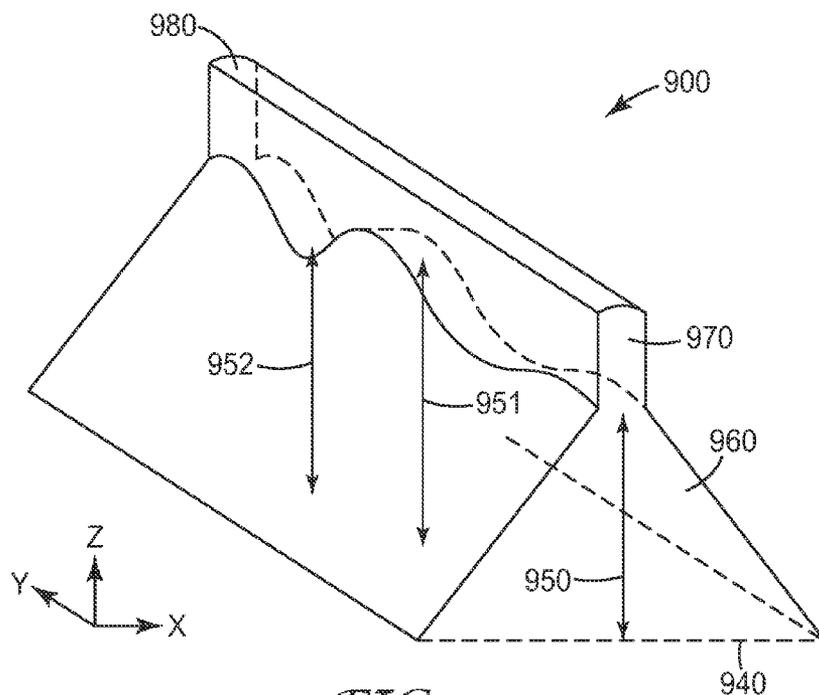


FIG. 9

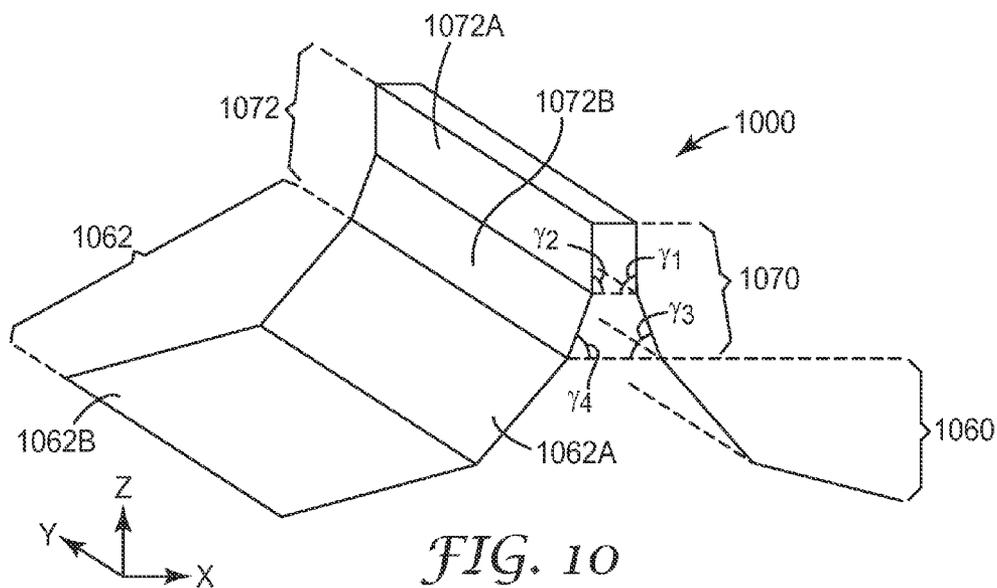


FIG. 10

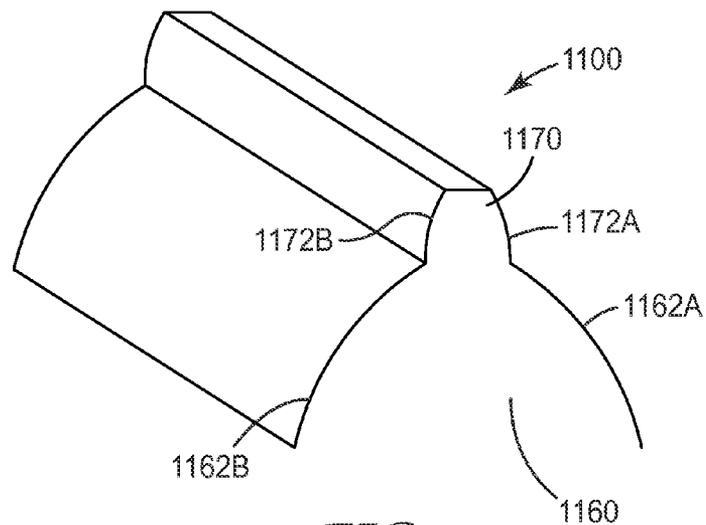


FIG. 11

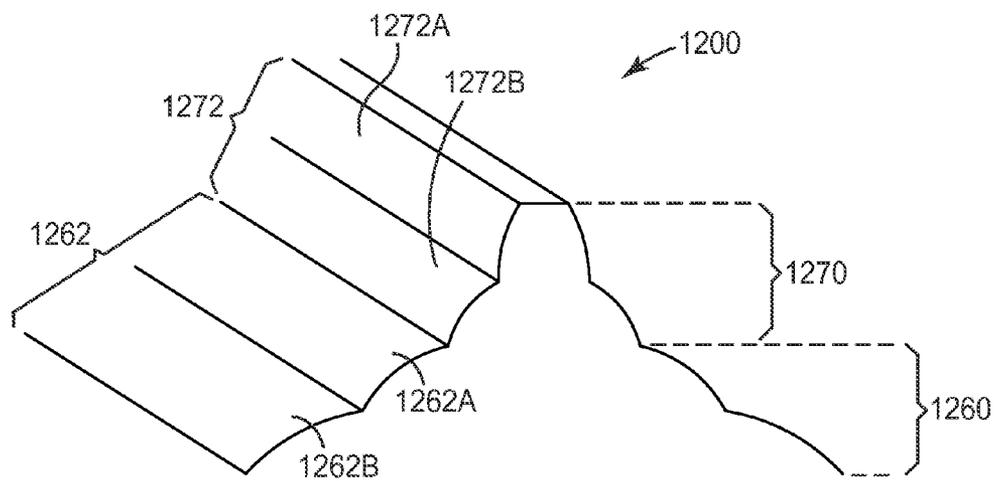
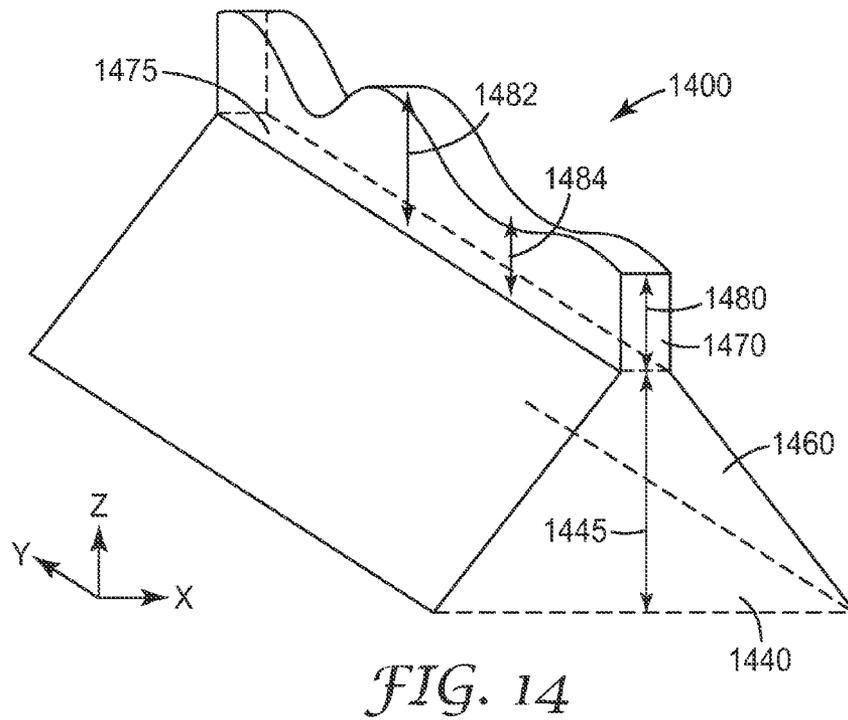
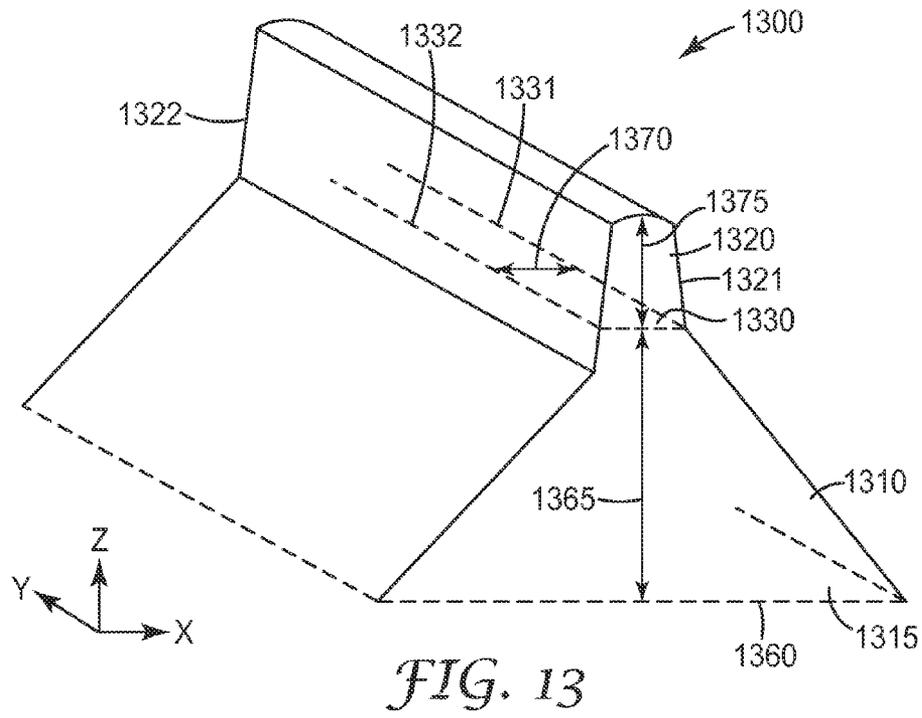
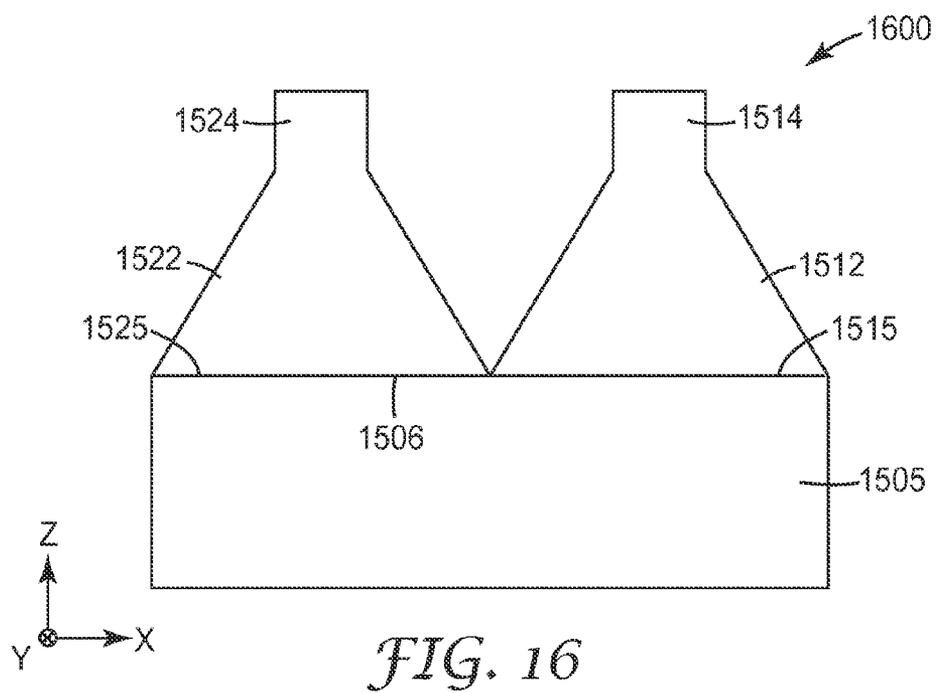
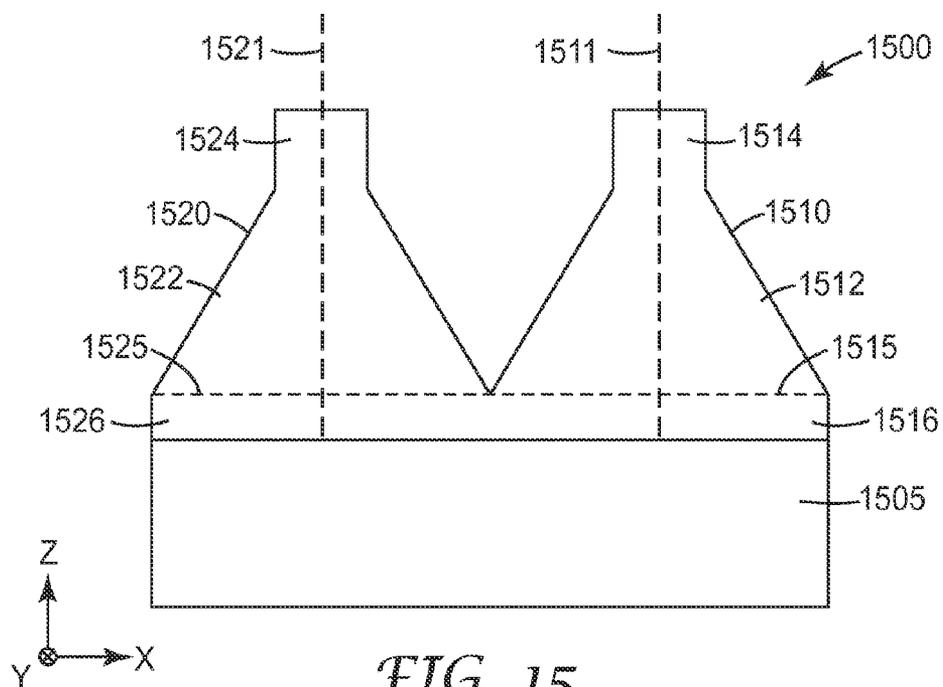


FIG. 12





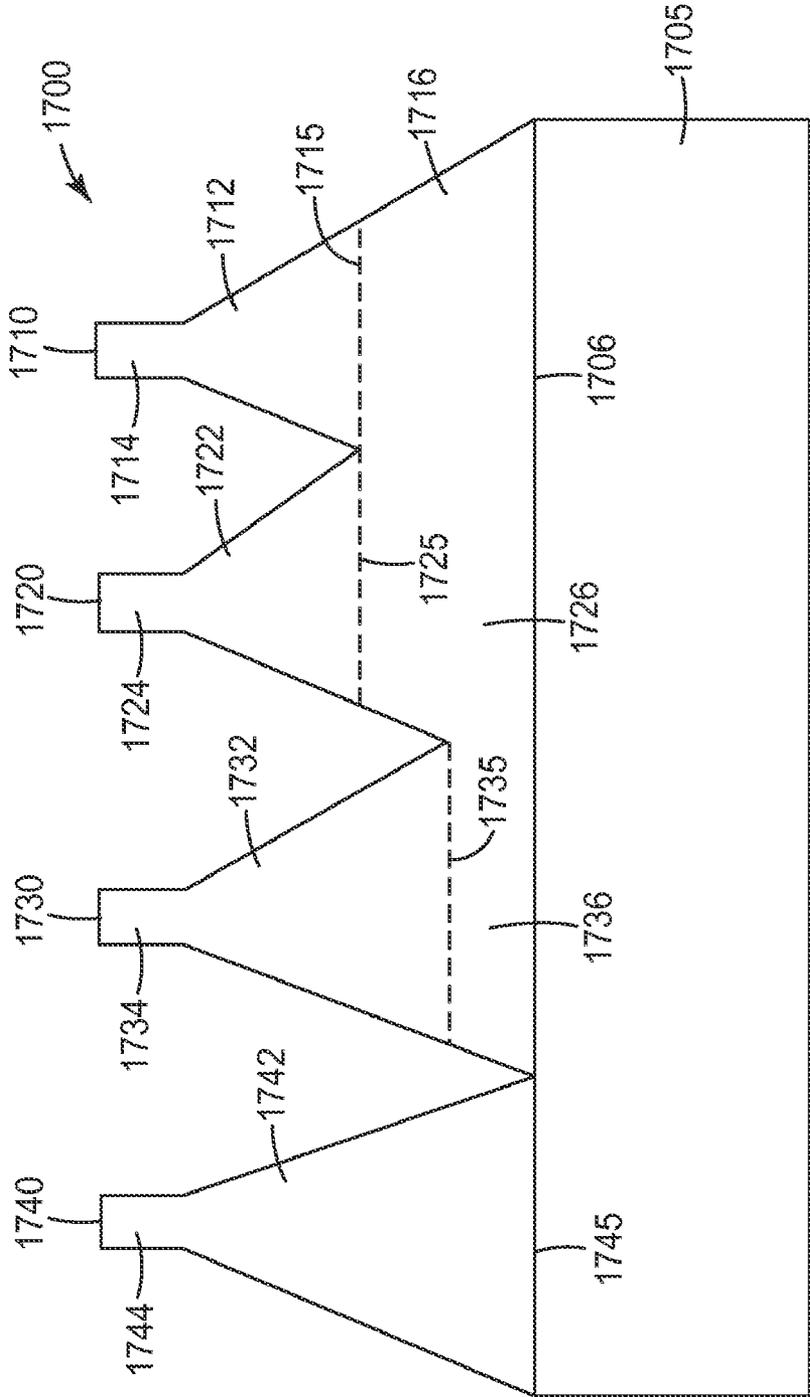


FIG. 17

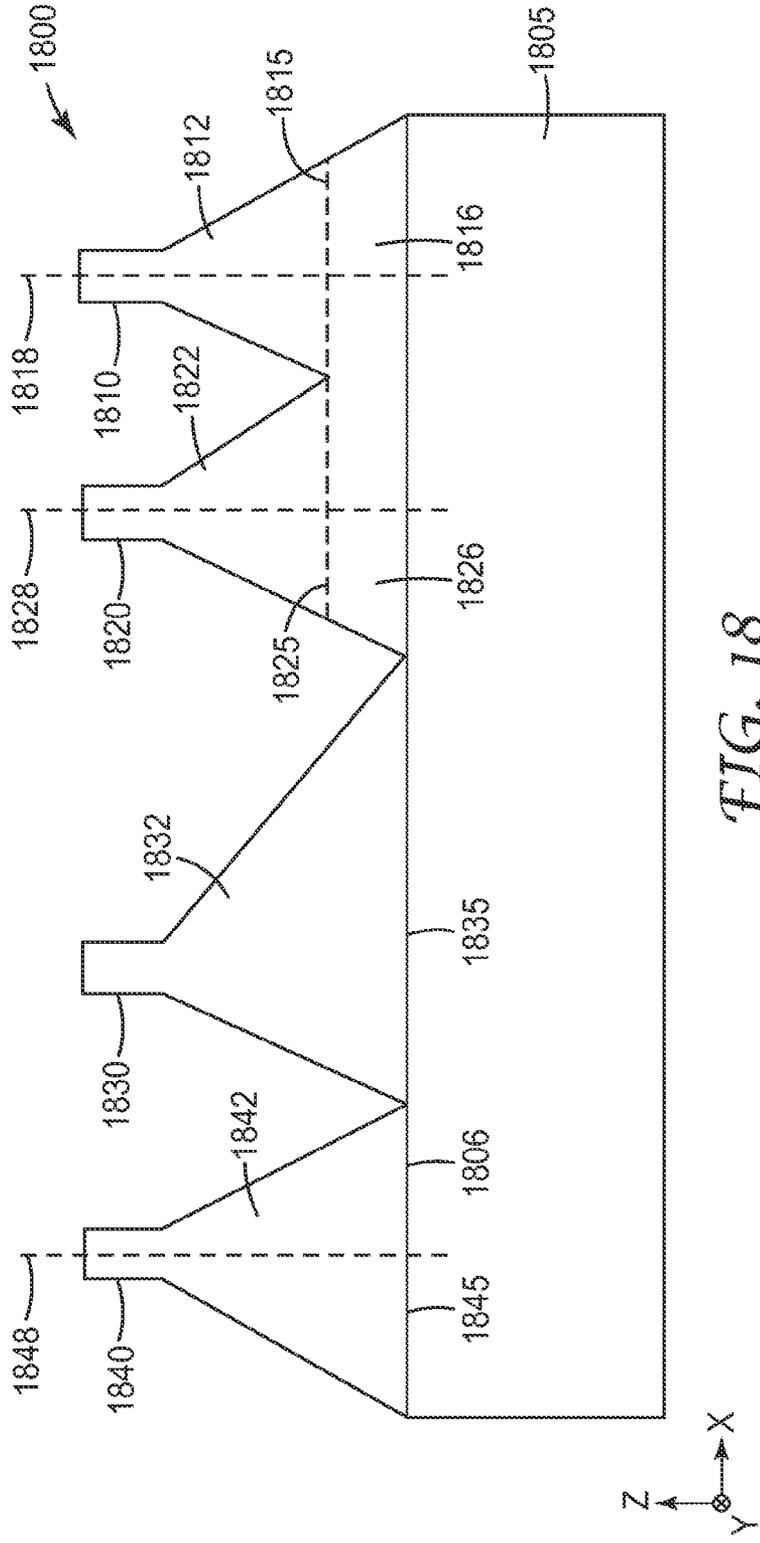


FIG. 18

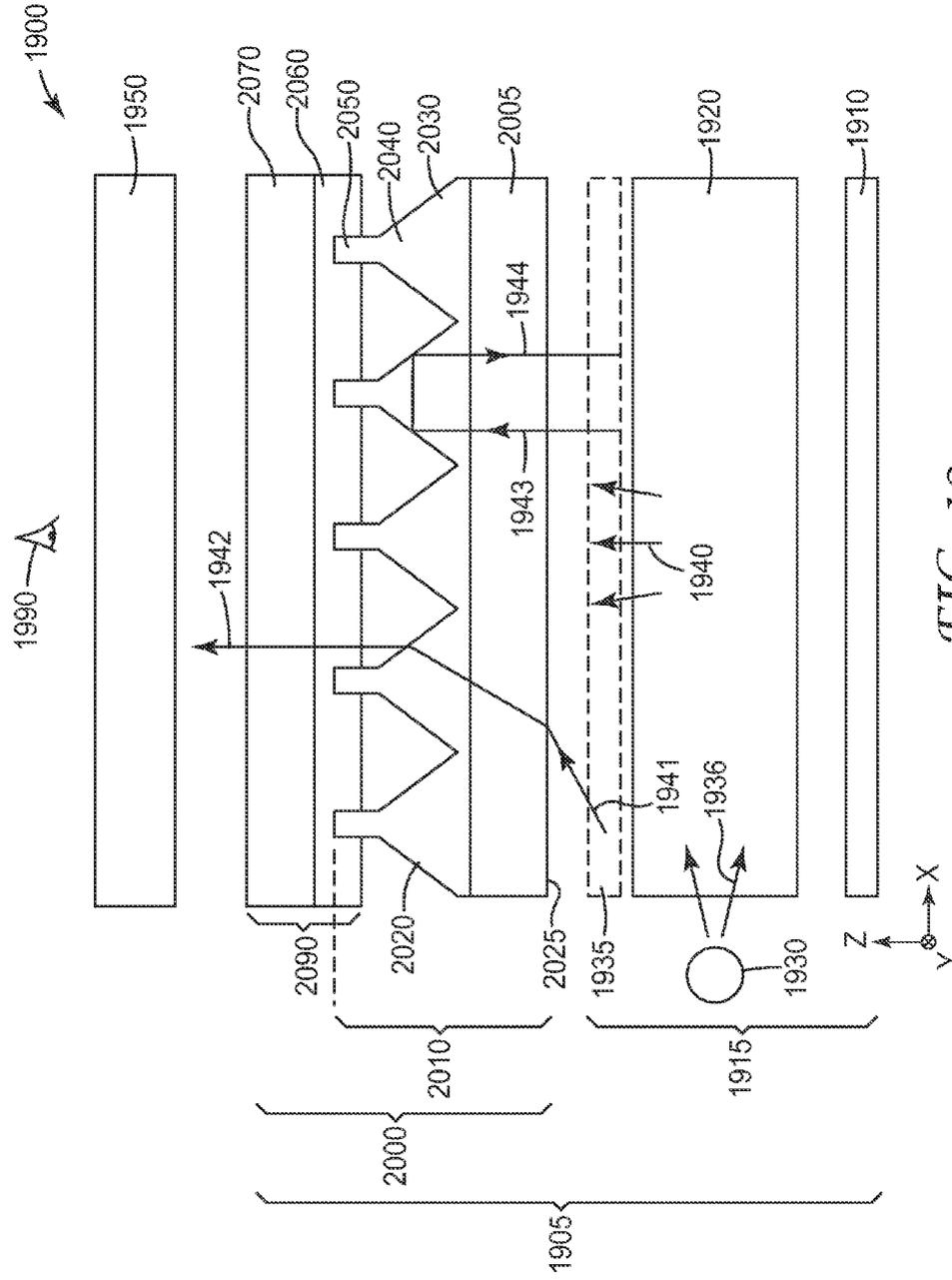


FIG. 19

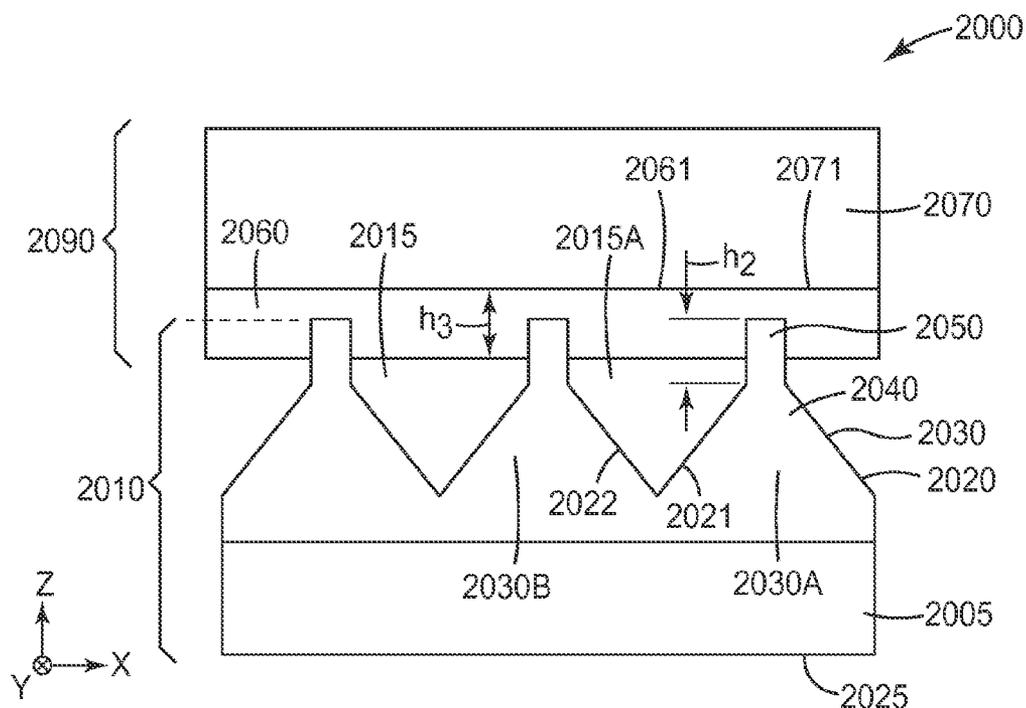


FIG. 20

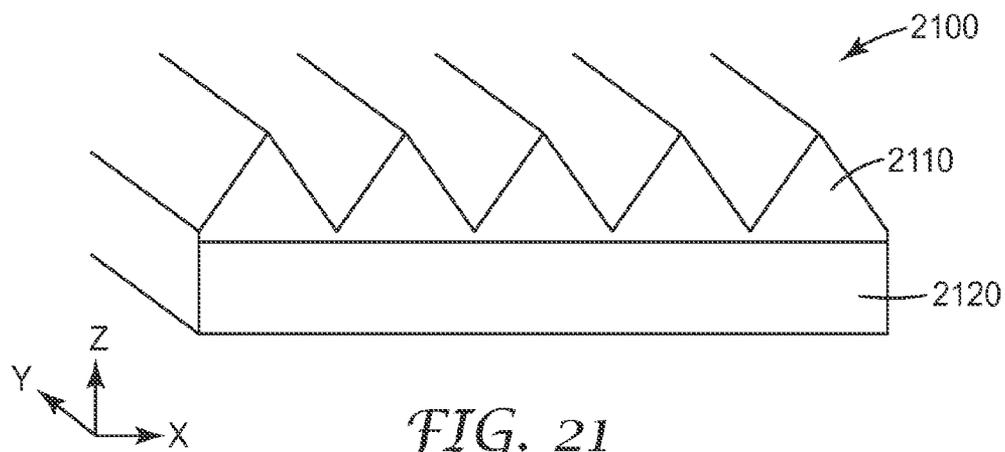


FIG. 21

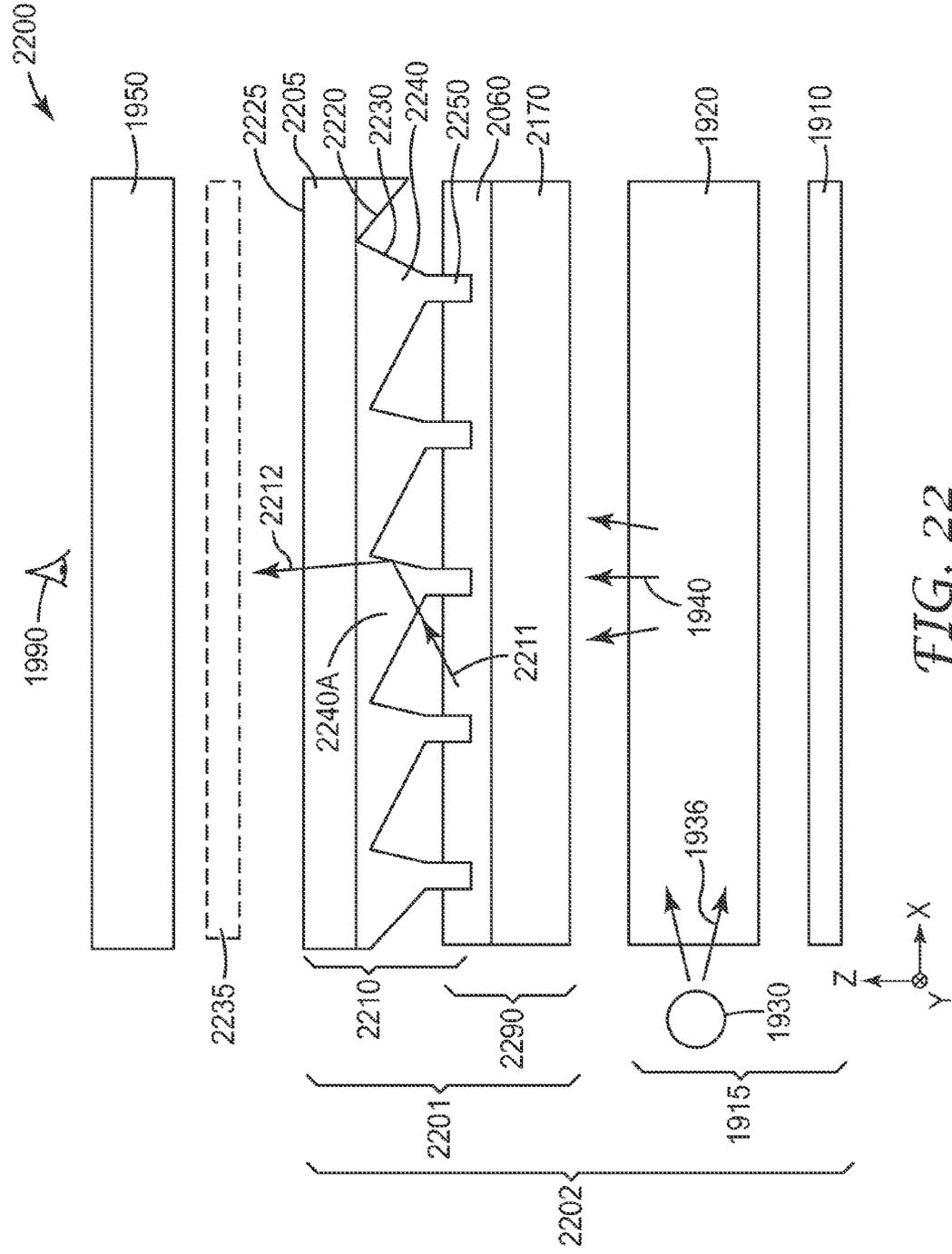


FIG. 22

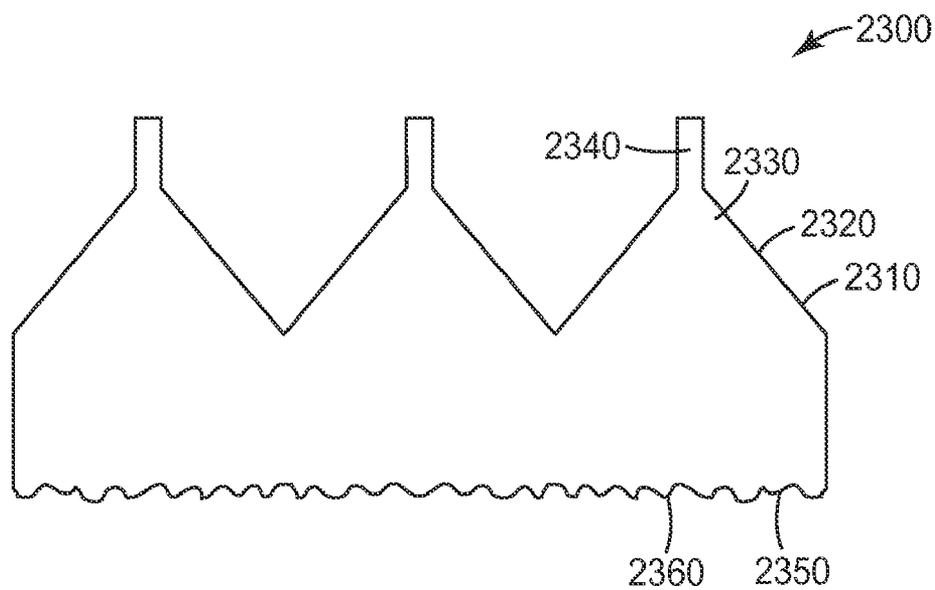


FIG. 23

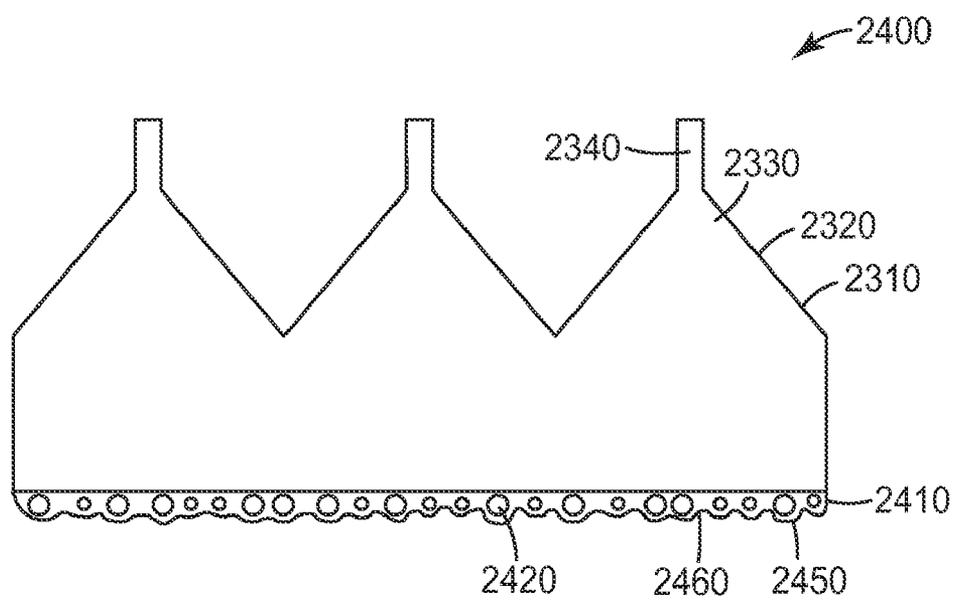


FIG. 24

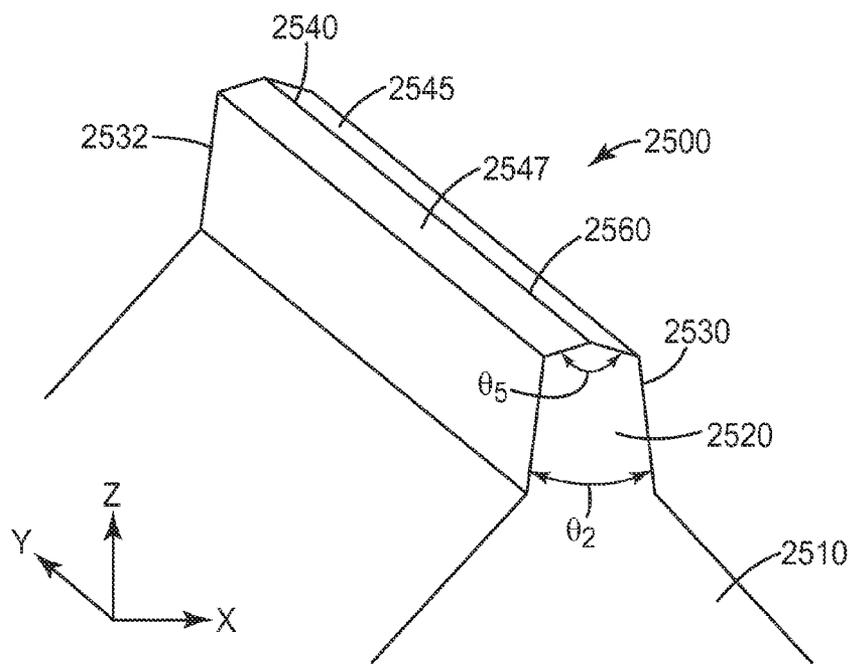


FIG. 25

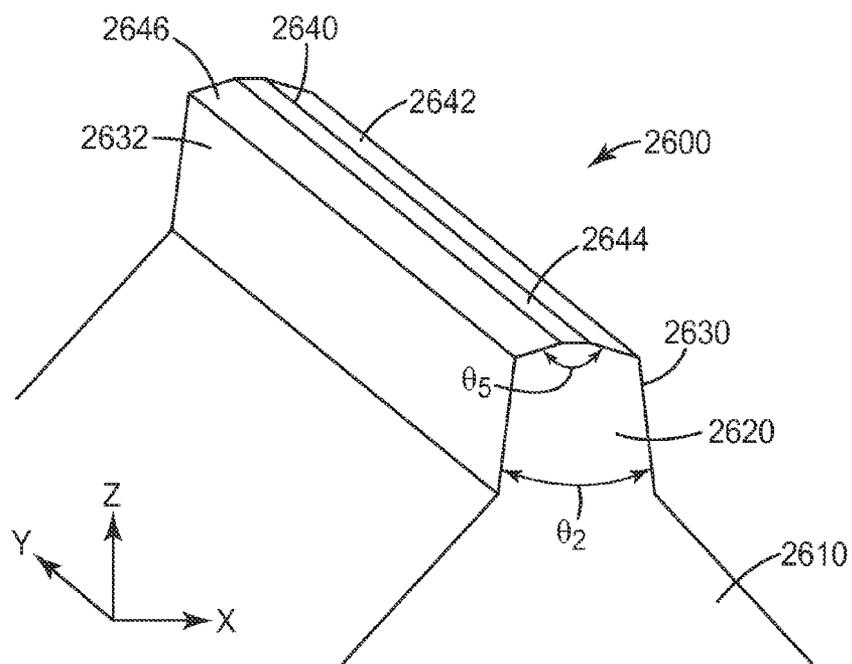


FIG. 26

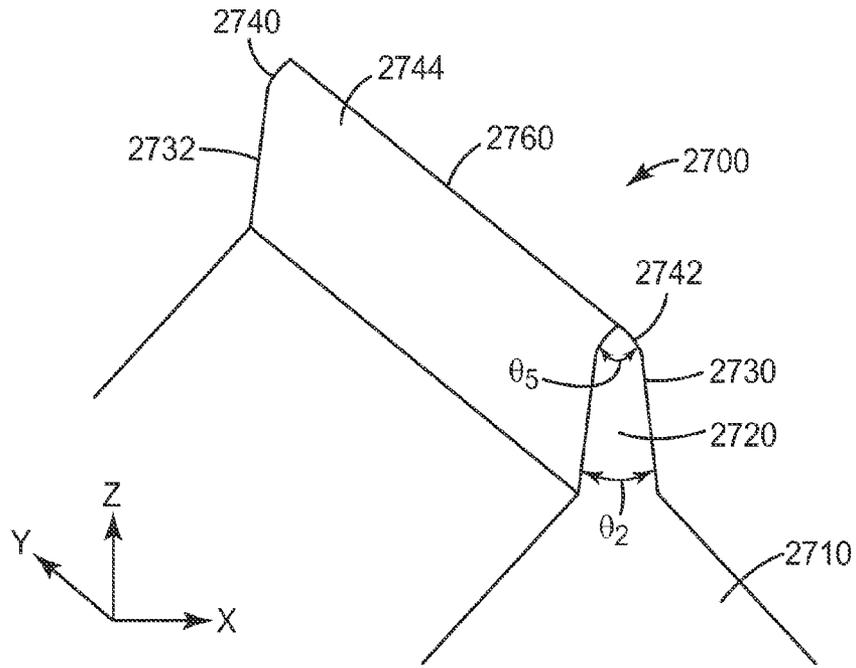


FIG. 27

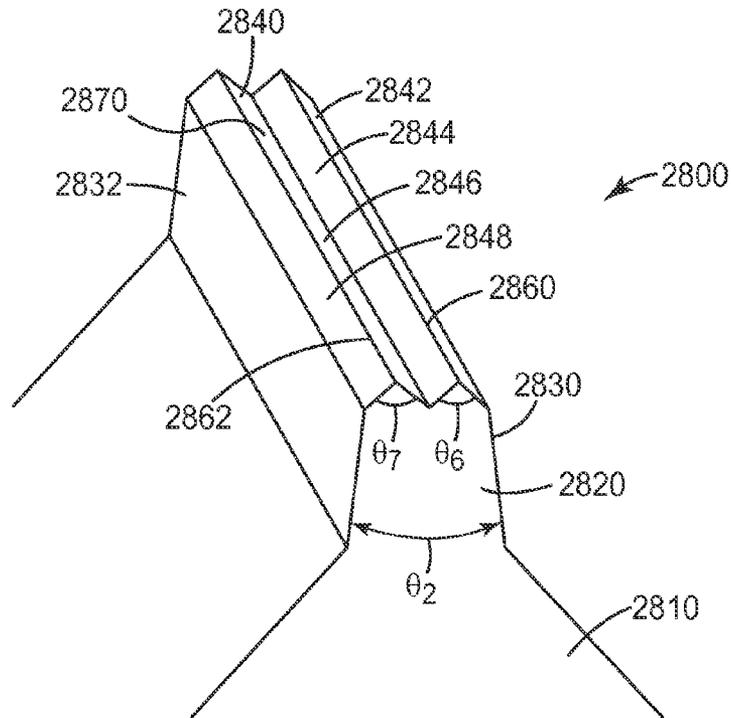


FIG. 28

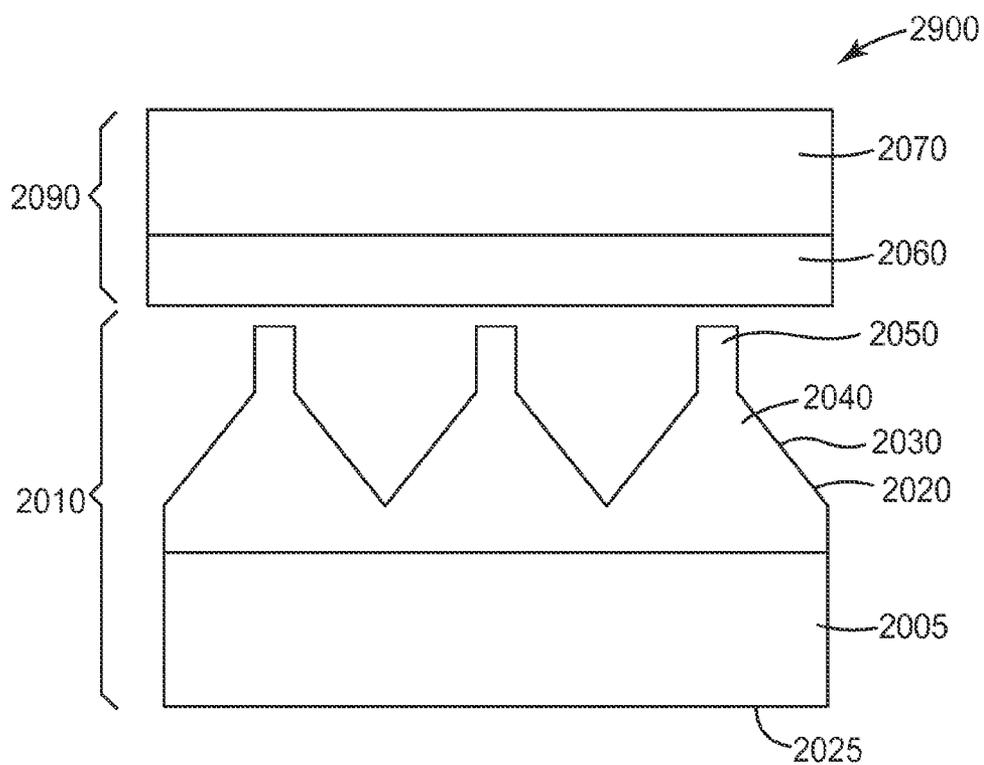


FIG. 29

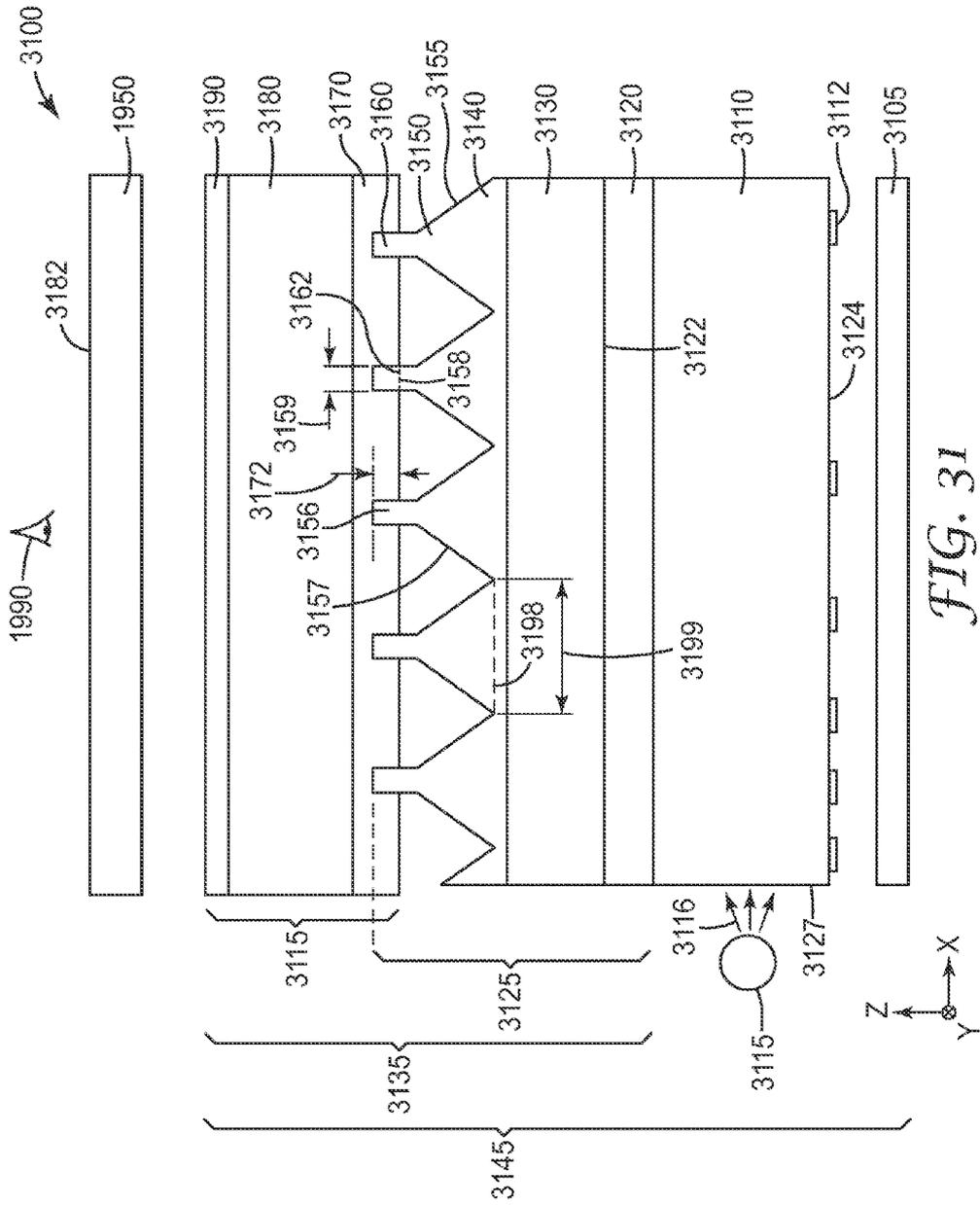


FIG. 31

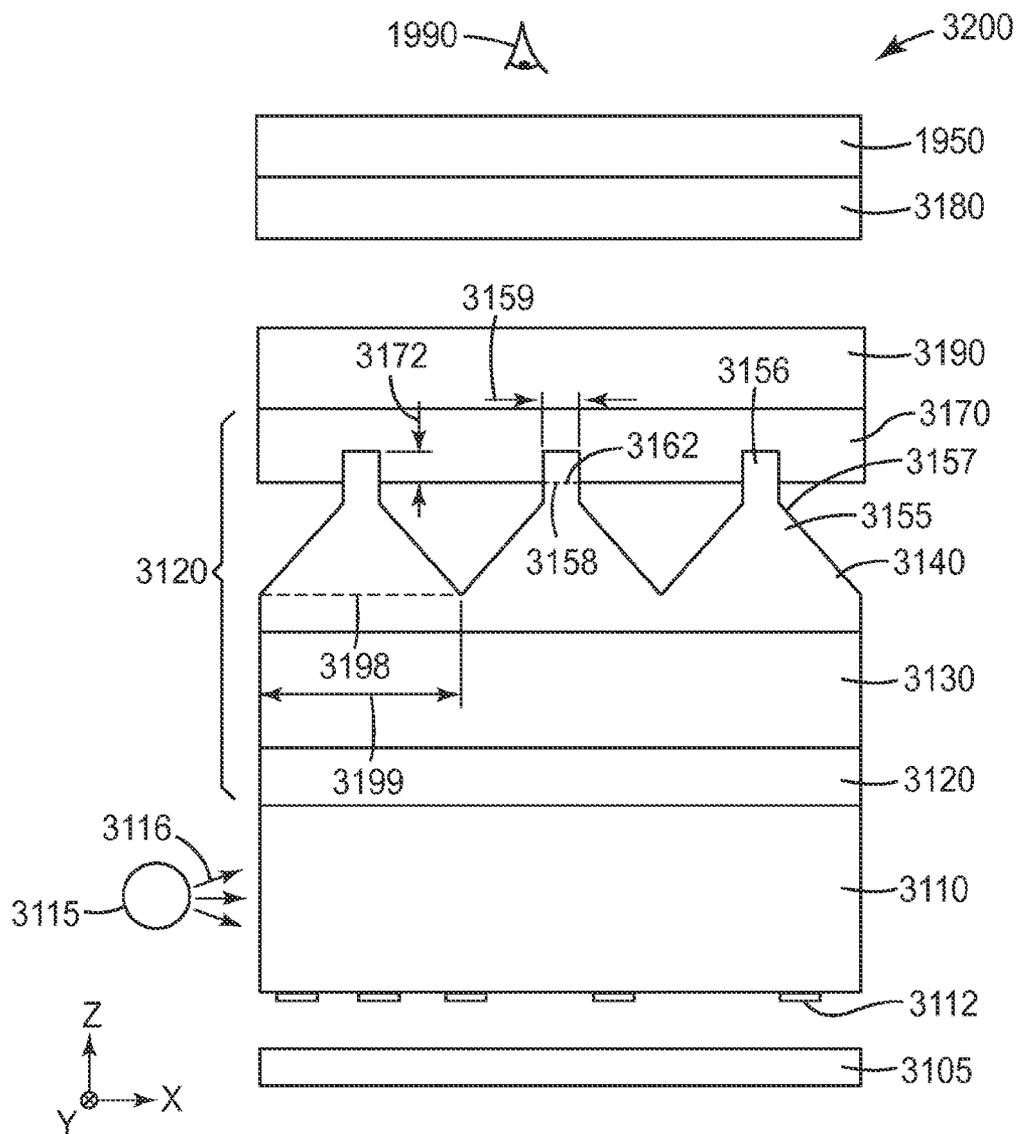


FIG. 32

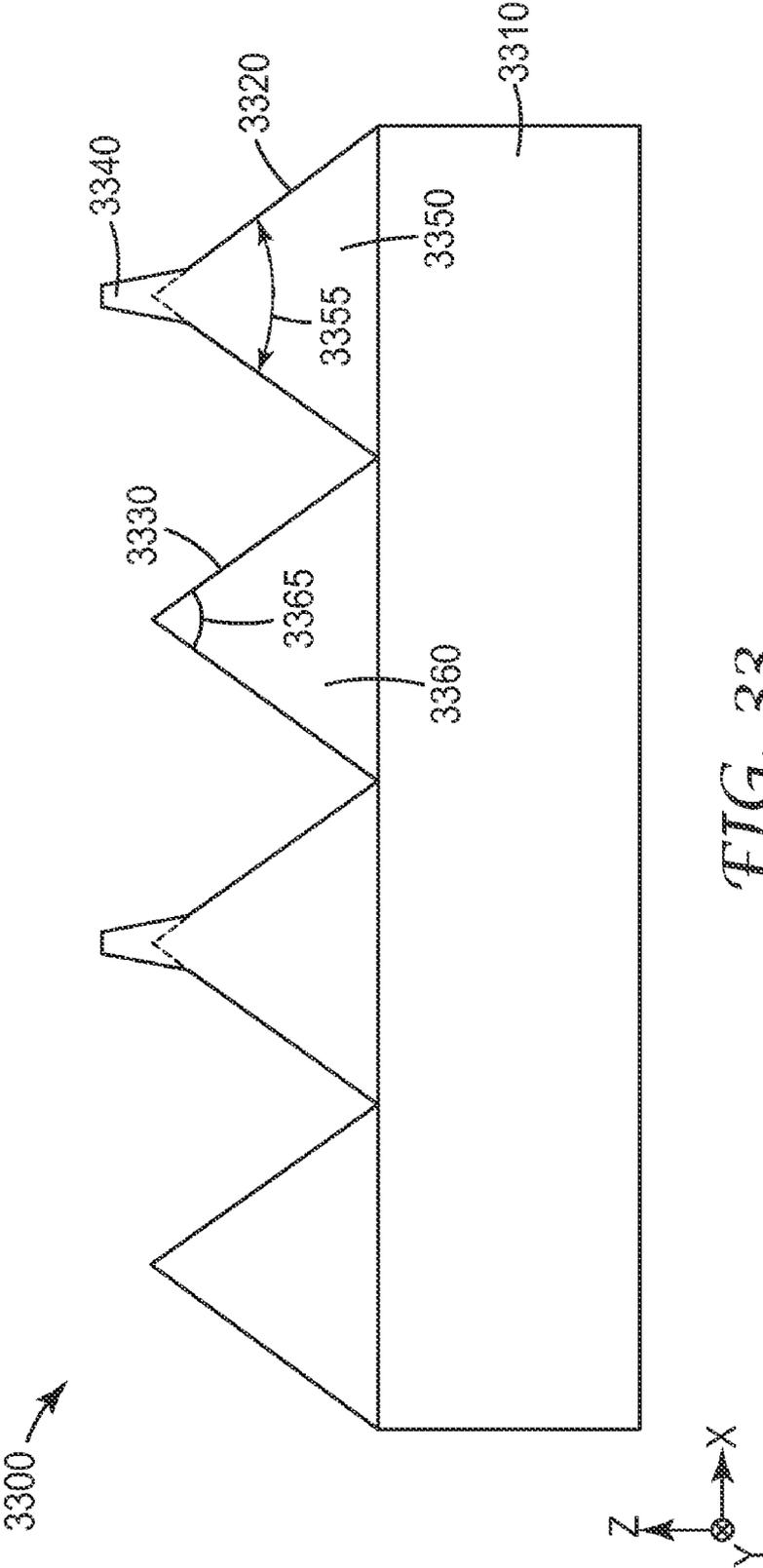


FIG. 33

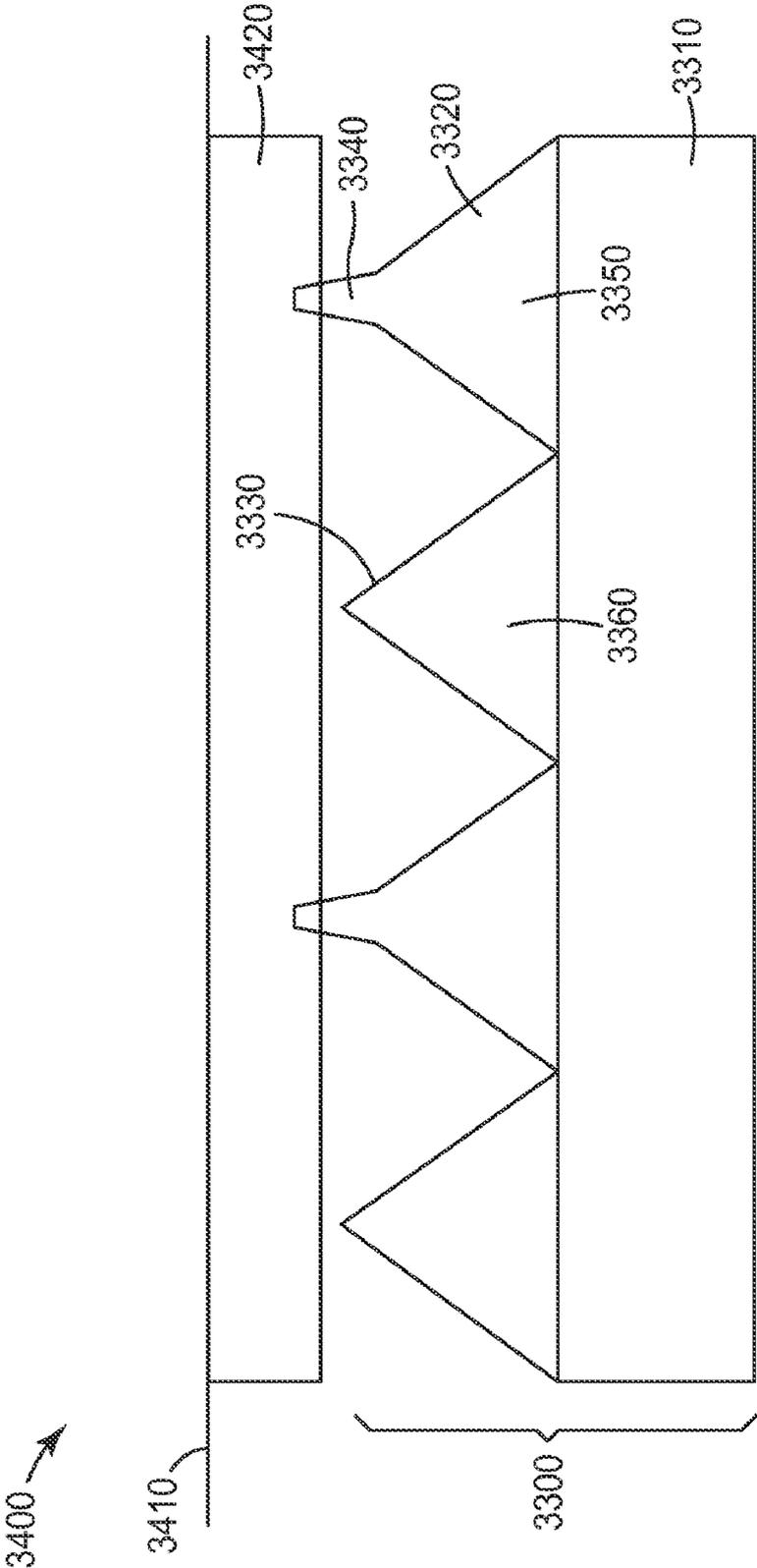


FIG. 34

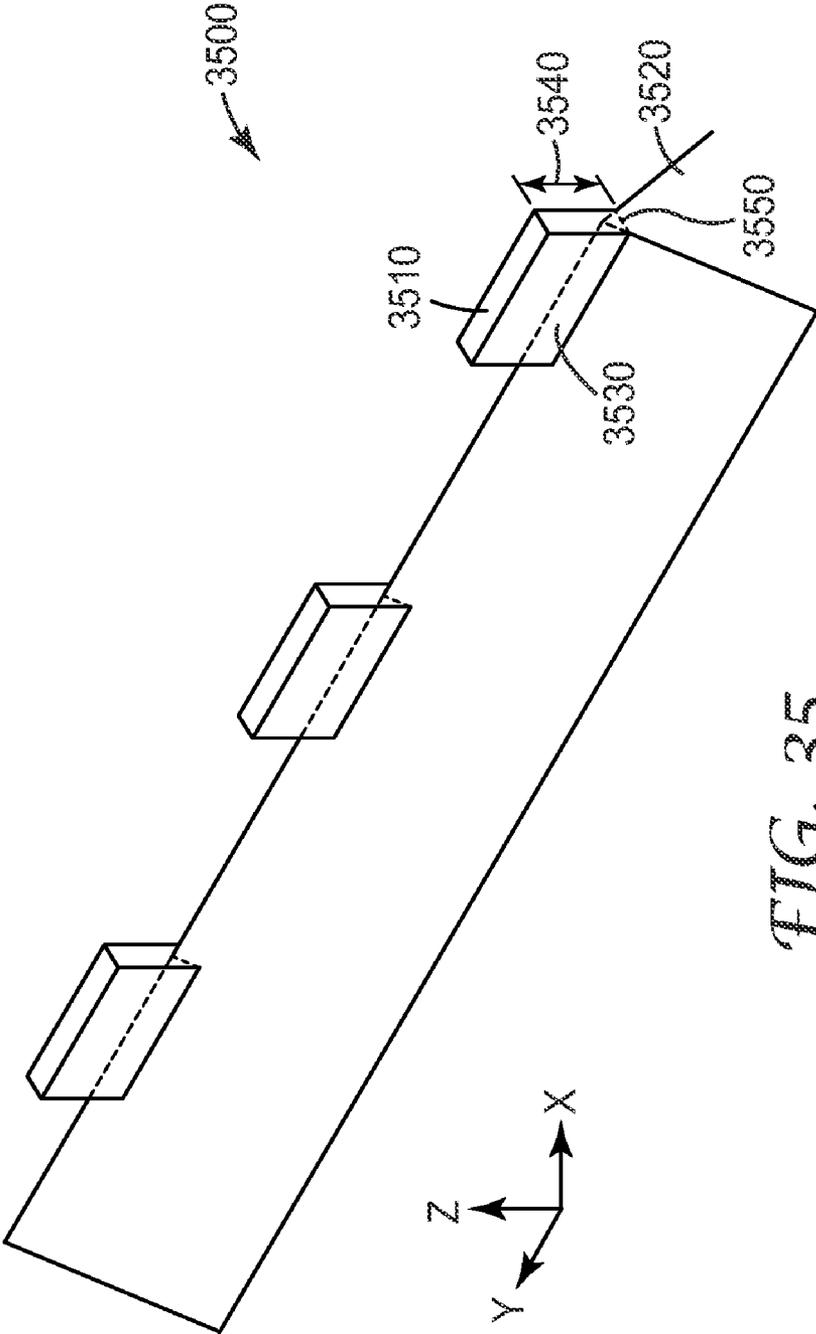


FIG. 35

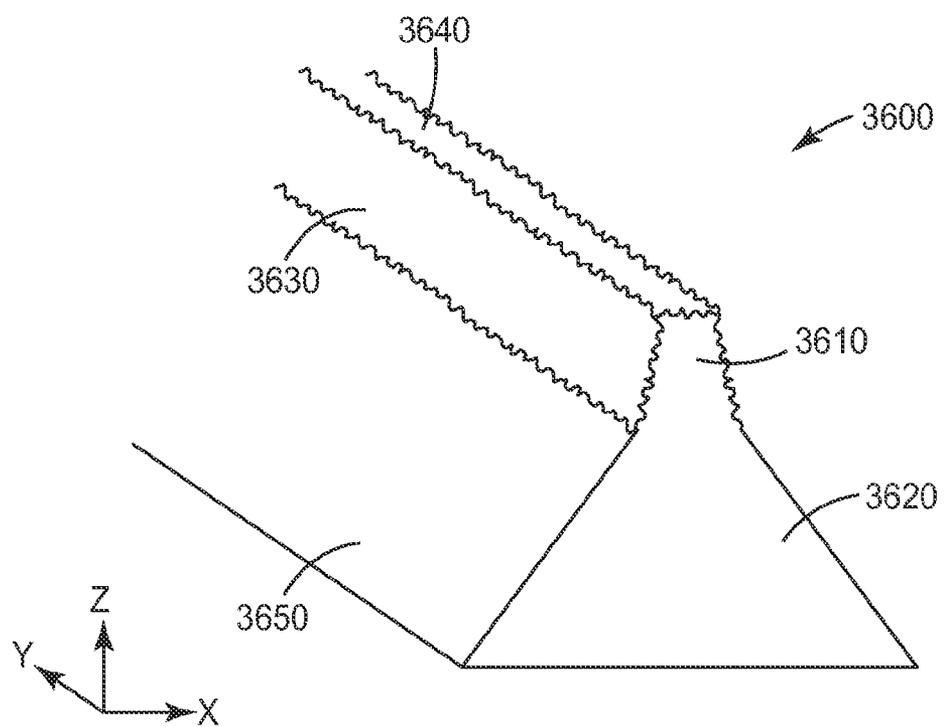


FIG. 36

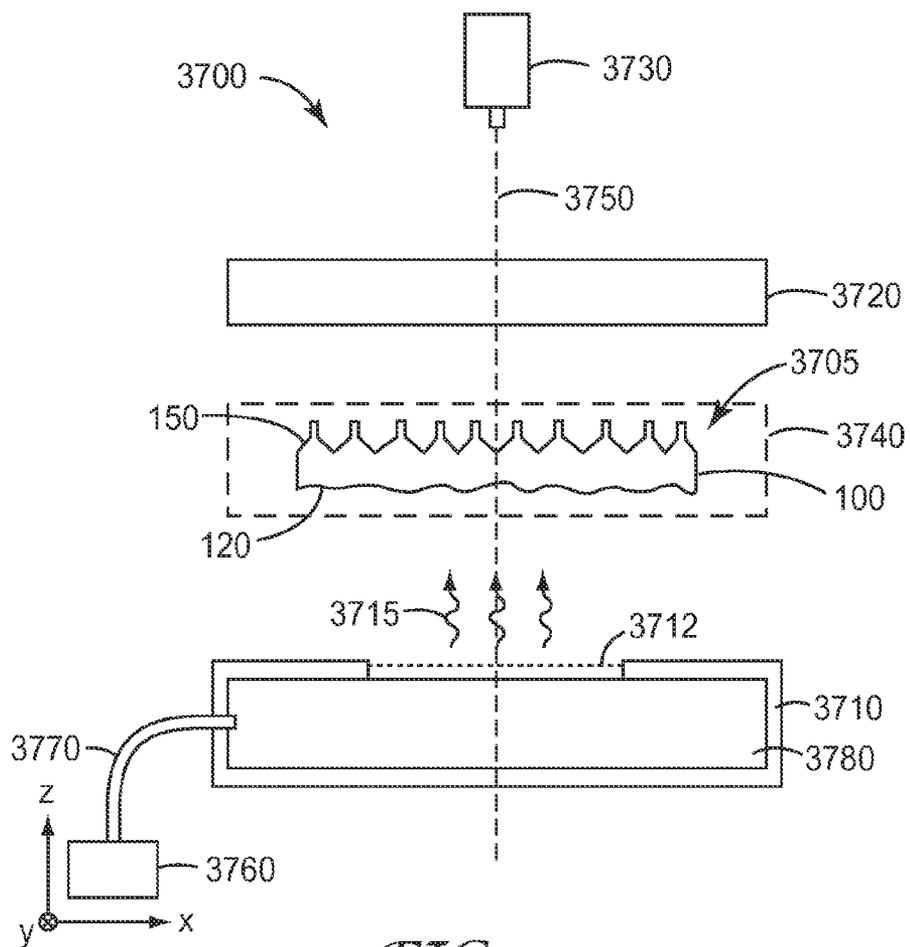
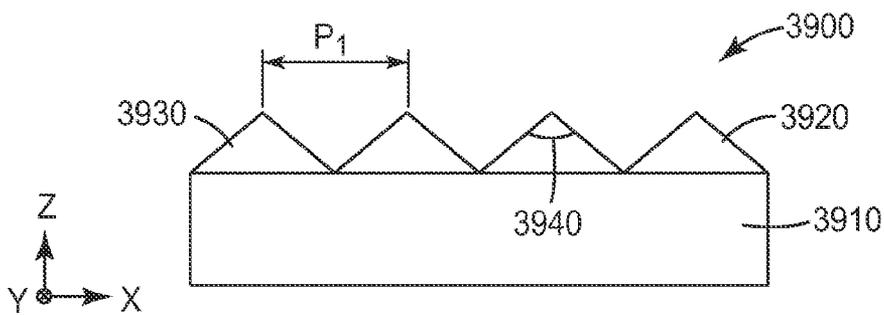
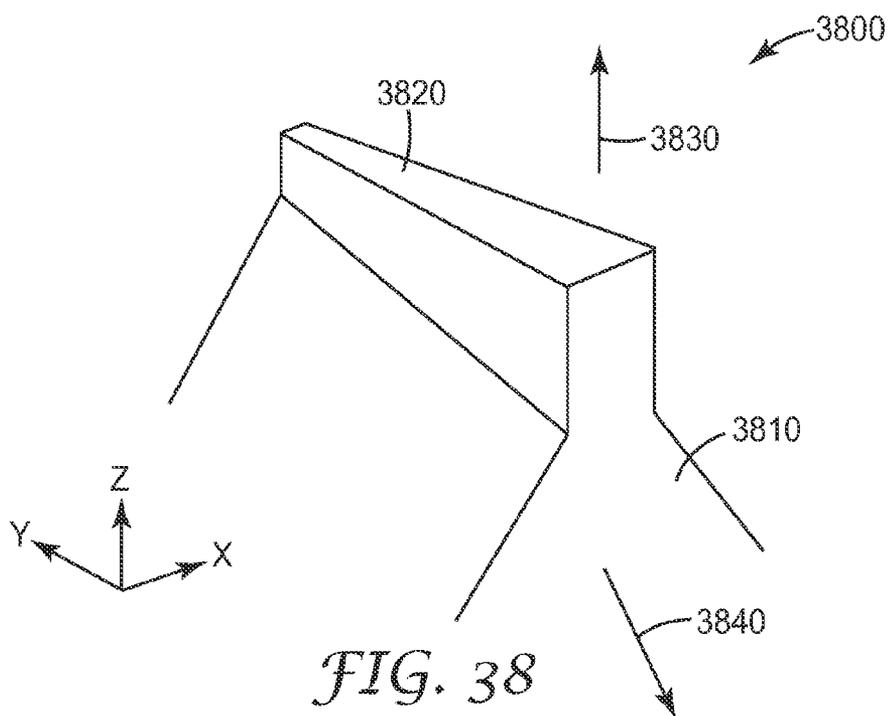


FIG. 37



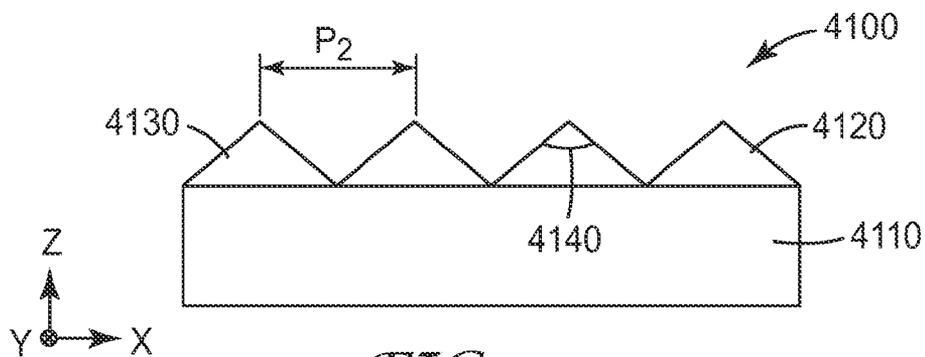


FIG. 41



FIG. 42

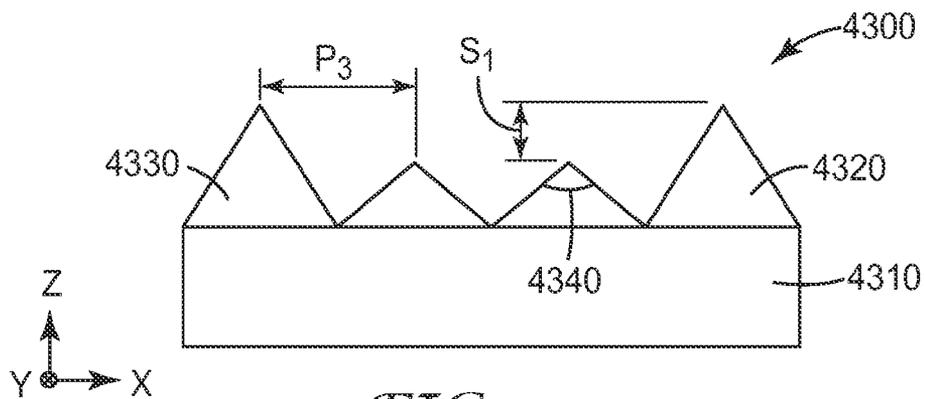


FIG. 43

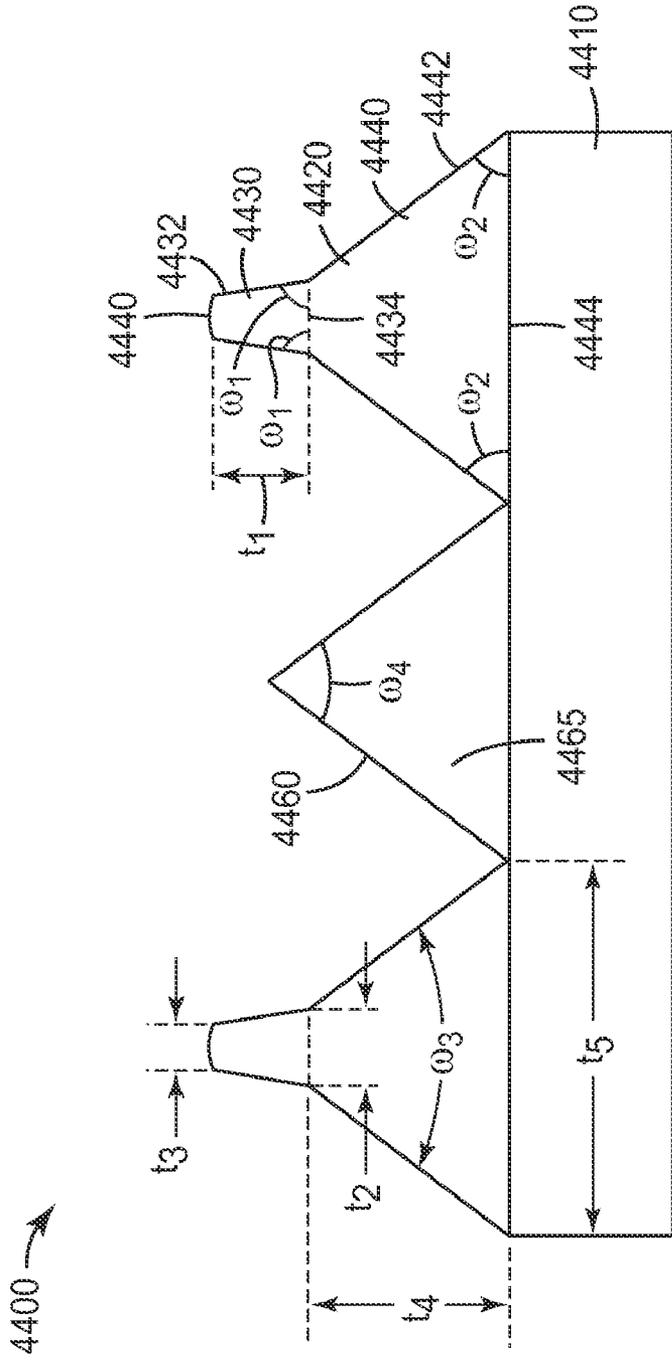


FIG. 44

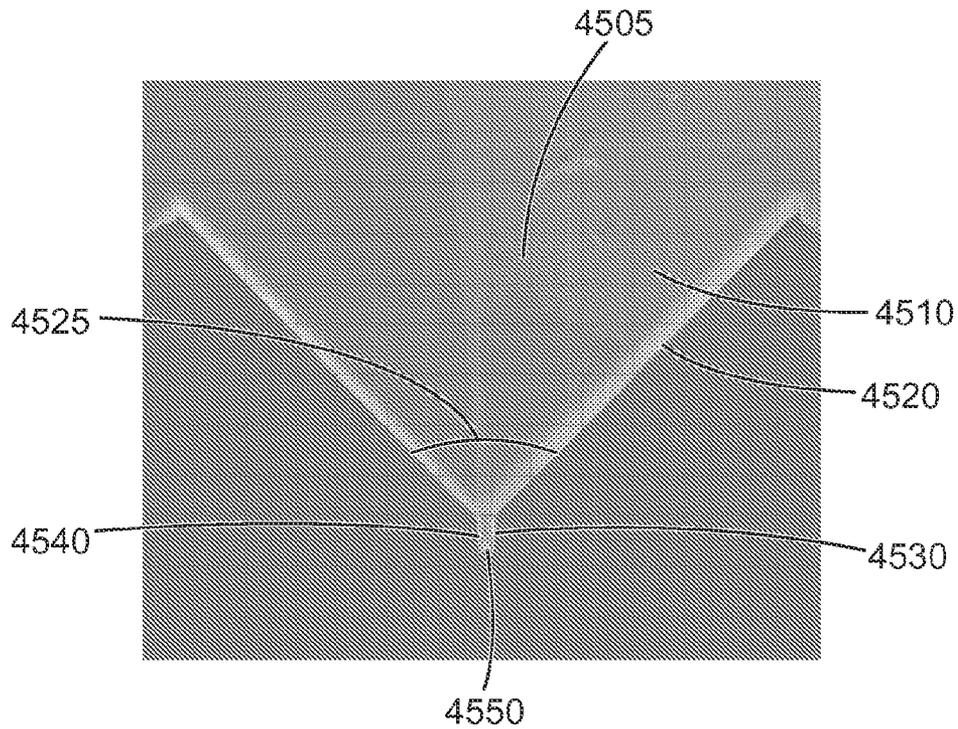


FIG. 45

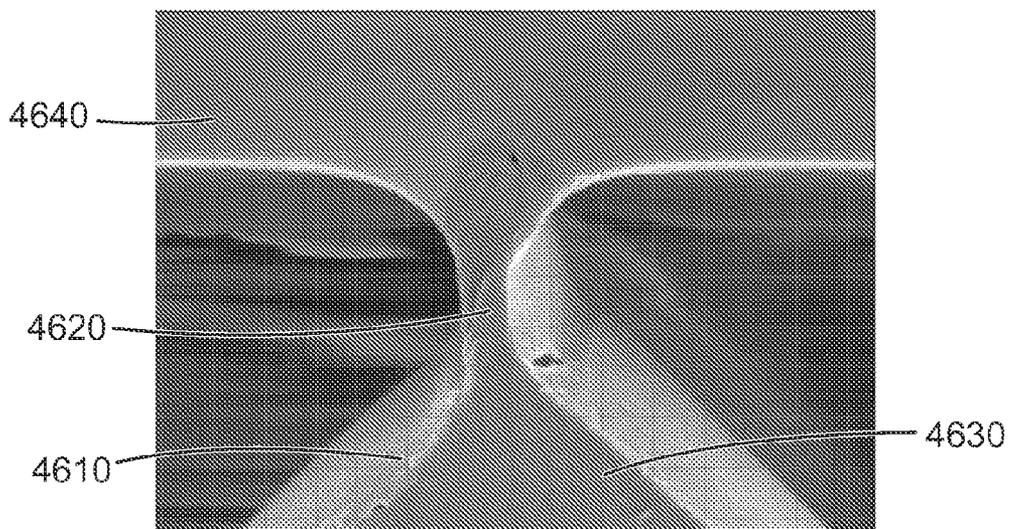


FIG. 46

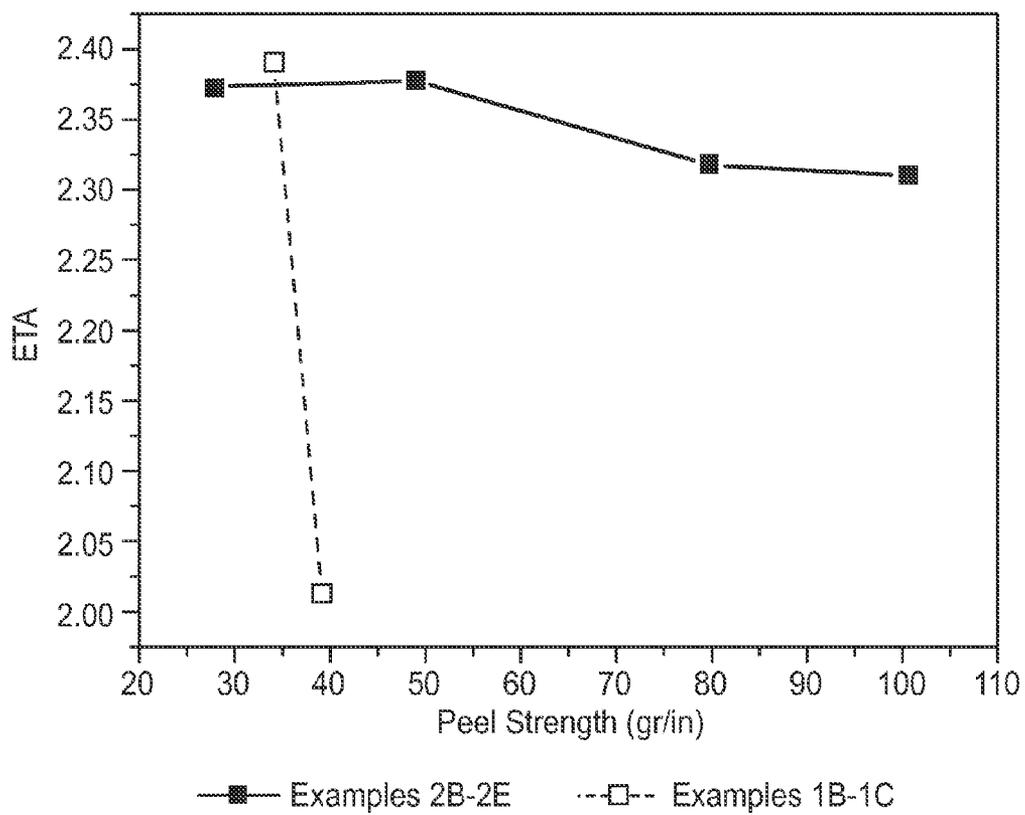


FIG. 47

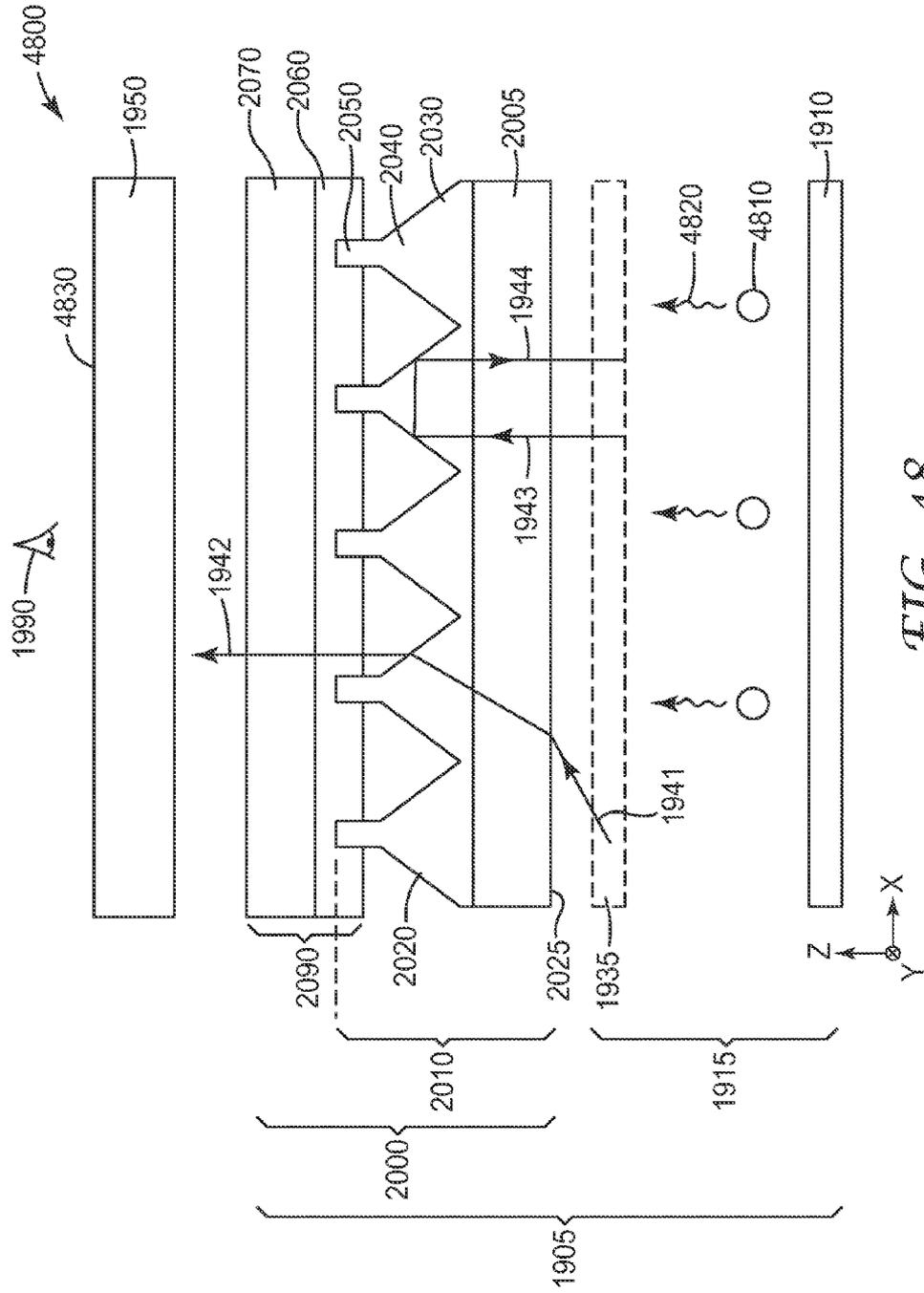


FIG. 48

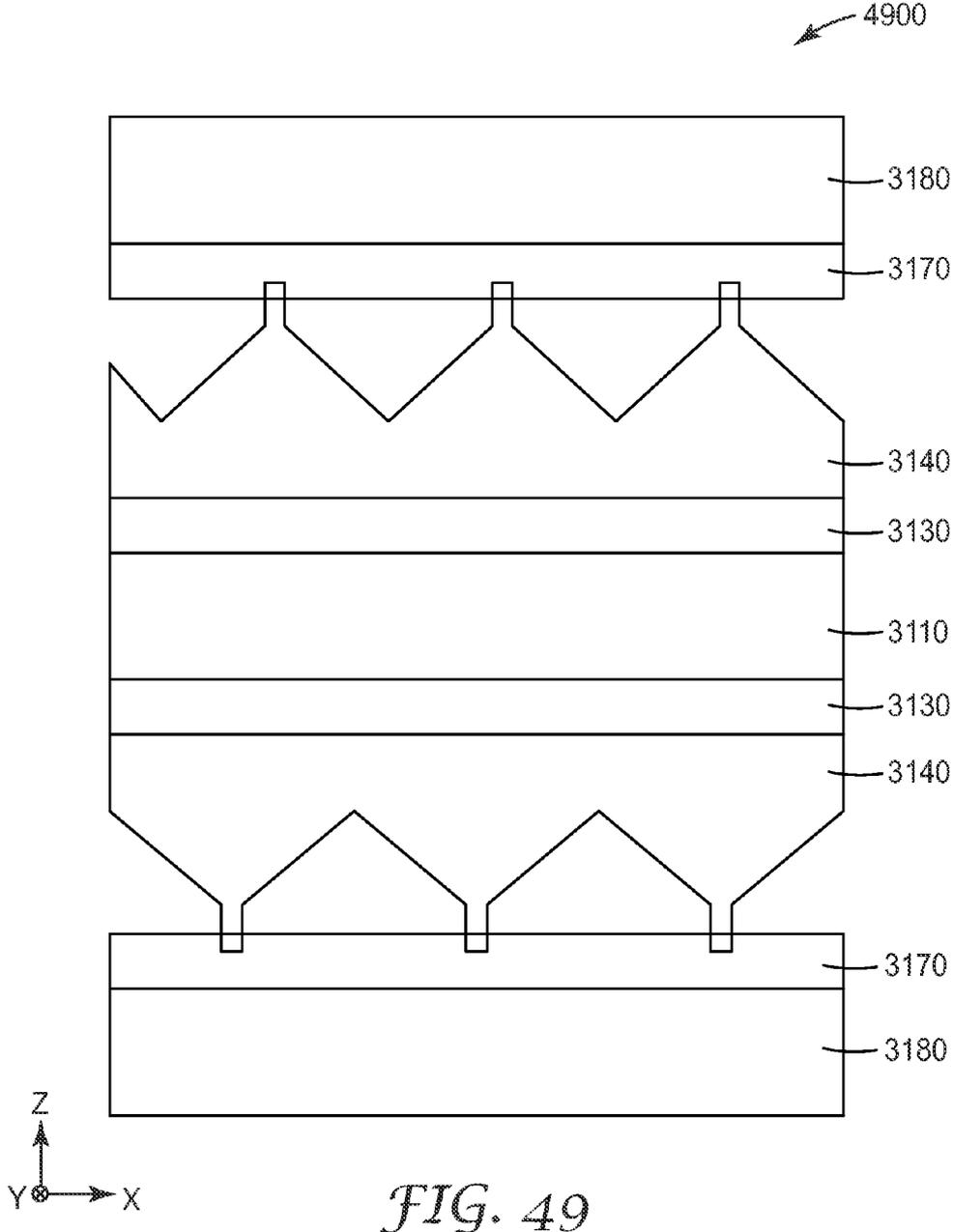


FIG. 49

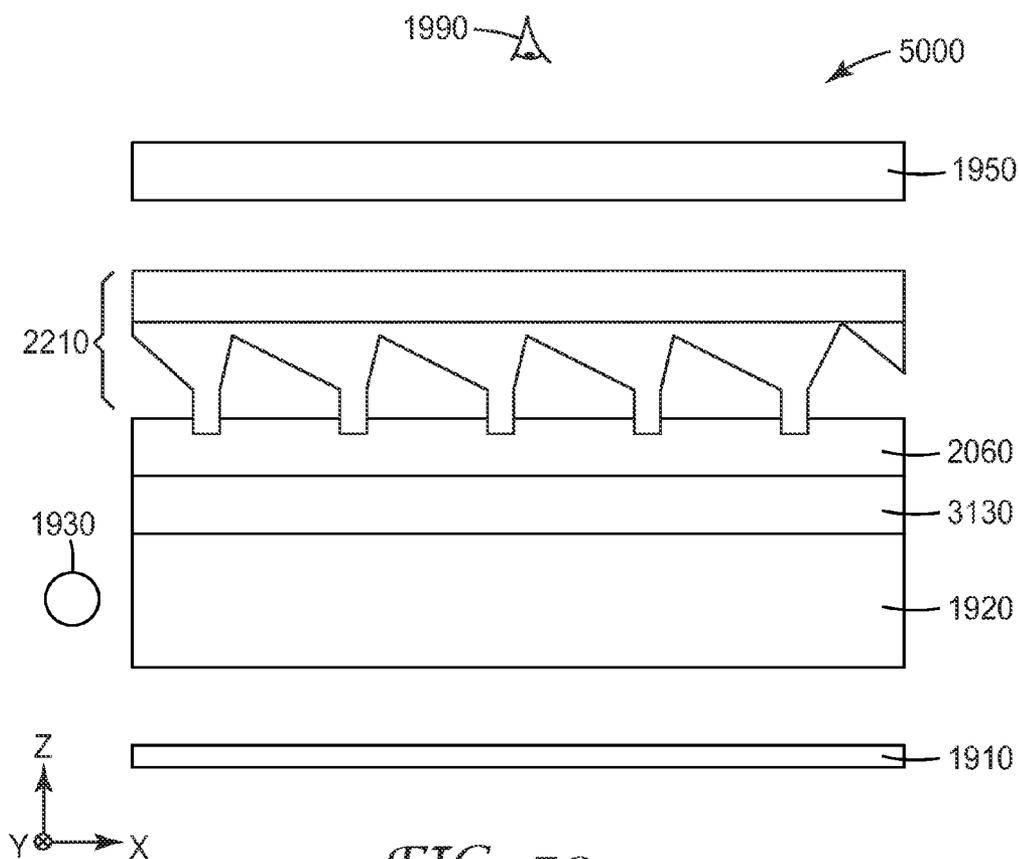


FIG. 50

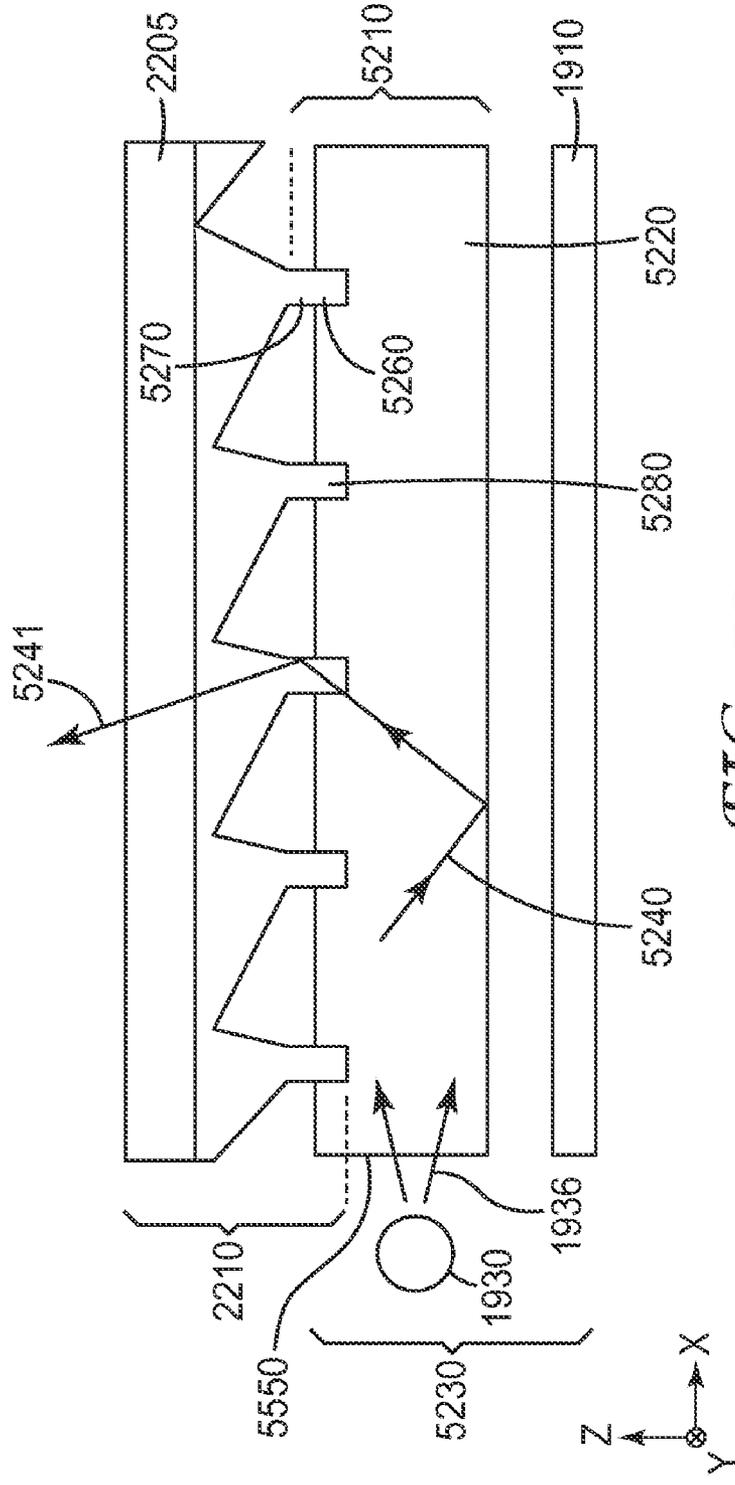


FIG. 52

OPTICAL STACK

RELATED APPLICATIONS

[0001] This application is related to the following U.S. patent applications, filed on even date herewith and which are incorporated by reference: “Light Directing Film” (Attorney Docket No. 65903US002), and “Optical Stack and Light-guide” (Attorney Docket No. 66401US002).

FIELD OF THE INVENTION

[0002] This invention generally relates to optical stacks and displays incorporating same.

[0003] In particular, the invention relates to optical stacks that have reduced thickness and high peel strength with no or very little loss in optical properties.

BACKGROUND

[0004] Flat panel displays, such as displays that incorporate a liquid crystal panel, often incorporate one or more light directing films to enhance display brightness along a pre-determined viewing direction. Such light directing films typically include a plurality of linear microstructures that have prismatic cross-sectional profiles.

[0005] In some applications a single prismatic film is used, while in others two crossed prismatic films are employed, in which case, the two crossed prismatic films are often oriented normal to each other.

SUMMARY OF THE INVENTION

[0006] Generally, the present invention relates to optical stacks. In one embodiment, an optical stack includes a light redirecting film that includes a first structured major surface that includes a plurality of unitary discrete structures. The optical stack also includes an optical adhesive layer that is disposed on the light directing film. At least portions of at least some unitary discrete structures in the plurality of unitary discrete structures penetrates into the optical adhesive layer. At least portions of at least some unitary discrete structures in the plurality of unitary discrete structures do not penetrate into the optical adhesive layer. The peel strength of the light redirecting film and the optical adhesive layer is greater than about 30 grams/inch. The average effective transmission of the optical stack is not less or is less than by no more than about 10% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer. In some cases, the average effective transmission of the optical stack is not less or is less than by no more than about 8%, or about 6%, or about 4%, as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer. In some cases, the optical stack includes a substrate that is directly bonded to the optical adhesive layer. In some cases, the optical stack includes another light directing film that is bonded to the optical adhesive layer and includes a plurality of linear prismatic structures. In some cases, the optical stack includes a reflective polarizer layer. In some cases, the peel strength of the light redirecting film and the optical adhesive layer is greater than about 40 grams/inch, or about 50 grams/inch, or about 60 grams/inch. In some cases, an illumination system includes a light source that emits light and the optical stack receiving the emitted light. In some cases, the light directing film is disposed between the optical film and the light source.

In some cases, the optical film is disposed between the light directing film and the light source.

[0007] In some cases, each of at least some unitary discrete structures in the plurality of unitary discrete structures includes a light directing portion that is primarily for directing light and includes a plurality of side facets, where each side facet makes an angle that is greater than about 40 degrees with the normal to the light directing film. Each unitary discrete structure also includes a bonding portion that is primarily for penetrating at least partially into the optical adhesive layer and includes a base that has a minimum dimension. The bonding portion also has a maximum height. The ratio of the maximum height to the minimum dimension is at least about 1.5.

[0008] In another embodiment, an optical stack includes a light directing film that includes a plurality of unitary discrete structures, and an optical adhesive layer that is disposed on the light directing film for adhering the light directing film to a surface. Portions of each unitary discrete structure penetrate into the optical adhesive layer and portions of each unitary discrete structure do not penetrate into the optical adhesive layer. Each unitary discrete structure defines a penetration depth and a penetration base at the interface between the penetrating and non-penetrating portions of the unitary discrete structure. The penetration base has a minimum penetration base dimension. The plurality of unitary discrete structures has an average penetration depth and an average minimum penetration base dimension. The ratio of the average penetration depth to the average minimum penetration base dimension is at least 1.5. The peel strength between the light directing film and the surface is greater than about 30 grams/inch. In some cases, the optical stack includes a plurality of voids between the optical adhesive layer and the light directing film. In some cases, each unitary discrete structure includes a light directing portion that is primarily for directing light and a bonding portion that is primarily for bonding the light directing film to the surface. At least portions of the bonding portion of each unitary discrete structure penetrate the optical adhesive layer. At least portions of the light directing portion of each unitary discrete structure do not penetrate the optical adhesive layer. In some cases, the ratio of the average penetration depth to the average minimum penetration base dimension is at least 2, or at least 3, or at least 4, or at least 5, or at least 7, or at least 10. In some cases, the peel strength between the light directing film and the surface is greater than about 40 grams/inch, or about 60 grams/inch, or about 80 grams/inch. In some cases, the average minimum penetration base dimension is less than about 10 microns, or about 7 microns, or about 5 microns, or about 4 microns, or about 3 microns.

[0009] In some cases, each unitary discrete structure has a base and a minimum base dimension. The plurality of unitary discrete structures has an average minimum base dimension. The average minimum penetration base dimension is less than about 10% of the average minimum base dimension. In some cases, the average minimum penetration base dimension is less than about 8%, or about 6%, or about 5%, or about 4%, or about 3%, of the average minimum base dimension.

[0010] In another embodiment, an optical stack includes a light directing film that includes a first plurality of unitary discrete structures, and an optical layer that is disposed on the light directing film. Portions of each unitary discrete structure in the first plurality of unitary discrete structures penetrate into the optical layer, and portions of each unitary discrete

structure in the first plurality of unitary discrete structures do not penetrate into the optical layer. Each unitary discrete structure in the first plurality of unitary discrete structures defines a penetration depth and a penetration base at the interface between the penetrating and non-penetrating portions of the unitary discrete structure. The penetration base has a minimum penetration base dimension. The first plurality of unitary discrete structures has an average penetration depth and an average minimum penetration base dimension. The ratio of the average penetration depth to the average minimum penetration base dimension is at least 1.5. The peel strength between the light directing film and the optical layer is greater than about 30 grams/inch. In some cases, the optical layer is a pressure sensitive adhesive, or a structural adhesive. In some cases, the optical layer is a lightguide that includes means for extracting light that propagates within the lightguide by total internal reflection. In some cases, the optical layer includes a glass transition temperature that is greater than the maximum operating temperature of the optical stack. In some cases, the light directing film includes a second plurality of unitary discrete structures, where at least one unitary discrete structure in the second plurality of unitary discrete structures does not penetrate into the optical layer. In some cases, the unitary discrete structures in the second plurality of discrete structures are shorter than the unitary discrete structures in the first plurality of discrete structures.

BRIEF DESCRIPTION OF DRAWINGS

- [0011] The invention may be more completely understood and appreciated in consideration of the following detailed description of various embodiments of the invention in connection with the accompanying drawings, in which:
- [0012] FIG. 1 is a schematic side-view of a light directing film;
- [0013] FIG. 2 is a schematic side-view of a composite structure;
- [0014] FIG. 3 is a schematic three-dimensional view of a unitary discrete structure;
- [0015] FIG. 4 is a schematic three-dimensional view of another unitary discrete structure;
- [0016] FIG. 5 is a schematic side-view of a unitary discrete structure partially penetrating an optical layer;
- [0017] FIG. 6 is a schematic three-dimensional view of a light directing film;
- [0018] FIG. 7 is a schematic three-dimensional view of another light directing film;
- [0019] FIGS. 8A-8E are schematic top-view of bases of different structures;
- [0020] FIG. 9 is a schematic three-dimensional view of a unitary discrete structure;
- [0021] FIG. 10 is a schematic three-dimensional view of another unitary discrete structure;
- [0022] FIG. 11 is a schematic three-dimensional view of another unitary discrete structure;
- [0023] FIG. 12 is a schematic three-dimensional view of yet another unitary discrete structure;
- [0024] FIG. 13 is a schematic three-dimensional view of yet another unitary discrete structure;
- [0025] FIG. 14 is a schematic three-dimensional view of yet another unitary discrete structure;
- [0026] FIG. 15 is a schematic side-view of a light directing film;
- [0027] FIG. 16 is a schematic side-view of another light directing film;
- [0028] FIG. 17 is a schematic side-view of another light directing film;
- [0029] FIG. 18 is a schematic side-view of yet another light directing film;
- [0030] FIG. 19 is a schematic side-view of a display system;
- [0031] FIG. 20 is a schematic side-view of an optical stack;
- [0032] FIG. 21 is a schematic three-dimensional view of a light directing film;
- [0033] FIG. 22 is a schematic side-view of a display system;
- [0034] FIG. 23 is a schematic side-view of a light directing film;
- [0035] FIG. 24 is a schematic side-view of another light directing film;
- [0036] FIG. 25 is a schematic three-dimensional view of a unitary discrete structure;
- [0037] FIG. 26 is a schematic three-dimensional view of another unitary discrete structure;
- [0038] FIG. 27 is a schematic three-dimensional view of another unitary discrete structure;
- [0039] FIG. 28 is a schematic three-dimensional view of yet another unitary discrete structure;
- [0040] FIG. 29 is a schematic side-view of an optical stack;
- [0041] FIG. 30 is a schematic side-view of another optical stack;
- [0042] FIG. 31 is a schematic side-view of a display system;
- [0043] FIG. 32 is a schematic side-view of another display system;
- [0044] FIG. 33 is a schematic side-view of a light directing film;
- [0045] FIG. 34 is a schematic side-view of an optical stack;
- [0046] FIG. 35 is a schematic three-dimensional view of a unitary discrete structure;
- [0047] FIG. 36 is a schematic three-dimensional view of another unitary discrete structure;
- [0048] FIG. 37 is a schematic side-view of an optical system;
- [0049] FIG. 38 is a schematic three-dimensional view of a cutting tool;
- [0050] FIG. 39 is a schematic side-view of a light directing film;
- [0051] FIG. 40 is a schematic side-view of a substrate;
- [0052] FIG. 41 is a schematic side-view of a light directing film;
- [0053] FIG. 42 is a schematic side-view of a reflective polarizer;
- [0054] FIG. 43 is a schematic side-view of a light directing film;
- [0055] FIG. 44 is a schematic side-view of another light directing film;
- [0056] FIG. 45 is an exemplary SEM of a cutting tool;
- [0057] FIG. 46 is an exemplary SEM of a unitary discrete structure partially penetrating an optical layer;
- [0058] FIG. 47 is a plot of average effective transmission as a function of peel strength;
- [0059] FIG. 48 is a schematic side-view of a display system;
- [0060] FIG. 49 is a schematic side-view of an optical stack;
- [0061] FIG. 50 is a schematic side-view of a display system;
- [0062] FIG. 51 is a schematic side-view of another display system; and

[0063] FIG. 52 is a schematic side-view of a lightguide.

[0064] In the specification, a same reference numeral used in multiple figures refers to the same or similar elements having the same or similar properties and functionalities.

DETAILED DESCRIPTION

[0065] The present invention generally relates to light directing films and displays that incorporate such light directing films. In particular, the invention relates to a light directing film that has a plurality of unitary discrete structures for directing and/or recycling light. The light directing film can bond to a surface, such as a major surface of an optical film or glass, via an optical adhesive layer, where the unitary discrete structures partially penetrate into the optical adhesive layer with no or very little loss in optical properties, such as optical gain or effective optical transmission.

[0066] FIG. 1 is a schematic side-view of a light directing film 100 that includes a first structured major surface 110 and an opposing second major surface 120. First structured major surface 110 includes a plurality of unitary discrete structures 150. Each unitary discrete structure 150 includes an upper portion or bonding portion 170 and a lower portion or light directing portion 160. As used herein, a unitary structure refers to a structure that is a single unit with no interior or internal physical or detectable interfaces between the different portions or segments of the structure. In other words, a unitary structure does not include any interfaces, such as a sharp interface, a gradient interface, or a distributed interface, within the interior of the structure. In some cases, a unitary structure is made of the same material composition meaning that different locations or portions within the structure have the same material composition and the same index of refraction. In some cases, a unitary structure can have a non-uniform material composition or index of refraction distribution. For example, in some cases, a unitary structure can have a gradient refractive index distribution along, for example, the thickness direction of the unitary structure.

[0067] For example, each unitary discrete structure 150 includes an upper portion 170 and a lower portion 160 that form a single unit without a physical or detectable interface between the upper and lower portions. As another example, FIG. 2 is a schematic side-view of a composite structure 200 that includes an upper portion 210 that is disposed on a lower portion 220, but is separated from the lower portion by a physical interface 230. Hence, exemplary composite structure 200 includes an internal and physical interface that physically separates two different portions in the composite structure. In some cases, portions 210 and 220 can have the same material composition. In such cases, structure 200 is still considered to be non-unitary if interface 230 can be detected between the two portions. A unitary structure is typically made or fabricated in a single step, meaning that the process of fabricating the unitary structure cannot reasonably be divided into multiple or separate steps. In some cases, however, a unitary structure can be made or fabricated in two or more steps. A non-unitary or composite structure is typically made in multiple steps. For example, composite structure 200 is made by first making lower portion 220 and then forming upper portion 210 on the lower portion.

[0068] Referring back to FIG. 1, unitary discrete structures 150 can have any shape, such as any regular or irregular shape, that may be desirable in an application. For example, in some cases, unitary discrete structures 150 can be or include a three-dimensional rectilinear body, such as a tetrahedron, a

prism, or a pyramid, or a portion, or a combination, of such bodies, such as a frustum. In some cases, unitary discrete structures 150 can be or include a three-dimensional curvilinear body, such as a segment of a sphere, an asphere, an ellipsoid, a spheroid, a paraboloid, a cone, or a cylinder. In some cases, at least some of the unitary discrete structures 150 have prismatic profiles.

[0069] Unitary structures 150 are discrete, meaning that each unitary structure can be identified individually and as being separate from other similar unitary structures disposed on substrate 130. Each unitary discrete structure 150 includes light directing portion 160 that is primarily designed to direct light. Light directing portion 160 can also be designed to perform other functions, but the primary function of the light directing portion is to redirect light by, for example, refracting or reflecting, such as totally internally reflecting, light.

[0070] In general, light directing portion 160 can have any shape, such as any regular or irregular shape, that may be desirable in an application. For example, in some cases, light directing portion 160 can be or include a three-dimensional rectilinear body, such as a tetrahedron, a prism, or a pyramid, or a portion, or a combination, of such bodies, such as a frustum. In some cases, light directing portion 160 can be or include a three-dimensional curvilinear body, such as a segment of a sphere, an asphere, an ellipsoid, a spheroid, a paraboloid, a cone, or a cylinder. In some cases, light directing portions 160 can have a rotationally symmetric bullet-shape structure.

[0071] Light directing portion 160 includes a plurality of first side facets 162. For example, in the exemplary light directing film 100, light directing portion 160A includes a first side facet 162A and an opposing first side facet 162B. In general, light directing portion 160 can have two or more side facets. For example, FIG. 3 is a schematic three-dimensional view of a unitary discrete structure 300 that is linear and extends along the y-axis or y-direction. Unitary discrete structure 300 includes a light directing portion 360 that includes opposing side facets 362A and 362B. In some cases, unitary discrete structure 300 can have in-plane (xy-plane) serpentine variations. As another example, FIG. 4 is a schematic three-dimensional view of a unitary discrete structure 400 that includes a light directing portion 460 that includes four first side facets: two opposing first side facets 462A and 462C, and two opposing first side facets 462B and 462D.

[0072] The light directing portions of the unitary discrete structures disclosed herein are primarily designed to redirect light by, for example, refraction or reflection. For example, FIG. 5 is a schematic side-view of a unitary discrete structure 500 that includes an upper or bonding portion 570 and a lower or light directing portion 560 that includes first side facets 562A and 562B and is primarily designed to direct light. For example, light directing portion 560 directs a light ray 540 as light ray 542 by first totally internally reflecting light ray 540 at side facet 562B as light ray 541 and then totally internally reflecting light ray 541 as light ray 542 at side facet 562A. As another example, light directing portion 560 directs light ray 545 as light ray 546 by refracting light ray 545 at side facet 562A.

[0073] Referring back to FIG. 1, each light directing portion 160 of unitary discrete structure 150 of light directing film 100 has a base that is the largest cross-section of the light directing portion that is parallel to the plane of the light directing film and is bound by the side facets of the light directing portion. For example, light directing portion 160 has

a base **164** that is the largest cross-section of the light directing portion in a direction parallel to a plane **105** of the light directing film and is bound by side facets **162C** and **162D**. The exemplary light directing film **100** defines a plane **105** of the light directing film that is in the xy-plane.

[0074] As another example, FIG. 6 is a schematic three-dimensional view of a light directing film **600** that includes a first structured major surface **610** and an opposing second major surface **620**. Light directing film **600** defines a plane **605** that is the plane of the light directing film, where in the exemplary light directing film **600**, plane **605** is parallel to the xy-plane. In general, light directing film **600** is capable of generally defining plane **605** even though the light directing film has a major surface **610** that is structured. Structured major surface **610** includes a plurality of unitary discrete structures **650**, where at least some structures **650** include a light directing portion **660** and a bonding portion **670** that is disposed on the light directing portion. Each light directing portion **660** is a linear structure that extends along the y-direction and includes two definable side facets that also extend along the y-axis or direction. Each light directing portion **660** has a base that is the largest cross-section of the light directing portion in the direction parallel to plane **605** and is bound by all the side facets of the light directing portions that are capable of being defined or identified. For example, light directing portion **660A** includes a rectangular base **661A** that is bound on one side by a side facet **612A** defining an edge **613A** of the base and on the other side by a side facet **612B** defining an edge **613B** of the base, light directing portion **660B** includes a rectangular base **661B** that is bound on one side by a side facet **622A** defining an edge **623A** of the base and on the other side by a side facet **622B** defining an edge **623B** of the base, light directing portion **660C** includes a rectangular base **661C** that is bound on one side by a side facet **632A** defining edge **623B** of the base and on the other side by a side facet **632B** defining an edge **633B** of the base, and light directing portion **660D** includes a rectangular base **661D** that is bound on one side by a side facet **642A** defining an edge **643A** of the base and on the other side by a side facet **642B** defining an edge **643B** of the base.

[0075] As another example, FIG. 7 is a schematic three-dimensional view of a light directing film **700** that includes a light directing portion **710A** that has a base **720A**, a light directing portion **710B** that has a base **720B**, and a light directing portion **710C** that has a base **720C**.

[0076] Referring back to FIG. 1, base **164** includes a minimum dimension d_1 that, in the exemplary light directing film **100**, is along the x-direction. For example, referring to FIG. 6, base **661D** of light directing portion **660D** has a minimum dimension **671D** that is along the x-direction. As another example, referring to FIG. 4, light directing portion **460** has a base **470** in the xy-plane that includes a minimum dimension **471** along the y-direction. As yet another example, referring to FIG. 7, base **720A** has a minimum dimension **730A** that is along the x-direction, base **720B** has a minimum dimension **730B** that is along the x-direction, and base **720C** has a minimum dimension **730C** that is along the x-direction.

[0077] In general, the minimum dimension of the base of a light directing portion can be any value or size that may be desirable in an application. For example, in some cases, the minimum dimension d_1 can be less than about 500 microns, or less than about 400 microns, or less than about 350 microns, or less than about 300 microns, or less than about 250 microns, or less than about 200 microns, or less than about

150 microns, or less than about 100 microns, or less than about 90 microns, or less than about 80 microns, or less than about 70 microns, or less than about 60 microns, or less than about 50 microns, or less than about 40 microns, or less than about 30 microns, or less than about 20 microns.

[0078] In general, the base of a light directing portion can have any shape, such as any regular or irregular shape, and any size minimum dimension that may be desirable in an application. For example, FIG. 8A is a schematic top-view of a linear base **810A** that extends along the y-direction and has a minimum dimension **810B**, FIG. 8B is a schematic top-view of a linear base **820A** that extends along the y-direction and has a minimum dimension **820B**, FIG. 8C is a schematic top-view of a base **830A** that has a minimum dimension **830B**, FIG. 8D is a schematic top-view of a hexagonal base **840A** that has a minimum dimension **840B**, and FIG. 8E is a schematic top-view of a linear base **850A** that extends along the y-direction and has a minimum dimension **850B**. In general, a base of a light directing portion can be linear meaning that the dimension, such as the average dimension, of the base along the linear direction of the base is substantially larger than the dimension, such as the average dimension, of the base along the orthogonal direction. For example, in such cases, the ratio of the average dimension of the base along the linear direction to the average dimension of the base along the orthogonal direction is at least about 10, or at least about 50, or at least about 100, or at least about 500, or at least about 1000. In some cases, such as when the ratio of the average dimension of the base along the linear direction to the average dimension of the base along the orthogonal direction is at least about 10,000, the base and the light directing portion and unitary discrete structure associated with the base can be considered to have an infinite or unlimited extent or dimension along the linear direction and a finite or limited extent or dimension along the orthogonal direction. In some cases, the base of a light directing portion can be in the shape of a rectilinear figure, such as a polygon. In some cases, the polygon can be an irregular polygon, such as a rectangle, or a regular polygon, such as an equilateral triangle, a square, a regular hexagon, or a regular octagon. In some cases, the base can be a trapezium, a trapezoid, a parallelogram, a rhombus, or deltoid. In some cases, the base can be in the shape of a curvilinear figure, such as a circle, an ellipse, or a parabola.

[0079] Referring back to FIG. 1, light directing portion **160** has a maximum height h_1 which is the maximum dimension or distance between base **164** and bonding portion **170** in a direction that is perpendicular to base **164** or plane **105**. For example, referring to FIG. 4, light directing portion **460** has a maximum height **472** that is along the z-direction and is the largest distance between base **470** and bonding portion **480** along the z-axis. As another example, referring to FIG. 7, light directing portion **710A** has a maximum height **740A** along the z-direction, light directing portion **710B** has a maximum height **740B** along the z-direction, and light directing portion **710C** has a maximum height **740C** along the z-direction. In general, the height of the light directing portions disclosed herein can vary along one or more directions. For example, FIG. 9 is a schematic three-dimensional view of a linear unitary discrete structure **900** that extends along the y-direction and includes a light directing portion **960** and a bonding portion **970** disposed on the light directing portion. Light directing portion **960** has a base **940** that lies in the xy-plane and extends along the y-direction, and a height **950** that is the distance between base **940** and bonding portion **970** along the

z-direction. Height **950** varies along the y-direction. Light directing portion **960** has a maximum height **951** which is the largest distance between base **940** and bonding portion **970** along the z-direction, and a minimum height **952** which is the smallest distance between base **940** and bonding portion **970** along the z-direction.

[0080] In some cases, each first side facet of a light directing portion makes an angle with the plane of the light directing film that is in a range from about 30 degrees to about 60 degrees. For example, in light directing film **100**, side facet **162C** makes an angle α_1 with plane **105** of the light directing film and side facet **162D** makes an angle α_2 with plane **105** of the light directing film, where each of α_1 and α_2 is in a range from about 30 degrees to about 60 degrees. As another example, referring to FIG. 7, light directing portion **710B** includes four side facets that make angles β_1 , β_2 , β_3 and β_4 with base **720B**, where each of the four angles β_1 - β_4 can be in a range from about 30 degrees to about 60 degrees. In some cases, each first side facet of a light directing portion makes an angle with the plane of the light directing film that is in a range from about 35 degrees to about 55 degrees, or from about 40 degrees to about 50 degrees, or from about 41 degrees to about 49 degrees, or from about 42 degrees to about 48 degrees, or from about 43 degrees to about 47 degrees, or from about 44 degrees to about 46 degrees. In some cases, each first side facet of a light directing portion makes an angle with the plane of the light directing film that is about 45 degrees. For example, in some cases, each of angles α_1 and α_2 can be about 45 degrees.

[0081] Referring back to FIG. 1, unitary discrete structure **150** includes bonding portion **170** that is primarily designed to bond the light directing film to a surface. In some cases, bonding portion **170** can also perform, or be designed to perform, other functions, but the primary function of the light directing portion is to bond the light directing film to a neighboring surface via, for example, an adhesive layer. Bonding portion **170** is disposed on light directing portion **160**. Bonding portion **170** is also disposed on and between side facets **162**. For example, bonding portion **170A** is disposed on and between side facets **162C** and **162D**.

[0082] In general, bonding portion **170** can have any shape, such as any regular or irregular shape, that may be desirable in an application. For example, in some cases, bonding portion **170** can be or include a three-dimensional rectilinear body, such as a tetrahedron, a prism, or a pyramid, or a portion, or a combination, of such bodies, such as a frustum. In some cases, bonding portion **170** can be or include a three-dimensional curvilinear body, such as a segment of a sphere, an asphere, an ellipsoid, a spheroid, a paraboloid, a cone, or a cylinder.

[0083] Bonding portion **170** includes a plurality of side facets **172**. For example, in the exemplary light directing film **100**, bonding portion **170A** includes a side facet **172A** and an opposing side facet **172B**. In general, bonding portion **170** can have two or more side facets. For example, referring to FIG. 3, unitary discrete structure **300** includes a bonding portion **370** that includes opposing side facets **372A** and **372B**. As another example, referring to FIG. 4, unitary discrete structure **400** includes a bonding portion **480** that includes four side facets: two opposing side facets **472A** and **472C**, and two opposing side facets **472B** and **472D**.

[0084] The bonding portions of the unitary discrete structures disclosed herein are primarily designed to bond the light directing portions to a neighboring surface. For example,

referring to FIG. 5, unitary discrete structure **500** includes bonding portion **570** that includes side facets **572A** and **572B** and bonds or attaches light directing portion **560** to a neighboring surface **595** via an optical adhesive layer **580**. The primary function of bonding portion **570** is to bond unitary discrete structure **500** or light directing portion **560** to surface **595**. In some cases or applications, bonding portion **570** can also direct light. For example, bonding portion **570** can direct a light ray **550** as a light ray **551**, but such light directing function is not the primary function of the bonding portion. Rather, the light directing function is a secondary function of the bonding portion.

[0085] The bonding portions and light directing portions of the unitary discrete structures disclosed herein have multiple or pluralities of side facets. In general, a side facet disclosed herein can have any shape, such as any regular or irregular shape, that may be desirable in an application. For example, in some cases, a side facet can be or include a planar portion. For example, referring to FIG. 4, side facets **462A-462D** of light directing portion **460** and side facets **472A-472D** of bonding portion **480** are planar. In some cases, a side facet can be piecewise planar. For example, FIG. 10 is a schematic three-dimensional view of a unitary discrete structure **1000** that includes a light directing portion **1060** and a bonding portion **1070** that is disposed on the light directing portion. Each of the light directing and bonding portions has a piecewise planar side facet. In particular, light directing portion **1060** includes a piecewise planar side facet **1062** that includes planar portions **1062A** and **1062B**, and bonding portion **1070** includes a piecewise planar side facet **1072** that includes planar portions **1072A** and **1072B**.

[0086] In some cases, a side facet can be or include a curved portion. For example, FIG. 11 is a schematic three-dimensional view of a unitary discrete structure **1100** that includes a light directing portion **1160** and a bonding portion **1170** that is disposed on the light directing portion. Each of the light directing and bonding portions has curved side facets.

[0087] In particular, light directing portion **1160** includes curved side facets **1162A** and **1162B**, and bonding portion **1170** includes curved side facets **1172A** and **1172B**.

[0088] In some cases, a side facet can be piecewise curved. For example, FIG. 12 is a schematic three-dimensional view of a unitary discrete structure **1200** that includes a light directing portion **1260** and a bonding portion **1270** that is disposed on the light directing portion. Each of the light directing and bonding portions has a piecewise curved side facet. In particular, light directing portion **1260** includes a piecewise curved side facet **1262** that includes curved portions **1262A** and **1262B**, and bonding portion **1270** includes a piecewise curved side facet **1272** that includes curved portions **1272A** and **1272B**. In some cases, a side facet of a unitary discrete structure can be planar, or piecewise planar and another side facet of the unitary discrete structure can be curved or piecewise curved.

[0089] Referring back to FIG. 1, each bonding portion **170** of unitary discrete structure **150** of light directing film **100** has a base that is the largest cross-section of the bonding portion that is parallel to the plane of the light directing film and is bound by the side facets of the bonding portion. Base **174** is bound by side facets **172**. For example bonding portion **170** has a base **174** that is the largest cross-section of the bonding portion that is parallel to plane **105** of the light directing film and is bound by side facets **172A** and **172B** of the bonding portion. As another example, referring to FIG. 4, bonding

portion **480** has a base **482** that is the largest cross-section of the bonding portion in the direction parallel to the xy-plane. Base **482** is bound by all the side facets of the light directing portions that are capable of being defined. In the exemplary unitary discrete structure **400**, base **482** is rectangular and bound by side facets **472A-472D**.

[0090] As another example, referring to FIG. 7, light directing film **700** includes a bonding portion **750A** that has a base **760A**, a bonding portion **750B** that has a base **760B**, and a bonding portion **750C** that has a base **760C**. As another example, FIG. 13 is a schematic three-dimensional view of a unitary discrete structure **1300** that is linear and extends along the y-direction. The unitary discrete structure includes a light directing portion **1310** that has a base **1315** that is in the xy-plane, and a bonding portion **1320** that has a base **1330** that is the largest cross-section of the bonding portion that is parallel to the xy-plane and is bound by side facet **1321** defining an edge **1331** of the base and side facet **1322** defining an edge **1332** of the base.

[0091] Referring back to FIG. 1, base **174** includes a minimum dimension d_2 that, in the exemplary light directing film **100**, is along the x-direction. For example, referring to FIG. 4, base **482** has a minimum dimension **474** that is along the y-direction. As another example, referring to FIG. 7, base **760A** has a minimum dimension **770A** that is along the x-direction, base **760B** has a minimum dimension **770B** that is along the x-direction, and base **760C** has a minimum dimension **770C** that is along the x-direction.

[0092] In general, a base of a bonding portion can have any shape, such as any regular or irregular shape, and any size minimum dimension that may be desirable in an application. For example, linear base **810** in FIG. 8A can be the base of a bonding portion that extends along the y-direction and has a minimum dimension **810B**, linear base **820A** in FIG. 8B can be the base of a bonding portion that extends along the y-direction and has a minimum dimension **820B**, base **830A** in FIG. 8C can be the base of a bonding portion that has a minimum dimension **830B**, base **840A** in FIG. 8D can be the base of a bonding portion that has a minimum dimension **840B**, and linear base **850A** in FIG. 8E can be the base of a bonding portion that extends along the y-direction and has a minimum dimension **850B**. In general, the base of a bonding portion can be linear meaning that the dimension, such as the average dimension, of the base along the linear direction of the base is substantially larger than the dimension, such as the average dimension, of the base along the orthogonal direction. For example, in such cases, the ratio of the average dimension of the base along the linear direction to the average dimension of the base along the orthogonal direction is at least about 10, or at least about 50, or at least about 100, or at least about 500, or at least about 1000. In some cases, such as when the ratio of the average dimension of the base along the linear direction to the average dimension of the base along the orthogonal direction is at least about 10,000, the base, the bonding portion and the unitary discrete structure associated with the base can be considered to have an infinite or unlimited extent or dimension along the linear direction and a finite or limited extent or dimension along the orthogonal direction. In some cases, the base of a bonding portion can be in the shape of a rectilinear figure, such as a polygon. In some cases, the polygon can be an irregular polygon, such as a rectangle, or a regular polygon, such as an equilateral triangle, a square, a regular hexagon, or a regular octagon. In some cases, the base can be a trapezium, a trapezoid, a parallelogram, a rhom-

bus, or deltoid. In some cases, the base can be in the shape of a curvilinear figure, such as a circle, an ellipse, or a parabola.

[0093] Referring back to FIG. 1, bonding portion **170** has a maximum height h_2 which is the maximum dimension or distance between base **174** and the top of the bonding portion in a direction that is perpendicular to base **174** or plane **105** of the light directing film. For example, referring to FIG. 4, bonding portion **480** has a maximum height **476** that is along the z-direction and is the largest distance between base **482** and a top surface **490** of the bonding portion. As another example, referring to FIG. 7, bonding portion **750A** has a maximum height **780A** along the z-direction, bonding portion **750B** has a maximum height **780B** along the z-direction, and bonding portion **750C** has a maximum height **780C** along the z-direction. In general, the height of the bonding portions disclosed herein can vary along one or more directions. For example, FIG. 14 is a schematic three-dimensional view of a linear unitary discrete structure **1400** that extends along the y-direction and includes a light directing portion **1460** and a bonding portion **1470** disposed on the light directing portion. Bonding portion **1470** has a base **1475** that lies in the xy-plane and extends along the y-direction, and a height **1480** that is the distance between base **1475** and the top of the bonding portion along the z-direction. Height **1480** varies along the y-direction. Bonding portion **1470** has a maximum height **1482** which is the largest distance between base **1475** and the top of the bonding portion along the z-direction, and a minimum height **1484** which is the smallest distance between base **1475** and the top of the bonding portion along the z-direction. Light directing portion **1460** has a base **1440** that is in the xy-plane, and a constant height **1445** that is the distance between base **1440** of the light directing portion and base **1475** of the bonding portion along the z-direction.

[0094] In general, the height of the disclosed linear unitary discrete structures can remain constant or vary along the length of the unitary discrete structures. For example, the height of unitary discrete structure **1400** varies along the linear extent of the structure. As another example, unitary discrete structure **1300** in FIG. 13 has a constant height along the linear direction of the structure.

[0095] In some cases, each side facet of a bonding portion makes an angle with the plane of the light directing film that is greater than about 60 degrees. For example, in unitary discrete structure **300**, side facet **372A** makes an angle α_3 with the xy-plane and side facet **372B** makes an angle α_4 with the xy-plane, where each of α_3 and α_4 is greater than about 60 degrees. As another example, referring to FIG. 10, bonding portion **1070** includes four side facets that make angles γ_1 , γ_2 , γ_3 and γ_4 with the xy-plane or the plane of the light directing film associated with unitary discrete structure **1000**, where each of the four angles γ_1 - γ_4 can be greater than about 60 degrees. In some cases, each side facet of a bonding portion makes an angle with the plane of the light directing film that is greater than about 65 degree, or greater than about 70 degrees, or greater than about 75 degrees, or greater than about 80 degrees, or greater than about 85 degrees.

[0096] In some cases, each unitary discrete structure in a light directing film disclosed herein includes a plurality of side facets, where the side facets that make an angle with the plane of the light directing film that is in a range from about 35 degrees to about 55 degrees, or from about 40 degrees to about 50 degrees, or from about 41 degrees to about 49 degrees, or from about 42 degrees to about 48 degrees, or from about 43 degrees to about 47 degrees, or from about 44

degrees to about 46 degrees, form or define the light directing portion of the unitary discrete structure, and the side facets that make an angle with the plane of the light directing film that is greater than about 60 degree, or greater than about 65 degrees, or greater than about 70 degrees, or greater than about 75 degrees, or greater than about 80 degrees, or greater than about 85 degrees, form or define the bonding portion of the unitary discrete structure.

[0097] In some cases, the minimum dimension of the base of the bonding portion of a unitary discrete structure is substantially less than the minimum dimension of the base of the light directing portion of the unitary discrete structure. For example, referring to FIG. 1, in some cases, the minimum dimension d_2 is substantially less than the minimum dimension d_1 . For example, in such cases, the minimum dimension d_2 is less than about 20%, or less than about 18%, or less than about 16%, or less than about 14%, or less than about 12%, or less than about 10%, or less than about 9%, or less than about 8%, or less than about 7%, or less than about 6%, or less than about 5%, or less than about 4%, or less than about 3%, or less than about 2%, or less than about 1%, of the minimum dimension d_1 .

[0098] In some cases, bonding portions 170 have aspect ratios that are greater than 1. For example, in some cases, the ratio of the maximum height h_2 of bonding portion 170 to the second minimum dimension d_2 of the bonding portion is greater than 1. For example, in such cases, the ratio h_2/d_2 is at least about 1.2, or at least about 1.4, or at least about 1.5, or at least about 1.6, or at least about 1.8, or at least about 2, or at least about 2.5, or at least about 3, or at least about 3.5, or at least about 4, or at least about 4.5, or at least about 5, or at least about 5.5, or at least about 6, or at least about 6.5, or at least about 7, or at least about 8, or at least about 9, or at least about 10, or at least about 15, or at least about 20.

[0099] FIG. 15 is a schematic side-view of a light directing film 1500 that includes a plurality of unitary discrete structures, such as unitary discrete structures 1510 and 1520, disposed on a substrate 1505, where the substrate provides support for the unitary structures. Unitary discrete structure 1510 includes a bonding portion 1514 disposed on a light directing portion 1512 that has a base 1515, and unitary discrete structure 1520 includes a bonding portion 1524 disposed on a light directing portion 1522 that has a base 1525. In some cases, such as in the exemplary light directing film illustrated in FIG. 15, at least some of the unitary discrete structures include a landing portion disposed between the base of the light directing portion and the substrate that supports the unitary discrete structure. In some cases, the primary functions of the land portion can include transmitting light with high efficiency, providing support for the light directing portion and the bonding portion, and providing sufficient adhesion between the unitary discrete structure and the substrate. For example, unitary discrete structure 1510 includes a land portion 1516 that is disposed between base 1515 and substrate 1505, and unitary discrete structure 1520 includes a land portion 1526 that is disposed between base 1525 and substrate 1505.

[0100] In general, the unitary discrete structures in a light directing film may or may not have land portions. In some cases, such as in the case of light directing film 1500 illustrated schematically in FIG. 15, the unitary discrete structures have land portions. In some cases, the unitary discrete structures do not have land portions. For example, FIG. 16, is a schematic side-view of a light directing film 1600 that is similar to light directing film 1500 except that the unitary

discrete structures do not have land portions. In particular, base 1515 of light directing portion 1512 coincides, or substantially coincides, with a top surface 1506 of substrate 1505, and base 1525 of light directing portion 1522 coincides, or substantially coincides, with top surface 1506 of substrate 1505. In some cases, some unitary discrete structures in a light directing film have land portions and some unitary discrete structures in the light directing film do not have land portions. For example, FIG. 17 is a schematic side-view of a light directing film 1700 that includes a plurality of unitary light structures, such as unitary discrete structures 1710, 1720, 1730 and 1740, disposed on a top surface 1706 of a substrate 1705. Unitary discrete structure 1710 includes a light directing portion 1712 that has a base 1715, a bonding portion 1714 that is disposed on the light directing portion, and a land portion 1716 that is disposed between base 1715 of the light directing portion and top surface 1706 of the substrate. Unitary discrete structure 1720 includes a light directing portion 1722 that has a base 1725, a bonding portion 1724 that is disposed on the light directing portion, and a land portion 1726 that is disposed between base 1725 of the light directing portion and top surface 1706 of the substrate. Unitary discrete structure 1730 includes a light directing portion 1732 that has a base 1735, a bonding portion 1734 that is disposed on the light directing portion, and a land portion 1736 that is disposed between base 1735 of the light directing portion and top surface 1706 of the substrate. Unitary discrete structure 1740 includes a light directing portion 1742 that has a base 1745 that coincides, or substantially coincides, with top surface 1706 of substrate 1705, and a bonding portion 1744 that is disposed on the light directing portion. Unitary discrete structures 1710, 1720 and 1730 include land portions and unitary discrete structure 1740 does not include a land portion.

[0101] In some cases, at least some of the unitary discrete structures in a plurality of unitary discrete structures in a light directing film have symmetric cross-sectional profiles in a direction perpendicular to the light directing film, where by a symmetric unitary discrete structure it is meant that the light directing portion and the bonding portion of the unitary discrete structure have symmetric profiles. For example, a unitary discrete structure is considered to have a symmetric profile if the bonding and light directing portions of the unitary discrete structure have symmetric profiles, even if other parts, such as the land portion, of the unitary discrete structure have asymmetric profiles.

[0102] For example, referring to FIG. 15, unitary discrete structures 1510 and 1520 have symmetric cross-sectional profiles in directions that are perpendicular to the light directing film. In particular, unitary discrete structure 1510 in light directing film 1500 has a symmetric cross-sectional profile in a direction 1511 that is perpendicular to the light directing film, and unitary discrete structure 1520 in light directing film 1500 has a symmetric cross-sectional profile in a direction 1521 that is perpendicular to the light directing film. Direction 1511 is a symmetry axis for unitary discrete structure 1510, and direction 1521 is a symmetry axis for unitary discrete structure 1520.

[0103] In some cases, at least some of the unitary discrete structures in a plurality of unitary discrete structures in a light directing film have asymmetric cross-sectional profiles in a direction perpendicular to the light directing film. For example, FIG. 18 is a schematic side-view of a light directing film 1800 that includes symmetric unitary discrete structures

1810, 1820 and 1840, and asymmetric unitary discrete structure **1830** disposed on a top surface **1806** of a substrate **1805**. Unitary discrete structure **1810** includes a light directing portion **1812** that includes a base **1815** and a land portion **1816** that is disposed between base **1815** of the light directing portion and top surface **1806** of substrate **1805**. Unitary discrete structure **1810** has a symmetric cross-sectional profile in a direction **1818** that is along the z-direction and perpendicular to the light directing film. Unitary discrete structure **1820** includes a light directing portion **1822** that includes a base **1825** and a land portion **1826** that is disposed between base **1825** of the light directing portion and top surface **1806** of substrate **1805**. Unitary discrete structure **1820** has a symmetric cross-sectional profile in a direction **1828** that is along the z-direction and perpendicular to the light directing film. Unitary discrete structure **1830** includes a light directing portion **1832** that includes a base **1835** that coincides, or substantially coincides, with top surface **1806** of substrate **1805**. Unitary discrete structure **1830** has an asymmetric cross-sectional profile. Unitary discrete structure **1840** includes a light directing portion **1842** that includes a base **1845** that coincides, or substantially coincides, with top surface **1806** of substrate **1805**. Unitary discrete structure **1840** has a symmetric cross-sectional profile in a direction **1848** that is along the z-direction and perpendicular to the light directing film.

[0104] FIG. 20 is a schematic side-view of an optical stack **2000** that includes an optical film **2090** that is disposed on a light directing film **2010**, where light directing film **2010** can be any light directing film disclosed herein. Light directing film **2010** includes a first structured major surface **2020** and an opposing second major surface **2025**. First structured major surface **2020** includes a plurality of unitary discrete structures **2030** that are disposed on a substrate **2005**. Each of at least some unitary discrete structures include a light directing portion **2040** primarily for directing light and a bonding portion **2050** primarily for bonding the light directing film to optical film **2090**. In some cases, such as in the case of the exemplary optical stack **2000**, at least portions of at least some bonding portions **2050** of light directing film **2010** penetrate into optical film **2090** and at least portions of at least some light directing portions **2040** of light directing film **2010** do not penetrate into optical film **2090**. In such cases, optical stack **2000** includes a plurality of unfilled voids **2015** between light directing film **2010** and optical film **2090**, where the unfilled voids can contain air and/or a gas. In some cases, each of at least some of the plurality of unfilled voids **2015** substantially covers a region that is defined by optical film **2090** and portions of two or more adjacent unitary discrete structures **2030** that do not penetrate into the optical film and immediately surround the region. For example, in such cases, an unfilled void covers at least 50%, or at least 60%, or at least 70%, or at least 80%, or at least 90%, of a region that is defined by optical film **2090** and portions of two or more adjacent unitary discrete structures **2030** that do not penetrate into the optical film. For example, in the case of linear unitary discrete structures **2030**, unfilled void **2015** substantially covers the region that is defined on the top by optical film **2090**, on the right side by portion **2021** of linear unitary discrete structure **2030A** that has not penetrated into the optical film, and on the left side by portion **2022** of linear unitary discrete structure **2030B** that has not penetrated into the optical film.

[0105] Optical film **2090** includes an optical layer **2070** that is disposed on an optical adhesive layer **2060**. The portions of bonding portions **2050** of light directing film **2010** that pen-

etrate into the optical film penetrate into the optical adhesive layer. Optical adhesive layer **2060** attaches or bonds light directing film **2010** to optical layer **2070** or major surface **2071** of optical layer **2070** while substantially maintaining an air environment or surrounding for light directing portions **2040**. In some cases, bonding portions **2050** have high aspect ratios which can result in strong bonding between optical film **2090** and light directing film **2010**.

[0106] Bonding portions **2050** that penetrate into optical adhesive layer have an average maximum height $h_{2,avg}$ which is the average of the maximum heights h_2 of the individual bonding portions that have penetrated into the optical adhesive layer. In some cases, $h_{2,avg}$ is greater than the average thickness h_3 of optical adhesive layer **2060**. For example, in such cases, $h_{2,avg}$ is greater than h_3 by at least 0.2 microns, or at least 0.3 microns, or at least 0.4 microns, or at least 0.5 microns, or at least 0.7 microns, or at least 1 micron, or at least 1.2 microns, or at least 1.5 microns, or at least 1.7 microns, or at least 2 microns.

[0107] In general, optical film **2090** can include any optical layer **2070** that may be desirable in an applications. For example, in some cases, optical layer **2070** can be or include an absorbing polarizer. As another example, in some cases, optical film **2090** or optical layer **2070** can include a reflective polarizer. In some cases, the reflective polarizer can include a multilayer optical film wherein at least some of the layers are birefringent. In some cases, the reflective polarizer can include alternating layers, where at least one of the alternating layers includes a birefringent material. In some cases, the reflective polarizer can include a wire grid reflective polarizer, or a cholesteric reflective polarizer. In some cases, the reflective polarizer can be or include a fiber polarizer. In such cases, the reflective polarizer includes a plurality of substantially parallel fibers that form one or more layers of fibers embedded within a binder with at least one of the binder and the fibers including a birefringent material. The substantially parallel fibers define a transmission axis and a reflection axis. The fiber polarizer substantially transmits incident light that is polarized parallel to the transmission axis and substantially reflects incident light that is polarized parallel to the reflection axis. Examples of fiber polarizers are described in, for example, U.S. Pat. Nos. 7,599,592 and 7,526,164, the entireties of which are incorporated herein by reference.

[0108] In some cases, the reflective polarizer can be a partially reflecting layer that has an intermediate on-axis average reflectance in the pass state. For example, the partially reflecting layer can have an on-axis average reflectance of at least about 90% for visible light polarized in a first plane, such as the xy-plane (for example, for visible light linearly polarized along the x-direction), and an on-axis average reflectance in a range from about 25% to about 90% for visible light polarized in a second plane, such as the xz-plane (for example, for visible light linearly polarized along the z-direction) perpendicular to the first plane.

[0109] In some cases, the reflective polarizer can be an extended band reflective polarizer that is capable of polarizing light at smaller incident angles and substantially reflecting one polarization state, or two mutually perpendicular polarization states, at larger incident angles as described in U.S. Patent Application Ser. No. 61/254,691 titled "Immersed Reflective Polarizer with High Off-Axis Reflectivity", Attorney Docket Number 65809US002, filed on Oct. 24, 2009; and U.S. Patent Application Ser. No. 61/254,692 "Immersed Reflective Polarizer With Angular Confinement

in Selected Planes of Incidence”, Attorney Docket No. 65900US002, filed on Oct. 24, 2009, the disclosures of which are incorporated herein in their entireties by reference.

[0110] In some cases, the reflective polarizer can be a diffuse reflective polarizer substantially transmitting one polarization state and substantially diffusely reflecting an orthogonal polarization state. Diffuse reflective polarizer films typically include a disperse phase of polymeric particles disposed within a continuous birefringent matrix. The film is oriented, typically by stretching, in one or more directions to develop the birefringence. Examples of diffuse reflective polarizers are described in, for example, U.S. Pat. Nos. 6,999,233 and 6,987,612 the disclosures of which are incorporated herein in their entireties by reference.

[0111] As another example, optical layer 2070 can be or include a substrate for providing, for example, support to optical film 2090. In general, a substrate disclosed herein, such as substrate 130, substrate 2005, or substrate 2070, can be or include any material that may be desirable in an application. For example, a substrate 2070 can include or be made of glass and/or polymers such as polyethylene terephthalate (PET), polycarbonates, and acrylics. In some cases, the substrate can have multiple layers. In some cases, optical layer 2070 can be glass. For example, a glass layer 2070 can be a glass layer in a liquid crystal panel.

[0112] As another example, optical layer 2070 can be or include a release liner that provides a transferable light directing film 2010, meaning that, for example, the exposed major surface 2025 of the light directing film may be placed in contact with a substrate or surface and the release liner may thereafter be stripped away to expose a major surface 2061 of optical adhesive layer 2060 that can, for example, be bonded to another substrate or surface. The release force for releasing optical adhesive layer 2060 or light directing film 2010 from a release liner 2070 is generally less than about 200 g-force/inch, or less than about 150 g-force/inch, or less than about 100 g-force/inch, or less than about 75 g-force/inch, or less than about 50 g-force/inch.

[0113] As yet another example, in some cases, optical layer 2070 can be or include a second light directing film that includes a plurality of linear prismatic structures. For example, FIG. 21 is a schematic three dimensional view of a light directing film 2100 that includes a plurality of linear prismatic structures 2110 that are disposed on a substrate 2120 and extend linearly along the y-direction. In some cases, optical layer 2070 can be or include light directing film 2100. In such cases, unitary discrete structures 2030 of light directing film 2010 can also be linear structures that extend in a direction that is perpendicular to the linear direction of linear prismatic structures 2110. In some cases, substrate 2120 can be similar to optical layer 2070 and may include any optical layer and provide any function that may be desirable in an application.

[0114] In general, a substrate disclosed herein, such as substrate 130 or substrate 2005, can include any optical layer and provide any function that may be desirable in an application. For example, in some cases, a disclosed substrate may primarily provide support for other layers. As another example, in some cases, a disclosed substrate may polarize light by including, for example, a reflective or absorbing polarizer, diffuse light by including an optical diffuser, direct or redirect light by including a light directing film, or have transferring capabilities by, for example, including a release liner.

[0115] Bonding portions 2050 allow for secure attachment of light directing film 2010 to optical film 2090 or surface 2071 with no or very little loss in optical properties, such as brightness. In particular, the bonding portions have sufficiently large aspect ratios to provide sufficient exterior surface to enhance adhesion between the light directing film and the optical film. The bonding portions are also sufficiently narrow relative to the width of the light directing portions so that there is no or very little loss in the effective transmission of the light directing film and/or the optical stack. As used herein, effective transmission (ET), or optical gain, is the ratio of the luminance of an optical system, such as a display system, with the film in place in the optical system to the luminance of the optical system without the film in place.

[0116] Unitary discrete structures 2030 can have any index of refraction that may be desirable in an application. For example, in some cases, the index of refraction of the unitary discrete structures is in a range from about 1.4 to about 1.8, or from about 1.5 to about 1.8, or from about 1.5 to about 1.7. In some cases, the index of refraction of the unitary discrete structures is not less than about 1.5, or not less than about 1.55, or not less than about 1.6, or not less than about 1.65, or not less than about 1.7.

[0117] In general, the peel strength of light redirecting film 2010 and optical adhesive layer 2060, surface 2071, or optical film 2090 is sufficiently large to provide secure adhesion between light directing film 2010 and optical film 2090 so that optical stack 2000 can be handled as a single film or unit without bonding portions 2050 delaminating or separating from optical film 2090. In some cases, the peel strength of light redirecting film 2010 and optical adhesive layer 2060 is greater than about 20 grams/inch, or about 25 grams/inch, or about 30 grams/inch, or about 35 grams/inch, or about 40 grams/inch, or about 45 grams/inch, or about 50 grams/inch, or about 60 grams/inch, or about 70 grams/inch, or about 80 grams/inch, or about 90 grams/inch, or about 100 grams/inch, or about 110 grams/inch, or about 120 grams/inch, or about 130 grams/inch, or about 140 grams/inch, or about 150 grams/inch.

[0118] Bonding portions 2050 are designed primarily to provide sufficient adhesion between light directing film 2010 and optical film 2090 by sufficiently penetrating into the optical film. While providing sufficient adhesion between the two films, the bonding portions are sufficiently narrow so as to have no, or very little, effect on the effective transmission of light directing film 2010 or optical stack 2000. For example, in some cases, an optical stack that is similar to optical stack 2000 except that no bonding portion 2050 or unitary discrete structure 2030 penetrates into optical adhesive layer 2060 or optical film 2090, has the same effective transmission or an effective transmission that is only slightly larger than the effective transmission of optical stack 2000. For example, FIG. 29 is a schematic side-view of an optical stack 2900 that has the same construction as optical stack 2000 except that no unitary discrete structure 2030 penetrates into optical adhesive layer 2060. In some cases, the effective transmission of optical stack 2000 is not less or is less than by no more than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, as compared to optical stack 2900.

In some cases, in FIG. 29, optical adhesive layer 2060 can be absent or can be replaced with an optical layer that is non-adhesive. In such cases, such as when optical adhesive layer

2060 is absent, bonding portions **2050** can be anti-wet-out structures preventing, or substantially reducing, optical coupling between light directing film **2010** and optical layer **2070**. In some cases, at least some bonding portions **2050** of unitary discrete structures **2030** physically contact but do not penetrate into optical layer **2070**. In some cases, no bonding portion **2050** of unitary discrete structures **2030** penetrates into optical layer **2070**.

[0119] In some cases, a light directing portion of a disclosed unitary discrete structure is designed to recycle light so that, for example, the brightness of an image viewed by a viewer is increased or enhanced. For example, FIG. 19 is a schematic side-view of a display system **1900** that includes an image forming panel **1950** that is capable of forming an image and displaying the image to a viewer **1990** and is disposed to receive light from an illumination system **1905**. Illumination system **1905** includes optical stack **2000** disposed on a light source **1915** that includes a lightguide **1920**; a lamp **1930** for emitting light **1936** that enters the lightguide, propagates within the lightguide by total internal reflection, and exits the lightguide as light **1940** towards the image forming panel; and a back reflector **1910** for redirecting light that is incident on the back reflector towards the image forming panel. Light directing portions **2040** are designed primarily to either redirect light that exits lightguide **1920** toward image forming panel **1950**, or reflect light that exits the lightguide for recycling. For example, light directing portions **2040** redirect light **1941** that exits lightguide **1920** as light **1942** towards the image forming panel or the viewer. As another example, light directing portions **2040** receive light **1943** that exits the lightguide and totally internally reflect back the received light as light **1944** for recycling.

[0120] In general, image forming panel **1950** can be any type panel that is capable of forming and image and displaying the image to viewer **1990**. In some cases, image forming panel **1950** can be or include a liquid crystal panel. In such cases, a liquid crystal image forming panel **1950** can include a layer of liquid crystal disposed between two panel plates such as glass plates, an upper light absorbing polarizer layer disposed above the liquid crystal layer and a lower absorbing polarizer disposed below the liquid crystal layer. The upper and lower light absorbing polarizers and the liquid crystal layer, in combination, control the transmission of light to viewer **1990**. In some cases, image forming panel **1950** can be a monolithic image forming panel or a tiled image forming panel that includes a plurality of image forming tiles. In some cases, light source **1915** can be a monolithic light source or a tiled light source that includes a plurality of light source tiles. In some cases, display system **1900** includes a monolithic image forming panel **1950** and a tiled light source **1915**. A tiled light source **1915** can include a plurality of independently controlled tiled lightguides **1920**, where each lightguide can illuminate a different zone in a displayed image.

[0121] In some cases, display system **1900** or illumination system **1905** can include one or more optional layers **1935** that are disposed between optical stack **2000** and lightguide **1920**. Exemplary optional layers **1935** include, light diffusing layers and polarization retardation layers.

[0122] In general, the disclosed light directing films include a first structured major surface that include a plurality of unitary discrete structures, and a second major surface that opposes the first structured major surface. In some cases, a disclosed light directing film is designed primarily to receive light from the second major surface side of the light directing

film. For example, light directing film **2010** in FIG. 19, is designed primarily to receive light from second major surface **2025** and emit or transmit light from first structured major surface **2020**.

[0123] In some cases, a light directing portion of a disclosed unitary discrete structure is designed primarily to redirect, but not recycle, light. For example, FIG. 22 is a schematic side-view of a display system **2200** for displaying information or an image to viewer **1990**. Display system **2200** includes image forming panel **1950** disposed on an illumination system **2202** that includes an optical stack **2201** that is disposed on light source **1915**. Optical stack **2201** includes a light directing film **2210** disposed on an optical film **2290**. Light directing film **2210** can be any light directing film disclosed herein and includes a first structured major surface **2220** that includes a plurality of unitary discrete structures **2230** disposed on a substrate **2205** and a second major surface **2225** that opposes major surface **2220**. Unitary discrete structures **2230** include bonding portions **2250** disposed on light directing portions **2240**. At least portions of bonding portions **2250** penetrate optical film **2290** and at least portions of light directing portions **2240** do not penetrate the optical film. Light directing film **2210** and light directing portions **2240** are designed primarily to direct or redirect, but not recycle, light. For example, light directing portion **2240A** is designed primarily to direct light **2211** that exits lightguide **1920** as light **2212** towards image forming panel **1950** and viewer **1990**.

[0124] In general, the disclosed light directing films include a first structured major surface that include a plurality of unitary discrete structures, and a second major surface that opposes the first structured major surface. In some cases, a disclosed light directing film is designed primarily to receive light from the first structured major surface side of the light directing film. For example, light directing film **2210** in FIG. 22, is designed primarily to receive light from first structured major surface **2220** and emit or transmit light from second major surface **2225**.

[0125] In some cases, optical film **2290** does not include optical layer **2170**. In such cases, optical adhesive layer **2060** can directly adhere to lightguide **1920** resulting in light directing film **2210** being securely adhered to lightguide **1920**.

[0126] In some cases, such as in the exemplary illumination system **2200** illustrated in FIG. 22, optical film **2290** is disposed between light directing film **2210** and light source **1915**. In some cases, such as in the exemplary illumination system **1905** illustrated in FIG. 19, light directing film **2010** is disposed between optical film **2090** and light source **1915**.

[0127] In some cases, optical layer **2170** can be a lightguide, such as lightguide **1920**. In such cases, unitary discrete structures **2230** can extract light from the lightguide and can be considered as light extractors of a lightguide **2170**. In some cases, unitary discrete structures **2230** may penetrate directly into a lightguide, an exemplary side-view of which is illustrated schematically in FIG. 52. In particular, in FIG. 52, a light source **5230** includes a lightguide **5210** that is disposed on back reflector **1910**. Lightguide **5210** includes a lightguide layer **5220** that receives light **1936** that is emitted by lamp **1930** from a side **5550** of the lightguide layer. The light that enters the lightguide layer propagates across the lightguide layer along, for example, the x-direction by total internal reflection. Light directing film **2210** is disposed on lightguide **5210** and includes a plurality of discrete structures **5280** that

are similar to unitary discrete structures **2230**. Each discrete structure **5280** is partially embedded in lightguide layer **5220** and extracts light that propagates within the lightguide layer by total internal reflection from the lightguide layer. For example, discrete structures **5280** extract light **5240** that propagates within lightguide layer **5220** by total internal reflection from the lightguide layer as light **5241**. As a result, each discrete structure **5280** can be considered to be a discrete light extractor **5280** of lightguide **5210**. Each discrete light extractor **5280** includes a first portion **5260** that penetrates into, or is embedded in, lightguide layer **5220** and a second portion **5270** that does not penetrate into, or is not embedded in, lightguide layer **5220**. In general, each discrete light extractor **5280** can be unitary or composite.

[0128] In some cases, the index of refraction of each discrete light extractor **5280** is different than the index of refraction of lightguide layer **5220**. In some cases, the index of refraction of each discrete light extractor **5280** is equal to the index of refraction of lightguide layer **5220**.

[0129] Referring back to FIG. **1**, in some cases, second major surface **120** includes a plurality of structures to assist in, for example, diffusing light, hiding or masking defects such as dust particles or scratches, and/or reducing the visibility of an undesirable optical effect such as moiré. For example, FIG. **23** is a schematic side-view of a light directing film **2300** that is similar to light directing film **100** and includes a first structured major surface **2310** and an opposing second structured major surface **2350**. First structured major surface **2310** includes a plurality of unitary discrete structures **2320**. Each unitary discrete structure **2320** includes a light directing portion **2330** that is designed primarily to direct light and a bonding portion **2340** that is disposed on the light directing portion and is designed primarily to bond the light directing film to a surface.

[0130] Structured major surface **2350** includes a plurality of structures **2360**. In some cases, structures **2360** are irregularly arranged. For example, in such cases, structures **2360** can form a random pattern. In some cases, structures **2360** are regularly arranged. For example, in such cases, structures **2360** can form a periodic pattern along one direction or two mutually orthogonal directions.

[0131] The exemplary light directing film **2300** is a unitary film as there are no internal interfaces within the light directing film. In some cases, structures **2360** can be part of a separate layer that can, for example, be coated onto the light directing film. For example, FIG. **24** is a schematic side-view of a light directing film **2400** that includes first structured major surface **2310** and an opposing second structured major surface **2450** that includes a plurality of structures **2460**. Light directing film **2400** is similar to light directing film **2300** except that second structured major surface **2450** is part of a light diffusing layer **2410** that is applied to, for example coated on, light directing film **2400**. In general, light diffusing layer **2410** may or may not include particles. In some cases, such as in the exemplary case illustrated in FIG. **24**, light diffusing layer **2410** includes a plurality of particles **2420**. In general, the plurality of structures **2460** have a first average height and the plurality of particles **2420** have a second average size. In some cases, such as when the average size of particles **2420** is of the same order of magnitude as the average height of structures **2460**, the ratio of the first average height to the second average size is less than about 50, or less than about 40, or less than about 30, or less than about 20, or less than about 10, or less than about 5, or less than about 2, or

less than about 1. In some cases, such as when the average size of particles **2420** is substantially less than the average height of structures **2460**, the ratio of the first average height to the second average size is greater than about 50, or greater than about 100, or greater than about 500, or greater than about 1000.

[0132] Referring back to FIG. **1**, in some cases, at least some of the unitary discrete structures **150** are linear structures and extend along the same direction. For example, referring to FIG. **6**, unitary discrete structures **650** are linear structures and extend along the y-direction. In some cases, the heights of the light directing portions of the unitary discrete structures that extend along the same direction do not vary along that direction. For example, referring to FIG. **7**, heights of light directing portions **710A**, **710B** and **710C** do not vary along the y-direction which is the linear direction of the light directing portions or their associated unitary discrete structures. In some cases, the heights of the light directing portions of the unitary discrete structures that extend along the same direction vary along that direction. For example, referring to FIG. **9**, height **950** of light directing portion **960** varies along the y-direction which is the linear direction of light directing portion **960** or unitary discrete structure **900**. In some cases, height **950** can vary regularly along the y-direction. In some cases, height **950** can vary irregularly along the y-direction.

[0133] In general, the light directing portions can have multiple side facets. In some cases, such as in the case of linear unitary discrete structures, each light directing portion can include two opposing side facets. For example, referring to FIG. **6**, light directing film **600** includes a plurality of linear unitary discrete structures **650** that extend along the y-direction, and where each light directing portion includes two opposing side facets. For example, light directing portion **660A** includes two opposing side facets: side facet **612A** and opposing side facet **612B**. In some cases, each light directing portion includes only two opposing side facets.

[0134] As another example, light directing portion **710A** in FIG. **7** includes four side facets or two pairs of opposing side facets. In particular, light directing portion **710A** includes a first pair of opposing side facets **701A** and **701B** and a second pair of opposing side facets **701C** and **701D**.

[0135] Referring back to FIG. **1**, opposing side facets **162** of light directing portions **160** define an included angle θ_1 which is the angle between the two opposing side facets. In some cases, the included angle θ_1 is in a range from about 60 degrees to about 120 degrees, or about 65 degrees to about 115 degrees, or about 70 degrees to about 110 degrees, or about 75 degrees to about 105 degrees, or about 80 degrees to about 100 degrees, or about 85 degrees to about 95 degrees. In some cases, the included angle θ_1 is about 88 degrees, or about 89 degrees, or about 90 degrees, or about 91 degrees, or about 92 degrees.

[0136] Side facet **162A** of light directing portion **160A** makes an angle θ_3 with a normal line **180** that is perpendicular to light directing film **100** or plane **105** of the light directing film. In some cases, the angle θ_3 between a side facet of a light directing portion and the normal to the light directing film is in a range from about 30 degrees to about 60 degrees, or from about 35 degrees to about 55 degrees, or from about 40 degrees to about 50 degrees, or from about 42 degrees to about 48 degrees, or from about 43 degrees to about 47 degrees, or from about 44 degrees to about 46 degrees.

[0137] Opposing side facets **172** of bonding portion **170** define an included angle θ_2 which is the angle between the

two opposing side facets. In some cases, the included angle θ_2 between two opposing side facets of a bonding portion is less than about 40 degrees, or less than about 35 degrees, or less than about 30 degrees, or less than about 25 degrees, or less than about 20 degrees, or less than about 15 degrees, or less than about 12 degrees, or less than about 10 degrees, or less than about 9 degrees, or less than about 8 degrees, or less than about 7 degrees, or less than about 6 degrees, or less than about 5 degrees, or less than about 4 degrees, or less than about 3 degrees, or less than about 2 degrees, or less than about 1 degree. In some cases, opposing side facets **172** of bonding portion **170** are parallel to each other. In such cases, the included angle between the two opposing side facets is zero.

[0138] Side facets **172** of bonding portions **170** make an angle θ_4 with a normal line **181** that is perpendicular to light directing film **100** or plane **105** of the light directing film. In some cases, the angle θ_4 between a side facet **172** of a bonding portion **170** and a normal **181** to the light directing film **100** is in a range from about zero degree to about 40 degrees, or from about zero degree to about 35 degrees, or from about zero degree to about 30 degrees, or from about zero degree to about 25 degrees, or from about zero degree to about 20 degrees, or from about zero degree to about 15 degrees, or from about zero degree to about 10 degrees, or from about zero degree to about 5 degrees.

[0139] In some cases, a side facet of the light directing portion of a unitary discrete structure **150** makes an angle θ_3 with a normal, such as normal **180**, to light directing film **100**, and a side facet of the bonding portion of the same unitary discrete structure makes an angle θ_4 with the normal, such as normal **180**, to light directing film **100**. In some cases, θ_4 is less than θ_3 . In some cases, θ_4 is less than θ_3 by at least about 5 degrees, or about 10 degrees, or about 15 degrees, or about 20 degrees, or about 25 degrees, or about 30 degrees, or about 35 degrees, or about 40 degrees.

[0140] In some cases, each side facet of the light directing portion of a unitary discrete structure **150** makes an angle θ_3 with a normal, such as normal **180**, to light directing film **100**, and each side facet of the bonding portion of the same unitary discrete structure makes an angle θ_4 with the normal, such as normal **180**, to light directing film **100**. In some cases, θ_4 is less than θ_3 . In some cases, θ_4 is less than θ_3 by at least about 5 degrees, or about 10 degrees, or about 15 degrees, or about 20 degrees, or about 25 degrees, or about 30 degrees, or about 35 degrees, or about 40 degrees.

[0141] In some cases, the light directing portions of a light directing film can have substantially equal maximum heights. For example, light directing portions **160** can have substantially equal maximum heights h_1 . In some cases, at least two light directing portions can have unequal maximum heights. For example, referring to FIG. 7, maximum height **740A** of light directing portion **710A** is different than maximum height **740C** of light directing portion **710C**. In some cases, the maximum heights of some of the light directing portions is less than the maximum heights of some other light directing portions. For example, maximum height **740C** is less than maximum height **740A**.

[0142] In some cases, the maximum height of a disclosed light directing portion is less than about 500 microns, or less than about 400 microns, or less than about 300 microns, or less than about 200 microns, or less than about 100 microns, or less than about 90 microns, or less than about 80 microns, or less than about 70 microns, or less than about 60 microns,

or less than about 50 microns, or less than about 40 microns, or less than about 30 microns, or less than about 20 microns, or less than about 10 microns.

[0143] Referring back to FIG. 1, each bonding portion **170** includes a top surface **190** that connects the plurality of side facets **172** of the bonding portion. In some cases, top surface **190** can be substantially planar. For example, referring to FIG. 3, top surface **390** of bonding portion **370** is substantially planar. As another example, referring to FIG. 4, top surface **490** of bonding portion **480** is substantially planar.

[0144] In general, the top surface of a bonding portion can have any shape, such as any regular or irregular shape, or profile that may be desirable in an application. For example, in some cases, the top surface of a bonding portion is substantially piecewise planar. For example, FIG. 25 is a schematic three-dimensional view of a linear unitary discrete structure **2500** that extends along the y-direction and includes a light directing portion **2510** and a bonding portion **2520** that is disposed on the light directing portion. Bonding portion **2520** includes a side facet **2530** and an opposing side facet **2532**, where the two side facets have an included angle θ_2 . In some cases, each side facet **2530** makes an angle with the xy-plane or the plane of the light directing film that is associated with unitary discrete structure **2500**, that is greater than about 60 degrees, or about 65 degrees, or about 70 degrees, or about 75 degrees, or about 80 degrees, or about 85 degrees. The bonding portion also includes and a top surface **2540** that connects side facets **2530** and **2532**. Top surface **2540** is piecewise planar and includes a first planar surface **2545** and a second planar surface **2547**. In some cases, each of the top planar surfaces **2545** and **2547** makes an angle with the xy-plane that is less than about 60 degrees, or about 55 degrees, or about 50 degrees, or about 45 degrees, or about 40 degrees, or about 35 degrees, or about 30 degrees, or about 25 degrees, or about 20 degrees, or about 15 degrees, or about 10 degrees. The two planar surfaces intersect at a peak **2560** of top surface **2540**, bonding portion **2520**, and unitary discrete structure **2500**, where peak **2560** is a line peak. Peak **2540** of the top surface or the bonding portion has an included angle θ_5 between the two planar surfaces that, in some cases, can be different than included angle θ_2 . In general, included angle θ_5 can be any angle, such as any angle from about zero degree to about 180 degrees, that may be desirable in an application. For example, in some cases, included angle θ_5 can be greater than about 90 degrees, or about 100 degrees, or about 110 degrees, or about 120 degrees, or about 130 degrees, or about 140 degrees, or about 150 degrees, or about 160 degrees, or about 170 degrees. In some cases, the included angle θ_5 is less than about 70 degrees, or about 65 degrees, or about 60 degrees, or about 55 degrees, or about 50 degrees, or about 45 degrees, or about 40 degrees, or about 35 degrees, or about 30 degrees, or about 25 degrees, or about 20 degrees.

[0145] As another example, FIG. 26 is a schematic three-dimensional view of a linear unitary discrete structure **2600** that extends along the y-direction and includes a light directing portion **2610** and a bonding portion **2620** that is disposed on the light directing portion. Bonding portion **2620** includes a side facet **2630** and an opposing side facet **2632**, where the two side facets have an included angle θ_2 . The bonding portion also includes a top surface **2640** that connects side facets **2630** and **2632**. Top surface **2640** is piecewise planar and includes a first planar surface **2642**, a second planar surface **2644**, and a third planar surface **2646**. Planar surface **2644** also forms a peak of top surface **2640**, bonding portion **2620**,

and unitary discrete structure **2600**. Peak **2644** has an included angle θ_5 that, in some cases, can be different than included angle θ_2 .

[0146] In some cases, such as when the facets are planar, facets of a bonding portion of a light directing film that make an angle with the plane of the light directing film that is greater than about 60 degrees, or about 65 degrees, or about 70 degrees, or about 75 degrees, or about 80 degrees, or about 85 degrees, form the side facets of the bonding portion and facets of the bonding portion that make an angle with the plane of the light directing film that is less than about 60 degrees, or about 55 degrees, or about 50 degrees, or about 45 degrees, or about 40 degrees, or about 35 degrees, or about 30 degrees, or about 25 degrees, or about 20 degrees, or about 15 degrees, or about 10 degrees, form the top facets of the bonding portion.

[0147] In some cases, the top surface of a bonding portion can be substantially curved. For example, referring to FIG. 9, top surface **980** of bonding portion **970** is substantially curved. In some cases, the top surface of a bonding portion can be substantially piecewise curved. For example, FIG. 27 is a schematic three-dimensional view of a linear unitary discrete structure **2700** that extends along the y-direction and includes a light directing portion **2710** and a bonding portion **2720** that is disposed on the light directing portion. Bonding portion **2720** includes a side facet **2730** and an opposing side facet **2732**, where the two side facets have an included angle θ_2 . The bonding portion also includes a top surface **2740** that connects side facets **2730** and **2732**. Top surface **2740** is piecewise curved and includes a first curved surface **2742** and a second curved surface **2744**. The two curved surfaces intersect at a peak **2760** of top surface **2740**, bonding portion **2720**, and unitary discrete structure **2700**, where peak **2760** is a line peak. Peak **2760** of the top surface, the bonding portion, and the unitary discrete structure has an included angle θ_5 between the two curved surfaces that, in some cases, can be different than included angle θ_2 . In some cases, the included angle θ_5 is less than about 70 degrees, or about 65 degrees, or about 60 degrees, or about 55 degrees, or about 50 degrees, or about 45 degrees, or about 40 degrees, or about 35 degrees, or about 30 degrees, or about 25 degrees, or about 20 degrees.

[0148] In some cases, the top surface of a bonding portion can include one or more recessions. For example, FIG. 28 is a schematic three-dimensional view of a linear unitary discrete structure **2800** that extends along the y-direction and includes a light directing portion **2810** and a bonding portion **2820** that is disposed on the light directing portion. Bonding portion **2820** includes a side facet **2830** and an opposing side facet **2832**, where the two side facets have an included angle θ_2 . The bonding portion also includes a top surface **2840** that connects side facets **2830** and **2832**. Top surface **2840** is piecewise planar and includes a first planar surface **2842**, a second planar surface **2844**, a third planar surface **2846**, and a fourth planar surface **2848**. Adjacent planar surfaces **2842** and **2844** intersect at a first peak **2860** of top surface **2840**, bonding portion **2820**, and unitary discrete structure **2800**, where first peak **2860** is a line peak. Top planar surfaces **2842** and **2844** define an included angle θ_6 at first peak **2860** that, in some cases, can be different than included angle θ_2 . Adjacent planar surfaces **2846** and **2846** intersect at a second peak **2862** of top surface **2840**, bonding portion **2820**, and unitary discrete structure **2800**, where first peak **2862** is a line peak. Top planar surfaces **2846** and **2848** define an included angle θ_7 at second peak **2862** that, in some cases, can be different than included angles θ_2 and/or θ_6 . Top surface **2840** includes a

recession **2870** in the form of a recessed surface that is disposed between first peak **2860** and second peak **2862**. In some cases, a sharp peak of a top surface of a bonding portion of a light directing film can assist the bonding portion in penetrating into an optical film or an optical adhesive layer of an optical film that is to be attached to the light directing film. In some cases, the top surface of a bonding portion, or a cross-section of the top surface in a direction perpendicular to the base of the bonding portion, can have multiple discrete peaks. For example, top surface **2840** of bonding portion **2820** includes two discrete peaks **2860** and **2862**. In general, the peak angles θ_6 and θ_7 of respective peaks **2860** and **2862** of top surface **2840** can have any value that may be desirable in an application. For example, in some cases, the peak angle of at least one of the multiple discrete peaks **2860** and **2862** can be less than about 70 degrees, or about 65 degrees, or about 60 degrees, or about 55 degrees, or about 50 degrees, or about 45 degrees, or about 40 degrees, or about 35 degrees, or about 30 degrees, or about 25 degrees, or about 20 degrees.

[0149] FIG. 30 is a schematic side-view of an optical stack **3000** that includes a light directing film **3020** that includes a plurality of unitary discrete structures **3030** disposed on a first substrate **3010**, a second substrate **3015** having a major surface **3018** facing the light directing film and an opposing major surface **3019** facing away from the light directing film, and an optical adhesive layer **3025** disposed between light directing film **3020** and second substrate **3015** for bonding or adhering the light directing film to surface **3018** of the second substrate.

[0150] Portion **3040** of each unitary discrete structure **3030** penetrates into optical adhesive layer **3025** and can be referred to as the penetrating portion **3040** of the unitary discrete structure. Portion **3045** of each unitary discrete structure **3030** does not penetrate into optical adhesive layer **3025** and can be referred to as the non-penetrating portion **3045** of the unitary discrete structure. Each penetrating unitary discrete structure defines a penetration depth **3050** which is the longest penetration distance normal to the optical stack (z-direction). For example, unitary discrete structure **3030A** has a penetration depth PD_1 and unitary discrete structure **3030B** has a penetration depth PD_2 . Each unitary discrete structure also defines a penetration base **3054** at interface **3056** between penetrating portion **3040** and non-penetrating portion **3045** of the unitary discrete structure. Penetration base **3054** has a minimum penetration base dimension **3058** that, in some cases, can be the width of the penetration base along the x-axis. For example, unitary discrete structure **3030A** has a minimum penetration base dimension MD_1 and unitary discrete structure **3030B** has a minimum penetration base dimension MD_2 . The plurality of unitary discrete structures **3030** has an average penetration depth and an average minimum penetration base dimension. For example, the unitary discrete structures **3030A** and **3030B** have an average penetration depth PD_{avg} that is equal to $(PD_1 + PD_2)/2$ and an average minimum penetration base dimension MD_{avg} that is equal to $(MD_1 + MD_2)/2$. The ratio of the average penetration depth to the average minimum penetration base dimension is sufficiently large so as to provide sufficient adhesion between light directing film **3020** and surface **3018**. In some cases, the ratio of the average penetration depth to the average minimum penetration base dimension is at least about 1.2, or at least about 1.4, or at least about 1.5, or at least about 1.6, or at least about 1.8, or at least about 2, or at least about 2.5, or at least about 3, or at least about 3.5, or at least about 4, or at least

about 4.5, or at least about 5, or at least about 5.5, or at least about 6, or at least about 6.5, or at least about 7, or at least about 8, or at least about 9, or at least about 10, or at least about 15, or at least about 20.

[0151] Each unitary discrete structure **3030** includes a base **3031** that has a minimum base dimension **3032**, where base **3031** is also the base of light directing portion **3070**. For example, the base of unitary discrete structure **3030A** has a minimum base dimension BMD_1 and the base of unitary discrete structure **3030B** has a minimum base dimension BMD_2 . The plurality of unitary discrete structures **3030** has an average minimum base dimension. For example, the unitary discrete structures **3030A** and **3030B** have an average minimum base dimension BMD_{avg} that is equal to $(BMD_1 + BMD_2)/2$. The average minimum penetration base dimension MD_{avg} is sufficiently smaller than the average minimum base dimension BMD_{avg} so that there is no, or very little loss, in the effective transmission of optical stack **3000**. For example, in some cases, the average minimum penetration base dimension is less than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, of the average minimum base dimension.

[0152] In some cases, the peel strength between light directing film **3020** and surface **3018** or second substrate **3015** is greater than about 20 grams/inch, or about 25 grams/inch, or about 30 grams/inch, or about 35 grams/inch, or about 40 grams/inch, or about 45 grams/inch, or about 50 grams/inch, or about 60 grams/inch, or about 70 grams/inch, or about 80 grams/inch, or about 90 grams/inch, or about 100 grams/inch, or about 110 grams/inch, or about 120 grams/inch, or about 130 grams/inch, or about 140 grams/inch, or about 150 grams/inch.

[0153] In some cases, optical stack **3000** includes a plurality of voids **3060** between optical adhesive layer **3025** and light directing film **3020**. In some cases, the voids are discrete meaning that each void can be identified individually and as being separate from other voids. In some cases, a discrete void is bound on top by optical adhesive layer **3025**, on bottom by light directing film **3020**, on one side by the non-penetrating portion of a unitary discrete structure, and on the opposite side by the non-penetrating portion of a neighboring or adjacent unitary discrete structure.

[0154] In some cases, the penetration of penetrating portions **3040** or unitary discrete structures **3030** into optical adhesive layer **3025** results in no, or very little, loss in the effective transmission of optical stack **3000**. For example, in such cases, the average effective transmission of optical stack **3000** is not less or is less than by no more than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into optical adhesive layer **3025**.

[0155] Each unitary discrete structure **3030** includes a light directing portion **3070** that is designed primarily for directing light and a bonding portion **3080** that is designed primarily for bonding light directing film **3020** to surface **3018** or second substrate **3015**. In some cases, at least portions of the bonding portion of each unitary discrete structure penetrates into optical adhesive layer **3025** and at least portions of the light directing portion of each unitary discrete structure does not penetrate into the optical adhesive layer. In some cases, such as when it is desirable to effectively direct light to enhance

brightness, only at least portions of bonding portions **3080** penetrate into optical adhesive layer **3025** and no, or very little, portions of light directing portions **3070** penetrate into optical adhesive layer **3025**.

[0156] In the exemplary optical stack **3000**, unitary discrete structures **3030** of light directing film **3020** penetrate into optical adhesive layer **3025**. In general, unitary discrete structures **3030** may penetrate into any optical layer that is capable of being penetrated and is desirable in an application. In general, optical stack **3000** includes light directing film **3020** that includes a first plurality of unitary discrete structures **3030**. Optical stack **3000** also includes an optical layer **3025** that is disposed on light directing film **3020**. Portions of each unitary discrete structure **3030** in the first plurality of unitary discrete structures penetrate into optical layer **3025**. Portions of each unitary discrete structure **3030** in the first plurality of unitary discrete structures does not penetrate into optical layer **3025**. Each unitary discrete structure (for example, unitary discrete structure **3030A**) in the first plurality of unitary discrete structures defines a penetration depth (for example, PD_1) and a penetration base (for example, penetration base **3054**) at an interface (for example, interface **3056**) between the penetrating and non-penetrating portions of the unitary discrete structure. The penetration base has a minimum penetration base dimension (for example, MD_1). The first plurality of unitary discrete structures **3030** has an average penetration depth and an average minimum penetration base dimension. The ratio of the average penetration depth to the average minimum penetration base dimension is at least 1.5 and the peel strength between light directing film **3020** and optical layer **3025** is greater than about 30 grams/inch.

[0157] In some cases, optical layer **3025** can be a pressure sensitive adhesive, a structural adhesive, or a hot melt adhesive. In some cases, optical layer **3025** can be a lightguide, such as lightguide **3110** in FIG. 32, that includes means, such as light extractors **3112**, for extracting light that propagates within the lightguide by total internal reflection.

[0158] In some cases, optical stack **3000** has a maximum operating temperature T_{max} and optical layer **3025** has a glass transition T_g that is greater than T_{max} . In such cases, optical stack **3000** can be prepared by first increasing the temperature of optical layer **3025** to a temperature that is greater than T_g of the optical layer. Next, the heated optical layer and light directing film **3070** can be pressed against each other so that portions of unitary discrete structures **3030** penetrate into the heated optical layer. Next, the temperature of the optical layer can be reduced to, for example, room temperature. Since, T_{max} is less than T_g , the optical stack remains intact and laminated when used at temperatures less than T_{max} .

[0159] All the structures in the first plurality of unitary discrete structures are unitary. Furthermore, only a portion of each structure penetrates into optical layer **3025** resulting in an average penetration depth and an average minimum penetration base dimension. In addition, the ratio of the average penetration depth to the average minimum penetration base dimension is at least about 1.2, or at least about 1.4, or at least about 1.5, or at least about 1.6, or at least about 1.8, or at least about 2, or at least about 2.5, or at least about 3, or at least about 3.5, or at least about 4, or at least about 4.5, or at least about 5, or at least about 5.5, or at least about 6, or at least about 6.5, or at least about 7, or at least about 8, or at least about 9, or at least about 10, or at least about 15, or at least about 20.

[0160] In some cases, light directing film 3020 can include a second plurality of unitary discrete structures, where at least one unitary discrete structure in the second plurality of unitary discrete structures does not penetrate into optical layer 3025. For example, some unitary discrete structures in the second plurality of structures may be sufficiently shorter than structures 3030 so that they do not penetrate into optical layer 3025. For example, referring to FIG. 34, the first plurality of unitary discrete structures may include structures 3320 and the second plurality of unitary discrete structures may include structures 3330 that do not penetrate into an optical layer 3420 because they are shorter than structures 3320. In some case, light directing film 3020 can include a second plurality of structures that are composite and not unitary. For example, the second plurality of structures can include composite structures similar to composite structure 200 illustrated in FIG. 2.

[0161] FIG. 31 is a schematic side-view of a display system 3100 that includes image forming panel 1950 for forming and displaying information to viewer 1990. Image forming panel 1950 is disposed on an illumination system 3145 that includes a back reflector 3105 for reflecting light that is incident on the back reflector towards image forming panel 1950 and viewer 1990, a lightguide 3110 receiving light 3116 emitted by a lamp 3115 and emitting the received light towards image forming panel 1950, and an optical stack 3135 disposed on and adhering to lightguide 3110.

[0162] Optical stack 3135 includes a first optical stack 3115 disposed on and securely attached to a second optical stack 3125. First optical stack 3115 includes a first optical adhesive layer 3170 for adhering the first optical stack to the second optical stack and a reflective polarizer layer 3180 disposed on first optical adhesive layer 3170. Reflective polarizer layer 3180 substantially reflects light of a first polarization state and substantially transmits light of a second polarization state orthogonal to the first polarization state. For example, reflective polarizer layer 3180 reflects at least 50%, or at least 60%, or at least 70%, or at least 80%, or at least 90%, of a first polarization state and transmits at least 50%, or at least 60%, or at least 70%, or at least 80%, or at least 90%, of a second polarization state orthogonal to the first polarization state. In general, the pass or transmission axis of reflective polarizer layer 3180 can be oriented along any direction that may be desirable in an application. For example, in some cases, the pass axis of the reflective polarizer layer can be along the x-axis or the y-axis or make a 45 degree angle with the x- and y-axes. In some cases, reflective polarizer layer 3180 can have light collimating effects along one or more directions meaning that the reflective polarizer layer can confine light into a narrower viewing cone in one or more directions. For example, in some cases, reflective polarizer layer 3180 can reduce the viewing cone in the xz-plane, yz-plane or both.

[0163] In some cases, display system 3100 does not include a reflective polarizer layer 3180. In such cases, the display system may include a second light directing film adhered to first optical adhesive layer 3170.

[0164] Second optical stack 3125 includes a second optical adhesive layer 3120 for adhering the second optical stack to lightguide 3110, a low index layer 3130 disposed on the second optical adhesive layer, and a light directing film 3140 disposed on low index layer 3130.

[0165] Low index layer 3130 includes a plurality of voids dispersed in a binder having an index of refraction n_b . In some

cases, the plurality of voids is or includes a plurality of interconnected voids dispersed in the binder.

[0166] In some cases, the low index layer has low optical haze. For example, in such cases, the optical haze of low index layer is not greater than about 8%, or not greater than about 7%, or not greater than about 6%, or not greater than about 5%, or not greater than about 4%, or not greater than about 3%, or not greater than about 2%, or not greater than about 1%. For light normally incident on low index layer 3130, optical haze, as used herein, is defined as the ratio of the transmitted light that deviates from the normal direction by more than 4 degrees to the total transmitted light. Haze values disclosed herein were measured using a Haze-guard Plus haze meter (BYK-Gardiner, Silver Springs, Md.) according to the procedure described in ASTM D1003.

[0167] In some cases, the voids in low index layer 3130 are sufficiently smaller than the wavelengths in the visible range of the spectrum, so that the low index layer has an effective index of refraction that is substantially less than the index of refraction n_b of the binder in the low index layer. In such cases, the effective index of the low index layer is the volume weighted average of the indices of refraction of the voids and the binder. For example, a low index layer 3130 that has a void volume fraction of about 50% and a binder that has an index of refraction of about 1.5, has an effective index of about 1.25. In some cases, the average effective refractive index of the low index layer in the visible range of the spectrum is less than about 1.4, or less than about 1.35, or less than about 1.3, or less than about 1.25, or less than about 1.2, or less than about 1.15, or less than about 1.1, or less than about 1.09, or less than about 1.08, or less than about 1.07, or less than about 1.06, or less than about 1.05.

[0168] In some cases, low index layer 3130 has a large optical haze. In such cases, the optical haze of low index layer is not less than about 10%, or not less than about 15%, or not less than about 20%, or not less than about 25%, or not less than about 30%, or not less than about 35%, or not less than about 40%, or not less than about 45%, or not less than about 50%, or not less than about 60%, or not less than about 70%, or not less than about 80%. In such cases, low index layer 3130 can be capable of enhancing internal reflection meaning that the reflection is greater than what a material with index n_b (binder index) would produce. In such cases, low index layer 3130 is sufficiently thick so that the evanescent tail of a light ray that undergoes total internal reflection at a surface of the low index layer, does not optically couple, or optically couples very little, across the thickness of the low index layer. In such cases, the thickness of low index layer 3130 is not less than about 1 micron, or not less than about 1.1 micron, or not less than about 1.2 microns, or not less than about 1.3 microns, or not less than about 1.4 microns, or not less than about 1.5 microns, or not less than about 1.7 microns, or not less than about 2 microns. A sufficiently thick low index layer 3130 can prevent or reduce an undesired optical coupling of the evanescent tail of an optical mode across the thickness of the low index layer.

[0169] In some cases, low index layer 3130 also includes a plurality of particles dispersed in the binder. The particles can have any size or shape, such as any regular or irregular shape, that may be desirable in an application. For example, in some cases, at least a majority of the particles, such as at least 60%, or at least 70%, or at least 80%, or at least 90%, or at least 95%, of the particles have a size that is in a desired range. For example, in some cases, at least a majority of the particles,

such as at least 60%, or at least 70%, or at least 80%, or at least 90%, or at least 95%, of the particles have a size that is not greater than about 5 microns, or not greater than about 3 microns, or not greater than about 2 microns, or not greater than about 1 micron, or not greater than about 700 nm, or not greater than about 500 nm, or not greater than about 200 nm, or not greater than about 100 nm, or not greater than about 50 nm.

[0170] In some cases, the particles have an average particle size that is not greater than about 5 microns, or not greater than about 3 microns, or not greater than about 2 microns, or not greater than about 1 micron, or not greater than about 700 nm, or not greater than about 500 nm, or not greater than about 200 nm, or not greater than about 100 nm, or not greater than about 50 nm.

[0171] In some cases, the particles in the low index layer are sufficiently small so that the primary optical effect of the particles is to affect the effective index of low index layer 3130. For example, in such cases, the particles have an average size that is not greater than about $\lambda/5$, or not greater than about $\lambda/6$, or not greater than about $\lambda/8$, or not greater than about $\lambda/10$, or not greater than about $\lambda/20$, where λ is the average wavelength of visible light. As another example, in such cases, the average particle size is not greater than about 70 nm, or not greater than about 60 nm, or not greater than about 50 nm, or not greater than about 40 nm, or not greater than about 30 nm, or not greater than about 20 nm, or not greater than about 10 nm.

[0172] The particles in low index layer 3130 can have any shape that may be desirable in an application. For example, the particles can have a regular or irregular shape. For example, the particles can be approximately spherical. As another example, the particles can be elongated.

[0173] In general, low index layer 3130 can have uniform or non-uniform effective index of refraction and/or optical haze. For example, in some cases, low index layer 3130 can have uniform effective index of refraction and uniform optical haze. As another example, in some cases, low index layer 3130 can have non-uniform optical haze. For example, in some cases, low index layer 3130 can have a gradient optical haze along, for example, the thickness direction of the low index layer. As another example, low index layer 3130 can include multilayers, where at least some of the layers have different effective refractive indices and/or optical haze values. For example, in some cases, low index layer 3130 can include multilayers, where each layer has a different effective index of refraction and/or optical haze. In such cases, the low index layer 3130 can have a staircase effective refractive index profile. As another example, low index layer 3130 can include multilayers having alternating high and low optical haze. Exemplary low index layers 3130 having non-uniform optical haze and/or effective refractive index are described in, for example, U.S. Patent Application Ser. No. 61/254,673 titled "Gradient Low Index Article and Method", Attorney Docket Number 65716US002, filed on Oct. 24, 2009, and U.S. Patent Application Ser. No. 61/254,674 titled "Process for Gradient Nanovoiced Article", Attorney Docket No. 65766US002, filed on Oct. 24, 2009, the disclosures of which are incorporated herein in their entireties by reference.

[0174] Light directing film 3140 includes a plurality of unitary discrete structures 3155. A portion 3156 of each unitary discrete structure 3155 penetrates into first optical adhesive layer 3170 and can be considered as the penetrating portion 3156 of the unitary discrete structure. A portion 3157

of each unitary discrete structure 3155 does not penetrate into first optical adhesive layer 3170 and can be considered as the non-penetrating portion 3157 of the unitary discrete structure. Each unitary discrete structure 3155 defines a penetration depth 3172 and a penetration base 3158 at an interface 3162 between the penetrating portion 3156 and the non-penetrating portion 3157 of the unitary discrete structure. Penetration base 3158 has a minimum penetration base dimension 3159 that, in some cases, can be the width of the penetration base along the x-direction. The plurality of unitary discrete structures 3155 has an average penetration depth which is the average of the penetration depths of the individual unitary discrete structures, and an average minimum penetration base dimension that is the average of the minimum penetration base dimensions of all the penetration bases. In some cases, the ratio of the average penetration depth to the average minimum penetration base dimension is at least about 1.2, or at least about 1.3, or at least about 1.4, or at least about 1.5, or at least about 1.6, or at least about 1.8, or at least about 2, or at least about 2.5, or at least about 3, or at least about 3.5, or at least about 4, or at least about 4.5, or at least about 5, or at least about 5.5, or at least about 6, or at least about 6.5, or at least about 7, or at least about 8, or at least about 9, or at least about 10, or at least about 15, or at least about 20.

[0175] Each unitary discrete structure 3155 includes a base 3198 that has a minimum base dimension 3199, where base 3198 is also the base of light directing portion 3150. The plurality of unitary discrete structures 3155 has an average minimum base dimension. The average minimum penetration base dimension is sufficiently smaller than the average minimum base dimension so that there is no, or very little loss, in the effective transmission of optical stack 3135. For example, in some cases, the average minimum penetration base dimension is less than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, of the average minimum base dimension.

[0176] In some cases, the peel strength between first optical stack 3115 and second optical stack 3125 is greater than about 20 grams/inch, or about 25 grams/inch, or about 30 grams/inch, or about 35 grams/inch, or about 40 grams/inch, or about 45 grams/inch, or about 50 grams/inch, or about 60 grams/inch, or about 70 grams/inch, or about 80 grams/inch, or about 90 grams/inch, or about 100 grams/inch, or about 110 grams/inch, or about 120 grams/inch, or about 130 grams/inch, or about 140 grams/inch, or about 150 grams/inch.

[0177] In some cases, unitary discrete structures 3155 are linear structures that extend along any direction that may be desirable in an application. For example, in some cases, the linear direction of structures 3155 can be parallel to the pass axis of reflective polarizer layer 3180. As another example, in some cases, the linear direction of structures 3155 can be perpendicular to the pass axis of reflective polarizer layer 3180.

[0178] In some cases, substantial portions of each two neighboring major surfaces in each of the first and second optical stacks are in physical contact with each other. For example, in such cases, at least 50%, or at least 60%, or at least 70%, or at least 80%, or at least 90%, of each two neighboring major surfaces in each of the first and second optical stacks are in physical contact with each other.

[0179] Light 3116 emitted by lamp 3115 enters lightguide 3110 from a side 3127 of the lightguide and propagates across the length of the lightguide along the x-direction. Low index layer 3130 facilitates the propagation of light within lightguide 3110 by supporting total internal reflection and/or enhancing internal reflection at an interface 3122 between low index layer 3130 and second optical adhesive layer 3120. In general, lightguide 3110 includes one or more means for extracting light that propagates within the lightguide toward the general direction of image forming panel 1950. For example, in some cases, lightguide 3110 includes a plurality of light extractors 3112 disposed, in some cases, on a bottom surface 3124 of the lightguide for extracting light. As another example, in some cases, the lightguide can be a wedge lightguide. Light extractors 3112 can be any type structure that is capable of extracting light by disrupting TIR. For example, light extractors 3112 can be depression or protrusions. In some cases, light extractors can be formed by printing, such as inkjet or screen printing or etching, such wet or dry etching.

[0180] In general, the lightguides disclosed herein, such as lightguides 1920 and 3110, can be any type lightguide that may be desirable in an application. For example, in some cases, a disclosed lightguide can be a thin film lightguide having a thickness that is less than about 500 microns, or about 400 microns, or about 300 microns, or about 200 microns, or about 100 microns, or about 75 microns, or about 50 microns, or about 25 microns. As another example, in some cases, a disclosed lightguide can be a plate lightguide having a thickness that is greater than about 0.5 mm, or about 1 mm, or about 1.5 mm, or about 2 mm. In some cases, a disclosed lightguide can be a slab lightguide having parallel major surfaces or a wedge lightguide having non-parallel, such as converging or diverging, major surfaces. In some cases, a disclosed lightguide can be rectangular or square. In some cases, a disclosed lightguide can be substantially flat or curved. In general, the disclosed lightguides can be made of any sufficiently optically transparent material that may be desirable in an application. Exemplary materials include polymers such as polycarbonate, acrylic and cyclo olefin polymer (COP) and glass.

[0181] First optical stack 3115 also includes a light diffusing layer 3190 that can be a surface and/or bulk diffuser. Light diffusing layer 3190 can assist in diffusing light, hiding or masking defects such as dust particles or scratches, and/or reducing the visibility of undesirable optical effects such as moiré. In some cases, light diffusing layer 3190 can be replaced by, or include, an optical layer or film disclosed herein. For example, in some cases, light diffusing layer 3190 can be replaced by a reflective polarizer or a light directing film such as light directing film 4100 or 4300. In such cases, a light directing film 3190 can include linear structures that extend along a first direction and light directing film 3140 can include linear unitary discrete structures that extend along a second direction, where the angle between the first and second directions can be any angle that may be desirable in an application. For example, the angle between the first and second directions can be about 90 degrees, or less than about 90 degrees, or less than about 80 degrees, or less than about 70 degrees, or less than about 60 degrees, or less than about 50 degrees, or less than about 40 degrees, or less than about 30 degrees, or less than about 20 degrees, or less than about 10 degrees. In some cases, reflective polarizer layer 3180 can be replaced by, or include a light directing film such as light directing film 4100 or 4300. In some cases, display system

3100 does not include any light diffusing layer, such as light diffusing layer 3190, between reflective polarizer layer 3180 and image forming panel 1950.

[0182] Each unitary discrete structure 3155 includes a light directing portion 3150 primarily for directing light and a bonding portion 3160 primarily for securely bonding second optical stack 3125 to first optical stack 3115 without reducing, or reducing very little, the effective transmission of optical stack 3135. In some cases, the penetration of penetrating portions 3156 or unitary discrete structures 3155 into first optical adhesive layer 3170 results in no, or very little, loss in the effective transmission of optical stack 3135. For example, in such cases, the average effective transmission of optical stack 3135 is not less or is less than by no more than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into first optical adhesive layer 3170.

[0183] In some cases, unitary discrete structures 3155 are linear structures that are substantially parallel to side 3127 of lightguide 3110, where side 3127 is the side of the lightguide that receives light 3116 emitted by lamp 3115. For example, in such cases, linear unitary discrete structures 3155 and side 3127 can extend along the y-direction. In some cases, side 3127 may extend along one direction, such as the y-direction, and the linear unitary discrete structures may extend along an orthogonal direction, such as the x-direction.

[0184] In general, display system 3100 can include any additional optical layer that is not expressly illustrated in FIG. 31. For example, in some cases, display system 3100 can include one or more additional layers between, for example, reflective polarizer layer 3180 and first optical adhesive layer 3170. As another example, in some cases, display system 3100 can include a sealing or barrier layer disposed between low index layer 3130 and second optical adhesive layer 3120 for preventing the adhesive layer from diffusing into and filling the voids in the low index layer.

[0185] Back reflector 3105 can be any light reflector that may be desirable in an application. For example, in some cases, back reflector 3105 can be primarily a specular reflector or primarily a diffuse reflector. As another example, in some cases, back reflector 3105 can be partially a diffuse reflector and partially a specular reflector. In some cases, back reflector 3105 can be an aluminized film, a silver coated film, or a multilayer polymeric reflective film, such as an enhanced specular reflector (ESR) film available from 3M Company, St. Paul, Minn. In some cases, back reflector 3105 can diffusely reflect light by including a surface and/or volume diffuser.

[0186] In the exemplary display system 3100 light that is extracted from lightguide 3110 is directed along the positive z-direction towards image forming device 1950. In some cases, light that is extracted from the lightguide may be directed along more than one direction. For example, FIG. 49 is a schematic side-view of an optical stack 4900 that directs a portion of light that is extracted from lightguide along the positive z-direction and directs another portion of the extracted light along the negative z-direction.

[0187] In some cases, the reflective polarizers, such as reflective polarizer layer 3180, disclosed herein can be replaced with a partially reflecting layer that reflects a portion of an incident light and transmits another portion of the incident light. In general, each of the reflected and transmitted

beams can have a specular portion and a diffuse portion. For example, a portion of an incident light can be specularly reflected by the partially reflecting layer and another portion of the incident light can be diffusely reflected by the partially reflecting layer. As another example, a portion of an incident light can be specularly transmitted by the partially reflecting layer and another portion of the incident light can be diffusely transmitted by the partially reflecting layer. As another example, a partially reflecting layer **3180** can specularly transmit light and diffusely reflect light, or diffusely transmit light and specularly reflect light. In some cases, a partially reflecting layer **3180** can be a non-polarizing partially reflecting layer. For example, a partially reflecting layer **3180** can include a partially reflective metal and/or dielectric layer. In some cases, a partially reflecting layer **3180** can be a polarizing partially reflecting layer similar to the reflective polarizers disclosed herein.

[0188] FIG. **32** is a schematic side-view of a display system **3200** that is similar to display system **3100**. In display system **3200**, reflective polarizer layer **3180** is disposed on and adhered to image forming panel **1950** and light diffusing layer **3190** is disposed on first optical adhesive layer **3170**. An optical stack **3210** in display system **3200** includes second optical adhesive layer **3120**, low index layer **3130** disposed on the second optical adhesive layer, light directing film **3140** that is disposed on the low index layer and includes plurality of unitary discrete structures **3155**, and first optical adhesive layer **3170** that is disposed on the light directing film. Portions **3156** of each unitary discrete structure penetrates into first optical adhesive layer **3170** and portions **3157** of each unitary discrete structure does not penetrate into first optical adhesive layer **3170**. Each unitary discrete structure **3155** defines a penetration depth **3172** and a penetration base **3158** at an interface **3162** between the penetrating and non-penetrating portions of the unitary discrete structure. Penetration base **3158** has a minimum dimension **3159**. Plurality of unitary discrete structures **3155** has an average penetration depth and an average minimum dimension. The ratio of the average penetration depth to the average minimum dimension is at least about 1.2, or at least about 1.3, or at least about 1.4, or at least about 1.5, or at least about 1.6, or at least about 1.8, or at least about 2, or at least about 2.5, or at least about 3, or at least about 3.5, or at least about 4, or at least about 4.5, or at least about 5, or at least about 5.5, or at least about 6, or at least about 6.5, or at least about 7, or at least about 8, or at least about 9, or at least about 10, or at least about 15, or at least about 20.

[0189] In some cases, the penetration of penetrating portions **3156** or unitary discrete structures **3155** into first optical adhesive layer **3170** results in no, or very little, loss in the effective transmission of optical stack **3210**. For example, in such cases, the average effective transmission of optical stack **3210** is not less or is less than by no more than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into first optical adhesive layer **3170**.

[0190] Each unitary discrete structure **3155** includes a base **3198** that has a minimum base dimension **3199**. The plurality of unitary discrete structures **3155** has an average minimum base dimension. The average minimum penetration base dimension is sufficiently smaller than the average minimum base dimension so that there is no, or very little loss, in the

effective transmission of optical stack **3210**. For example, in some cases, the average minimum penetration base dimension is less than about 20%, or about 15%, or about 10%, or about 9%, or about 8%, or about 7%, or about 6%, or about 5%, or about 4%, or about 3%, or about 2%, or about 1%, of the average minimum base dimension.

[0191] In some cases, the peel strength between light directing film **3140** and first optical adhesive layer **3170** is greater than about 20 grams/inch, or about 25 grams/inch, or about 30 grams/inch, or about 35 grams/inch, or about 40 grams/inch, or about 45 grams/inch, or about 50 grams/inch, or about 60 grams/inch, or about 70 grams/inch, or about 80 grams/inch, or about 90 grams/inch, or about 100 grams/inch, or about 110 grams/inch, or about 120 grams/inch, or about 130 grams/inch, or about 140 grams/inch, or about 150 grams/inch.

[0192] In some cases, a light directing film that is primarily designed to direct, but not recycle light, can be adhered to a lightguide via a low index layer. For example, FIG. **50** is a schematic side-view of a display system **5000** that includes light directing film **2210** from FIG. **22** laminated to lightguide **1920** via optical adhesive layer **2060** and low index layer **3130**. In some cases, light directing film **2210** can be laminated to image forming device **1950** via an optical adhesive layer not expressly illustrated in FIG. **50**.

[0193] Low index layer **3130** can be any optical layer that includes a plurality of voids dispersed in a binder. For example, low index layer **3130** can be an optical layer described in U.S. Patent Application Ser. No. 61/169,466 titled "Optical Film", Attorney Docket Number 65062US002, filed on Apr. 15, 2009; and U.S. Patent Application Ser. No. 61/169,521 "Optical Construction and Display System Incorporating Same", Attorney Docket No. 65354US002, filed on Apr. 15, 2009. As another example, low index layer **3130** can be an optical layer described in U.S. Patent Application Ser. No. 61/254,676 titled "Voided Diffuser", Attorney Docket Number 65822US002, filed on Oct. 24, 2009; and U.S. Patent Application Ser. No. 61/254,243 "Optical Construction and Method of Making the Same", Attorney Docket No. 65619US002, filed on Oct. 23, 2009; the disclosures of which are incorporated herein in their entireties by reference.

[0194] The disclosed optical adhesive layers, such as optical adhesive layers **2060**, **3025**, **3120** and **3170** can be or include any optical adhesive that may be desirable in an application. Exemplary optical adhesives include pressure sensitive adhesives (PSAs), heat-sensitive adhesives, solvent-volatile adhesives, and UV-curable adhesives such as UV-curable optical adhesives available from Norland Products, Inc. Exemplary PSAs include those based on natural rubbers, synthetic rubbers, styrene block copolymers, (meth)acrylic block copolymers, polyvinyl ethers, polyolefins, and poly (meth)acrylates. As used herein, (meth)acrylic (or acrylate) refers to both acrylic and methacrylic species. Other exemplary PSAs include (meth)acrylates, rubbers, thermoplastic elastomers, silicones, urethanes, and combinations thereof. In some cases, the PSA is based on a (meth)acrylic PSA or at least one poly(meth)acrylate. Exemplary silicone PSAs include a polymer or gum and an optional tackifying resin. Other exemplary silicone PSAs include a polydiorganosiloxane polyoxamide and an optional tackifier.

[0195] In some cases, an optical adhesive layer disclosed herein can be or include a structural adhesive. Generally, useful structural adhesives contain reactive materials that

cure to form a strong adhesive bond. The structural adhesive may cure spontaneously upon mixing (such as a 2 part epoxy adhesive) or upon exposure to air (such as a cyanoacrylate adhesive) or curing may be effected by the application of heat or radiation (such as UV light). Examples of suitable structural adhesives include epoxies, acrylates, cyanoacrylates, urethanes, and the like.

[0196] In some cases, a disclosed optical adhesive layer can be a removable adhesive such as those described in, for example, U.S. Pat. Nos. 3,691,140; 4,166,152; 4,968,562; 4,994,322; 5,296,277; 5,362,516, the disclosures of which are incorporated herein in their entireties by reference. The phrase “removable adhesive” for adhering a film to a substrate means an adhesive that affords convenient, manual removal of the film from the substrate without damaging the substrate or exhibiting excessive adhesive transfer from the film to the substrate.

[0197] In some cases, a disclosed optical adhesive layer can be a reusable and/or repositionable adhesive such as those described in, for example, U.S. Pat. No. 6,197,397; U.S. Patent Publication No. 2007/0000606; and PCT Publication No. WO 00/56556, the disclosures of which are incorporated herein in their entireties by reference. The phrases “reusable adhesive” or “repositionable adhesive” for adhering a film to a substrate mean an adhesive that (a) affords a temporary, secure attachment of the film to the substrate while affording convenient, manual removal of the film from the substrate without damaging the substrate or exhibiting excessive adhesive transfer from the film to the substrate, and (b) then affords subsequent reuse of the film on, for example, another substrate.

[0198] In some cases, a disclosed optical adhesive layer can be optically diffusive. In such cases, the optical adhesive layer can be optically diffusive by including a plurality of particles dispersed in an optical adhesive where the particles and the optical adhesive have different indices of refraction. The mismatch between the two indices of refraction can result in light scattering. In some cases, a disclosed optical adhesive can be a continuous layer. In some cases, a disclosed optical adhesive layer can be patterned.

[0199] In some cases, some discrete structures in a light directing film can have bonding portions and light directing portions and some other discrete structures may have no bonding portions and may only have light directing portions. For example, FIG. 33 is a side-view schematic of a light directing film 3300 that includes a first plurality of unitary discrete structures 3320 and a second plurality of discrete structures 3330 disposed on a substrate 3310. Unitary discrete structures 3320 includes bonding portions 3340 designed primarily for bonding the light directing film to a surface and light directing portions 3350 designed primarily for directing light and have an included angle 3355. Discrete structures 3330 do not include bonding portions and only include light directing portions 3360 that are prismatic and have an apex angle 3365. In some cases, apex angle 3365 and included angle 3355 can be substantially equal and can, for example, be about 90 degrees. In general, unitary discrete structures can be any unitary discrete structure disclosed herein and discrete structures 3330 can be any discrete structure that is capable of directing light. In some cases, unitary discrete structures 3320 and discrete structures 3330 can be linear structures extending along the same direction, such as, for example, the y-direction. In the exemplary light directing film 3300, the rows of the discrete structures alternate between

unitary discrete structures 3320 and discrete structures 3330. In general, each of unitary discrete structures 3320 and discrete structures 3330 can form any pattern or arrangement that may be desirable in an application. For example, discrete structures 3320 and 3330 can form a regular, such as periodic, or an irregular, such as a random, pattern.

[0200] FIG. 34 is a schematic side-view of an optical stack 3400 that includes light directing film 3300 laminated to a surface 3410 via an optical adhesive layer 3420. Bonding portions 3340 of unitary discrete structures 3320 at least partially penetrate into optical adhesive layer 3420 to provide secure attachment between light directing film 3300 and surface 3410. In the exemplary optical stack 3400, discrete structures 3330 do not penetrate into the optical adhesive layer, although, in some cases, portions of at least some discrete structures 3330 can penetrate into the optical adhesive layer. Light directing film 3300 includes sufficient number of bonding portions 3340 to provide sufficient adhesion between light directing film 3300 and surface 3410. At the same time, the number or density of bonding portions 3340 is sufficiently low so that there is no, or very little, loss in the optical gain or effective transmission of optical stack 3400.

[0201] Some of the exemplary display systems disclosed herein, such as display system 1900 in FIG. 19 or display system 3100 in FIG. 31, illustrate “edge-lit” displays. In an edge-lit display, one or more lamps, such as lamp 3115 in FIG. 31, are disposed along an edge or side, such as side 3127, of the display and outside an output or viewing face, such as viewing face 3182, of the display, where the viewing face of the display is the area across which information is displayed to viewer 1990. Light, such as light 3116, emitted by the lamps typically enters a lightguide, such as lightguide 3110, which spreads and redirects the light towards the viewing face of the display. In a direct-lit display, one or more, or an array of, lamps are disposed directly behind the major surfaces, such as output face 3182, of the various layers in the display system. For example, FIG. 48 is a schematic side-view of a display system 4800 that is similar to display 1900 except that display system 4800 is a direct-lit display and includes a plurality of lamps 4810 that are disposed behind the major surfaces of the various layers in the display system. In particular, lamps 4810 are disposed directly behind viewing face 4830 of display system 4800 or image forming panel 1950. Lamps 4810 emit light 4820 towards the image forming panel. In some cases, optional layer 1935 can include an optical diffuser layer for diffusing light 4820 and masking lamps 4810. As another example, FIG. 51 is a schematic side-view of a display system 5100 that is similar to display system 3100 except that lamps 3115 have been replaced with a plurality of lamps 5110 that emit light 5120 into lightguide 3110 and are housed in cavities 5130 formed within the lightguide.

[0202] In general, the light directing films in the disclosed optical stacks, such as optical stacks 3000, 3135 and 3210, may or may not have unitary structures. For example, referring to FIG. 31, in some cases, structures 3155 may be composite structures. For example, in such cases, bonding portions 3160 may form detectable interfaces with light directing portions 3150.

[0203] In some cases, only portions of a unitary discrete structure includes bonding portions. For example, FIG. 35 is a schematic three-dimensional view of a linear unitary discrete structure 3500 that extends along the y-direction and includes a plurality of discrete bonding portions 3510 dis-

posed on a light directing portion **3520**. Bonding portions **3510** and light directing portion **3520** can be any bonding portion and light directing portion disclosed herein. Each bonding portion **3510** includes a base **3530** that has a minimum dimension **3550**. Each bonding portion also has a maximum height **3540**. The density of bonding portions **3510** is sufficiently high, the ratio of maximum height **3540** to minimum dimension **3550** is sufficiently large, and minimum dimension **3550** is sufficiently small so that the bonding portions can provide sufficient adhesion between unitary discrete structure and a surface with no, or very little, loss in the effective transmission of the unitary discrete structure or the light directing film that is associated with the unitary discrete structure. In general, bonding portions **3510** can form any distribution or arrangement that may be desirable in an application. For example, in some cases, bonding portions **3510** can be irregularly, such as randomly, arranged in a light directing film.

[0204] In some cases, at least portions of the side facets and/or the top surface of the bonding portions of unitary discrete structures can be structured, such as roughened, to enhance adhesion of the bonding portions to a surface. For example, FIG. 36 is a schematic three-dimensional view of a linear unitary discrete structure **3600** that extends along the y-direction and includes a bonding portion **3610** disposed on a light directing portion **3620**. Side facets **3630** and top surface **3640** of the bonding portion are roughened to improve adhesion of the bonding portion to a surface. Light directing portion **3620** includes smooth side facets **3650** to provide efficient light directing or recycling.

[0205] Effective transmission (ET) can be measured using optical system **3700**, a schematic side-view of which is shown in FIG. 37. Optical system **3700** is centered on an optical axis **3750** and includes a hollow lambertian light box **3710** that emits a lambertian light **3715** through an emitting or exit surface **3712**, a linear light absorbing polarizer **3720** for polarizing light **3715**, and a photodetector **3730**. Light box **3710** is illuminated by a stabilized broadband light source **3760** that is connected to an interior **3780** of the light box via an optical fiber **3770**. A test sample **3705**, the ET of which is to be measured by the optical system, is placed at location **3740** between the light box and the absorbing linear polarizer.

[0206] Test sample **3705** can be any light directing film or optical stack disclosed herein. For example, test sample **3705** can be light directing film **100** having a plurality of linear unitary discrete structures **150** extending along the y-direction. The ET of light directing film **100** can be measured by placing the light redirecting film in location **3740** with unitary discrete structures **150** facing the photodetector and second major surface **120** facing the light box. Next, the spectrally weighted axial luminance I_1 (luminance along optical axis **3750**) is measured through the linear absorbing polarizer by the photo detector. Next, light directing film **100** is removed and the spectrally weighted luminance I_2 is measured without the light directing film placed at location **3740**. ET is the ratio I_1/I_2 . ET0 is the effective transmission when linear unitary discrete structures **150** extend along a direction that is parallel to the polarizing axis of linear absorbing polarizer **3720**, and ET90 is the effective transmission when linear unitary discrete structures **150** extend along a direction that is perpendicular to the polarizing axis of the linear absorbing polarizer. The average effective transmission (ETA) is the average of ET0 and ET90.

[0207] Effective transmission values disclosed herein were measured using an EPP2000 spectrometer (available from StellarNet Inc, Tampa, Fla.) for detector **3730**. The spectrometer was connected to a collimating lens via a Vis-NIR fiber optic cable (available as F1000-Vis-NIR from StellarNet Inc, Tampa, Fla.). The collimating lens included a lens tube (available as SML30 from Thorlabs, Newton, N.J.) and a plano-convex lens (available as LA1131 from Thorlabs, Newton, N.J.). The collimating lens produced a focused spot size of about 5 mm at the detector. Detector **3730** was oriented along optical axis **3750**. Linear absorbing polarizer **3720** (Melles Griot 03 FPG 007 available from CVI Melles Griot, Albuquerque, N. Mex.) was mounted on a rotary stage. Location **3740** was adjacent to emitting surface **3712** of lambertian light box **3710**. The light box was a six-sided hollow rectangular solid with approximate dimensions 12.5 cm by 12.5 cm by 11.5 cm made from diffuse PTFE plates about 0.6 mm thick. The light box had an average total diffuse reflectance of about 83%, measured at emitting surface **3712**, over the visible range. Light source **3760** and optical fiber **3770** were a stabilized broadband incandescent light source attached to a fiber optic bundle (available as Fostec DCR-III with a one cm diameter fiber bundle extension from Schott North America, Southbridge Mass.).

[0208] Peel strength values reported herein were measured using an IMASS SP-2000 tester (available from IMASS Inc., Accord, Mass.). Test strips (optical stacks with a bottom prismatic light directing film) approximately 2.54 cm wide and 20.3 cm long were prepared with the linear prisms of the bottom light directing film extending along the length of the test strips. The test strips were adhered to the tester platform using 2.54 cm wide Scotch double-coated tape (available as Scotch 665 from 3M Company, St. Paul, Minn.). The tester was configured to measure the 180 degree peel force. Test strips were oriented so that the plano side (the side opposite the prismatic structures) of the bottom prism film was adhered to the tester platform and the top film was attached to the force balance. The load cell capacity was 10 lb-ft (13.6 nt-m). Peel force was measured at a rate of 12 in/min (30.5 cm/min). Data was collected after an initial delay of 2 seconds. Measurements were then averaged over a test period of 10 seconds. For each test strip, a minimum of two sequential 10 second measurements were collected and averaged.

[0209] Light directing films disclosed herein, such as light directing film **100**, can be fabricated by first fabricating a cutting tool, such as a diamond cutting tool. The cutting tool can then be used to create the desired unitary discrete structures, such as linear unitary discrete structures, in a microreplication tool. The microreplication tool can then be used to microreplicate the structures into a material or resin, such as a UV or thermally curable resin, resulting in a light directing film. The microreplication can be achieved by any suitable manufacturing method, such as UV cast and cure, extrusion, injection molding, embossing, or other known methods.

[0210] FIG. 38 is a schematic three-dimensional view of an exemplary cutting tool, such as a diamond cutting tool, **3800** that can be used to create a microreplication tool. Cutting tool **3810** is designed to plunge into a workpiece along a plunging direction **3830** to a desired and pre-determined depth. Next, the cutting tool can cut, for example, a linear unitary discrete structure, by moving the cutting tool along a desired and predetermined cutting direction **3840** where, in some cases, direction **3840** can be generally parallel to a major surface of the workpiece. Cutting tool **3800** includes a top surface **3820**

for leading the plunging of the cutting tool into the workpiece and a cutting surface **3810** for cutting a desired profile as the cutting tool moves inside the workpiece along cutting direction **3840**. In some cases, cutting surface **3810** can be planar and in the xz-plane. In such cases, top surface **3820** can be recessed relative to the xy-plane so that the top surface does not interfere with the cutting. Cutting tool **3800** and similar cutting tools can be fabricated using focused ion beam milling processes described in, for example, U.S. Pat. No. 7,140,812, the disclosure of which is incorporated in its entirety herein by reference thereto.

[0211] FIG. 45 is an exemplary scanning electron micrograph (SEM) of a diamond cutting tool that was fabricated according to the processes disclosed herein. The diamond cutting tool had a cutting surface **4505** designed to cut linear structures in a microreplication tool that once replicated, would result in linear unitary discrete structures disclosed herein. Cutting surface **4505** included a bottom portion **4510** for fabricating the light directing portions of the unitary discrete structures and a top portion **4530** for fabricating the bonding portions of the unitary discrete structures. Bottom portion **4510** had two opposing side facets **4520** that defined an included angle **4525** that was about 88.4 degrees. Top portion **4530** had two opposing side facets that defined an included angle close to 90 degrees, and a top surface **4550** that had a recession similar to recession **2870** in FIG. 28. Top portion **4530** was about 6.4 microns long and 3.1 microns wide.

[0212] The light directing films and optical stacks disclosed herein can be employed in any application that may be desirable to increase brightness, reduce the number of separate components or layers, and reduce the overall thickness. Exemplary applications include televisions, computer monitors, projectors, potable displays such as portable video players, and hand-held devices such as cell-phones. Other exemplary applications include large displays, such as large area televisions, and small displays, such as cell-phone displays. Other exemplary applications include displays for displaying an image or information or general lighting optical systems.

[0213] Some of the advantages of the disclosed light directing films, optical stacks, and optical systems are further illustrated by the following examples. The particular materials, amounts and dimensions recited in this example, as well as other conditions and details, should not be construed to unduly limit the present invention.

[0214] In the examples, the index of refraction was measured using a Metricon Model 2010 Prism Coupler (available from Metricon Corp., Pennington, N.J.).

Example A

[0215] A light directing film **3900**, a schematic side-view of which is illustrated in FIG. 39, was made. A microreplication tool was made using the processes outlined and described in, for example, U.S. Patent Publication No. 2009/0041553, the disclosure of which is incorporated in its entirety herein by reference thereto. The microreplication tool was then used to make light directing film using the processes outlined and described in, for example, U.S. Pat. No. 5,175,030, the disclosure of which is incorporated in its entirety herein by reference thereto. Light directing film **3900** included a structured layer **3920** disposed on a substrate **3910**. Substrate **3910** was made of PET, had a thickness of about 29 microns and an index of refraction of about 1.65. Structured layer **3920** included a plurality of linear prisms **3930** that extended along

the y-direction (cross-web direction). Apex angle **3940** of each prism **3930** was about 90 degrees. The prism had a pitch P_1 of about 24 microns along the x-direction. The index of refraction of the linear prisms was about 1.56. Light directing film **3900** had an average effective transmission ETA of about 1.67.

Example B

[0216] A substrate **4000**, a schematic side-view of which is illustrated in FIG. 40, was provided. Substrate **4000** was made of PET, had a thickness of about 50 microns and an index of refraction of about 1.65. Substrate **4000** had an average effective transmission ETA of about 1.02.

Example C

[0217] A light directing film **4100**, a schematic side-view of which is illustrated in FIG. 41, was made. Light directing film **4100** was a Vikuiti™ BEF-RP-II 90/24r, which is a brightness-enhanced, reflective polarizer having a prismatic surface, available from 3M Company, St. Paul, Minn. Light directing film **4100** included a structured layer **4120** disposed on a reflective polarizer **4110**. Reflective polarizer **4110** had a thickness of about 96 microns. Structured layer **4120** included a plurality of linear prisms **4130** that extended along the y-direction. Apex angle **4140** of each prism **4130** was about 90 degrees. The prism had a pitch P_2 of about 24 microns along the x-direction. The index of refraction of the linear prisms was about 1.58. Light directing film **4100** had an average effective transmission ETA of about 2.42.

Example D

[0218] A reflective polarizer **4200**, a schematic side-view of which is illustrated in FIG. 42, was made. Reflective polarizer **4200** was a Vikuiti™ reflective polarizer available from 3M Company, St. Paul, Minn. Reflective polarizer **4200** had a thickness of about 96 microns and an average effective transmission ETA of about 1.73.

Example E

[0219] A light directing film **4300**, a schematic side-view of which is illustrated in FIG. 43, was made. Light directing film **4300** was a Vikuiti™ TBEF3, which is a brightness-enhanced film having a prismatic surface, available from 3M Company, St. Paul, Minn.

[0220] Light directing film **4300** included a structured layer **4320** disposed on a substrate **4310**. Substrate **4310** was made of PET, had a thickness of about 29 microns and an index of refraction of about 1.65. Structured layer **4320** included a plurality of linear prisms **4330** that extended along the y-direction. Apex angle **4340** of each prism **4330** was about 90 degrees. The prism had a pitch P_3 of about 24 microns along the x-direction. Every fourteenth prism was slightly raised relative to the other prisms. The maximum height difference S_1 between the tallest prisms and the shortest prisms was about 2 microns. The index of refraction of the linear prisms was about 1.56. Light directing film **4300** had an average effective transmission ETA of about 1.65.

Example F

[0221] A light directing film **4400**, a schematic side-view of which is illustrated in FIG. 44, was made. Light directing film **4400** was similar to light directing film **3300** and included a

first plurality of linear symmetric unitary discrete structures **4420** and a second plurality of linear symmetric discrete structures **4460**. Structures **4420** and **4460** extended along the y-direction and were disposed on a substrate **4410**. Substrate **4410** was made of PET, had a thickness of about 29 microns and an index of refraction of about 1.65. The index of refraction of structures **4420** and **4460** was about 1.56. Each unitary discrete structure included a bonding portion **4430** designed primarily for bonding the light directing film to a surface and disposed on a light directing portion **4440** designed primarily for directing and recycling light. Discrete structures **4460** did not include any bonding portions and were primarily designed to direct and recycle light. Unitary discrete structures **4420** alternated with discrete structures **4460**.

[0222] Each bonding portion **4430** included two opposing side facets **4432** that made angles ω_1 with the xy-plane (the plane of the light directing film) that was about 85-90 degrees. Each bonding portion had a base **4434**, a minimum base dimension t_2 that was about 0.9 (± 0.2) microns, and a maximum height t_1 that was about 3.4 (± 0.2) microns. Each bonding portion also included a curved or rounded top surface that had a minimum top surface dimension t_3 of about 0.9 (± 0.2) microns.

[0223] Each light directing portion **4420** included two opposing side facets **4422** that made angles ω_2 with the xy-plane (the plane of the light directing film) that was about 45 degrees. Each light directing portion had a base **4444**, a minimum base dimension t_5 of about 24 microns, and a maximum height t_4 that was about 11.9 microns. Light directing film **4400** had an average effective transmission ETA of about 1.65.

Example G

[0224] An adhesion solution was prepared. The adhesion solution included the following components: (a) a pressure sensitive adhesive (29.39 gr, 26% solids, available as RD2739 from 3M Company, St. Paul, Minn.); (b) aliphatic urethane diacrylate (1.84 gr, 100% solids, available as CN964 from Sartomer Company, Exton, Pa.); (c) tripropylene glycol diacrylate (3.69 gr, 100% solids, available as SR306 from Sartomer Company); (d) toluene (15.15 gr, 0% solids, available from Aldrich Company, Milwaukee, Wis.); (e) methanol (10.81 gr, 0% solids, available from Aldrich Company); (f) ethyl acetate (37.76 gr, 0% solids, available from Aldrich Company); (g) photoinitiator (0.14 gr, 100% solids, available as Lucirin TPO from BASF, Charlotte, N.C.); (h) photoinitiator (0.16 gr, 100% solids, available as Irgacure 907 from Ciba, Tarrytown, N.Y.); and polyvinylcaprolactam (0.477 gr, 40% solids, available as Luviskol Plus from BASF).

Example H

[0225] A coating process for coating the adhesive solution of Example G was developed. The adhesive solution was coated on the plano side of the substrate of the upper film using a No. 8 or No. 20 Mayer rod (available from RD Specialties, Webster, N.Y.). The wet adhesive layer thickness for the No. 8 Mayer rod was about 9 microns. The wet adhesive layer thickness for a No. 20 Mayer rod was about 26 microns. The coating was then dried at 60° C. for about 2.5 minutes resulting in a dry optical adhesive layer. For a No. 8 Mayer rod, the thickness of the optical adhesive layer was about 1.0 micron (± 0.2 microns). For a No. 20 Mayer rod, the thickness of the optical adhesive layer was about 3.0 microns

(± 0.2 microns). The dry thickness values were measured using a TranSpec Spectrometer and light source (available from Applied Spectroscopy, Aalen Germany). The upper film was then laminated to the lower film using a rubber hand roller with 30 Shore A hardness at 0.5 lbf/in (0.88 N/cm). The resulting laminated optical stack was then cured through the lower film at 60 ft/min (18.3 m/min) using a Fusion belt processor (available from Fusion UV Systems, Gaithersburg Md.). The UV dosages were 920 mJ/cm² (UV-A), 375 mJ/cm² (UV-B), and 43 mJ/cm² (UV-C). The dosage was measured using a UV PowerPuck II (available from EIT Inc., Sterling N.Y.).

Example I

[0226] An adhesion solution was prepared. The adhesion solution included the following components: (a) a pressure sensitive adhesive (29.11 kg, 26% solids, available as RD2739 from 3M Company, St. Paul, Minn.); (b) aliphatic urethane diacrylate (1.75 kg, 100% solids, available as CN964 from Sartomer Company, Exton, Pa.); (c) tripropylene glycol diacrylate (3.55 kg, 100% solids, available as SR306 from Sartomer Company); (d) toluene (24.06 kg, 0% solids, available from Aldrich Company, Milwaukee, Wis.); (e) methanol (17.21 kg, 0% solids, available from Aldrich Company); (f) ethyl acetate (59.38 kg, 0% solids, available from Aldrich Company); (g) photoinitiator (0.27 kg, 100% solids, available as Lucirin TPO from BASF, Charlotte, N.C.); (h) photoinitiator (0.27 kg, 100% solids, available as Irgacure 907 from Ciba, Tarrytown, N.Y.); and polyvinylcaprolactam (0.48 kg, 40% solids, available as Luviskol Plus from BASF).

Example J

[0227] A coating process for coating the adhesive solution of Example I was developed. The adhesive solution was coated on the plano side of the substrate of the upper film using a slot-type coating die. The coating width was 50.8 cm, and the web speed of the coating process was 18.3 m/min. Solution was pre-metered using a Zenith gear pump and delivered at a flow rate of 400 cubic centimeters per minute. The wet adhesive layer thickness was approximately 43 microns. The coating was then dried at 65.6° C. for approximately 2.5 minutes resulting in a dry optical adhesive layer with a thickness of approximately 3.5 microns. The dry thickness value was measured using a TranSpec Spectrometer and light source (available from Applied Spectroscopy, Aalen Germany). The upper film was then laminated to the lower film between a rubber nip roll (60 Shore A hardness) and a steel roll at a nip force of 1.8 lbf/in (3.2 N/cm). The laminate was then nipped again between a second rubber nip roll (60 Shore A hardness) and a temperature controlled UV backup roll; the nip force of the UV laminator was 4.8 lbf/in (8.4 N/cm). The resulting laminated optical stack was then cured using Fusion F600 light sources equipped with "D" bulbs (available from Fusion UV Systems, Gaithersburg Md.). The laminated optical stack was cured through the lower film at 18.3 m/min on the temperature controlled UV backup roll. The temperature set point of the UV backup roll was 43.4° C. The delivered UV dosages were 993 mJ/cm² (UV-A), 312 mJ/cm² (UV-B), and 29 mJ/cm² (UV-C). The dosage was measured using a UV PowerPuck (available from EIT Inc., Sterling N.Y.).

Example 1A

[0228] An optical stack was made by placing a light directing film **3900** of Example A on another light directing film

4300 of Example E. The plano side of the top light directing film faced the structured side of the bottom light directing film. Each light directing film **4300** was about 22.9 cm wide and 30.5 cm long. The linear prisms in the two films extended along orthogonal directions. There was no optical adhesive layer bonding the two light directing films. The ETA of the optical stack was about 2.51.

Example 1B

[0229] An optical stack similar to the optical stack of Example 1A was made except that the two light directing films were bonded to each other via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 34 gr/in and an ETA of about 2.39.

Example 1C

[0230] An optical stack similar to the optical stack of Example 1A was made except that the two light directing films **4300** were bonded to each other via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 39 gr/in and an ETA of about 2.01.

Example 2A

[0231] An optical stack was made by placing a light directing film **3900** of Example A on a light directing film **4400** of Example F. The plano side of the top light directing film faced the structured side of the bottom light directing film. The linear prisms in the two films extended along orthogonal directions. There was no optical adhesive layer bonding the two light directing films. The ETA of the optical stack was about 2.45.

Example 2B

[0232] An optical stack similar to the optical stack of Example 2A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4400** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 28 gr/in and an ETA of about 2.37.

Example 2C

[0233] An optical stack similar to the optical stack of Example 2A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4400** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 49 gr/in and an ETA of about 2.38.

Example 2D

[0234] An optical stack similar to the optical stack of Example 2A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4400** via a 3.5 micron thick optical adhesive layer and the bonding process described in Example J. The resulting optical stack had a peel strength of about 79.9 gr/in and an ETA of about 2.32.

Example 2E

[0235] An optical stack similar to the optical stack of Example 2A was made except that the top light directing film **4300** was laminated to the bottom light directing film **4400** via a 3.5 micron thick optical adhesive layer and the bonding process described in Example J except that the plano side of the upper film was first nitrogen corona treated at a dosage of 1.5 J/cm². The resulting optical stack had a peel strength of about 100.6 gr/in and an ETA of about 2.31.

[0236] FIG. 47 is ETA as a function of peel strength for Examples 1B-1C where the prisms did not have any portions designed primarily for bonding the prisms to a neighboring surface and Examples 2B-2E where every other prism was a unitary discrete structure that included a bonding portion designed primary to bond the unitary discrete structure to a neighboring surface. In Examples 2B-2E, the peel strength was significantly increased with no, or very little, drop in the ETA. In sharp contrast, in Examples 1B-1C, even a slight increase in the peel strength resulted in a significant drop in the ETA.

Example 3A

[0237] An optical stack was made by placing a substrate **4000** of Example B on a light directing film **4300** of Example E. Each film was about 22.9 cm wide and 30.5 cm long. There was no optical adhesive layer bonding the two light films. The ETA of the optical stack was about 1.61.

Example 3B

[0238] An optical stack similar to the optical stack of Example 3A was made except that the top substrate **4000** was laminated to the bottom light directing film **4300** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 26 gr/in and an ETA of about 1.55.

Example 3C

[0239] An optical stack similar to the optical stack of Example 3A was made except that the top substrate **4000** was laminated to the bottom light directing film **4300** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 32 gr/in and an ETA of about 1.37.

Example 4A

[0240] An optical stack was made by placing a substrate **4000** of Example B on a light directing film **4400** of Example F. Each film was about 22.9 cm wide and 30.5 cm long. There was no optical adhesive layer bonding the two light films. The ETA of the optical stack was about 1.61.

Example 4B

[0241] An optical stack similar to the optical stack of Example 4A was made except that the top substrate **4000** was laminated to the bottom light directing film **4400** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 21 gr/in and an ETA of about 1.58.

Example 4C

[0242] An optical stack similar to the optical stack of Example 4A was made except that the top substrate **4000** was laminated to the bottom light directing film **4400** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 30 gr/in and an ETA of about 1.58.

Example 5A

[0243] An optical stack was made by placing a light directing film **4100** of Example C on a light directing film **4300** of Example E. The plano side of the top light directing film faced the structured side of the bottom light directing film. Each light directing film was about 22.9 cm wide and 30.5 cm long. The linear prisms in the two films extended along orthogonal directions. There was no optical adhesive layer bonding the two light directing films. The ETA of the optical stack was about 3.06.

Example 5B

[0244] An optical stack similar to the optical stack of Example 5A was made except that the top light directing film **4100** was laminated to the bottom light directing film **4300** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 37 gr/in and an ETA of about 2.84.

Example 5C

[0245] An optical stack similar to the optical stack of Example 5A was made except that the top light directing film **4100** was laminated to the bottom light directing film **4300** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 106 gr/in and an ETA of about 2.51.

Example 6A

[0246] An optical stack was made by placing a light directing film **4100** of Example C on a light directing film **4400** of Example F. The plano side of the top light directing film faced the structured side of the bottom light directing film. Each light directing film was about 22.9 cm wide and 30.5 cm long. The linear prisms in the two films extended along orthogonal directions. There was no optical adhesive layer bonding the two light directing films. The ETA of the optical stack was about 3.07.

Example 6B

[0247] An optical stack similar to the optical stack of Example 6A was made except that the top light directing film **4100** was laminated to the bottom light directing film **4400** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 37 gr/in and an ETA of about 2.93.

Example 6C

[0248] An optical stack similar to the optical stack of Example 6A was made except that the top light directing film **4100** was laminated to the bottom light directing film **4400** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack

had a peel strength of about 88 gr/in and an ETA of about 2.82. FIG. 46 is an exemplary SEM of a unitary discrete structure **4610** that included a bonding portion **4620** and a light directing portion **4630**. Bonding portion **4620** had partially penetrated into an optical adhesive layer **4640**. Bonding portion **4620** was about 3 microns tall and a bout 1 micron wide.

Example 7A

[0249] An optical stack was made by placing a light directing film **3900** of Example A on a light directing film **4300** of Example E. The plano side of the top light directing film faced the structured side of the bottom light directing film. Each light directing film was about 22.9 cm wide and 30.5 cm long. The linear prisms in the two films extended along orthogonal directions. There was no optical adhesive layer bonding the two light directing films. The ETA of the optical stack was about 2.35.

Example 7B

[0250] An optical stack similar to the optical stack of Example 7A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4300** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 37 gr/in and an ETA of about 2.24.

Example 7C

[0251] An optical stack similar to the optical stack of Example 7A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4300** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 90 gr/in and an ETA of about 1.97.

Example 8A

[0252] An optical stack was made by placing a light directing film **3900** of Example A on a light directing film **4400** of Example F. The plano side of the top light directing film faced the structured side of the bottom light directing film. Each light directing film was about 22.9 cm wide and 30.5 cm long. The linear prisms in the two films extended along orthogonal directions. There was no optical adhesive layer bonding the two light directing films. The ETA of the optical stack was about 2.36.

Example 8B

[0253] An optical stack similar to the optical stack of Example 8A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4400** via a 1 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 33 gr/in and an ETA of about 2.33.

Example 8C

[0254] An optical stack similar to the optical stack of Example 8A was made except that the top light directing film **3900** was laminated to the bottom light directing film **4400** via a 3 micron thick optical adhesive layer and the bonding process described in Example H. The resulting optical stack had a peel strength of about 64 gr/in and an ETA of about 2.29. Item 1. An optical stack comprising:

[0255] a light redirecting film comprising a first structured major surface comprising a plurality of unitary discrete structures; and

[0256] an optical adhesive layer disposed on the light directing film, at least portions of at least some unitary discrete structures in the plurality of unitary discrete structures penetrating into the optical adhesive layer, at least portions of at least some unitary discrete structures in the plurality of unitary discrete structures not penetrating into the optical adhesive layer, a peel strength of the light redirecting film and the optical adhesive layer being greater than about 30 grams/inch, an average effective transmission of the optical stack not being less or being less than by no more than about 10% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer.

Item 2. The optical stack of item 1, wherein the average effective transmission of the optical stack is not less or is less than by no more than about 8% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer.

Item 3. The optical stack of item 1, wherein the average effective transmission of the optical stack is not less or is less than by no more than about 6% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer.

Item 4. The optical stack of item 1, wherein the average effective transmission of the optical stack is not less or is less than by no more than about 4% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer.

Item 5. The optical stack of item 1, wherein each of at least some unitary discrete structures in the plurality of unitary discrete structures comprises:

[0257] a light directing portion primarily for directing light and comprising a plurality of side facets, each side facet making an angle that is greater than about 40 degrees with a normal to the light directing film; and

[0258] a bonding portion primarily for penetrating at least partially into the optical adhesive layer and comprising:

[0259] a base having a minimum dimension; and

[0260] a maximum height, a ratio of the maximum height to the minimum dimension being at least about 1.5.

Item 6. The optical stack of item 1 comprising a substrate directly bonded to the optical adhesive layer.

Item 7. The optical stack of item 1 comprising another light directing film bonded to the optical adhesive layer and comprising a plurality of linear prismatic structures.

Item 8. The optical stack of item 1 comprising a reflective polarizer layer.

Item 9. The optical stack of item 1, wherein the peel strength of the light redirecting film and the optical adhesive layer is greater than about 40 grams/inch.

Item 10. The optical stack of item 1, wherein the peel strength of the light redirecting film and the optical adhesive layer is greater than about 50 grams/inch.

Item 11. The optical stack of item 1, wherein the peel strength of the light redirecting film and the optical adhesive layer is greater than about 60 grams/inch.

Item 12. An illumination system comprising:

[0261] a light source emitting light; and

[0262] the optical stack of item 1 receiving the emitted light.

Item 13. The illumination system of item 12, wherein the light directing film is disposed between the optical film and the light source.

Item 14. The illumination system of item 12, wherein the optical film is disposed between the light directing film and the light source.

Item 15. An optical stack comprising:

[0263] a light directing film comprising a plurality of unitary discrete structures; and

[0264] an optical adhesive layer disposed on the light directing film for adhering the light directing film to a surface, portions of each unitary discrete structure penetrating into the optical adhesive layer, portions of each unitary discrete structure not penetrating into the optical adhesive layer, each unitary discrete structure defining a penetration depth and a penetration base at an interface between the penetrating and non-penetrating portions of the unitary discrete structure, the penetration base having a minimum penetration base dimension, the plurality of unitary discrete structures having an average penetration depth and an average minimum penetration base dimension, a ratio of the average penetration depth to the average minimum penetration base dimension being at least 1.5, a peel strength between the light directing film and the surface being greater than about 30 grams/inch.

Item 16. The optical stack of item 15 comprising a plurality of voids between the optical adhesive layer and the light directing film.

Item 17. The optical stack of item 15, wherein each unitary discrete structure comprises a light directing portion primarily for directing light and a bonding portion primarily for bonding the light directing film to the surface, at least portions of the bonding portion of each unitary discrete structure penetrating the optical adhesive layer, at least portions of the light directing portion of each unitary discrete structure not penetrating the optical adhesive layer.

Item 18. The optical stack of item 15, wherein the ratio of the average penetration depth to the average minimum penetration base dimension is at least 2.

Item 19. The optical stack of item 15, wherein the ratio of the average penetration depth to the average minimum penetration base dimension is at least 3.

Item 20. The optical stack of item 15, wherein the ratio of the average penetration depth to the average minimum penetration base dimension is at least 4.

Item 21. The optical stack of item 15, wherein the ratio of the average penetration depth to the average minimum penetration base dimension is at least 5.

Item 22. The optical stack of item 15, wherein the ratio of the average penetration depth to the average minimum penetration base dimension is at least 7.

Item 23. The optical stack of item 15, wherein the ratio of the average penetration depth to the average minimum penetration base dimension is at least 10.

Item 24. The optical stack of item 15, wherein the peel strength between the light directing film and the surface is greater than about 40 grams/inch.

Item 25. The optical stack of item 15, wherein the peel strength between the light directing film and the surface is greater than about 60 grams/inch.

Item 26. The optical stack of item 15, wherein the peel strength between the light directing film and the surface is greater than about 80 grams/inch.

Item 27. The optical stack of item 15, wherein the average minimum penetration base dimension is less than about 10 microns.

Item 28. The optical stack of item 15, wherein the average minimum penetration base dimension is less than about 7 microns.

Item 29. The optical stack of item 15, wherein the average minimum penetration base dimension is less than about 5 microns.

Item 30. The optical stack of item 15, wherein the average minimum penetration base dimension is less than about 4 microns.

Item 31. The optical stack of item 15, wherein the average minimum penetration base dimension is less than about 3 microns.

Item 32. The optical stack of item 15, wherein each unitary discrete structure has a base and a minimum base dimension, the plurality of unitary discrete structures having an average minimum base dimension, the average minimum penetration base dimension being less than about 10% of the average minimum base dimension.

Item 33. The optical stack of item 32, wherein the average minimum penetration base dimension is less than about 8% of the average minimum base dimension.

Item 34. The optical stack of item 32, wherein the average minimum penetration base dimension is less than about 6% of the average minimum base dimension.

Item 35. The optical stack of item 32, wherein the average minimum penetration base dimension is less than about 5% of the average minimum base dimension.

Item 36. The optical stack of item 32, wherein the average minimum penetration base dimension is less than about 4% of the average minimum base dimension.

Item 37. The optical stack of item 32, wherein the average minimum penetration base dimension is less than about 3% of the average minimum base dimension.

Item 38. An optical stack comprising:

[0265] a light directing film comprising a first plurality of unitary discrete structures; and

[0266] an optical layer disposed on the light directing film, portions of each unitary discrete structure in the first plurality of unitary discrete structures penetrating into the optical layer, portions of each unitary discrete structure in the first plurality of unitary discrete structures not penetrating into the optical layer, each unitary discrete structure in the first plurality of unitary discrete structures defining a penetration depth and a penetration base at an interface between the penetrating and non-penetrating portions of the unitary discrete structure, the penetration base having a minimum penetration base dimension, the first plurality of unitary discrete structures having an average penetration depth and an average minimum penetration base dimension, a ratio of the average penetration depth to the average minimum penetration base dimension being at least 1.5, a peel strength between the light directing film and the optical layer being greater than about 30 grams/inch.

Item 39. The optical stack of item 38, wherein the optical layer is a pressure sensitive adhesive.

Item 40. The optical stack of item 38, wherein the optical layer is a structural adhesive.

Item 41. The optical stack of item 38, wherein the optical layer is a lightguide having means for extracting light that propagates within the lightguide by total internal reflection.

Item 42. The optical stack of item 38, wherein the optical layer comprises a glass transition temperature that is greater than a maximum operating temperature of the optical stack.

Item 43. The optical stack of item 38, wherein the light directing film comprises a second plurality of unitary discrete structures, at least one unitary discrete structure in the second plurality of unitary discrete structures not penetrating into the optical layer.

Item 44. The optical stack of item 38, wherein the unitary discrete structures in the second plurality of discrete structures are shorter than the unitary discrete structures in the first plurality of discrete structures.

[0267] As used herein, terms such as “vertical”, “horizontal”, “above”, “below”, “top”, “bottom”, “left”, “right”, “upper” and “lower”, “clockwise” and “counter clockwise” and other similar terms, refer to relative positions as shown in the figures. In general, a physical embodiment can have a different orientation, and in that case, the terms are intended to refer to relative positions modified to the actual orientation of the device. For example, even if the image in FIG. 38 is flipped as compared to the orientation in the figure, surface 3820 is still considered to be the top surface.

[0268] All patents, patent applications, and other publications cited above are incorporated by reference into this document as if reproduced in full. While specific examples of the invention are described in detail above to facilitate explanation of various aspects of the specifics of the examples. Rather, the intention is to cover all modifications, embodiments, and alternatives falling within the spirit and scope of the invention as defined by the appended claims.

1. An optical stack comprising:

a light redirecting film comprising a first structured major surface comprising a plurality of unitary discrete structures; and

an optical adhesive layer disposed on the light directing film, at least portions of at least some unitary discrete structures in the plurality of unitary discrete structures penetrating into the optical adhesive layer, at least portions of at least some unitary discrete structures in the plurality of unitary discrete structures not penetrating into the optical adhesive layer, a peel strength of the light redirecting film and the optical adhesive layer being greater than about 30 grams/inch, an average effective transmission of the optical stack not being less or being less than by no more than about 4% as compared to an optical stack that has the same construction except that no unitary discrete structure penetrates into the optical adhesive layer.

2. The optical stack of claim 1, wherein each of at least some unitary discrete structures in the plurality of unitary discrete structures comprises:

a light directing portion primarily for directing light and comprising a plurality of side facets, each side facet making an angle that is greater than about 40 degrees with a normal to the light directing film; and

a bonding portion primarily for penetrating at least partially into the optical adhesive layer and comprising:

a base having a minimum dimension; and

a maximum height, a ratio of the maximum height to the minimum dimension being at least about 1.5.

3-10. (canceled)

11. The optical stack of claim 1 comprising a reflective polarizer layer.

- 12.** An optical stack comprising:
a light directing film comprising a plurality of unitary discrete structures; and
an optical adhesive layer disposed on the light directing film for adhering the light directing film to a surface, portions of each unitary discrete structure penetrating into the optical adhesive layer, portions of each unitary discrete structure not penetrating into the optical adhesive layer, each unitary discrete structure defining a penetration depth and a penetration base at an interface between the penetrating and non-penetrating portions of the unitary discrete structure, the penetration base having a minimum penetration base dimension, the plurality of unitary discrete structures having an average penetration depth and an average minimum penetration base dimension, a ratio of the average penetration depth to the average minimum penetration base dimension being at least 1.5, a peel strength between the light directing film and the surface being greater than about 30 grams/inch.
- 13.** The optical stack of claim **12** comprising a plurality of voids between the optical adhesive layer and the light directing film.
- 14.** The optical stack of claim **12**, wherein each unitary discrete structure comprises a light directing portion primarily for directing light and a bonding portion primarily for bonding the light directing film to the surface, at least portions of the bonding portion of each unitary discrete structure penetrating the optical adhesive layer, at least portions of the light directing portion of each unitary discrete structure not penetrating the optical adhesive layer.
- 15.** The optical stack of claim **12**, wherein the average minimum penetration base dimension is less than about 10 microns.
- 16.** The optical stack of claim **12**, wherein the average minimum penetration base dimension is less than about 5 microns.
- 17.** The optical stack of claim **12**, wherein each unitary discrete structure has a base and a minimum base dimension, the plurality of unitary discrete structures having an average

minimum base dimension, the average minimum penetration base dimension being less than about 10% of the average minimum base dimension.

- 18.** An optical stack comprising:
a light directing film comprising a first plurality of unitary discrete structures; and
an optical layer disposed on the light directing film, portions of each unitary discrete structure in the first plurality of unitary discrete structures penetrating into the optical layer, portions of each unitary discrete structure in the first plurality of unitary discrete structures not penetrating into the optical layer, each unitary discrete structure in the first plurality of unitary discrete structures defining a penetration depth and a penetration base at an interface between the penetrating and non-penetrating portions of the unitary discrete structure, the penetration base having a minimum penetration base dimension, the first plurality of unitary discrete structures having an average penetration depth and an average minimum penetration base dimension, a ratio of the average penetration depth to the average minimum penetration base dimension being at least 1.5, a peel strength between the light directing film and the optical layer being greater than about 30 grams/inch.
- 19.** The optical stack of claim **18**, wherein the optical layer is a pressure sensitive adhesive.
- 20.** The optical stack of claim **18**, wherein the optical layer is a lightguide having means for extracting light that propagates within the lightguide by total internal reflection.
- 21.** The optical stack of claim **18**, wherein the optical layer comprises a glass transition temperature that is greater than a maximum operating temperature of the optical stack.
- 22.** The optical stack of claim **18**, wherein the light directing film comprises a second plurality of unitary discrete structures, at least one unitary discrete structure in the second plurality of unitary discrete structures not penetrating into the optical layer.
- 23.** The optical stack of claim **18**, wherein the unitary discrete structures in the second plurality of discrete structures are shorter than the unitary discrete structures in the first plurality of discrete structures.

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