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(54) Title: GREEN TO TRANSMISSIVE SOLUBLE ELCTROCHROMIC POLYMERS

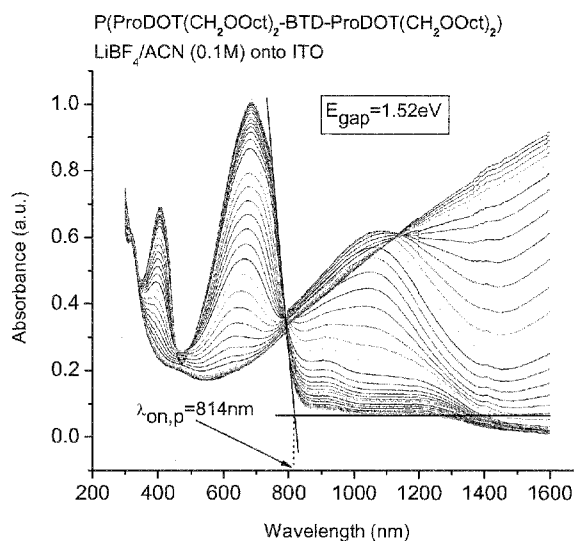


Figure 1A

(57) Abstract: Green to transmissive soluble electrochromic polymers are conjugated polymers having a plurality of repeating units where repeating units are a plurality of substituted dioxyheterocycle based donor groups coupled to an acceptor group. The conjugated polymer absorbs radiation within a first band of the visible spectrum and a second band of the visible spectrum when in a neutral state resulting in a green color and is transmissive when in an oxidized state. The polymers are soluble allowing processing of films and coatings from solution.

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DESCRIPTION

GREEN TO TRANSMISSIVE SOLUBLE ELECTROCHROMIC POLYMERS

CROSS-REFERENCE TO RELATED APPLICATION

5 The present application claims the benefit of U.S. Provisional Application Serial No. 61/000,908, filed October 30, 2007, which is hereby incorporated by reference herein in its entirety, including any figures, tables, or drawings.

BACKGROUND OF THE INVENTION

10 Polymeric electrochromics capable of a fast and reversible color change upon electrochemical oxidation and reduction have received a considerable attention over the past decade. A particular emphasis has been placed on incorporating the most stable of these electroactive materials in devices such as windows, mirrors (rear-view/side-view mirrors for cars) and displays, for anticipated industrial and commercial applications.

15 While a number of neutral state red and blue absorbing conjugated polymers have been synthesized and integrated into electrochromic devices, attempts at synthesizing saturated green polymers chemically or electrochemically, which can switch to a transmissive state, have met with limited success due to the complex nature of the required absorption spectrum that must contain at least two bands in the neutral state of the material.

20 To date, only one article reports the existence of a green conjugated polymer with a transmissive state (with a blue hue) upon oxidation. (Durmus *et al.*, *Chem. Commun.*, 2007, 3246–3248). However, this material is prepared by an electrochemical polymerization/film deposition and does not show any solubility/processability making it difficult to be integrated into devices, restricting the scope of possible applications.

25 Accordingly, soluble neutral state green conjugated polymers with high electrochromic contrasts, fast switching times and highly transmissive oxidized states would be a desirable improvement in the field of conjugated polymers. Additionally, materials that are solution processable would provide advantages in a wide range of applications.

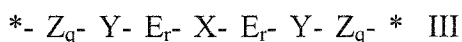
30 BRIEF SUMMARY OF THE INVENTION

 Embodiments of the invention are directed to a conjugated polymer constructed with a plurality of repeating units where the repeating units have a plurality of substituted

dioxyheterocycle based donor groups coupled to an acceptor group. The conjugated polymer absorbs radiation within a first band of the visible spectrum and a second band of the visible spectrum when in a neutral state but is transmissive in these bands in an oxidized state. The absorbance of radiation within the first and second bands in the oxidized state is less than in the neutral state to the extent, often by 200% or more, such that one can discern the polymer as colored in the neutral state but of little or no color in the oxidized state. The first absorption band can have a visible absorption maximum at a wavelength below about 500 nm and the second absorption band can have a visible absorption maximum at a wavelength above about 550 nm and a local minimum between 480 and 580 such that the neutral state colored polymer is green in appearance.

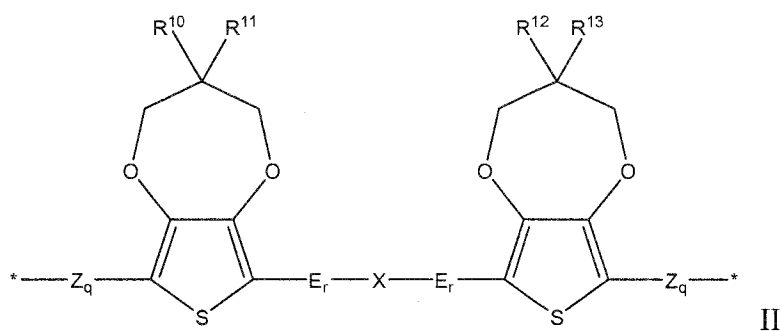
The polymer can be soluble in one or more solvents, for example methylene chloride, chloroform, tetrachloroethane, tetrahydrofuran, dioxane, benzene, toluene, xylenes, chlorobenzene, dichlorobenzene, pyridine, ethyl acetate, butanol, ethanol, methanol, acetonitrile, acetone, isopropanol, water and mixtures thereof. The polymer can then be prepared and processed into films or coatings from solution. The dioxyheterocycle of the polymer can be a dioxythiophene, such as an alkylendioxythiophene, for example a 3,4-propylenedioxythiophene. The acceptor group is an electron poor aromatic unit such as a substituted or unsubstituted benzothiadiazole group, thiadiazoloquinoxaline group, quinoxaline group, thienothiadiazole group, thienopyrazine group, pyrazinoquinoxaline group, benzobisthiadiazole group or thiadiazolothienpyrazine group.

In many embodiments the conjugated polymer can be envisioned by the repeating unit is a sequence of structural formula III:



where X is an electron poor aromatic unit, E is an electron rich conjugated unit, Y is a substituted dioxyheterocycle, Z is a conjugated unit, and q and r are 0, 1, 2 or 3. The unit Y can be a substituted dioxythiophene that can be an alkylendioxythiophene substituted with at least one linear or branched aliphatic carbon chain that can have one or more heteroatoms within the chain as indicated by the propylenedioxythiophene (ProDOT) in formula II:

3



where X is an electron poor aromatic unit, E is an electron rich conjugated unit, Z is a conjugated unit, q and r are 0, 1, 2 or 3, and R¹⁰, R¹¹, R¹² and R¹³ are the same or different and at least one of R¹⁰, R¹¹, R¹² and R¹³ includes a linear or branched aliphatic carbon chain that optionally includes one or more heteroatoms. The electron poor aromatic unit, X, can be a substituted or unsubstituted benzothiadiazole group, thiadiazoloquinoxaline group, quinoxaline group, thienothiadiazol group; thienopyrazine group, pyrazinoquinoxaline group, benzobisthiadiazole group or thiadiazolothienopyrazine group. For example, in embodiments of the invention the electron poor aromatic unit can be a 2,1,3-benzothiadiazole group (BTD). The electron rich conjugated unit E can be a substituted or unsubstituted thiophene and Z can be a substituted or unsubstituted dioxothiophene group.

Another embodiment of the invention involves a method of forming a conjugated polymer, which includes steps of reacting two donor compounds having a substituted dioxheterocyclic moiety with a conjugated acceptor compound having an acceptor moiety to form a polymerizable unit, which is an oligomer where dioxheterocycle based donor groups are attached to an acceptor group. A plurality of these oligomeric polymerizable units can then be linked covalently to form the conjugated polymer, where the conjugated polymer absorbs radiation within a first band of the visible spectrum and a second band of the visible spectrum when in a neutral state and upon oxidation the polymer is transmissive as described above. The polymer is soluble in at least one solvent. In one embodiment the dioxheterocyclic moiety can be a dioxothiophene moiety having a coupling moiety which can be an organometallic substituent such as an organotin substituent, organoboron substituent, organomagnesium substituent, organozinc substituent, or organosilane substituent and the conjugated acceptor compound contains a pair of complementary halogen functional groups symmetrically situated on the conjugated acceptor compound. Conversely, in another embodiment, a pair of

organometallic substituents can be attached to the conjugated acceptor compound and a halogen group can be the coupling moiety of the dioxyheterocyclic moiety.

BRIEF DESCRIPTION OF THE DRAWINGS

5 **Figure 1** shows absorbance spectra of polymers (a) **6a**, (b) **6b**, (c) **9** and (d) **12** respectively where thin films were cast onto ITO from toluene (**6a**, **6b**, **9**) or chloroform (**12**) and electrochemically oxidized in a 0.1M solution of LiBF₄ in Acetonitrile.

Figure 2 shows relative luminance measured on thin films of Polymers **6a** (P([ProDOT-OOct₂]₂-BTD)) (●), **6b** (P([ProDOT-OEtHex₂]₂-BTD)) (▲), **9** (P([ProDOT-OOct₂-Th]₂-BTD)) (□) and **12** (P([ProDOT-OOct₂-Th]₂-BTD)) (▼). Experiments were carried out using solid thin films spray cast onto ITO from toluene (**6a**, **6b**, **9**) or chloroform (**12**).

Figure 3 shows photographs of the neutral and oxidized polymers (a) **6a** (P([ProDOT-OOct₂]₂-BTD)), (b) **6b** (P([ProDOT-OEtHex₂]₂-BTD)), (c) **9** (P([ProDOT-OOct₂-Th]₂-BTD)) and (d) **12** (P([ProDOT-OOct₂-EDOT]₂-BTD)) as solid thin or/and thick films spray cast onto ITO from Toluene (**6a**, **6b**, **9**) or Chloroform (**12**).

DETAILED DESCRIPTION OF THE INVENTION

One embodiment of the invention is a new and efficient route towards synthesizing novel, soluble conjugated polymers that are green in the neutral state and high transmissive in the oxidized state. According to an embodiment of the invention, the soluble conjugated polymer provides one or more of the following advantages: high optical contrast in the visible region; outstanding electrochemical switching properties; charge transport properties, as desired for green colored solar cells; and the ability to be processed into electrochromic devices using convenient deposition methods, such as spin coating, roll-to-roll coating, spray casting, and various methods of printing (e.g. ink jet printing).

To achieve a neutral state green polymer, absorption in the red and the blue regions of the visible spectrum is required. Fine tuning of the energy gap, as well as introduction of an adequate set of absorption bands in the electromagnetic spectrum, is achieved by the choice of the structure of the repeating units that compose the conjugated portion of the polymer. Structural parameters are controlled to achieve the desired optical

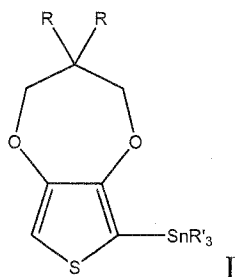
properties and processability for this new family of soluble polymers. Careful analysis and comparison of the bathochromic shift occurring upon polymerization can allow determination of an expected absorption spectrum of a single polymerizable unit to be synthesized and polymerized. This polymerizable unit comprises electron donating and accepting moieties that constitute the backbone of the electrochromic polymer.

In embodiments of the invention, a dioxythiophenes moieties having at least one solubilizing chain substituted thereon comprise the donating moieties within the polymerizable units employed to form the polymers. Any solubilizing chains can be employed that provide a desired solubility during processing. In one embodiment, the solubilizing chains can be alkoxy solubilizing chains (linear or branched), which allow processing into solid thin film by solution casting and can enhance transmissivity of the oxidized state. For a polymeric material transmitting/reflecting green light, obtaining highly transmissive contrasts upon oxidation requires simultaneous and efficient bleaching of the two absorption bands that occur in the blue and red portions of the visible spectrum.

The soluble conjugated polymers of embodiments of the invention are prepared by coupling dioxyheterocyclic donor moieties with acceptor moieties via coupling reactions. Coupling reactions that can be used, include, but are not restricted to: Stille coupling, Kumada coupling, Hiyama coupling, Negishi coupling and Suzuki coupling.

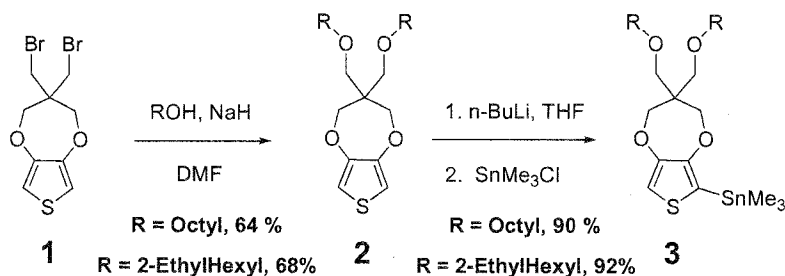
In one embodiment of the invention Stille coupling is employed as the coupling reaction. In this embodiment, the polymerizable units are prepared using stannylated dioxythiophenes, which can be prepared using any suitable technique, followed by an oxidative polymerization of the units. The units are appropriately functionalized oligomers of donor and acceptor moieties that in combination yield the electrochromic properties of the green to transmissive polymers. In an embodiment, the stannylated dioxythiophene compounds can be 3,4-propylenedioxythiophenes compounds of formula 3 in Scheme 1, below, shown as trimethyl tin (-SnMe₃), or any suitable organotin substituent, such as triethyl tin (-SnEt₃) or tributyl tin (-SnBu₃). The organotin substituent can be replaced with any suitable substituent, such as an organoboron, organomagnesium, organozinc, or organosilane substituent. The R groups of formula 3 can be the same or different and can be chosen to be a linear or branched aliphatic carbon chain, or a carbon chain containing aromatic moieties, wherein the aliphatic or aromatic carbon chain can

optionally comprise one or more heteroatoms (e.g., oxygen or nitrogen atoms) or functional groups chosen from oligoether groups, ester groups, amide groups, carboxylic acid groups, sulfonate groups, amine groups and other polar functional groups. The entire CH₂OR group can be replaced with an alkyl or aryl chain and one of the CH₂OR groups can be replaced with a hydrogen substituent. A general formula for a stannylated 3,4-propylenedioxythiophene is given in Formula I:



where R groups are the same or different and comprise linear or branched aliphatic carbon chains and can optionally comprise one or more functional groups chosen from oligoether groups, ester groups, amide groups, carboxylic acid groups, sulfonate groups, amine groups and other polar functional groups and R' comprises an alkyl group.

Scheme 1



15

An embodiment of the invention includes preparing stannylated alkylenedioxythiophenes, as shown in Scheme 1, above, where a monostannylated bis-alkoxymethyl substituted 3,4-propylenedioxythiophene (**3**), which can be coupled into a polymerizable unit. The synthesis begins with a facile nucleophilic substitution of alkoxy derivatives (solubilizing group) for Br of compound **1**, which is shown as a Williamson etherification in N,N-dimethylformamide (DMF) where a sodium alkoxide is formed by the reaction of an alcohol with sodium hydride to form compound **2**. The R groups of scheme 1 are shown as being octyl or 2-ethylhexyl, although any suitable linear or

20

branched alkyl groups, such as C2 to C30 alkyl groups, can be employed. Appropriate reaction conditions for etherification reactions are known to those skilled in the art. Other reactions can be employed to form appropriately substituted 3,4-propylenedioxythiophenes for use as donor moieties to form the polymerizable units.

5 The resulting symmetrical alkoxy substituted compound 2 of Scheme 1 is monolithiated using a suitable organolithium reagent, such as, for example, n-butyllithium, t-butyllithium, or methyllithium. Other sufficiently basic reagents can be employed for the preparation of an organometallic intermediate, where the metal can be, for example, any alkali or earth alkali metal, for the preparation of the monostannylated
10 product 3. The reaction can be performed in any suitable organic solvent, generally a polar aprotic solvent such as tetrahydrofuran (THF). The resulting compound is then monostannylated by replacing the resulting lithium substituent with an organotin substituent using any suitable tin containing reagent, such as trimethyltin chloride or tributyltin chloride, to afford the relatively air-stable compound 3 in high yield. Other
15 stannylated alkylendioxythiophenes or dioxythiophenes can be prepared in an analogous fashion to that illustrated in Scheme 1 by employing the appropriate starting compound. Although an etherification reaction is not necessary for many embodiments of the reaction, appropriate groups to achieve solubility are needed. The donor moiety used in the coupling reaction does not necessarily require the presence of a substituent to impart
20 solubility; however, at least one moiety in the polymerizable unit has a substituent to impart solubility to the polymer.

The stannylated alkylendioxythiophenes can then be used to form oligomers having alkylendioxythiophene end groups, which are the polymerizable units. This process includes mixing the stannylated alkylene dioxythiophenes with an additional
25 compound, which contains at least one acceptor moiety. For example, in an embodiment, compound 3 can react with one or more halogenated compounds containing the acceptor moiety.

Scheme 2 illustrates an example of a method according to an embodiment of the invention that progresses through the construction of soluble and symmetric conjugated
30 oligomers, polymerizable units, having donor and acceptor moieties and through the polymerization of the oligomers to yield linear conjugated polymers. Table 1 discloses the characterization of a number of polymers according to embodiments of the invention.

As illustrated in Scheme 2, a Stille reaction can be used to couple stannylated compound **3** with dibrominated acceptor containing species **4**, **7** or **10**. Other halogens, such as chlorine, iodine, or even fluorine can be used in place of the bromine on the acceptor compounds. The acceptors are generally, but not necessarily, symmetrically halogenated where halogens are positioned on equivalent opposite sites of the acceptor compounds, as shown for compounds **4**, **7** and **10**. Stille reaction processes are well known in the art, and can be carried out using, for example, a Palladium(0) or Palladium (II) catalyst. In many embodiments, the reaction is carried out under air and moisture-free conditions to maximize the reaction yields. Soluble oligomers **5**, **8** and **11** can be isolated by various techniques, including, for example, column chromatography using silica as the stationary phase and varying the ratios of solvents employed for elution. Such solvents can include, for example, mixtures of hexanes, dichloromethane and ethyl acetate.

The oligomers can be polymerized in a step-growth fashion where the alkylenedioxythiophene end groups self-condense to form the conjugated polymer. For example, as illustrated in Scheme 2, the target oligomers **5**, **8** and **11** can be self-condensed in chloroform, or other suitable solvent, through the low oxidation potential 3,4-propylenedioxythiophene chain-ends using ferric chloride as an efficient oxidative agent to afford fully conjugated and well-defined electroactive polymers **6a**, **6b**, **9** and **12** as indicated in Table 1. Polymer purification can be carried out by precipitation in MeOH, reduction in chloroform using hydrazine monohydrate followed by a 48 hours Soxhlet purification. (see Table 1) Although the "R" groups of scheme 2 are shown as being octyl or 2-ethylhexyl, any suitable linear or branched alkyl groups, such as C2 to C30 alkyl groups, can be employed to enhance processability, fine tune the color, including the hue and saturation of the green color, enhance transmissivity of the oxidized form, and modify the solid film's morphology.

Scheme 2

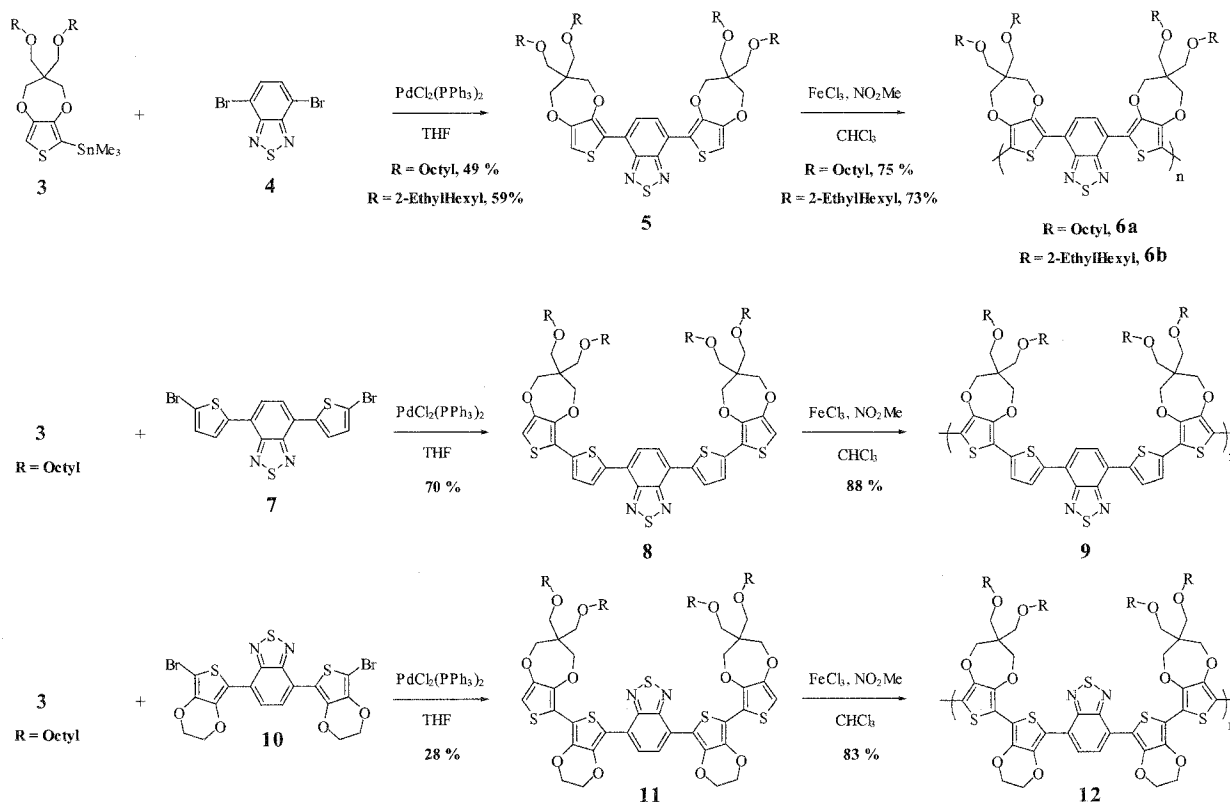


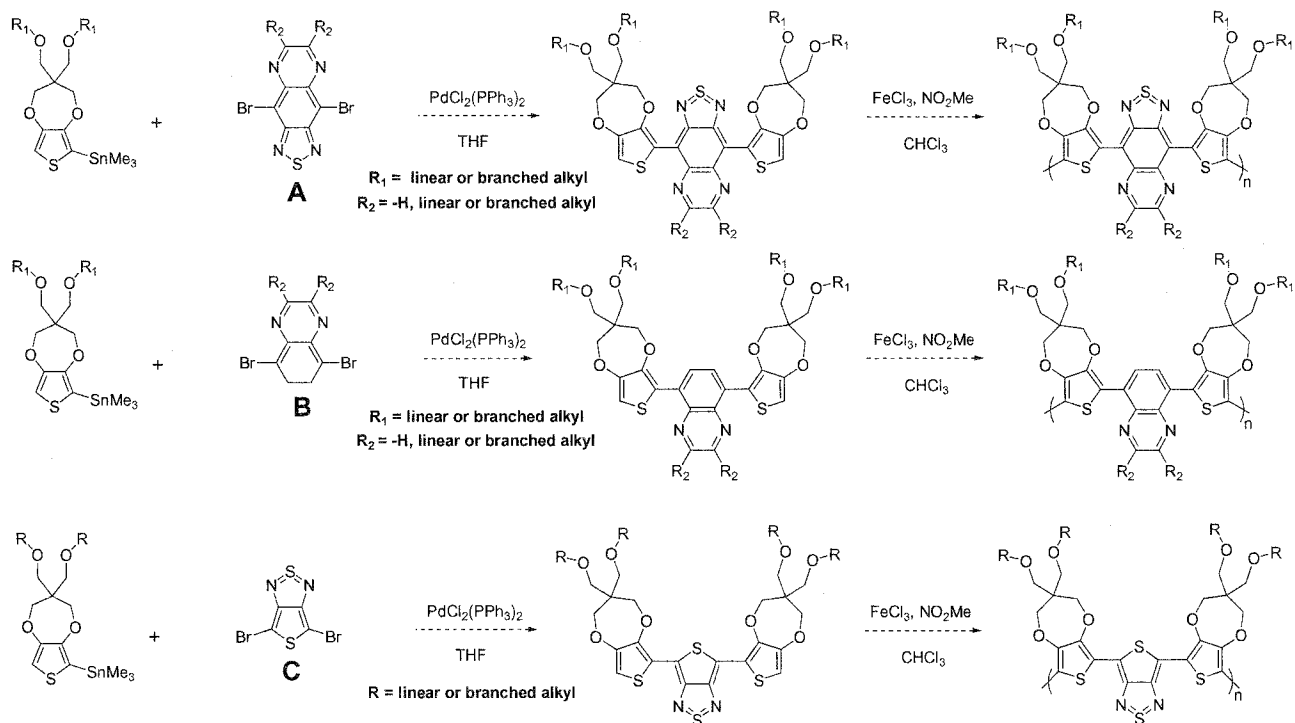
Table 1. GPC Estimated Molecular Weights in THF, Isolated Yields for the Polymerizations, Elemental Analysis of the Copolymers **6a** (P([ProDOT-OOct₂]₂-BTD)), **6b** (P([ProDOT-OEtHex₂]₂-BTD)), **9** (P([ProDOT-OOct₂-Th]₂-BTD)) and **12** (P([ProDOT-OOct₂-EDOT]₂-BTD)).

Polymer	M_n (g/mol)	M_w (g/mol)	PDI	Avg. no. of repeat units	Avg. no. of rings	Yield (%)	EA (Calcd/Found)		
							C	H	N
P([ProDOT-OOct ₂] ₂ -BTD)	14700	32150	2.2	15	45	75	66.5/66.42	8.57/8.64	2.77/2.79
P([ProDOT-OEtHex ₂] ₂ -BTD)	27800	59000	2.1	27	81	73	66.5/66.21	8.57/8.48	2.77/2.73
P([ProDOT-OOct ₂ -Th] ₂ -BTD)	18900	60300	3.2	16	80	88	65.38/66.08	7.72/7.75	2.38/2.21
P([ProDOT-OOct ₂ -EDOT] ₂ -BTD)	10300	17800	1.7	8	40	83	63.22/62.88	7.33/7.27	2.17/2.28

Schemes 3, 4 and 5 illustrate other embodiments of the invention for preparing neutral state green polymers with transmissive oxidized states using the efficient synthetic strategy illustrated in Scheme 2. Scheme 3 shows the synthesis of a series of trimers differing by the nature of the acceptor core incorporated to the polymerizable unit. As illustrated in Scheme 3, other acceptor units that may be used rather than or in addition to the dibrominated 2,1,3-benzothiadiazole, **4**, (Scheme 2) with a thiadiazoloquinoxaline derivative (A), a quinoxaline derivative (B) or a thienothiadiazol (C), for example. Other acceptor units that can be used in embodiments of the invention include thienopyrazine

derivatives, pyrazinoquinoxaline derivatives, benzobisthiadiazoles and thiadiazolothienopyrazines.

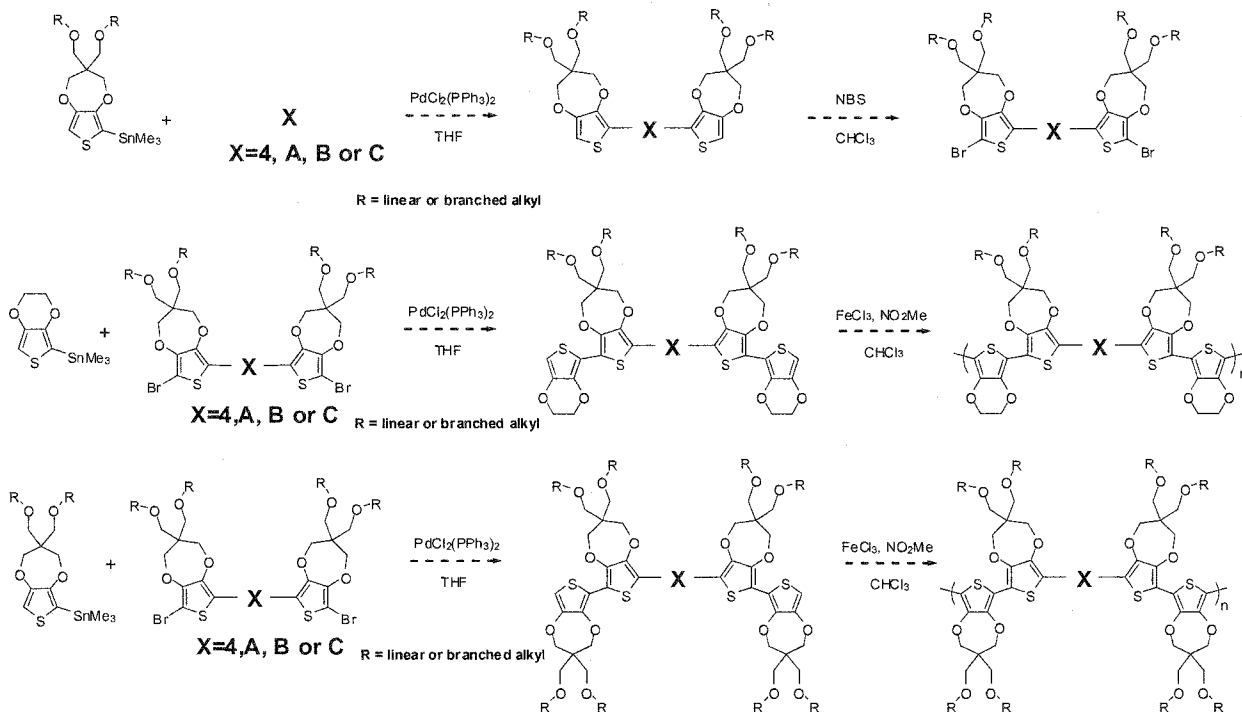
Scheme 3



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Scheme 4 shows other polymers according to embodiments of the invention where the acceptor core is part of a pentameric polymerizable unit. These pentameric polymerizable units can be oxidatively polymerized using the conditions of Scheme 2.

Scheme 5



The chemistry outlined in Schemes 1-5 illustrate how the optical properties can be controlled by the nature of the conjugated backbone by varying the thiophene-based donors and the acceptors. Although the polymers illustrated above have linear and branched alkyl groups as substituents to provide organic solvent solubility and processability, in other embodiments polar or ionic side chains can be employed. For example, any of the R, R¹ and/or R² groups of the compounds shown in Schemes 1-5 can include oligoether, ester, amide, carboxylic acid, sulfonate, amine, phosphonic acid and other polar functionalities. Compounds including such R, R¹ and R² groups can be made using the proposed chemistry or modified chemistry, as would be readily understood by one of ordinary skill in the art. Ionic or highly polar pendant groups can provide solubility and processability in water or polar solvents which can permit electrochromic switching in water based electrolytes and can allow polymers to be adsorbed onto oxide surfaces of electrochromism and titania based solar cells (Graetzel Cells).

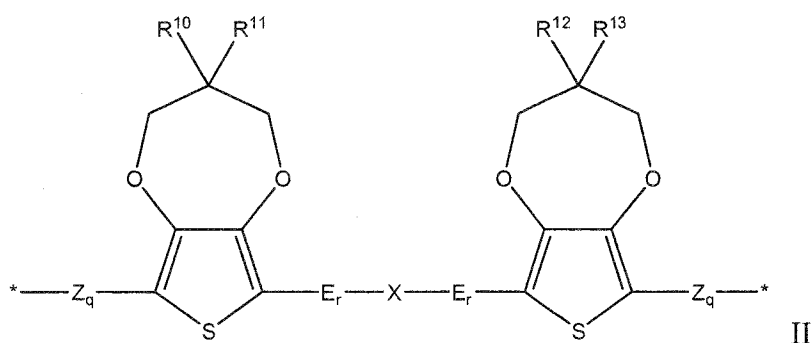
In another embodiment of the invention, ester functionalized PProDOTs can be used as the donors where after processing into films the ester can be hydrolyzed or otherwise converted to alcohols and carboxylic acids, or their derivatives, which allows for the conversion of the soluble films according to embodiments of the invention to

insoluble films, as is disclosed in Reynolds *et al.*, Published International Application WO/2007/087587, August 2, 2007, incorporated herein by reference in its entirety, and Reeves *et al.*, *Macromolecules* 2007, 40, 5344, incorporated herein by reference in its entirety. In this manner, insoluble green to transmissive films can be formed from the soluble green to transmissive films according to an embodiment of the invention.

In the above exemplary embodiments, the dioxyheterocyclic donor moieties are included in activated coupling reagents that react with halogenated compounds including acceptor moieties. In alternative embodiments, the acceptor moieties can be part of the activated coupling reagents and the dioxyheterocyclic donor compounds can have halide functionality for coupling into polymerizable units. For example, instead of being halogenated, the acceptor compounds described above can include a coupling group selected from the group consisting of organotin substituents (including any of the organotin groups described above), organoboron substituents, organomagnesium substituents, organozinc substituents, and organosilane substituents. Such coupling groups can be positioned, for example, to replace the two halogen functional groups of the above illustrated acceptor compounds. This acceptor compound can be coupled with a dioxyheterocycle based donor compounds, as described above, where a monohalogen group allows coupling to the difunctionalized acceptor compound described above.

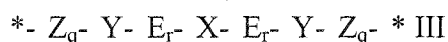
The resulting polymers formed from the above described methods comprise a plurality of repeating units, which comprise at least two substituted dioxyheterocycle based donor group coupled to an acceptor group. Suitable examples of dioxyheterocyclic groups can be any of the dioxythiophene groups disclosed herein, as well as 3,4-alkylenedioxy pyrrole, 3,4-alkylenedioxy furan, 3,4-alkylenedioxy selenophene, 3,4-alkylenedioxy telurophene or other dioxy pyrrole, dioxy furan, dioxy selenophene, or dioxy telurophene groups. Suitable dioxyheterocyclic groups include those derived from the dioxyheterocycles disclosed in Reynolds *et al.*, U.S. Patent No. 6,791,738, September 14, 2004. In one embodiment, the dioxyheterocycle groups employed to form the repeating units include 3,4 – propylenedioxy thiophenes. For example, the repeating units can have a general formula II:

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where X can be chosen from any suitable electron poor acceptor group. The X groups can be substituted or unsubstituted benzothiadiazole groups, thiadiazoloquinoxaline groups, quinoxaline groups, thienothiadiazole groups, thienopyrazine groups, pyrazinoquinoxaline groups, benzobisthiadiazole groups or thiadiazolothienopyrazine groups. The E groups can be any suitable electron rich conjugated unit, and the Z groups can be chosen from any suitable conjugated unit. Suitable conjugated units for both E and Z include substituted or unsubstituted thiophene groups, alkylendioxythiophene groups, such as substituted or unsubstituted ethylendioxythiophene groups and propylendioxythiophene groups, as well as any of the other dioxyheterocycle groups disclosed herein; q and r can be 0, 1 or 2; and R¹⁰ to R¹³ can be the same or different and can be chosen to be a linear or branched aliphatic carbon chain that can optionally comprise one or more heteroatoms (e.g., oxygen or nitrogen atoms) or functional groups chosen from oligoether groups, ester groups, amide groups, carboxylic acid groups, sulfonate groups, amine groups and other polar functional groups. In one embodiment, R¹⁰, R¹¹, R¹² and R¹³ can each be an -R'OR'' group, where R' can be a methyl, ethyl or propyl and R'' can be a linear or branched C₂ to C₃₀ alkyl, such as octyl or 2-ethylhexyl. In an embodiment, R¹⁰, R¹¹, R¹² and R¹³ can be chosen to be the same substituent.

In another embodiment of the invention, repeating units can have a general formula III:



where X, E, Z, q and r are defined as above for formula I; and where Y is any suitable substituted dioxyheterocycle. For example Y can be a dioxythiophene, such as an alkylendioxythiophene substituted with at least one linear or branched aliphatic carbon chain that optionally comprises one or more heteroatoms.

The X, E and Z groups of Formulae I and II can include any suitable substituents which can be positioned on any possible substituent site of the ring structures of these

compounds. Examples of suitable substituents can include any of the R¹⁰ to R¹³ substituent groups disclosed herein. One of ordinary skill in the art would readily be able to determine suitable substituents and positioning of the substituents for these groups.

The number average molecular weight of the conjugated polymers of the present application can vary widely, depending on the particular repeating units employed, and the processing parameters used to form the polymers. Exemplary number average molecular weights can range from about 3000 g/mol to about 100,000 g/mol, as measured by gel permeation chromatography, although polymers having number average molecular weights outside of these ranges can also be formed.

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MATERIALS AND METHODS

Figure 1 characterizes the optical properties of polymers that were synthesized (6a, 6b, 9, 12) and their electroactivity upon electrochemical oxidation. As expected for a neutral state green polymer, all materials characterized showed two absorption bands in the visible region of the electromagnetic spectrum, including a first, moderately high absorption peak in the blue portion (below about 500 nm) and a second absorption peak that is generally higher than the first peak (indicating intense absorption) in the orange to red portion (above about 580 nm), with very little or no overlap in the green region (about 480 to about 580nm), so that a minimum absorption point occurs between the first and second peaks in the green region. For all materials characterized, these two absorption bands bleached simultaneously upon oxidation and a new absorption band arises in the near infrared as charge carriers are formed (polarons and bi-polarons). In embodiments, the intense bleaching of the two p-p* transitions observed, as well as the quasi-absence of residual tail of the near infrared absorption bands into the visible, are observed and the polymer has a high transmissivity of the oxidized state. Taking the onset of absorption of the most intense absorption band as a reference for calculation, the optical energy gaps of these materials were found in the range 1.43 - 1.54 eV, and can therefore be considered to be "Narrow Band-Gap" polymers.

Figure 2 shows the relative luminance measured under constant illumination from thin films of polymer that were spray cast onto ITO and submitted to progressive electrochemical oxidation. An average of 30% of optical change upon oxidation characterizes this family of polymers. While the relative luminance of polymer 12 reaches

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the moderate value of 73%, polymer **6b** shows outstanding transmissivity upon oxidation with a relative luminance value reaching 84% in its fully oxidized state. The photographs reproduced in Figure 3 illustrate this difference where all materials have been photographed in their neutral state (left) and in their fully oxidized state (right) as thin films (top) and/or thicker films (bottom). While polymers **6a** and **6b** reflect a rather “aquamarine” (blue-green or persian green) color in their neutral state, polymer **9** can be considered “pine green”. The more red-shifted polymer **12** seems to offer a green certainly more “olive-like” (forest green) seemingly due to a residual dark-yellow reflection. Table 2 summarizes the color coordinates of all synthesized materials as well as the potentials at which the materials undergo optical changes. Examples of neutral state green colors that can be achieved using the conjugated polymers of the present application can include the range of colors defined by the CIELab color system having “L” values ranging from about 71 to about 80; “a” values ranging from about -15 to about -23; and “b” values ranging from about -11 to about 14, although green colors outside of this range can also be achieved.

Table 2. Colorimetric Results for the Neutral and Oxidized Polymers **6a** (P([ProDOT-OOct₂]₂-BTD)), **6b** (P([ProDOT-OEtHex₂]₂-BTD)), **9** (P([ProDOT-OOct₂-Th]₂-BTD)) and **12** (P([ProDOT-OOct₂-EDOT]₂-BTD)).

Polymer Film	Charge State	<i>E</i> (V)	<i>L</i>	<i>a</i>	<i>b</i>	Observed Color
P([ProDOT-OOct ₂] ₂ -BTD)	N	0	80	-22	-10	Persian Green
	O	0.8	93	-2	0	Transmissive-Grey
P([ProDOT-OEtHex ₂] ₂ -BTD)	N	-0.05	80	-23	-11	Persian Green
	O	0.7	94	-1	0	Transmissive-Grey
P([ProDOT-OOct ₂ -Th] ₂ -BTD)	N	-0.35	75	-15	1	Pine Green
	O	0.75	91	-3	-3	Transmissive-Clear Blue
P([ProDOT-OOct ₂ -EDOT] ₂ -BTD)	N	-0.6	71	-19	14	Forest Green
	O	0.8	89	-5	-5	Transmissive-Clear Blue

5 The conjugated polymers of the present disclosure can be employed in a variety of electronic devices. Suitable examples of such devices include electrochromic windows, mirrors and displays; SolarTurf, or artificial turfs that can harvest solar energy and generate electricity; Common Photovoltaic Devices; Electronic paper; Anti-Stat Conductors and Transparent Conductors; and Field Effect Transistors, supercapacitors, batteries, and other electronic components.

10 Other embodiments of the invention will be apparent to those skilled in the art from consideration of the specification and practice of the invention disclosed herein. It is intended that the specification and examples be considered as exemplary only, with a true scope and spirit of the invention being indicated by the following claims.

15 All patents, patent applications, provisional applications, and publications referred to or cited herein, *supra* or *infra*, are incorporated by reference in their entirety, including all figures and tables, to the extent they are not inconsistent with the explicit teachings of this specification.

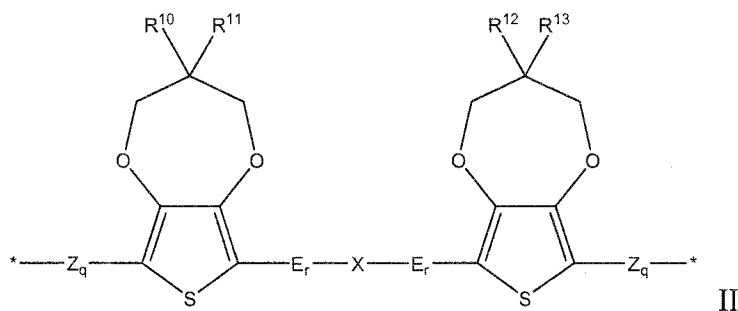
20 It should be understood that the examples and embodiments described herein are for illustrative purposes only and that various modifications or changes in light thereof will be suggested to persons skilled in the art and are to be included within the spirit and purview of this application.

CLAIMS

We claim:

1. A conjugated polymer comprising a plurality of repeating units, the repeating units comprising a plurality of substituted dioxyheterocycle based donor groups coupled to an acceptor group, wherein the conjugated polymer absorbs radiation within a first band of the visible spectrum and a second band of the visible spectrum when in a neutral state and upon oxidation the conjugated polymer is in a transmissive state with absorbance of radiation within the first and second bands being less than in the neutral state.
2. The polymer of claim 1, wherein the polymer exhibits solubility in at least one solvent
3. The polymer of claim 2, wherein the solvent comprises methylene chloride, chloroform, tetrachloroethane, tetrahydrofuran, dioxane, benzene, toluene, xylenes, chlorobenzene, dichlorobenzene, pyridine, ethyl acetate, butanol, ethanol, methanol, acetonitrile, acetone, isopropanol, water or mixtures thereof.
4. The polymer of claim 1, wherein the first absorption band has a visible absorption maximum at a wavelength below about 500 nm and the second absorption band has a visible absorption maximum at a wavelength above about 550 nm and a local minimum of absorption between 480 and 580 nm.
5. The polymer of claim 4, wherein the polymer has a green hue when in the neutral state.
6. The polymer of claim 1, wherein the conjugated polymer absorbs radiation within the first and second bands in the neutral state at an intensity of more than or equal to about 200% of the intensity in the transmissive state.
7. The polymer of claim 1, wherein the dioxyheterocycle is a dioxythiophene.

8. The polymer of claim 1, wherein the dioxyheterocycle is an alkylenedioxythiophene.
9. The polymer of claim 1, wherein the dioxyheterocycle is a 3,4-propylenedioxythiophene.
10. The polymer of claim 1, wherein the acceptor group is an electron poor aromatic unit.
11. The polymer of claim 10, wherein the electron poor aromatic unit comprises a substituted or unsubstituted benzothiadiazole group, thiadiazoloquinoxaline group, quinoxaline group, thienothiadiazole group, thienopyrazine group, pyrazinoquinoxaline group, benzobisthiadiazole group or thiadiazolothienpyrazine group.
12. The polymer of claim 10, wherein the electron poor aromatic unit is a 2,1,3-benzothiadiazole group (BTD).
13. The polymer of claim 1, wherein the repeating unit has a structure of formula III:
*- Z_q- Y- E_r- X- E_r- Y- Z_q- * III
where X is an electron poor aromatic unit, E is an electron rich conjugated unit, Y is a substituted dioxyheterocycle, Z is a conjugated unit, and q and r are 0, 1, 2 or 3.
14. The polymer of claim 13, wherein Y is a substituted dioxythiophene.
15. The polymer of claim 14, wherein the substituted dioxythiophene is an alkylenedioxythiophene substituted with at least one linear or branched aliphatic carbon chain that optionally comprises one or more heteroatoms.
16. The polymer of claim 1, wherein the repeating unit has a structure of formula II:



where X is an electron poor aromatic unit, E is an electron rich conjugated unit, Z is a conjugated unit, q and r are 0, 1, 2 or 3, and R^{10} , R^{11} , R^{12} and R^{13} are the same or different and at least one of R^{10} , R^{11} , R^{12} and R^{13} comprises a linear or branched aliphatic carbon chain that optionally comprises one or more heteroatoms.

17. The polymer of claim 16, wherein X comprises a substituted or unsubstituted benzothiadiazole group, thiadiazoloquinoxaline group, quinoxaline group, thienothiadiazol group; thienopyrazine group, pyrazinoquinoxaline group, benzobisthiadiazole group and thiadiazolothienopyrazine group.

18. The polymer of claim 16, wherein E comprises a substituted or unsubstituted thiophene and Z comprises a substituted or unsubstituted dioxothiophene group.

19. The polymer of claim 16, wherein R^{10} , R^{11} , R^{12} and R^{13} comprise a functional group chosen from oligoether, ester, amide, carboxylic acid, sulfonate, and amine.

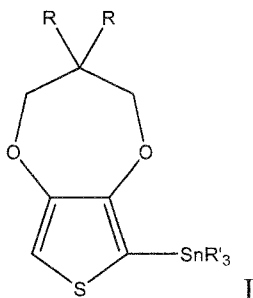
20. The polymer of claim 16, wherein R^{10} , R^{11} , R^{12} and R^{13} are $-R'OR''$ groups, where R' is a methylene, ethylene or propylene group and R'' is a linear or branched C2 to C30 alkyl.

21. A method of forming a conjugated polymer, the method comprising the steps of:
 reacting two donor compounds comprising a substituted dioxoheterocyclic moiety with a conjugated acceptor compound comprising an acceptor moiety to form a polymerizable unit; and
 linking covalently a plurality of the polymerizable units at ends of said polymerizable units to form the conjugated polymer, wherein the conjugated polymer

absorbs radiation within a first band of the visible spectrum and a second band of the visible spectrum when in a neutral state and upon oxidation the polymer is transmissive with absorbance of radiation within the first and second bands being less than in the neutral state, and wherein the polymer is soluble in at least one solvent.

22. The method of claim 21, wherein the step of reacting occurs in the presence of a metal catalyst.
23. The method of claim 21, wherein the ends of the polymerizable unit comprise dioxythiophene moieties.
24. The method of claim 21, wherein the dioxyheterocyclic moiety contains a coupling moiety comprising an organotin substituent, organoboron substituent, organomagnesium substituent, organozinc substituent, or organosilane substituent and the conjugated acceptor compound contains two halogen functional groups symmetrically situated on the conjugated acceptor compound.
26. The method of claim 21, wherein the conjugated acceptor compound has coupling moieties comprising two organotin substituents, organoboron substituents, organomagnesium substituents, organozinc substituents, or organosilane substituents symmetrically situated on the conjugated acceptor compound and the dioxyheterocycle moiety comprising a dioxythiophene moiety having a coupling moiety comprising a halogen.
27. The method of claim 21, wherein the conjugated acceptor compounds are chosen from dihalogenated benzothiadiazoles, dihalogenated thiadiazoloquinoxalines, dihalogenated quinoxalines, dihalogenated thienothiadiazoles, dihalogenated thienopyrazines, dihalogenated pyrazinoquinoxalines, dihalogenated benzobisthiadiazoles and dihalogenated thiadiazolothienpyrazines.
28. The method of claim 26, wherein the acceptor compounds are dibrominated 2,1,3-benzothiadiazoles.

29. The method of claim 21, wherein the donor compounds are chosen from compounds having a formula I:



where R groups are the same or different and comprise linear or branched aliphatic carbon chains and can optionally comprise one or more functional groups chosen from oligoether groups, ester groups, amide groups, carboxylic acid groups, sulfonate groups, amine groups and other polar functional groups and R' comprises an alkyl group.

30. The method of claim 29, wherein R is -R''OR''' group, where R'' is a methylene, ethylene or propylene and R''' is a linear or branched C2 to C30 alkyl.

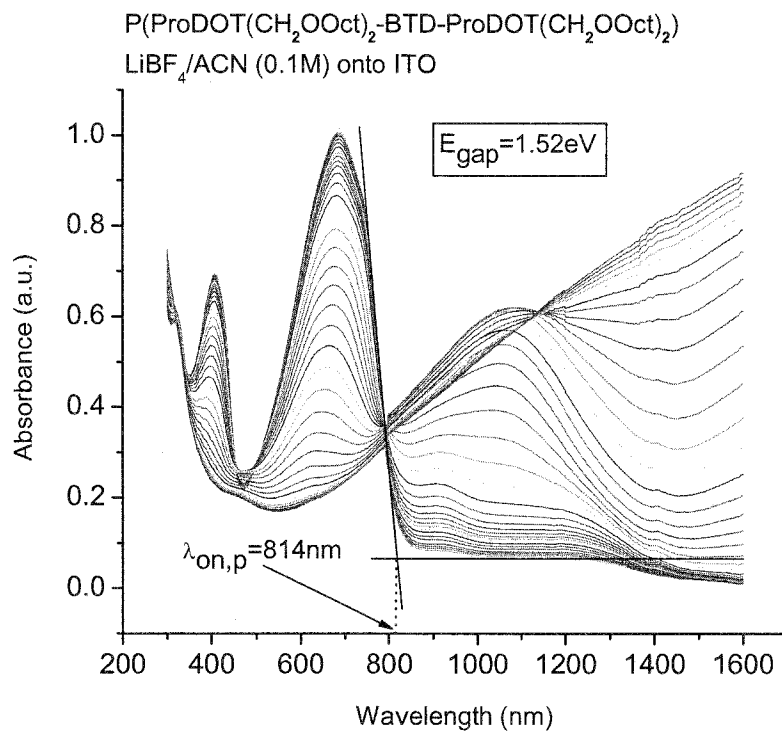


Figure 1A

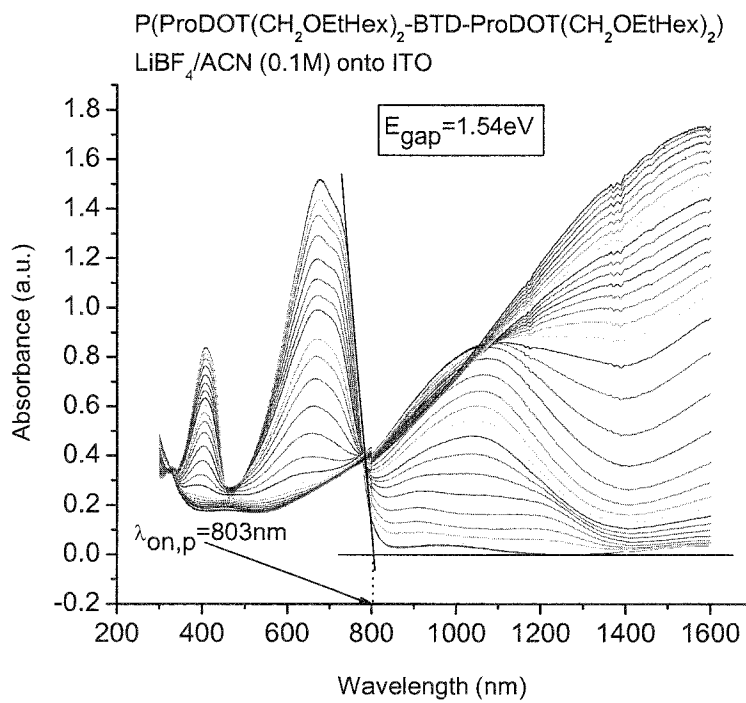


Figure 1B

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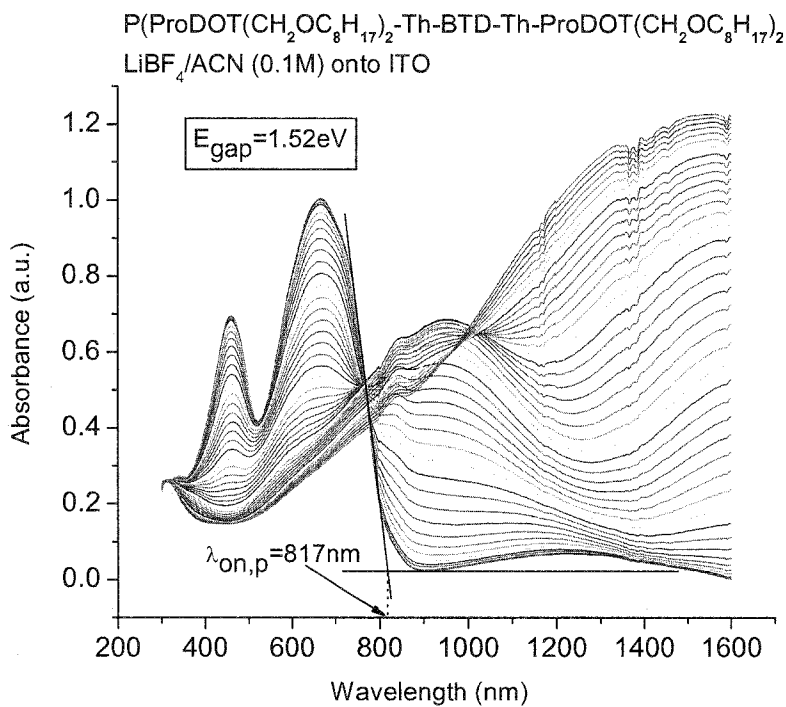


Figure 1C

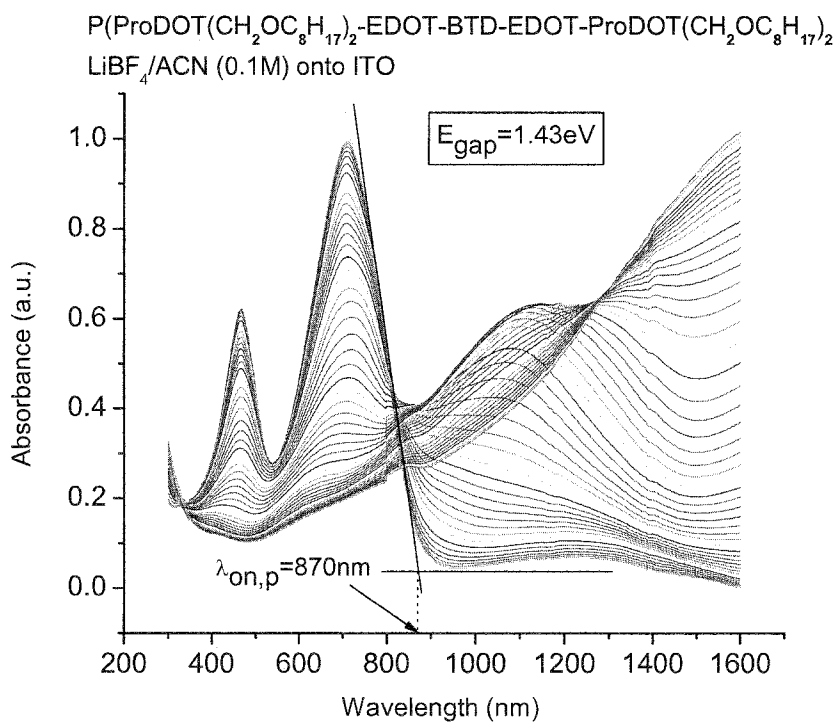


Figure 1D

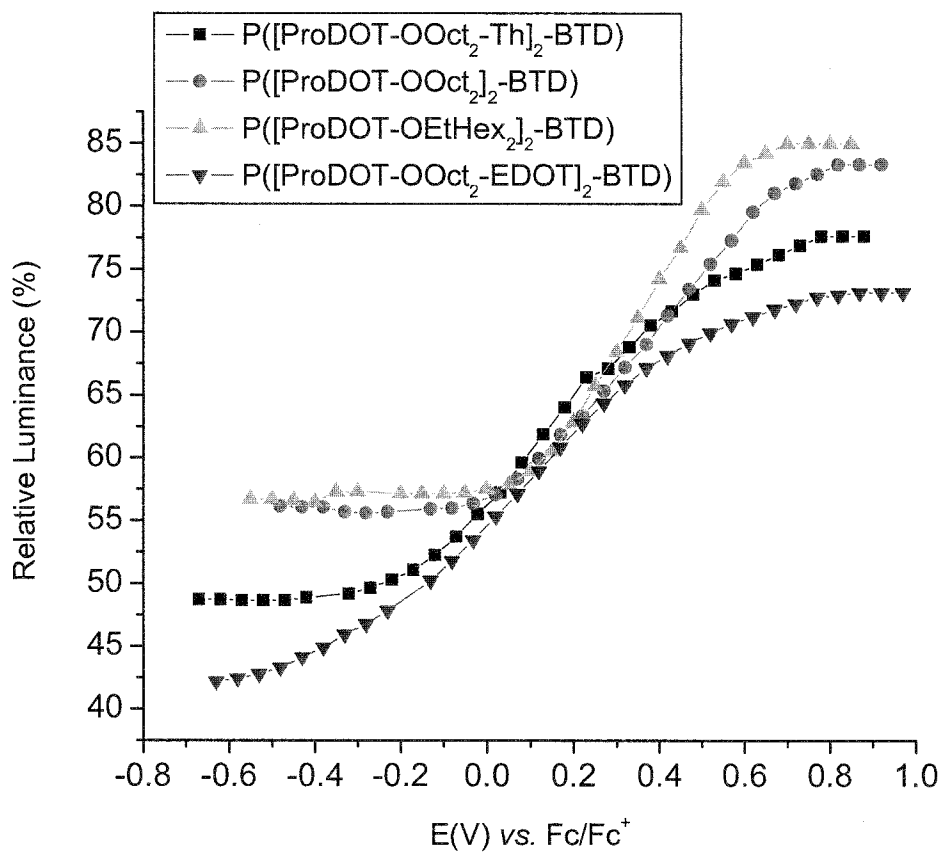


Figure 2

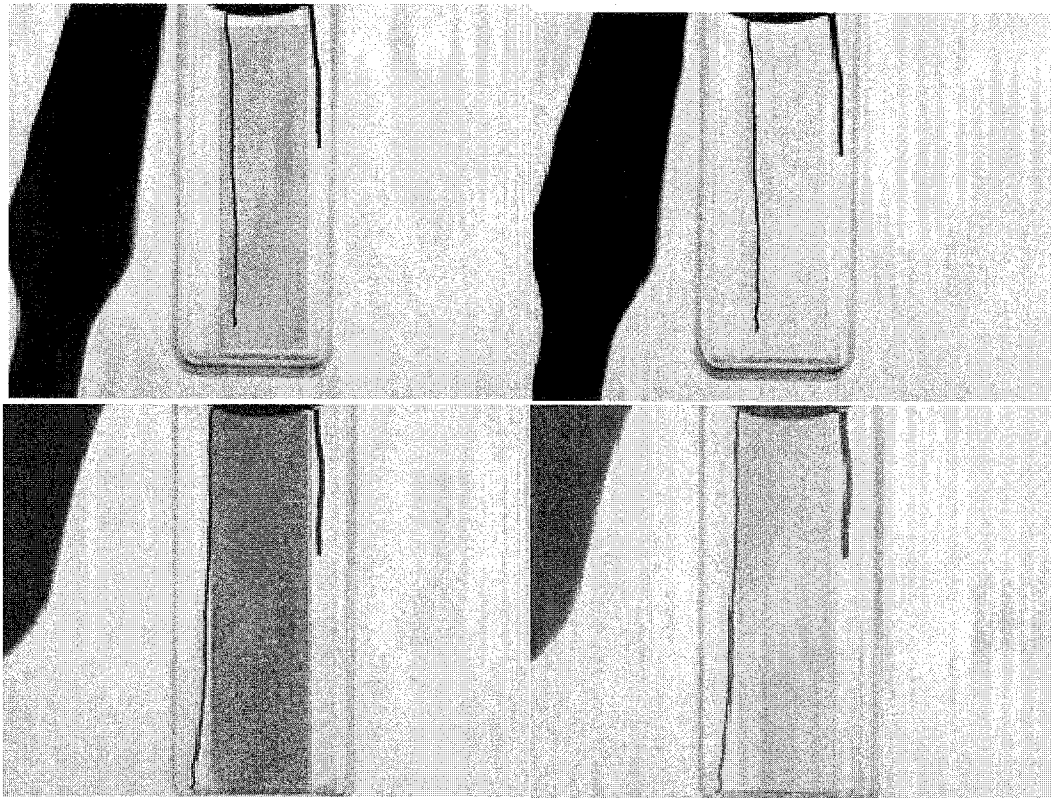


Figure 3A

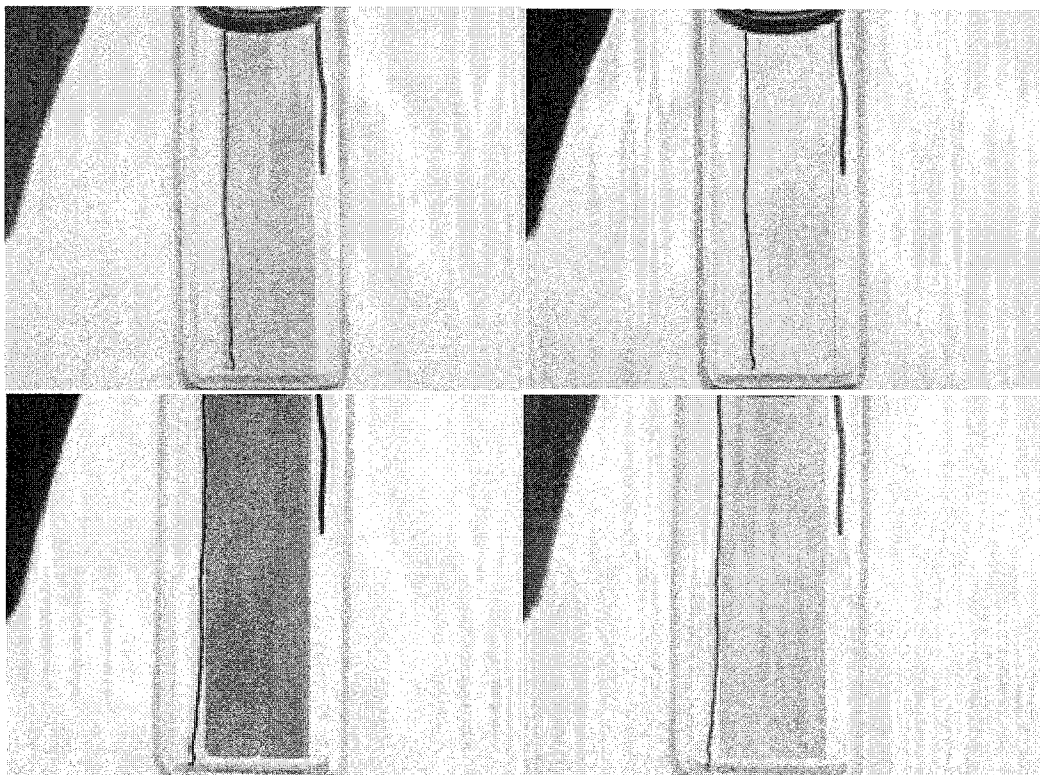


Figure 3B

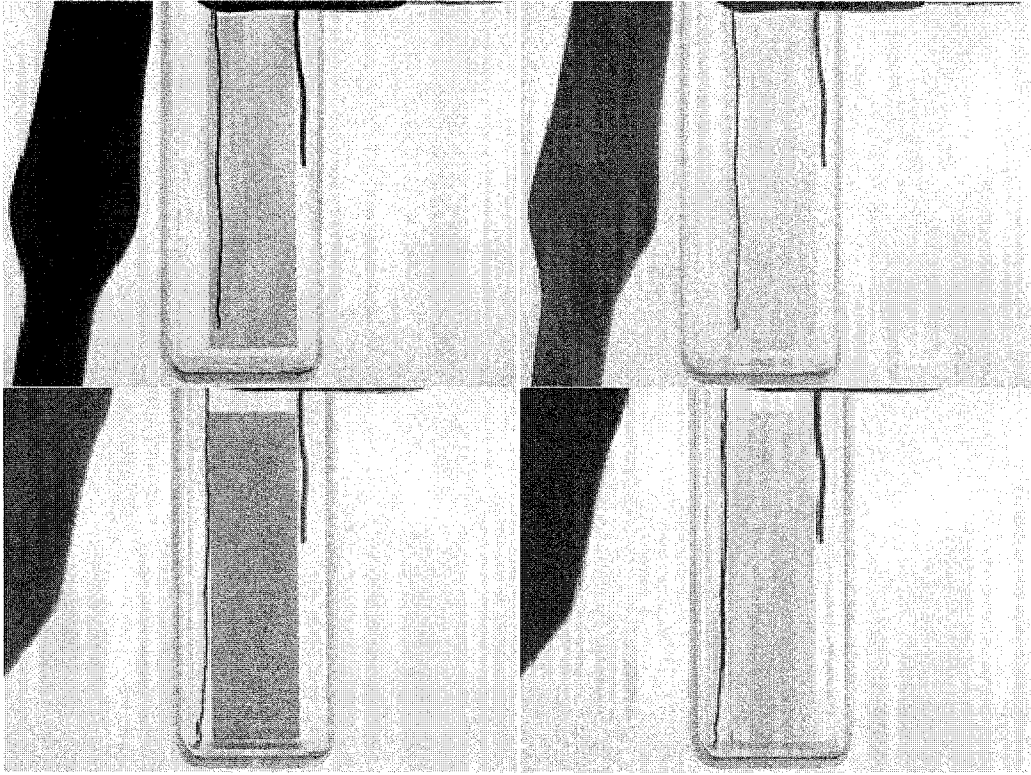


Figure 3C

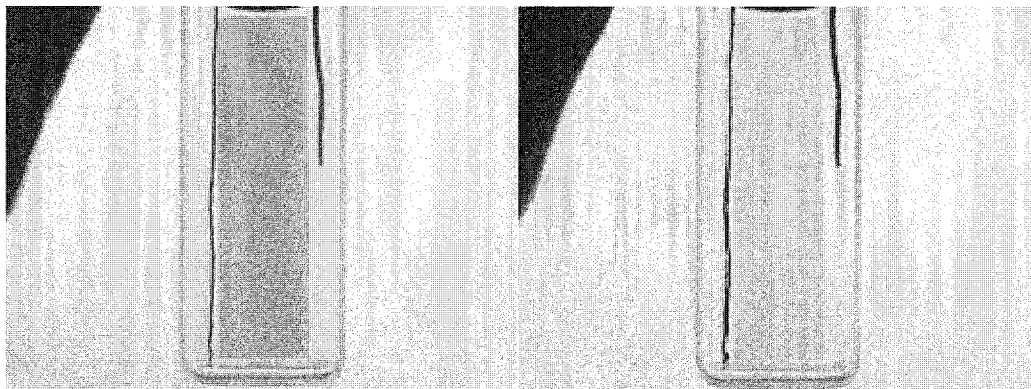


Figure 3D

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2008/081599

A. CLASSIFICATION OF SUBJECT MATTER INV. C08G61/12				
According to International Patent Classification (IPC) or to both national classification and IPC				
B. FIELDS SEARCHED				
Minimum documentation searched (classification system followed by classification symbols) C08G C08L C09D C09K G02F H01B H05B H01L				
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched				
Electronic data base consulted during the international search (name of data base and, where practical, search terms used) EPO-Internal, WPI Data				
C. DOCUMENTS CONSIDERED TO BE RELEVANT				
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.		
X	WON SUK SHIN ET AL.: "Synthesis and Photovoltaic Properties of a Low-Band-Gap Polymer Consisting of Alternating Thiophene and Benzothiadiazole Derivatives for Bulk-Heterojunction and Dye-Sensitized Solar Cells" JOURNAL OF POLYMER SCIENCE: PART A: POLYMER CHEMISTRY, vol. 45, no. 8, 15 April 2007 (2007-04-15), pages 1394-1402, XP002512443	1-18, 21-24, 26-29		
Y	the whole document ----- -/--	1-24, 26-30		
<table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none;"> <input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C. </td> <td style="width: 50%; border: none;"> <input checked="" type="checkbox"/> See patent family annex. </td> </tr> </table>			<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C.	<input checked="" type="checkbox"/> See patent family annex.
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C.	<input checked="" type="checkbox"/> See patent family annex.			
* Special categories of cited documents :				
<table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none; vertical-align: top;"> <ul style="list-style-type: none"> *A* document defining the general state of the art which is not considered to be of particular relevance *E* earlier document but published on or after the international filing date *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) *O* document referring to an oral disclosure, use, exhibition or other means *P* document published prior to the international filing date but later than the priority date claimed </td> <td style="width: 50%; border: none; vertical-align: top;"> <ul style="list-style-type: none"> *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art. *&* document member of the same patent family </td> </tr> </table>			<ul style="list-style-type: none"> *A* document defining the general state of the art which is not considered to be of particular relevance *E* earlier document but published on or after the international filing date *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) *O* document referring to an oral disclosure, use, exhibition or other means *P* document published prior to the international filing date but later than the priority date claimed 	<ul style="list-style-type: none"> *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art. *&* document member of the same patent family
<ul style="list-style-type: none"> *A* document defining the general state of the art which is not considered to be of particular relevance *E* earlier document but published on or after the international filing date *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) *O* document referring to an oral disclosure, use, exhibition or other means *P* document published prior to the international filing date but later than the priority date claimed 	<ul style="list-style-type: none"> *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art. *&* document member of the same patent family 			
Date of the actual completion of the international search <p style="text-align: center; font-weight: bold;">2 February 2009</p>		Date of mailing of the international search report <p style="text-align: center; font-weight: bold;">10/02/2009</p>		
Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016		Authorized officer <p style="text-align: center; font-weight: bold;">Meiners, Christian</p>		

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2008/081599

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>US 2005/200935 A1 (LIU LU [US] ET AL) 15 September 2005 (2005-09-15)</p> <p>paragraphs [0002], [0019], [0138]; figures 2,3,17</p> <p>-----</p>	<p>1-3,6-8, 10,13, 14,16, 18,21-24</p>
X	<p>WO 03/046106 A (UNIV FLORIDA [US]; REYNOLDS JOHN R [US]; ZONG KYUKWAN [US]; SCHWENDEMA) 5 June 2003 (2003-06-05)</p> <p>abstract page 19, lines 22-26 page 38, line 5 - page 39, line 9 claim 1 figures 6,17,20,22,26 tables 3,4</p> <p>-----</p>	<p>1-3, 6-10,13, 14,16, 18,21-24</p>
X	<p>MORTIMER ET AL: "Electrochromic organic and polymeric materials for display applications" DISPLAYS DEVICES, DEMPA PUBLICATIONS, TOKYO, JP, vol. 27, no. 1, 1 January 2006 (2006-01-01), pages 2-18, XP005211598 ISSN: 0141-9382 page 11, item 4.4 - page 14, item 4.5 abstract figure 11</p> <p>-----</p>	<p>1-8,10, 13,14</p>
X	<p>VAN MULLEKOM H A M ET AL: "Developments in the chemistry and band gap engineering of donor-acceptor substituted conjugated polymers" MATERIALS SCIENCE AND ENGINEERING R: REPORTS, ELSEVIER SEQUOIA S.A., LAUSANNE, CH, vol. 32, no. 1, 1 February 2001 (2001-02-01), pages 1-40, XP004226962 ISSN: 0927-796X scheme 24 abstract</p> <p>-----</p>	<p>1-8,10, 11,13, 14, 21-23,27</p>
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INTERNATIONAL SEARCH REPORT

International application No

PCT/US2008/081599

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>PAI ET AL: "Electronic structure and properties of alternating donor-acceptor conjugated copolymers: 3,4-Ethylenedioxythiophene (EDOT) copolymers and model compounds" POLYMER, ELSEVIER SCIENCE PUBLISHERS B.V, GB, vol. 47, no. 2, 13 January 2006 (2006-01-13), pages 699-708, XP005238806 ISSN: 0032-3861 abstract figures 1-6; table 4</p> <p>-----</p>	1-8, 10-15
X	<p>A. DURMUS, G. E. GUNBAS, P. CAMURLU, L. TOPPARE: "A neutral state green polymer with a superior transmissive light blue oxidised state" CHEMICAL COMMUNICATIONS, 15 May 2007 (2007-05-15), pages 3246-3248, XP002512444 cited in the application abstract scheme 1</p> <p>-----</p>	1-8, 10-14, 21-24, 27,28
X	<p>J. CASADO ET AL.: "Alternated Quinoid/Aromatic Units in Terthiophenes Building Blocks for Electroactive Narrow Band Gap Polymers. Extended Spectroscopic, Solid State, Electrochemical, and Theoretical Study" JOURNAL OF PHYSICAL CHEMISTRY B, vol. 109, no. 35, 17 August 2005 (2005-08-17), pages 16616-16627, XP002512445 AMERICAN CHEMICAL SOCIETY, COLUMBUS, OH, US figure 1 scheme 1 abstract</p> <p>-----</p>	1-8, 10-14, 21-24,27
Y	<p>REEVES, B.D. ET AL.: "Spray Coatable Electrochromic Dioxothiophene Polymers with High Coloration Efficiencies" MACROMOLECULES, vol. 37, no. 20, 4 September 2004 (2004-09-04), pages 7559-7569, XP002512513 ACS, WASHINGTON, DC, US abstract schemes 1-5 figures 3-12 tables 1-4</p> <p>-----</p>	1-24, 26-30

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2008/081599

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 2005200935	A1	15-09-2005	NONE
WO 03046106	A	05-06-2003	AU 2002362016 A1 10-06-2003
			CA 2467840 A1 05-06-2003
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