

(51) International Patent Classification:
B01D 53/02 (2006.01)(21) International Application Number:
PCT/US2010/061446(22) International Filing Date:
21 December 2010 (21.12.2010)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
61/284,645 22 December 2009 (22.12.2009) US
12/973,562 20 December 2010 (20.12.2010) US(71) Applicant (for all designated States except US):
EXXONMOBIL RESEARCH AND ENGINEERING COMPANY [US/US]; 1545 Route 22 East, P.O.Box 900, Annandale, NJ 08801-0900 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **BAUGH, Lisa, S.** [US/US]; 71 Manners Road, Ringoes, NJ 08551 (US). **CALABRO, David, C.** [US/US]; 1584 Mountaintop Road, Bridgewater, NJ 08807 (US). **LI, Quanchang** [CN/US]; 912 Blossom Circle, Dayton, NJ 08810 (US). **BERLUCHE, Enock** [US/US]; 55 Peddlers Lane, Phillipsburg, NJ 08865 (US).(74) Agents: **BAKUN, Estelle, C.** et al.; Exxonmobil Research and Engineering Company, 1545 Route 22 East, P.O. Box 900, Annandale, NJ 08801-0900 (US).

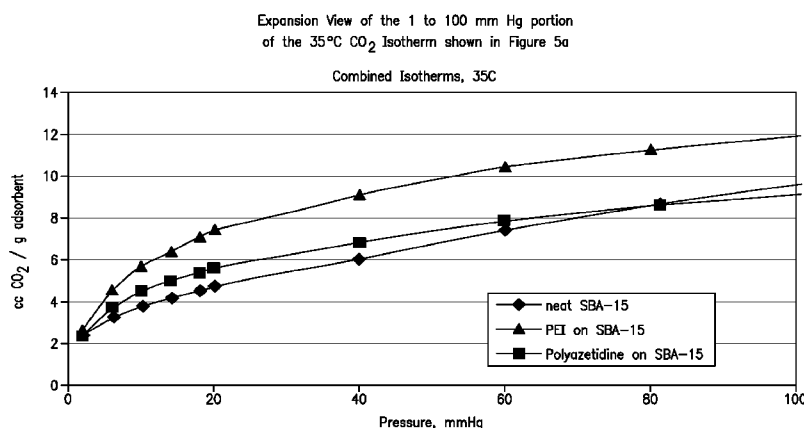
(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PE, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— with international search report (Art. 21(3))

(54) Title: CARBON DIOXIDE SORBENTS

**FIG. 6**(57) Abstract: Improved CO₂ sorbents comprised of a mesoporous silica functionalized with a polyamine are obtained by the in-situ polymerization of azetidine. Also included herein are processes utilizing the improved CO₂ sorbents wherein CO₂ is chemisorbed onto the polyamine portion of the sorbent and the process is thermally reversible.

CARBON DIOXIDE SORBENTS

FIELD OF THE INVENTION

[0001] The present invention relates to an improved CO₂ sorbent comprised of a mesoporous silica functionalized with a polyamine obtained by the in-situ polymerization of a cyclic amine, such as azetidine. CO₂ is chemisorbed onto the polyamine portion of the sorbent, which is thermally reversible.

BACKGROUND OF THE INVENTION

[0002] The world remains dependent on petroleum-derived feedstreams as the source of energy, especially for use as transportation fuels. These feedstreams are produced from crude oils using various refinery processes in complex commercial petroleum refineries. While many useful products are produced in these refineries, undesirable side streams, such as acid gases (CO₂ and H₂S), are also produced. An increase of the concentration of CO₂, a greenhouse gas, in the atmosphere due to carbon emissions is expected to occur unless energy systems incorporate carbon emission reduction technology. CO₂ capture and sequestration, along with reduced carbon content of fuels and improved efficiency of energy production and use, are considered to be viable ways to stabilize and ultimately reduce the concentration of greenhouse gases.

[0003] CO₂ capture in industrial processes is typically done by aqueous amine scrubbing, which generally involves contacting the CO₂-containing gas stream with an aqueous solution of one or more simple amines such as diethanolamine, monoethanolamine, and the like. The amines chemically react with CO₂ in a reversible manner to form one or more of carbamate, ammonium bicarbonate, and

ammonium carbonate species. Another acid gas scrubbing technology is the so-called "Rectisol Wash" process that uses an organic solvent, typically methanol, at subzero temperatures. SELEXOLTM is another conventional acid gas removal process wherein a proprietary solvent is used into which acid gases are dissolved from a hydrocarbon stream. Another commercial process for removing acid gases from hydrocarbon streams is a process marketed under the tradename PURISOLTM, which uses N-methyl-2-pyrrolidone (NMP) as a solvent for absorbing acid gases.

[0004] Another gas scrubbing technology in commercial use is the FlexsorbTM process. This process removes acid gases from natural or flue gas streams using aqueous solutions of sterically hindered simple amines in a temperature swing process operating at temperatures of about 35 to about 85°C, or higher. The steric hindrance of the amine is used to suppress CO₂ uptake in order to best favor selective H₂S removal. Since most process gas streams enter the scrubbing stage at elevated temperatures, much energy is consumed in heat transfer to cool the feed gas to the CO₂/H₂S absorption temperature. A process that could operate in a non-aqueous-phase environment, and at higher temperatures, would be highly desirable, as would a process that is more selective for CO₂ as opposed to H₂S.

[0005] Polymeric amines (polyamines) and amine-bearing polymers are also used as CO₂ sorbents. Polymeric amines have much larger molecular weights than simple small-molecule amines and are therefore less volatile. Smaller sorbent loss is achieved through vaporization over the lifetime of the process for CO₂ sorption processes performed in the liquid phase using temperature swing. Polymeric amines may also be used in neat form as bulk sorbents.

[0006] Polyethylenimine, also known as poly(aziridine), is a polyamine of interest as a CO₂ sorbent. Poly(aziridine) is the polymeric form of aziridine (ethylenimine), a three membered ring cyclic amine, and is typically hyperbranched

in microstructure. Branchy poly(aziridine)s are amorphous, viscous liquids at room temperature. Poly(aziridine) provides a number of advantages as a sorbent polymer, particularly a very high density of amine sites per weight (one amine site for every two carbon atoms). This high density of potentially reactive amine sites gives poly(aziridine) a very high potential CO₂ uptake on a weight basis and renders it a potentially very efficient sorbent.

[0007] CO₂ capture has also been performed using solid-phase sorbents in which simple amines are supported on the surface of, and/or within the pores of, silica and zeolite materials which may already function as active physisorbents for CO₂. These solid sorbents are advantageous over liquid-phase sorbents in that the CO₂-containing gas stream can be contacted directly with the sorbent without need of a liquid medium in a variety of configurations such as particles in fixed beds, fibers, etc. Both small molecule and polymeric amines, including poly(aziridine), have been used in supported form to absorb CO₂ from moist gases at moderate temperatures (≤ 120 °C). Polymeric amines which are physically impregnated into, or chemically attached to a support, offer a greater number of amine binding sites than impregnated small-molecule amines due to the multifunctional (multi-amine) nature of the polymer species. Pre-made poly(aziridine)s have been impregnated and/or covalently attached to supports such as mesoporous silicas (MCM-41, SBA-15), other polymers, and carbon nanotubes and used for reversible CO₂ capture. Liquid poly(aziridine)s on poly(methyl methacrylate) substrates are utilized by NASA for CO₂ removal on the Space Shuttle. As compared to CO₂ absorption by neat poly(aziridine)s, synergistic effects between zeolitic supports and the poly(aziridine) can raise the absorption capacities of the polymer by a factor of about 2 to 3.

[0008] Poly(aziridine) can be introduced to an inorganic support in multiple fashions. Pre-polymerized poly(aziridine) may be physically impregnated onto the

support by mixing in solution followed by evaporation of the solvent. This technique is non-selective in siting the polymer molecules on both the surface of the support and within its pores. Large, high-molecular-weight polymers may be too large to enter the pores, or may block entrance to them, giving non-optimal surface area of the chemical sorbent or destroying the synergistic effects provided by physisorption of the CO₂ within the pores of the mesoporous silica. In situ polymerization of aziridine in the presence of the inorganic support provides a method for efficiently introducing polymer molecules into pores, for example into those of mesoporous silicas, as described in Rosenholm, J. et al. *Chem. Mater.* 2007, 19, 5023; *Chem. Commun.* 2006, 3909. The chemisorptions of CO₂ using high surface area SBA-15 silica supports, such as MCM-41 mesoporous silica, that contain in-situ grown poly(aziridine)s are described in United States Patent Application Publication US2007/0149398A1, which is incorporated herein by reference. The poly(aziridine)s are prepared from aziridine monomer within the pores of the support utilizing the pendant hydroxyl, carboxylic acid, or other similar groups of the silica as initiating moieties for polymerization in the presence of a catalytic amount of a Brønsted acid such as acetic acid. In these materials, the loading (amount) of the branchy poly(aziridine)s is greater than in materials prepared by simple impregnation of pre-grown poly(aziridine)s, and higher CO₂ sorption capacities are achieved. These materials also offer good long-term stability as a result of the covalent attachment of the poly(aziridine) to the support.

[0009] While there exists several commercial processes for the sequestration of CO₂ from various hydrocarbon streams, there is still a need in the art for improvement, particularly with respect to costs, effectiveness, reversibility and toxicity. In particular, what is needed is a method to manipulate the properties of polyamine sorbents to provide improved safety, versatility, and CO₂ sorption capacity. For nanotube-supported poly(aziridine)s, CO₂ absorption efficiencies of only about $\leq 15\%$ are known, suggesting that there is much room for manipulation

of the polymer microstructure to improve CO₂ uptake. The accessibility of amine sites in supported poly(aziridine)s for CO₂ sorption has in some instances also been shown to be less than for monomeric amines. Furthermore, poly(aziridine) is prepared from a very volatile monomer, aziridine, having a high toxicity.

SUMMARY OF THE INVENTION

[0010] In accordance with the present invention there is provided a functionalized adsorbent material for adsorbing CO₂ from CO₂-containing gaseous streams, which adsorbent material comprises a mesoporous silica material having at least a portion of its pores functionalized with in-situ polymerized cyclic amine in which the density of amine sites on the polymer is below 20.0 mmol amine/gram.

[0011] In a preferred embodiment, the cyclic amine is azetidine and the resulting polymer is poly(azetidine) which is at least about 2% of the total weight of the adsorbent material.

[0012] In another preferred embodiment, the mesoporous silica material is selected from the group consisting of SBA-15 and MCM-41.

[0013] In still another preferred embodiment of the present invention the functionalized adsorbent material is further comprised of one or more additional components selected from the group consisting of amorphous silica binder, aluminum oxide binder, residual polymerization solvent, and residual polymerization initiator.

[0014] Also in accordance with the present invention is a method of preparing a functionalized adsorbent material comprised of a cyclic amine polymer for removing CO₂ from CO₂-containing gaseous streams, which method comprises:

- forming a mixture comprised of a cyclic amine, a Brønsted acid initiator in a solvent, and a mesoporous silica;
 - forming the cyclic amine polymer in the presence of the mesoporous silica; and
 - retrieving the resultant functionalized adsorbent material from the mixture as a solid;
- wherein the resulting cyclic amine polymer has an amine density of below about 20.0 mmol amine/gram.

[0015] Also in accordance with the present invention is a method utilizing the functionalized adsorbent materials for removing CO₂ from a CO₂-containing gaseous stream, which method comprises contacting said stream with an effective amount of a functionalized adsorbent material comprising a mesoporous silica material having at least a portion of its pores functionalized with in-situ polymerized cyclic amine in which the density of amine sites of the in-situ polymerized cyclic amine is below 20.0 mmol amine/gram.

BRIEF DESCRIPTION OF THE FIGURES

[0016] Figure 1 hereof shows the thermogravimetric analysis under nitrogen of calcined and uncalcined SBA-15, the poly(azetidine)/SBA-15 material of Example 1 made with uncalcined SBA-15, and the analogous poly(aziridine)/SBA-15 material of Comparative Example C1.

[0017] Figure 2 hereof shows overlaid combined 35-100 °C isotherms contrasting CO₂ adsorption behavior for neat uncalcined SBA-15, the poly(azetidine)/SBA-15 of Example 1, and the poly(aziridine)/SBA-15 (“PEI”) of Comparative Example C1.

[0018] Figure 3 hereof shows the thermogravimetric analysis under nitrogen and air of the bulk poly(azetidine) prepared in Example 5.

[0019] Figure 4 hereof shows the thermogravimetric analysis under nitrogen of calcined SBA-15, the poly(azetidine)/SBA-15 material of Example 6 made with calcined SBA-15, and the analogous poly(aziridine)/SBA-15 material of Comparative Example C2.

[0020] Figures 5a and 5b hereof shows overlaid combined 35-100 °C isotherms contrasting CO₂ absorption behavior for neat uncalcined SBA-15, the poly(azetidine)/SBA-15 of Example 6, and the poly(aziridine)/SBA-15 ("PEI") of Comparative Example C2.

[0021] Figure 6 hereof shows an expansion of the low pressure region (0 to 0.13 atm) of the 35 °C isotherm of Figure 5.

[0022] Figures 7a and 7b hereof shows ¹³C NMR spectra for the aqueous poly(azetidine) solution of Example 9 (and 5) before (Fig 7a, 24 °C) and after (Fig 7b, 30 °C) treatment with 1 atm CO₂ for ca. 10 hours.

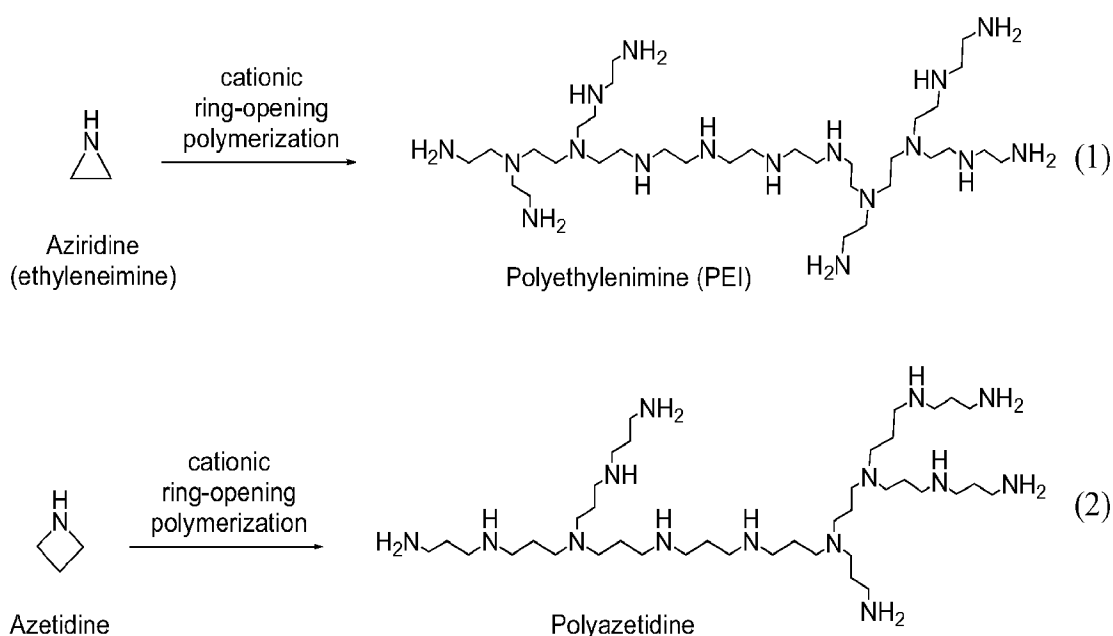
[0023] Figures 8a and 8b hereof shows ¹³C NMR spectra for the aqueous poly(aziridine) solution ("PEI") of Comparative Example C3 before (Fig 8a, 24 °C) and after (Fig 8b, 24 °C) treatment with 1 atm CO₂ for 7 hours.

DETAILED DESCRIPTION OF THE INVENTION

[0024] It is unexpectedly found by the inventors hereof that poly(azetidine), despite having a lower density of amine sites per weight than poly(aziridine), provides unexpected advantages as a CO₂ sorbent when supported in the pores of a

mesoporous silica material, or used as a component in a liquid phase sorbent, including higher molar sorption efficiency under industrially useful conditions, particularly conditions of low partial CO₂ pressure. The higher polyamine, poly(azetidine), is the polymeric form of azetidine (propylenimine or trimethylenimine), a four membered ring cyclic amine. Poly(azetidine)s synthesized from trimethylenimine by cationic polymerization are hyperbranched. The general conditions for the synthesis of branchy poly(azetidine) are described in the literature, as for example in *Encyclopedia of Polymer Science and Engineering* (Wiley-Interscience), 1985, vol. 1, pp 680-739; Goethals, E. and Schacht, E. *Polymeric Amines and Ammonium Salts* (Pergamon), 1980, pp 67-77; Goethals, E. et al. *Polym. J.* 1980, 12, 571; Schacht, E. et al. *Makromol. Chem.* 1974, 175, 3447.

[0025] Equations 1 and 2 compare the chemical structures of azetidine / poly(azetidine) and aziridine / poly(aziridine) (the monomer and polymer of the analogous three membered ring cyclic amine). While both polymers are prepared via cationic polymerization, the conditions for azetidine polymerization typically require higher temperatures than those for aziridine polymerization.



[0026] The current invention, involving poly(azetidine), provides a polymeric CO₂ sorbent material with a greater spacing between amine groups than poly(aziridine) while still maintaining a very high density of amines (one amine site for every three carbons). Table 1 provides a property comparison between azetidine and aziridine monomers and their polymers. In particular, the amine density (mmol amine per gram of polymer) is lower for poly(azetidine) than poly(aziridine). For example, the amine density per gram of poly(azetidine) is less than about 20 mmol, preferably from about 16.5 to about 19 mmol. Furthermore, azetidine monomer has a higher boiling point, lower vapor pressure, and higher flash point than aziridine, providing fewer hazards during polymerization to manufacture the sorbent. The greater relative hydrocarbon content of poly(azetidine) as compared to poly(aziridine) should give it greater solubility in non-aqueous solvents and miscibility with less polar polymers, offering opportunities to broaden its use window for CO₂ chemisorption.

[0027] Yet another benefit of the use of poly(azetidine) polymers versus the more common poly(aziridine)s, is improved oxidative stability. The poly(aziridine) structure shown in equation 1, is built from an ethylenimine repeat unit having a nitrogen atom every two carbon atoms. This structural unit has been shown to be particularly susceptible to oxidative degradation during regeneration of the amine-CO₂ complex (see H. Lepaumier, et al., *Ind.Eng. Chem. Res.*, 48, 9061 (2009), and C.W. Jones and W. Li, *paper no. 573b, Amer. Inst. Chem. Engr., National meeting*, November 11, 2010, Salt Lake City). The poly(azetidine) structure disclosed here utilizes a propylenimine repeat unit having a nitrogen atom every three carbon atoms, thereby avoiding the presence of the oxidatively unstable ethylenediamine unit.

Table 1. Comparison of some properties of azetidine and aziridine monomers.

Property	Azetidine	Aziridine
Molecular weight (g/mol)	57.09	43.07
Boiling point (°C)	62-63	55-56
Density	0.844	0.832
Molality (moles/gram) of polymer	17.5 millimolal	23.2 millimolal
mMol amine per gram of polymer	17.5	23.2
Predicted pKa	11.26	8.13
Predicted vapor pressure, 25 °C	162 torr	221 torr
Flash point	-23.6, -21.0 °C	-39.0

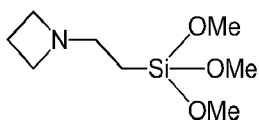
[0028] In the CO₂-adsorbed form of poly(aziridine) (containing carbamate, ammonium bicarbonate, and/or ammonium carbonate functionalities depending on whether or not water is present), the very high amine density results in very closely spaced charge density and/or carbamate groups. The lower amine density of poly(azetidine), while nominally unfavorable from a theoretical weight capacity basis, is thought by the inventors hereof to lessen the stresses of charge repulsion and steric hindrance, and therefore improve sorption behavior and thereby influence important polymer structure-property parameters, such as glass transition.

[0029] In one aspect of the present invention, there is provided an adsorbent material for adsorbing CO₂ from CO₂-containing gaseous streams, which adsorbent material is comprised of a mesoporous silica material having at least a portion of its pores functionalized with in-situ polymerized azetidine (poly(azetidine)).

[0030] In one embodiment of the invention, the poly(azetidine) is branched or hyperbranched and contains primary, secondary, and tertiary amine groups. The

ratios of primary:secondary:tertiary amines in the polymer ranges from between about 2:96:2 to about 46:8:46.

[0031] In another embodiment, copolymerizations of free azetidine with other cyclic amines, such as N-substituted azetidines, or aziridines, or higher cyclic amines, may be performed in order to further tailor the polyamine structure. Copolymerizations of free azetidine with a small amount of an N-substituted azetidine bearing a siloxy group, for example:



(3)

may be employed in order to produce materials that are anchorable to a silica support via hydrolysis and polycondensation of the siloxane group with the surface hydroxyl groups on the support. In this instance, the cyclic amine monomer (azetidine) is actually a mixture of azetidine with one or more other cyclic amine monomers.

[0032] The present invention is directed to the use of mesoporous silica supports. Mesoporous silicas, such as MCM-41 and SBA-15 (the most common mesoporous silicas), are porous, surfactant-templated silicas having an ordered array of mesopores that are monodispersed in pore diameter, and that are separated by silicon oxide walls that are disordered on an atomic scale. The mesopore diameter can be varied over the range of about 2 nm to about 20 nm. The pore volume of these materials ranges from about 0.3 cc/g to about 1.8 cc/g. In embodiments herein, the BET surface area of the functionalized mesoporous silica adsorbent ranges from about 100 m²/g to about 1600 m²/g; from about 150 m²/g to about 1500 m²/g; from about 200 m²/g to about 1500 m²/g; from about 300 m²/g to about 1500 m²/g; from about 700 m²/g to about 1500 m²/g; or from about 1000 m²/g

to about 1500 m²/g. In more preferable embodiments herein the BET surface area of the functionalized mesoporous silica adsorbent ranges from about 200 m²/g to about 1500 m²/g; or even more preferably from about 300 m²/g to about 1500 m²/g. The large pore size and ordered pore morphology of these materials ensures that the reactant molecules are small enough to diffuse into the pores prior to polymerization and that the polymerized species can be accommodated within the pores.

[0033] In a preferred embodiment, the mesoporous silica material is selected from the group consisting of SBA-15, SBA-16, MCM-41, and MCM-48, preferably SBA-15 and MCM-41. The preparation of these materials is well known in the art. They are generally prepared by surfactant templating of a silica sol gel polycondensation. The products have structures featuring regularly order mesopores with walls consisting of an amorphous silica network. The amorphous wall structure has a very high concentration of surface hydroxyl groups that serve very effectively as anchoring sites for a variety of functional group attachments.

[0034] Also in accordance with the present invention is a method of preparing an adsorbent material for removing CO₂ from CO₂-containing gaseous streams. In general the adsorbent material is prepared by functionalizing a portion of the pores of a mesoporous silica material. The pores are functionalized by polymerizing, within the pores, a cyclic amine, which as previously mentioned is preferably azetidine. This is generally accomplished by contacting (i.e., producing a mixture of) a cyclic amine (or, as previously mentioned, a mixture of cyclic amines) having an amine density of below about 20.0 mmol amine/gram with a Brønsted acid initiator in a solvent in the presence of a mesoporous silica. The molar ratio of cyclic amine to Brønsted acid initiator will be from about 8:1 to about 30:1 and reaction temperatures will range from about 20 °C to about 120 °C. Preferred Brønsted acid initiators include acetic acid and perchloric acid, with perchloric acid

being more preferred. Preferred solvents include toluene and methanol, with methanol being more preferred. The in-situ polymer will represent from about 2% to about 65%, preferably from about 5% to about 65%, more preferably from about 7% to about 65%, most preferably from about 10% to about 65%, particularly from about 15% to about 65% of the total weight of the adsorbent material.

[0035] Also in accordance with the present invention is a method for removing CO₂ from a CO₂-containing gaseous stream, which method comprises contacting said stream with an effective amount of adsorbent material comprised of a mesoporous silica material having at least a portion of its pores functionalized with in-situ polymerized azetidine (poly(azetidine)).

[0036] It is within the scope of this invention that a liquid phase sorbent containing a polymerized cyclic amine, preferably poly(azetidine), be used. It will typically be used in an absorption tower, where a gaseous stream containing CO₂ countercurrently contacts the liquid absorbent. The CO₂ and amine of the sorbent chemically react to form chemisorption products, thereby removing the CO₂ from the gaseous stream. After the sorbent is loaded with CO₂ to a satisfactory level, or at a designated cycle time, the sorbent can be regenerated. When used as a liquid phase sorbent, regeneration of the CO₂ containing sorbent typically involves desorbing the absorbed CO₂ by stripping the liquid-phase sorbent with an inert gas, a natural gas stream or steam in a regeneration zone. During this step, the chemisorption products are decomposed, CO₂ is removed, and the amine is freed to its original state and ready for re-use. It is preferred that the liquid be water and that the polymer comprise from about 1% to about 30% of the total liquid phase sorbent in the adsorption phase of the process. It is also preferred that the temperature during the adsorption phase of the process be from about 15° C to about 120°C.

[0037] Most commercially practiced chemical absorption of CO₂ with amines is performed in aqueous solution. In aqueous solutions, there are several chemisorption products that form including ammonium carbamates and ammonium bicarbonates/carbonates. When bicarbonate/carbonate products (which require the presence of a stoichiometric amount of water) are present, bicarbonates are preferred because they provide a theoretical 1:1 CO₂:amine uptake ratio (an ammonium bicarbonate, R₃NH⁺ HCO₃⁻) whereas a carbonate only provides a theoretical 1:2 CO₂:amine uptake ratio (a diammonium carbonate, [R₃NH⁺]₂ CO₃²⁻). In one embodiment of the invention, the chemisorption products remain soluble in the reaction medium after CO₂ uptake so that they can be regenerated as a liquid phase by the techniques described above.

[0038] The following Examples demonstrate the synthesis of poly(azetidine) via cationic polymerization in the presence and absence of a mesoporous silica support, and its use as a solid CO₂ sorbent on the mesoporous silica, or in a liquid sorbent composition. The purpose of these Examples is to illustrate several preferred embodiments of the present invention and are not to be taken as limiting the scope of the present invention in any way.

Examples

[0039] **Materials and Instrumentation.** Samples for elemental analysis were handled under an inert atmosphere or only briefly exposed to air before analysis. Thermogravimetric analysis was performed using a TA Instruments AutoTGA 2950HR instrument from 25-800 °C at 10 °C minute (60 cc gas/min flow through furnace; 40 cc gas/min flow through balance; sample size 1.5-5 mg). Samples were maintained in sealed vials under argon until just before use. Differential Scanning Calorimetry (DSC) was performed using a TA Instruments 2920 calorimeter fitted with a liquid N₂ cooling accessory. Samples were loaded at room temperature under N₂ in a dry-box into sealed pans, cooled to about -130°C at 10°C/min and

analyzed on heating (two cycles) to 150°C at a rate of 10°C/min. NMR spectra not run as part of uptake experiments were obtained in 5 mm tubes using a narrow-bore Bruker Advance III 400 MHz Ultrashield spectrometer with a high resolution 5-mm QNP probe.

[0040] Examples 1 and C1 hereof demonstrate the polymerization or oligomerization of azetidine and aziridine in situ over SBA-15 mesoporous silica in toluene at 25 °C using acetic acid as the catalytic Brønsted acid initiator. This procedure is successful for aziridine to produce a high loading of poly(aziridine) on the mesoporous silica, but produces only a low weight of poly(azetidine). Examples 2 and 3 hereof demonstrate the bulk polymerization of azetidine under similar conditions at higher temperatures. In these cases, the poly(azetidine) formed is primarily dimer or oligomer structures, rather than high molecular weight polymer.

Example 1. Synthesis of SBA-15-supported poly(azetidine) in toluene at 25 °C using acetic acid initiator.

[0041] SBA-15 mesoporous silica was prepared by mixing 100 mL of a 1.7 M aqueous HCl solution with 2.83 g Pluronic^(R) P-123 organic template. To this solution was added slowly at room temperature a 6.0 g (6.4 mL) portion of tetraethylorthosilicate. The resulting mixture was stirred for 30 minutes, heated to 40 °C for 20 hours, and aged at 90 °C without stirring for 1 day. It was cooled and the solids were collected by filtration, rinsed with deionized water and acetone, and dried at 90 °C under vacuum. A 2.0 g portion of the resultant material was dispersed in 240 mL of a 48 wt% aqueous H₂SO₄ solution, heated at 95 °C for 1 day, and cooled to room temperature. The solids were again collected by filtration and rinsed with deionized water until the filtrate showed a pH of 7. The product SBA-15 solids were then dried at 95 °C under vacuum (BET surface area 622 m²/g; pore volume 1.21 cc/g; structural confirmation by X-ray diffraction). Azetidine

(Aldrich Chemical Co., 98%) was distilled at 50 °C / 520 mm Hg into an ice water-cooled receiving flask, degassed by several freeze-pump-thaw cycles, and taken into a dry box. A 1.53 g portion (26.8 mmol) was weighed into a Schlenk flask which was capped with a rubber septum. An 0.825 g portion of SBA-15 (dried under high vacuum for 3 hours and separately taken into the dry box) was added to a 50 mL Schlenk flask containing a stirbar and slurried with 7 mL dry toluene (previously dried by distillation from sodium benzophenone ketyl). Both flasks were removed from the drybox and placed under argon on a Schlenk line. Under atmospheric conditions, 150 mg glacial acetic acid (2.5 mmol) was weighed into a third Schlenk flask, placed under argon on a Schlenk line, and degassed by several freeze-pump-thaw cycles. Dry toluene (4 mL; loaded into a dry syringe in the dry box) was added to the acetic acid. The toluene/acetic acid solution was then added to the stirred SBA-15 slurry via syringe, followed by addition of the azetidine monomer solution. The slurry was stirred overnight at room temperature. The silica particles were then collected by filtration under atmospheric conditions and re-slurried with 200 mL dry toluene. After re-filtration and rinsing with additional dry toluene, the silica particles were dried in a vacuum oven for 7 days at 50 °C and further dried on a Schlenk line under high vacuum (0.742 g of white solid; 33% of theoretical yield for 100% azetidine conversion). Elemental analysis (ash differential) indicated a 5.26 wt % content of poly(azetidine) in the material (Table 2 hereof).

[0042] Thermogravimetric analysis was performed on the sample under both air and nitrogen from room temperature to 800 °C. To calculate the weight percent of the material attributable to polymer, its TGA curves were overlaid with that for the precursor SBA-15 material (as well as those for the material prepared in Comparative Example C1 and the calcined SBA-15 used in Example 6 hereof). All of the materials showed a small initial weight loss (< 200 °C) presumably due to adsorbed ambient moisture and/or CO₂. Given that the neat SBA-15 and the

polymer-functionalized material are likely to have different surface properties and amounts of ambient adsorbate, and thus may desorb these adsorbates at different apparent rates in the TGA, care was taken to select an appropriate temperature “start” point to represent the beginning of true weight loss due to organic matter (e.g. polymer, residual template).

[0043] Figure 1 hereof shows the thermogravimetric analysis under nitrogen of calcined and uncalcined SBA-15, the poly(azetidine)/SBA-15 material, and the analogous poly(aziridine)/SBA-15 material of Comparative Example C1 hereof. As shown, a start point of 89.3 °C was selected as the start point for weight loss under N₂ (90.5 °C under air). These temperatures represent the point at which the curves began to deviate from each other and otherwise similar initial weight loss behavior. The weight loss from the start point to 800 °C was calculated for each material, normalized as if the 90.5 or 89.3 °C weight was 100%, and the difference between the SBA-15 and the polymer-functionalized material was taken as the weight % polymer. The value obtained under nitrogen (5.62 wt %, relatively consistent with elemental analysis data) was chosen as the best value to represent wt % polymer for calculational purposes (Table 2 hereof). The inconsistency for values seen with TGA under air are attributed to the high amount of residual organic template in the SBA-15.

Comparative Example C1. Synthesis of SBA-15-supported poly(aziridine) (polyethylenimine) in toluene at 25 °C using acetic acid initiator.

[0044] A procedure similar to Example 1 hereof was carried out using the following reagents: 1.3 g aziridine (ethylenimine; 3B Scientific, 99.75%; 30.2 mmol, distilled similarly to azetidine), 0.7 g SBA-15 silica, 127.3 mg (2.1 mmol), and 10 mL total dry toluene. An 0.75 g quantity (40% of theoretical yield) of a white solid was obtained. Elemental analysis (ash differential) indicated a 19.17 wt % content of poly(aziridine) in the material; thermogravimetric analysis as

described in Example 1 indicated a 17.99 wt % content (Table 2 and Figure 1 hereof).

Table 2. Characterization data for materials prepared in Example 1 and Comparative Example C1.

Elemental Analysis

Material	% C	% H	% N	Sum CHN	% Si	% Ash
SBA-15	4.04	0.86	0.57	5.47	38.84	84.16
Ex. 1 poly(azetidine)/SBA-15 ^a	9.06	1.70	1.89	12.65	35.61	78.90
“	8.86	1.88	1.88	12.62	34.88	---
Ex. C1 poly(aziridine)/SBA-15 ^a	14.96	3.53	6.22	24.71	31.77	64.95
“	4.78	3.64	6.22	24.64	34.44	65.04
Theo. for poly(azetidine)	63.11	12.36	24.53	---	---	---
Theo. for poly(aziridine)	55.78	11.70	35.52	---	---	---
Net avg. poly(azetidine), Ex. 1	4.92	0.93	1.32	7.17	---	5.26 ^b
Net avg. poly(aziridine), Ex. C1	10.83	2.73	5.65	19.21	---	19.17 ^b

^aNote in each case there is ~9-11% wt % unaccounted for when ash and total CHN are summed; this may represent oxygen from the unremoved organic template or from other sources (C and H wt% arising from the template would be included in the CHN measurement). ^bDifference in ash between SBA-15 and polymer-functionalized materials (using average ash measurement).

Thermogravimetric Analysis

Material	90.5-800 °C loss, air	89.3-800 °C loss, N ₂
SBA-15 ^a	17.78	13.64
Ex. 1 poly(azetidine)/SBA-15	19.25	19.26
Ex. C1 poly(aziridine)/SBA-15	32.42	31.63
% poly(azetidine), Ex. 1	1.47	5.62
% poly(aziridine), Ex. C1	14.64	17.99

^aThe calcined SBA-15 used in Example 6 showed a weight loss of 3.36% in air and 2.34% under nitrogen.

Summary of Important Parameters

Material	Wt. polymer in 1 gram (mg) ^a	Amine molality (mmol amine/gram)	BET surface area (m ² /gram) ^b	Pore volume (cc/gram) ^b
Ex. 1 poly(azetidine)/SBA-15	56.2	0.984	425	0.96
Ex. C1 poly(aziridine)/SBA-15	179.9	4.174	270	0.63

^aUsing TGA, N₂ data. ^bFor starting silica: surface area = 622 m²/g; pore volume = 1.21 cc/g.

Example 2. Synthesis of oligomeric bulk poly(azetidine) in toluene at 80 °C using acetic acid initiator.

[0045] Azetidine (1.035 g, 18.1 mmol; distilled as described in Example 1 hereof and stored in a freezer in the drybox between uses) was mixed with 5 mL dry toluene in a Schlenk tube in the dry-box along with a stirbar. A stirbar was added and the tube was removed from the drybox and placed under argon on a Schlenk line. Glacial acetic acid (100 mg, 1.67 mmol, was prepared and

transferred as described in Example 1 hereof) was added. The Schlenk tube was partially immersed in an 80 °C oil bath (up to the level of liquid inside) leaving a large volume of empty tube above. Tubing containing a flow of chilled water was wrapped around this empty volume of Schlenk tube a few times to create a condensing zone. After the contents of the tube had warmed to 80 °C, the tube was shut off from argon and stirred for 1 hour. Subsequently, the tube was opened to the atmosphere, cooled, and the contents were diluted with 20 mL dry toluene to assist in terminating the polymerization. The toluene was then removed under vacuum and the residual material dried further under high vacuum. A ~120 mg portion (12%) of low-viscosity liquid was obtained. ¹H NMR analysis of the material was similar to that reported for the dimer (*N*-3-aminopropyl)azetidine, plus residual acetic acid. ¹H NMR (CDCl₃, 400 MHz): δ 3.54 (tr, 4 H, J = 7.6 Hz, ring NCH₂-), 2.93 (tr, 2 H, J = 6.6 Hz, linear NCH₂-), 2.83 (tr, 2 H, J = 6.8 Hz, -CH₂NH₂), 2.22 (quintet, 2 H, J = 7.6 Hz, ring NCH₂CH₂-), 1.77 (quintet, 2 H, J = 6.7 Hz, -CH₂CH₂NH₂). ¹³C NMR (CDCl₃, 100 MHz): δ 55.28, 53.95 (~ 2 C), 38.23, 23.87, 16.67, plus peaks attributed to residual acetic acid by DEPT-135 at 177.44 and 23.37 ppm.

Example 3. Synthesis of oligomeric bulk poly(azetidine) in toluene at 100 °C using acetic acid initiator.

[0046] A procedure similar to Example 2 hereof was performed using 1.3 g (22.8 mmol) azetidine, 103 mg (1.72 mmol) acetic acid, and 5 mL dry toluene. The polymerization was carried out for 20 hours at 100 °C in a sealed Schlenk tube wrapped with chilled-water tubing. After cooling, the contents of the tube were not diluted with additional toluene; the polymer solution was transferred to a vial and the toluene was evaporated by blowing nitrogen into the vial, followed by drying the polymer residue under high vacuum at room temperature. A ~150 mg portion (12%) of light yellow, viscous liquid was obtained. The ¹H and ¹³C NMR spectra of this product were more complex than the sample made at 80 °C, but still

suggested the predominant species had an intact cyclic azetidine endgroup (indicating low molecular weight). ^1H NMR (CDCl_3 , 400 MHz): major peaks at δ 3.07 (tr, >4 H, $J = 7.1$ Hz, ring NCH_2 -), 2.71 (tr, 2 H, $J = 6.7$ Hz, linear NCH_2 -), 2.40 (tr, 2 H, $J = 7.1$ Hz, $-\text{CH}_2\text{NH}_2$), 1.93 (app tr, 2 H, $J = 6.7$ Hz, ring NCH_2CH_2 -), 1.46 (app tr, 2 H, $J = 6.7$ Hz, $-\text{CH}_2\text{CH}_2\text{NH}_2$); multiple smaller resonances. ^{13}C NMR (CDCl_3 , 100 MHz): major peaks at δ 57.49, 54.64 (~ 2 C), 39.51, 26.96, 17.15 (shoulder), 17.13; multiple smaller resonances.

Example 4. CO_2 uptake of acetic acid-initiated poly(azetidine)-functionalized mesoporous SBA-15 silica and comparative neat and poly(aziridine)-functionalized SBA-15 silicas at 0.1 and 1.0 atm CO_2 .

[0047] An Autosorb-1 (Quantachrome Instruments, Boynton Beach, FL equipped with a furnace for temperature control and supplied with Airgas research grade CO_2) was used to obtain CO_2 uptake curves for the materials prepared in Examples 1 and C1 hereof along with the starting SBA-15 silica. For each material, a portion of the designated weight was weighed into the dried sample tube in a drybox and capped with a rubber septum. The sealed tube was not opened until immediately before loading and pre-treatment under vacuum (105°C , 2 hours). Typically, a strong combined isotherm (representing both physisorption and chemisorption) was first measured as the sample was exposed to CO_2 from vacuum to 1.0 atm to obtain the volume of CO_2 adsorbed per gram of adsorbent. Typically the uptake is measured at 29 points between 0.003 and 1.0 atm. The sample was then evacuated (to remove weakly bound, i.e. physisorbed, molecules), and then re-measured ("weak isotherm") to separately quantify the re-adsorbing (physisorbing) molecules. An equilibrium time of 3 minutes was used. The tubes were backfilled with helium after completion of analysis, and were weighed quickly after removal from the Autosorb to determine weight loss. The data is summarized in Figure 2 and Table 3 hereof. Figure 2 hereof shows overlaid combined 35 - 100°C isotherms

contrasting CO₂ absorption behavior for neat SBA-15, poly(azetidine)/SBA-15, and poly(aziridine)/SBA-15 (“PEI”).

Table 3. Total Autosorb CO₂ uptake in cc CO₂ per gram of sorbent for the poly(azetidine)-functionalized mesoporous SBA-15 silica of Example 1, comparative neat SBA-15 silica, and the comparative poly(aziridine)-functionalized SBA-15 silica of Example C1.

Sample (Ex. No.) ^a	CO ₂ uptake, 35 °C	CO ₂ uptake, 85 °C	CO ₂ uptake, 100 °C
0.1 atm CO₂^b			
Neat SBA-15	5.81	5.03	4.76
Poly(azetidine)/SBA-15, 5.62 wt% polymer (Ex. 1)	1.95	0.96	0.84
Poly(aziridine)/SBA-15, 17.99 wt% polymer (Ex. C1)	15.27	8.03	5.94
1.0 atm CO₂^c			
Neat SBA-15	30.00	33.47	15.87
Poly(azetidine)/SBA-15, 5.62 wt% polymer (Ex. 1)	9.79	5.01	4.25
Poly(aziridine)/SBA-15, 17.99 wt% polymer (Ex. C1)	26.85	17.81	15.54

^aSample weights: SBA-15, 3.4 mg; poly(azetidine)/SBA-15, 36.6 mg; poly(aziridine)/SBA-15, 32.8 mg. ^bData points taken at 0.1057-0.1082 atm. ^cData point taken at end of run (1.0026-1.0013 atm).

[0048] In this example, the poly(azetidine)/SBA-15 material adsorbs CO₂ at both low partial pressures (e.g. 0.1 atm) and high partial pressures (1.0 atm), and at all three temperatures. However, the low weight per cent and low molecular weight of the polymer provides non-optimal results. The poly(azetidine), unlike the poly(aziridine), does not provide a synergistic effect to enhance the adsorption capacity of the SBA-15 at low partial pressures.

[0049] Examples 5 and 6 hereof demonstrate the synthesis of higher molecular weight poly(azetidine) in bulk and in the presence of calcined SBA-15 by cationic polymerization using a more polar solvent (methanol), a stronger Brønsted acid initiator (perchloric acid), and a higher polymerization temperature. Comparative Example C2 hereof describes the synthesis of a comparative poly(aziridine)/SBA-15 under identical conditions.

Example 5. Synthesis of bulk poly(azetidine) at 70 °C using perchloric acid initiator.

[0050] A small glass vial was charged with 65 mg (0.45 mmol) of 70% aqueous perchloric acid, which was diluted with 5 mL methanol. Separately, as-received azetidine (500 mg, 8.76 mmol, undistilled) was added to a Schlenk tube containing a stirbar. The perchloric acid solution was then added via pipet. The contents of the tube were degassed by several freeze-pump-thaw cycles (not heating above ~45 °C during thaw). The tube (under vacuum) was then placed in an oil bath at 70 °C and stirred for 1 week. The closed sidearm of the tube was maintained under a positive pressure of Ar in case of leakage into the tube. Subsequently, the methanol was removed under high vacuum at room temperature and the polymeric residue was further dried under high vacuum to give 0.538 g of a solid material. This material was dissolved in distilled water to make a 1 wt% solution which was lyophilized by freeze drying. The residue was further dried under high vacuum at room temperature overnight and then at 50 °C overnight to give 0.45 g (90%) of a hard, sticky, light orange semitransparent material.

[0051] Elemental analysis indicated the presence of chlorine, presumably residual HClO₄ either in acid form or partially as poly(azetidinium) perchlorate salts. Average values from two analyses: C, 51.69; H, 10.04; N, 19.19; Cl, 9.66 (see Table 2 hereof for theoretical values; normalizing the C and H to the found %N gives a 78.2% content of poly(azetidine)). DSC T_g: 1st heat, 12.9 °C; 2nd heat,

7.5 °C. Thermogravimetric analysis of the polymer (Figure 3) indicated minor weight loss from 135 to 200-205 °C (~9%) with onset of major decomposition occurring at 205.6 °C in air and 201.6 °C under nitrogen. ¹H NMR (D₂O, 50 °C, 400 MHz; shown in Figure 7): δ 4.69 (protio D₂O typically set to 4.81 ppm exchanging with -NH), 3.30 and 3.12 (overlapped br m and br s, minor, endgroup structures NCH₂-), 2.97 and 2.89 (each br tr, minor, ring and endgroup structures NCH₂- in 1:1 ratio), 2.71 (br, polymer -CH₂NH₂), 2.60 (br, -CH₂NH-), 2.44 (br) (4 H, polymer -CH₂N<), 1.61 (br, 2 H, polymer NCH₂CH₂-). A small amount of residual methanol was present (br s, 3.75 ppm). The polymer was stored in a dry box until use. ¹³C NMR (D₂O, 100 MHz, 24 °C, 60 second repetition delay, no calibrant; shown in Figure 7): δ 51.97, 51.14, 50.73, 50.31, 46.57, 46.12, 45.71 (-NCH₂-), 43.20 (-NCH₂-, may be associated with products from minor ambient CO₂ uptake and/or minor peaks near 164 ppm), 38.50, 38.02 (-NCH₂-), 28.27, 26.75, 25.79, 24.33, 21.76 (-NCH₂CH₂-). The ratio of primary to secondary to tertiary amines was approximately 27.6:44.8:27.6 by ¹H NMR. Assuming no cyclic structures, such that the number of primary and tertiary amines must be the same, 1/3 of the tertiary amine -CH₂N< integral may be attributed to primary amine -CH₂NH₂ groups in the combined 2.71-2.60 secondary and primary amine NCH₂CH₂-/-CH₂NH- integral.

Example 6. Synthesis of SBA-15-supported poly(azetidine) in methanol at 70 °C using perchloric acid initiator.

[0052] A small glass vial was charged with 65 mg (0.45 mmol) of 70% aqueous perchloric acid, which was diluted with 5 mL methanol. In the drybox, a Schlenk tube was loaded with a stirbar and 700 mg SBA-15 mesoporous silica (prepared similarly to the SBA-15 of Example 1 hereof but subsequently calcined at 550 °C in air for 3 hours). The tube was removed from the drybox, and as-received azetidine (300 mg, 5.25 mmol) was added under atmospheric conditions. The perchloric acid solution was then added via pipet. The contents of the tube were

degassed by several freeze-pump-thaw cycles (not heating above ~45 °C during thaw). The tube (under vacuum) was then placed in an oil bath at 70 °C and stirred for 1 week. The closed sidearm of the tube was maintained under a positive pressure of Ar in case of leakage into the tube. The contents of the tube were subsequently cooled, opened to the atmosphere, and the silica particles were collected by filtration, rinsed with additional methanol, and dried under vacuum at 50 °C overnight to give a fluffy white powder (0.8 g, 80% of theoretical yield for 100% azetidine conversion).

[0053] Elemental analysis indicated the presence of chlorine, presumably residual HClO₄ either in acid form or partially as (poly(azetidinium) perchlorate salts. The content of poly(azetidine) + residual HClO₄ by ash differential was 18.66 wt % (Table 4). The content of poly(azetidine) based on the found %N was 15.16 wt %. Thermogravimetric analysis as described in Example 1 showed a 17.34 wt % content of poly(azetidine) + residual HClO₄ (Table 4). The TGA curves for the material and the precursor calcined SBA-15 (along with the material prepared in Comparative Example C2) are shown in Figure 4 hereof. The SBA-15 was redried at 200 °C overnight under high vacuum and reanalyzed by TGA at the same time as the polymer-functionalized material to provide the best baseline for analysis. The freshly redried SBA-15 sample showed a slightly higher weight loss than upon initial analysis, likely due to an increased affinity for atmospheric water and CO₂; the start point for analysis under N₂ was increased from 89.3 to 140 °C to account for this effect.

Comparative Example C2. Synthesis of SBA-15-supported poly(aziridine) in methanol at 70 °C using perchloric acid initiator.

[0054] A procedure identical to Example 6 hereof was carried out substituting 300 mg (6.97 mmol) aziridine instead of azetidine. The aziridine was distilled as described in Comparative Example C1 hereof and loaded into the Schlenk tube

containing the SBA-15 while still in the drybox. After overnight vacuum drying, an 0.83 g quantity of a fluffy white powder was obtained (83% of theoretical yield for 100% aziridine conversion). Elemental analysis (ash differential) indicated a 21.33 wt % content of poly(aziridine) + residual HClO_4 . The content of poly(aziridine) based on the found %N was 17.89 wt %. Thermogravimetric analysis as described in Example 6 hereof indicated a 20.69 wt % content (Table 4 and Figure 4 hereof).

Table 4. Characterization data for materials prepared in Example 6 and Comparative Example C2.**Elemental Analysis**

Material	% C	% H	% N	Sum CHN	% Cl	Sum CHN+ Cl^a	% Si	% Ash
SBA-15	0.17	0.31	<0.05	0.48	---	---	41.51	93.50
Ex. 6 poly(azetidine)/SBA-15	11.28	2.49	3.67	17.44	1.24	18.69	31.49	74.84
“	11.21	2.46	3.77	17.44	1.26	18.69	31.13	---
Ex. C2 poly-(aziridine)/SBA-15	11.31	2.87	5.75	19.93	0.61	20.54	31.05	72.17
“	11.33	2.70	5.88	19.91	0.60	20.52	29.97	---
Theo. for poly(azetidine)	63.11	12.36	24.53	100	0	100	---	---
Theo. for poly(aziridine)	55.78	11.70	32.52	100	0	100	---	---
Net avg. Ex. 6 poly(azetidine)	11.25	2.48	3.72	17.44	1.25	18.69	31.31	18.66
Net avg. from %N, ^b Ex. 6 poly(azetidine)	9.57	1.87	3.72	15.16	---	---	---	---
Net avg. Ex. C2 poly(aziridine)	11.32	2.79	5.82	19.92	0.61	20.53	30.51	21.33
Net avg. from %N, ^b Ex. C2 poly(aziridine)	9.98	2.09	5.82	17.89	---	---	---	---

^aTaking average % Cl for sum. ^bBecause the unfunctionalized SBA-15 has 0% N, the CHN attributable specifically to the polyamine may be calculated from the found %N value.

Thermogravimetric Analysis

Material	90.5-800 °C loss, air	140-800 °C loss, N₂
SBA-15 (initial analysis ^a)	3.36	2.20 ^b
SBA-15 (redried)	4.03	3.34
Ex. 6 poly(azetidine)SBA-15	21.83	20.69
Ex. C2 poly(aziridine)/SBA-15	26.32	24.23
% poly(azetidine), Ex. 6	17.80	17.34
% poly(aziridine), Ex. C2	22.29	20.69

^aAnalyzed in the same data set as Table 2. ^bWt loss from 89.3-800 °C = 2.34 %.

Summary of Important Parameters

Material	Wt. polymer in 1 gram (mg)^a	Amine molality (mmol amine/gram)	BET surface area (m²/gram)^b	Pore volume (cc/gram)^b
Ex. 6 poly(azetidine)SBA-15	151.6	2.653	346	0.75
Ex. C2 poly(aziridine)/SBA-15	178.9	4.150	218	0.48

^aUsing elemental analysis data calculated from found %N. ^bNot taken for starting silica.

Example 7. CO₂ uptake of perchloric acid-initiated poly(azetidine)-functionalized mesoporous SBA-15 silica and comparative neat and poly(aziridine)-functionalized SBA-15 silicas at 0.02, 0.04, 0.1, and 1.0 atm CO₂.

[0055] CO₂ uptake of the materials prepared in Examples 6 and C2 hereof was studied, along with the starting SBA-15 silica, using a similar Autosorb procedure as described in Example 4 hereof with an additional set of isotherms collected at 55 °C. The data is summarized in Figures 5a, 5b, and 6 as well as Table 5 hereof. Figures 5a and 5b herein show overlaid combined 35-100 °C isotherms contrasting CO₂ absorption behavior for neat SBA-15, poly(azetidine)/SBA-15, and poly(aziridine)/SBA-15 ("PEI"). Both the poly(azetidine)/SBA-15 and

poly(aziridine)/SBA-15 materials show enhanced CO₂ adsorption over the unfunctionalized SBA-15 at lower partial pressures (up to ca. 0.1 atm, see Figure 6), an important feature given that flue and natural gas streams typically contain only low to moderate amounts of CO₂.

Table 5. Total Autosorb CO₂ uptake in cc CO₂ per gram of sorbent for the poly(azetidine)-functionalized mesoporous SBA-15 silica of Example 6, comparative neat SBA-15 silica, and the comparative poly(aziridine)-functionalized SBA-15 silica of Example C2.

Sample (Ex. No.) ^a	CO ₂ uptake, 35 °C	CO ₂ uptake, 55 °C	CO ₂ uptake, 85 °C	CO ₂ uptake, 100 °C
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0.02 atm CO₂^b

Neat SBA-15	4.16	4.55	3.86	3.86
Poly(azetidine)/SBA-15, 15.16 wt% pol. (Ex. 6)	4.98	3.69	1.96	1.58
Poly(aziridine)/SBA-15, 17.89 wt% pol. (Ex. C2)	6.40	5.35	2.35	1.56

0.05 atm CO₂^c

Neat SBA-15	6.04	6.51	5.07	5.06
Poly(azetidine)/SBA-15, 15.16 wt% pol. (Ex. 6)	6.83	5.46	3.19	2.45
Poly(aziridine)/SBA-15, 17.89 wt% pol. (Ex. C2)	9.10	8.12	4.17	2.76

0.1 atm CO₂^d

Neat SBA-15	8.68	8.57	6.81	6.27
Poly(azetidine)/SBA-15, 15.16 wt% pol. (Ex. 6)	8.62	7.05	4.36	3.31
Poly(aziridine)/SBA-15, 17.89 wt% pol. (Ex. C2)	11.25	10.34	6.04	4.12

1.0 atm CO₂^e

Neat SBA-15	40.95	35.23	28.11	23.48
Poly(azetidine)/SBA-15, 15.16 wt% pol. (Ex. 6)	21.41	18.70	14.01	11.12
Poly(aziridine)/SBA-15, 17.89 wt% pol. (Ex. C2)	24.50	22.79	17.20	13.56

^aSample weights: SBA-15, 5.2 mg; poly(azetidine)/SBA-15, 20.6 mg; poly(aziridine)/SBA-15, 34.2 mgs. ^bData points taken at 0.0184-0.0193 atm. ^cData points taken at 0.0525-0.0531 atm. ^dData points taken at 0.1049-0.1080 atm. ^eData point taken at end of run (1.0005-1.0027 atm).

Example 8. Calculation of efficiency of amine CO₂ uptake by poly(azetidine)/SBA-15 and poly(aziridine)/SBA-15 materials at 0.02, 0.05, 0.1, and 1.0 atm CO₂.

[0056] For each temperature and pressure point, the total CO₂ uptake in millimoles per gram of sorbent of the polyamine-functionalized SBA-15 materials was divided by its amine molality (mmol amine per gram) given in Table 4 hereof. The resultant absorption efficiencies are given in Table 6 below. These show that the poly(azetidine) is more efficient than the poly(aziridine) on a molar basis for the adsorption of CO₂ at all temperatures and partial pressures.

Table 6. Amine efficiency at various pressures of CO₂ absorption for the poly(azetidine)- and poly(aziridine)-functionalized mesoporous SBA-15 silicas of Examples 6 and C2 (units = mmol CO₂/mmol amine).

Sample (Ex. No.)	35 °C	55 °C	85 °C	100 °C
0.02 atm CO₂				
Poly(azetidine)/SBA-15 (Ex. 6)	0.084	0.062	0.033	0.027
Poly(aziridine)/SBA-15 (Ex. C2)	0.069	0.058	0.025	0.017
0.05 atm CO₂				
Poly(azetidine)/SBA-15 (Ex. 6)	0.115	0.092	0.054	0.041
Poly(aziridine)/SBA-15 (Ex. C2)	0.098	0.087	0.045	0.030
0.1 atm CO₂				
Poly(azetidine)/SBA-15 (Ex. 6)	0.145	0.119	0.073	0.056
Poly(aziridine)/SBA-15 (Ex. C2)	0.121	0.111	0.065	0.044
1.0 atm CO₂				
Poly(azetidine)/SBA-15 (Ex. 6)	0.360	0.315	0.236	0.187
Poly(aziridine)/SBA-15 (Ex. C2)	0.264	0.245	0.185	0.146

[0057] Figure 7 hereof shows ^{13}C NMR spectra for the aqueous poly(azetidine) solution of Example 9 before (top, 24 °C) and after (bottom, 30 °C) treatment with 1 atm CO_2 for ca. 10 hours.

[0058] Figure 8 hereof shows ^{13}C NMR spectra for the aqueous poly(aziridine) (“PEI”) solution of Comparative Example C3 before (top, 24 °C) and after (bottom, 24 °C) treatment with 1 atm CO_2 for 7 hours.

[0059] Example 9 hereof demonstrates the use of poly(azetidine) as an efficient CO_2 sorbent when used in the aqueous phase. Comparative Example C3 presents a comparative adsorption experiment using a commercial poly(aziridine). Similarly to the results seen in the dry, solid-state absorption experiments of Example 7, the poly(azetidine) is a more efficient sorbent on a molar amine basis than the poly(aziridine). The poly(azetidine) also produces a different balance of ammonium carbamate and ammonium (bi)carbonate products. The enhanced proportion of (bi)carbonate species formed with the poly(azetidine) may provide advantages for low-temperature-swing adsorption, since (bi)carbonates are less thermally stable than carbamates and may require lower desorption temperatures.

Example 9. Liquid phase CO_2 adsorption using an aqueous solution of poly(azetidine).

[0060] A 128.4 mg portion of the poly(azetidine) prepared in Example 5 was dissolved in D_2O in an 8-inch 10 mm NMR tube to make a 2.69 wt% solution. The solution was exposed to a CO_2 purge (1 atm, 10 cc/min, measured by a Brooks 5896 flow controller) via a plastic capillary dip tube at 30 °C inside a 10 mm wide-bore Bruker Advance 400 MHz NMR spectrometer with a BBO probe. The ^1H and ^{13}C NMR spectra were monitored until no further CO_2 uptake was observed; the ^{13}C spectrum after ca. 10 hours (as shown in Figure 7 hereof before and after adsorption) indicated formation of both ammonium carbamate and ammonium

(bi)carbonate products, as well as the presence of physisorbed CO₂ in solution (physisorbed CO₂ is not seen in control experiments with neat D₂O). Integrating the three carbonyl peaks versus the total aliphatic (polymer) integral (mmol CO₂ per mmol amine) gave molar loadings of 11.2% carbamate, 38.6% (bi)carbonate, and 7.2% physisorbed CO₂ (overall 57.0 mol% loading; 43.9 wt% loading of polymer weight; 30.5 wt % loading of combined polymer + CO₂ weight). The ¹H NMR showed two broad peak clusters with major peaks at 3.39, 3.17 (major), 2.87, 2.75 (4 H, NCH₂-) and 2.15, 1.97 (major) (2 H, NCH₂CH₂-). ¹³C NMR (30 °C, 100 MHz, no calibrant, 60 second repetition delay): δ 181.28 (minor, unassigned), 164.21 (br, carbamate C=O), 160.17 (bicarbonate and/or carbonate C=O in fast equilibrium), 124.62 (physisorbed CO₂ C=O, 50.31, 49.67, 45.69, 44.53 (-NCH₂-), 42.03 (-NCH₂-, may be associated with CO₂ products), 37.60, 36.45, 35.42 (-NCH₂-), 23.81, 22.84, 22.14, 20.60 (-NCH₂CH₂-).

Comparative Example C3. Liquid phase CO₂ adsorption using an aqueous solution of poly(aziridine).

[0061] A procedure similar to that carried out in Example 9 was performed using a 2.69 wt% D₂O solution of commercial poly(aziridine) (Aldrich Chemical Co. polyethyleneimine 40,872-7, nominal *M_n* ~10,000). ¹³C NMR of the starting poly(aziridine) (24 °C, D₂O, 400 MHz, no calibrant, shown in Figure 8 along with ¹H NMR; 25 wt% sample prepared and measured at 24 °C in a 5 mm NMR tube as described in Example 5): δ 56.11 (tertiary amine NCH₂- next to primary amine), 53.11 (tertiary amine NCH₂- next to secondary amine), 51.00 (tertiary amine NCH₂- next to tertiary amine), 50.78 (secondary amine NHCH₂- next to primary amine, overlapped with previous peak; the amount of integral assumed to derive from the secondary amine peak in the total was set equal to that of the related peak at 39.86), 47.65 (secondary amine NHCH₂- next to secondary amine), 45.54 (secondary amine NHCH₂- next to tertiary amine), 39.86 (primary amine H₂NCH₂- next to secondary amine), 37.78 (primary amine H₂NCH₂- next to tertiary amine).

The ratio of primary:secondary:tertiary amines was 30.4:39.9:29.7. After a 7 hour period of CO₂ bubbling, the ¹³C NMR spectrum (as shown in Figure 8 hereof, acquired similarly to that in Example 9) indicated formation of the same kinds of products seen in Example 9 hereof with molar loadings of 24.7% carbamate, 23.4% (bi)carbonate, and 4.2% physisorbed CO₂ were obtained (overall 53.2 mol% loading, 54.5 wt% loading of polymer weight, 29.1 wt% of combined polymer + CO₂ weight). ¹³C NMR (30 °C, 100 MHz, 60 second repetition delay, no calibrant): δ 164.14 (br, carbamate C=O, 12.3% of polymer integral), 160.24 (bicarbonate and/or carbonate C=O in fast equilibrium, 11.7% of polymer integral), 124.67 (physisorbed CO₂ C=O, 2.1% of polymer integral), 50.06, 44.62, 38.81, 37.64, 36.61, 35.43 (polymer -NCH₂-).

CLAIMS:

1. A functionalized adsorbent material for adsorbing CO₂ from CO₂-containing gaseous streams, which adsorbent material comprises a mesoporous silica having at least a portion of its pores functionalized with in-situ polymerized cyclic amine in which the density of amine sites of the in-situ polymerized cyclic amine is below 20.0 mmol amine/gram.
2. The functionalized adsorbent material of claim 1 wherein the density of amine sites of the in-situ polymerized cyclic amine is from about 16.5 to about 19.0 mmol amine/gram.
3. The functionalized adsorbent material of claim 1 wherein the cyclic amine of the in-situ polymerized cyclic amine is azetidine and the resulting in-situ polymerized cyclic amine is poly(azetidine).
4. The functionalized adsorbent material of claim 1 wherein the in-situ polymerized cyclic amine has a branched structure and contains primary, secondary, and tertiary amine sites.
5. The functionalized adsorbent material of claim 4 wherein the ratios of primary:secondary:tertiary amines in the in-situ polymerized cyclic amine ranges from between about 2:96:2 to about 46:8:46.
6. The functionalized adsorbent material of claim 1 wherein the functionalized adsorbent material has a BET surface area from about 100 m²/g to about 1500 m²/g, and a pore volume from about 0.3 cc/g to about 1.8 cc/g.
7. The functionalized adsorbent material of claim 1 further comprising one or more additional components selected from the group consisting of

amorphous silica binder, aluminum oxide binder, residual polymerization solvent, and residual polymerization initiator.

8. A method of preparing a functionalized adsorbent material comprised of a cyclic amine polymer for removing CO₂ from CO₂-containing gaseous streams, which method comprises:

- forming a mixture comprised of a cyclic amine, a Brønsted acid initiator in a solvent, and a mesoporous silica;
 - forming the cyclic amine polymer in the presence of the mesoporous silica; and
 - retrieving the resultant functionalized adsorbent material from the mixture as a solid;
- wherein the resulting cyclic amine polymer has an amine density of below about 20.0 mmol amine/gram.

9. The method of claim 8 wherein the cyclic amine polymer has a density of amine sites from about 16.5 to about 19.0 mmol amine/gram.

10. The method of claim 8 wherein the cyclic amine is azetidine and the cyclic amine polymer is poly(azetidine).

11. The method of claim 8 wherein the Brønsted acid initiator is selected from the group consisting of acetic acid and perchloric acid.

12. The method of claim 8 wherein the molar ratio of cyclic amine to Brønsted acid initiator is from about 8:1 to about 30:1.

13. The method of claim 8 wherein the mixture is at a temperature of from about 20 °C to about 120 °C.

14. The method of claim 8 wherein the solvent is selected from the group consisting of toluene and methanol.

15. The method of claim 8 wherein the resultant functionalized adsorbent material has a BET surface area from about 100 m²/g to about 1500 m²/g, and a pore volume from about 0.3 cc/g to about 1.8 cc/g.

16. A method for removing CO₂ from a CO₂-containing gaseous stream, which method comprises contacting said stream with an effective amount of a functionalized adsorbent material comprising a mesoporous silica material having at least a portion of its pores functionalized with in-situ polymerized cyclic amine in which the density of amine sites of the in-situ polymerized cyclic amine is below 20.0 mmol amine/gram.

17. The method of claim 16 wherein the in-situ polymerized cyclic amine is poly(azetidine).

18. The method of claim 17 wherein the in-situ polymerized cyclic amine has a branched structure and contains primary, secondary, and tertiary amine sites.

19. The method of claim 18 wherein the ratios of primary:secondary:tertiary amines in the in-situ polymerized cyclic amine ranges from between about 2:96:2 to about 46:8:46.

20. The method of claim 16 wherein the functionalized adsorbent material has a BET surface area from about 100 m²/g to about 1500 m²/g, and a pore volume from about 0.3 cc/g to about 1.8 cc/g.

21. The method of claim 17 wherein the functionalized adsorbent material further comprises one or more additional components selected from the group consisting of amorphous silica binder, aluminum oxide binder, residual polymerization solvent, and residual polymerization initiator.

22. A method for removing CO₂ from a CO₂-containing gaseous stream, which method comprises contacting said gaseous stream with an effective amount of a liquid phase sorbent comprising an aqueous solution of a polymerized cyclic amine in which the density of amine sites of the polymerized cyclic amine is below about 20.0 mmol amine/gram.

23. The method of claim 22 wherein the polymerized cyclic amine is poly(azetidine).

24. The method of claim 23 wherein the poly(azetidine) has a branched structure and contains primary, secondary, and tertiary amine sites.

25. The method of claim 24 wherein the ratios of primary:secondary:tertiary amines in the polymerized cyclic amine ranges from between about 2:96:2 to about 46:8:46.

26. The method of claim 25 wherein the polymerized cyclic amine comprises from about 1% to about 30% of the total weight of the liquid phase sorbent.

27. The method of claim 26 wherein the contacting is performed at a temperature from about 15 °C to about 120 °C.

28. The method of claim 27 wherein the liquid phase sorbent is comprised of water; the chemisorption products comprise a mixture of carbamate, bicarbonate, and carbonate species; and the chemisorption products maintain solubility in water.

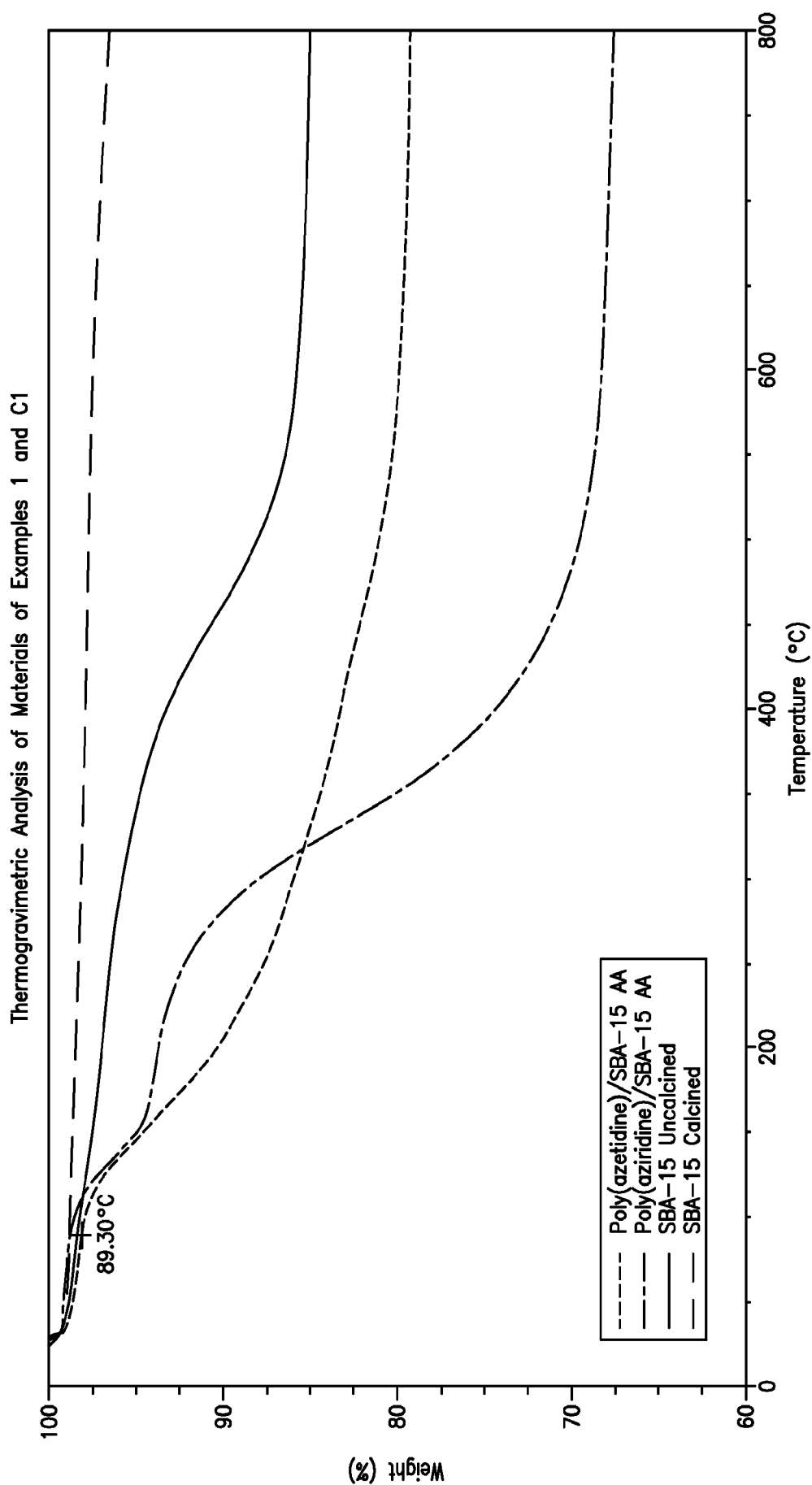
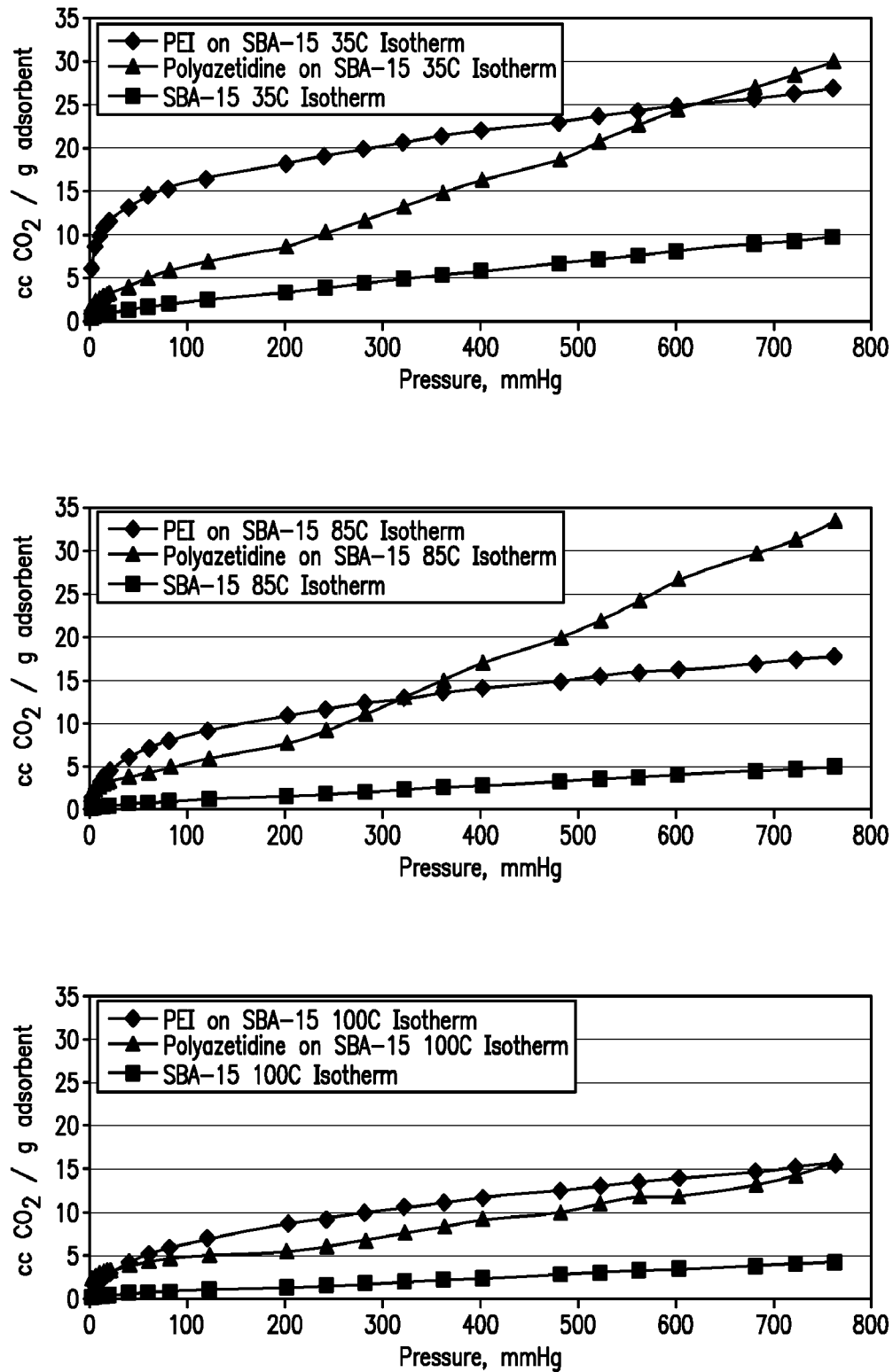
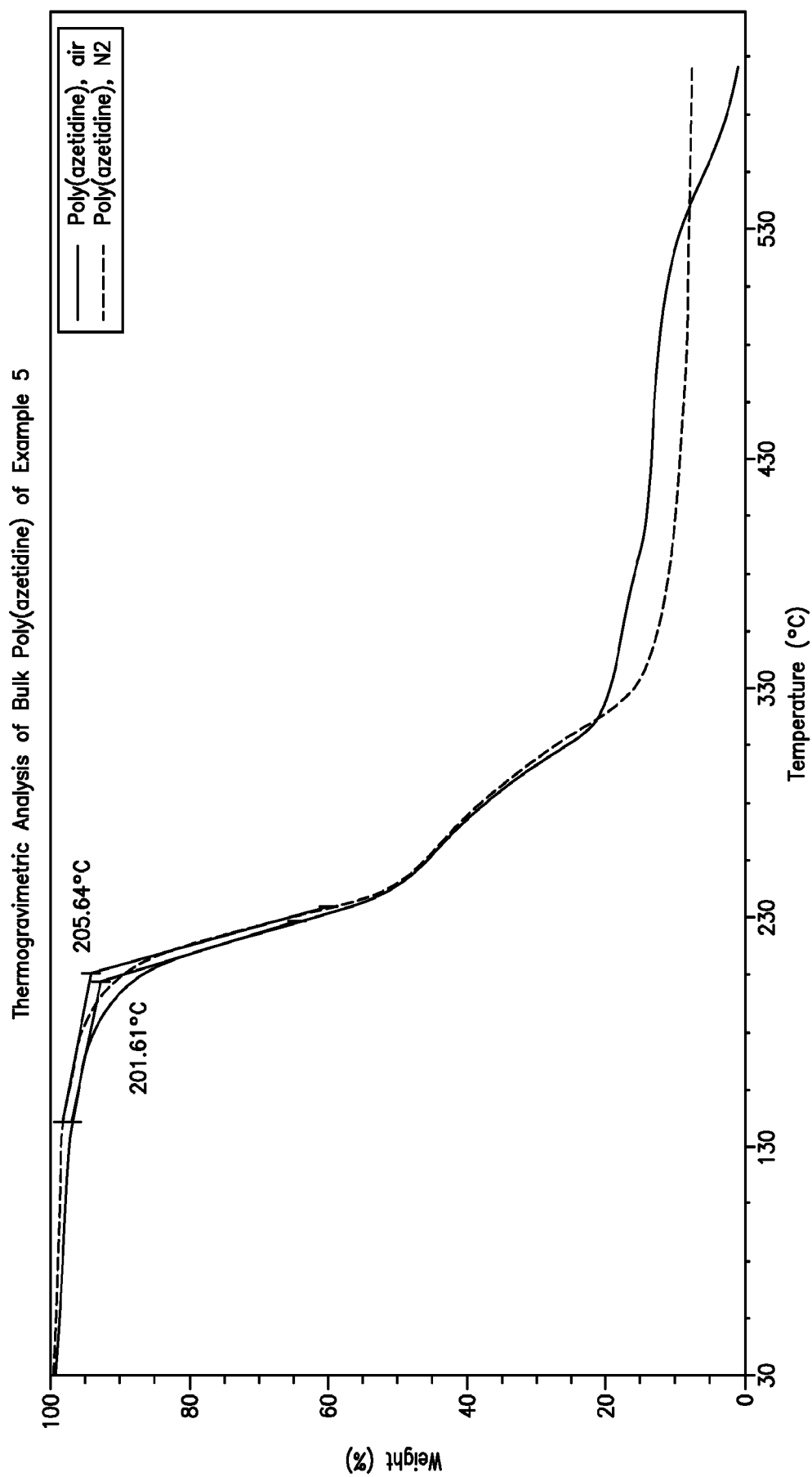


FIG. 1

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35 °C, 85 °C, and 100 °C CO₂ Isotherms for Materials of Examples 1 and C1**FIG. 2**

**FIG. 3**

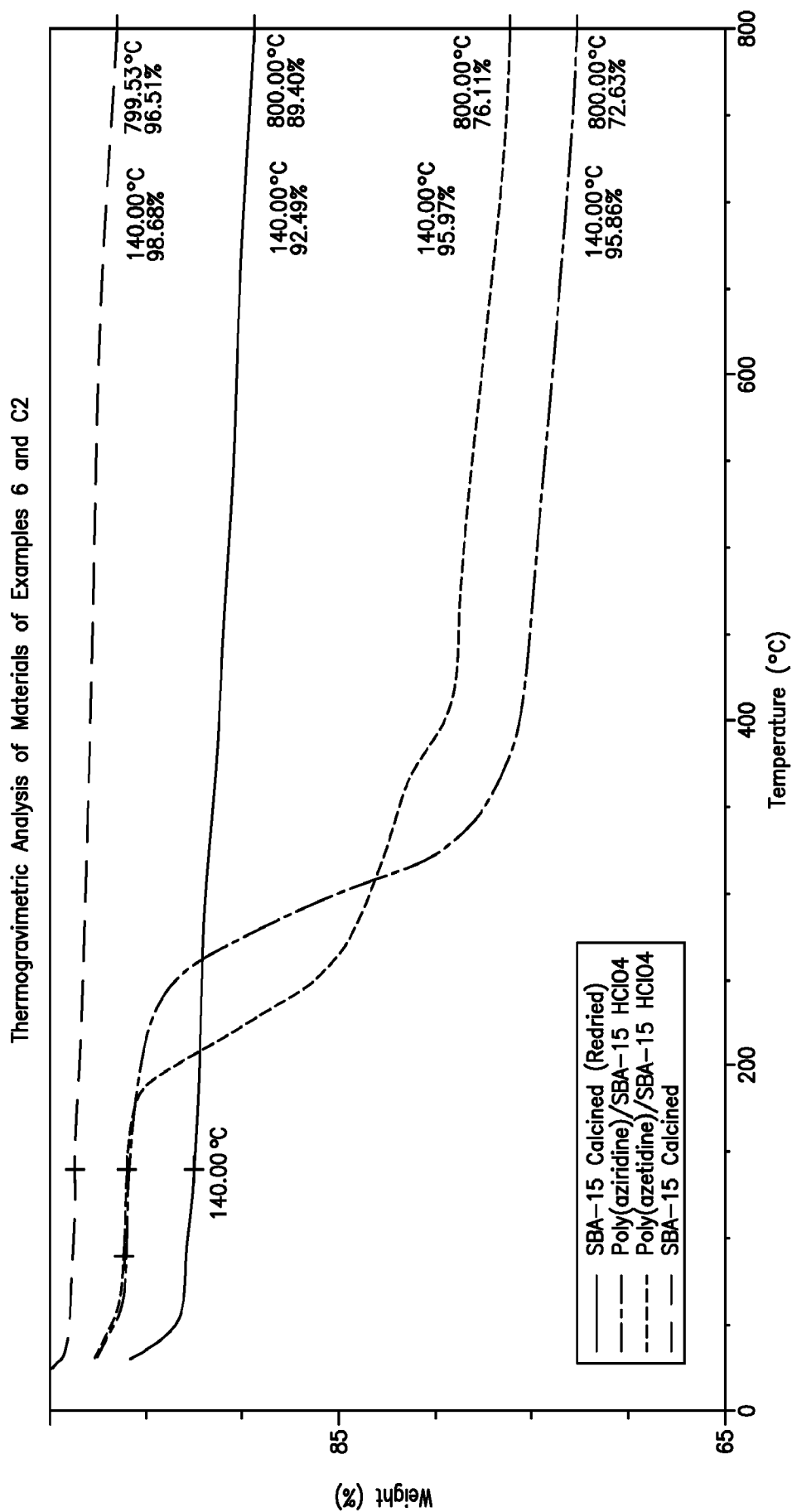


FIG. 4

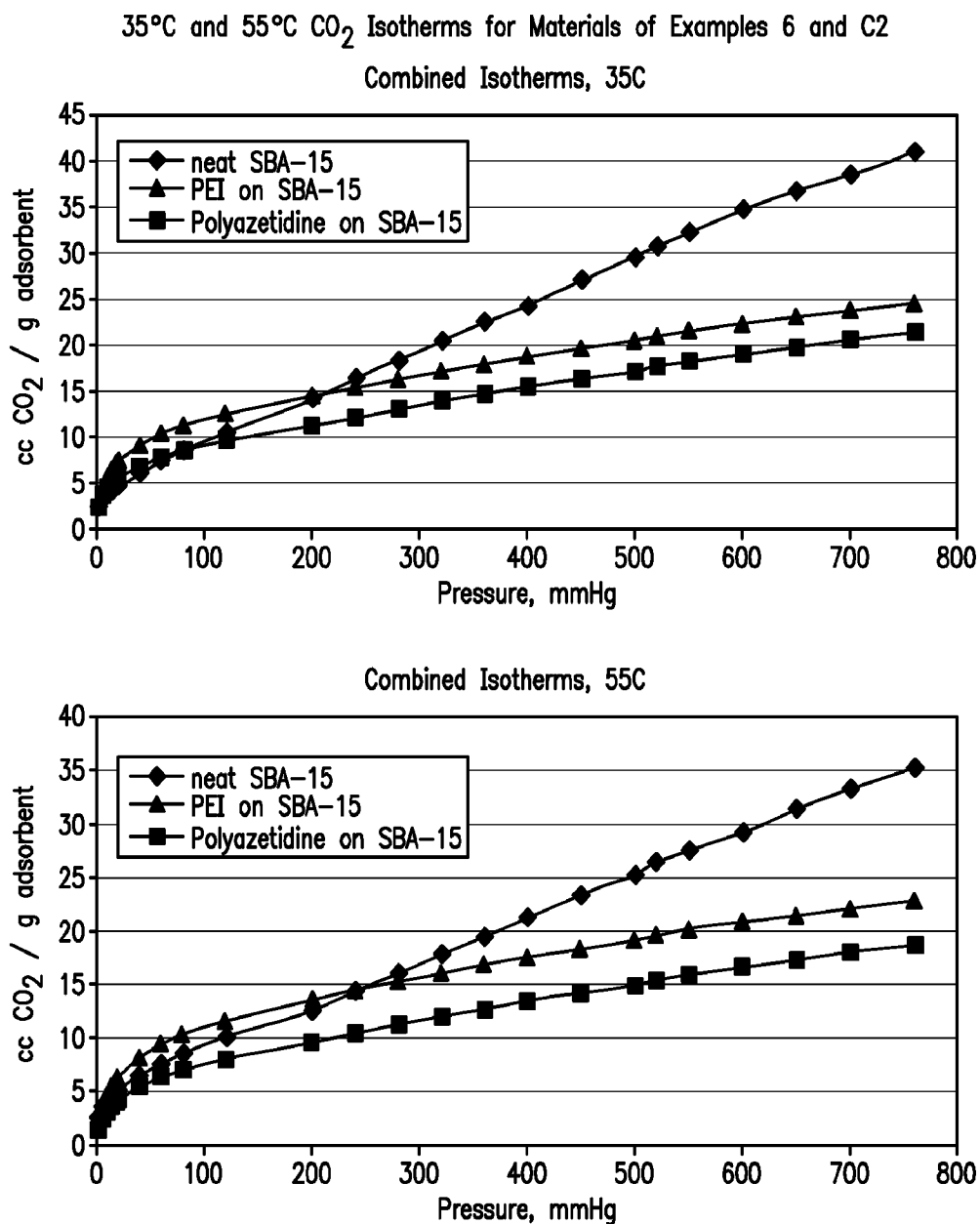
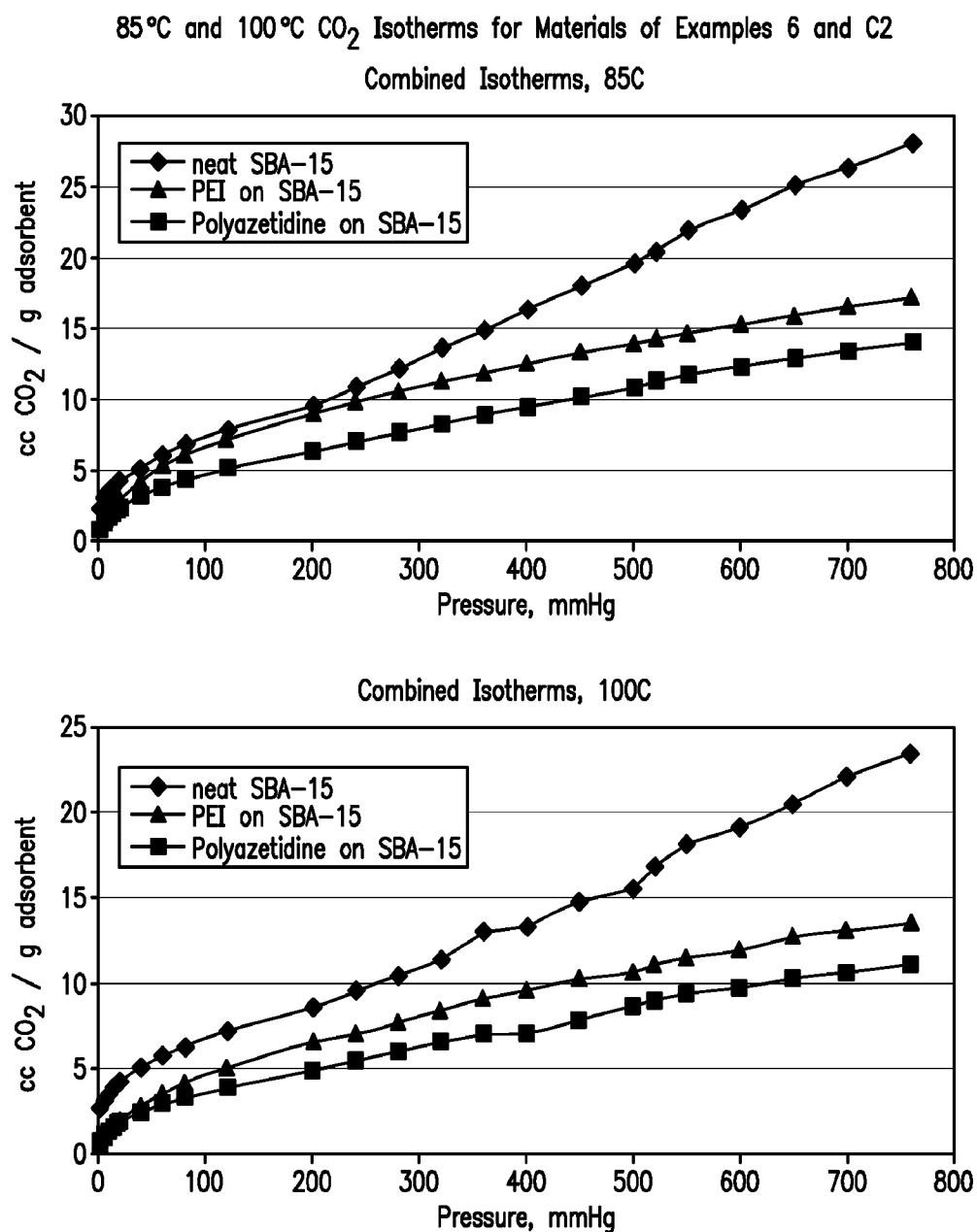


FIG. 5a

**FIG. 5b**

Expansion View of the 1 to 100 mm Hg portion
of the 35°C CO₂ Isotherm shown in Figure 5a

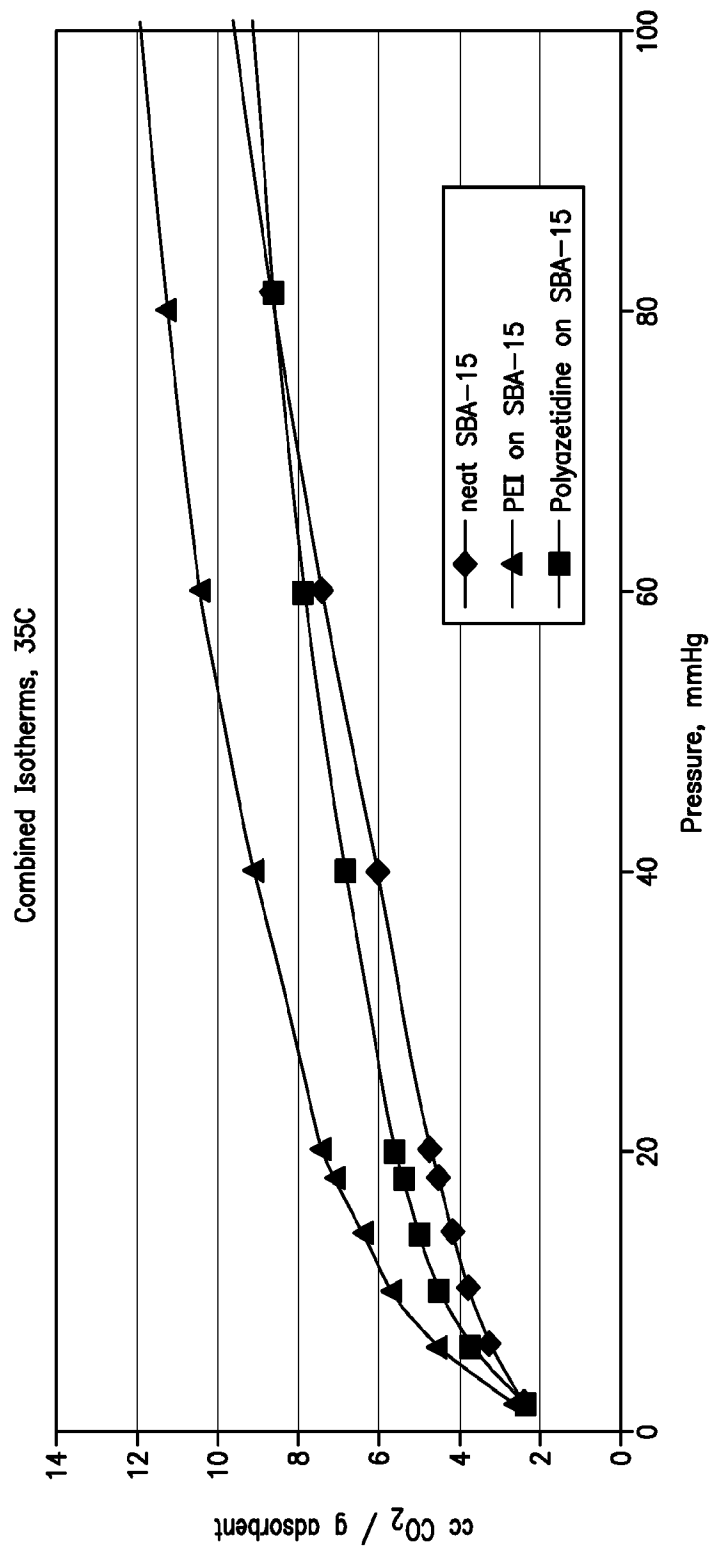


FIG. 6

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^{13}C NMR for the Aqueous Poly(azetidine) Solution of Example 9 (and 5)
before (Fig. 7a, 24°C) and after (Fig. 7b, 30°C) Treatment with CO_2

Bruker Avance III, 5-mm QNP probe

Sample: 2.69 wt% poly (azetidine) in D_2O / as received

^{13}C , DC, T = +24C

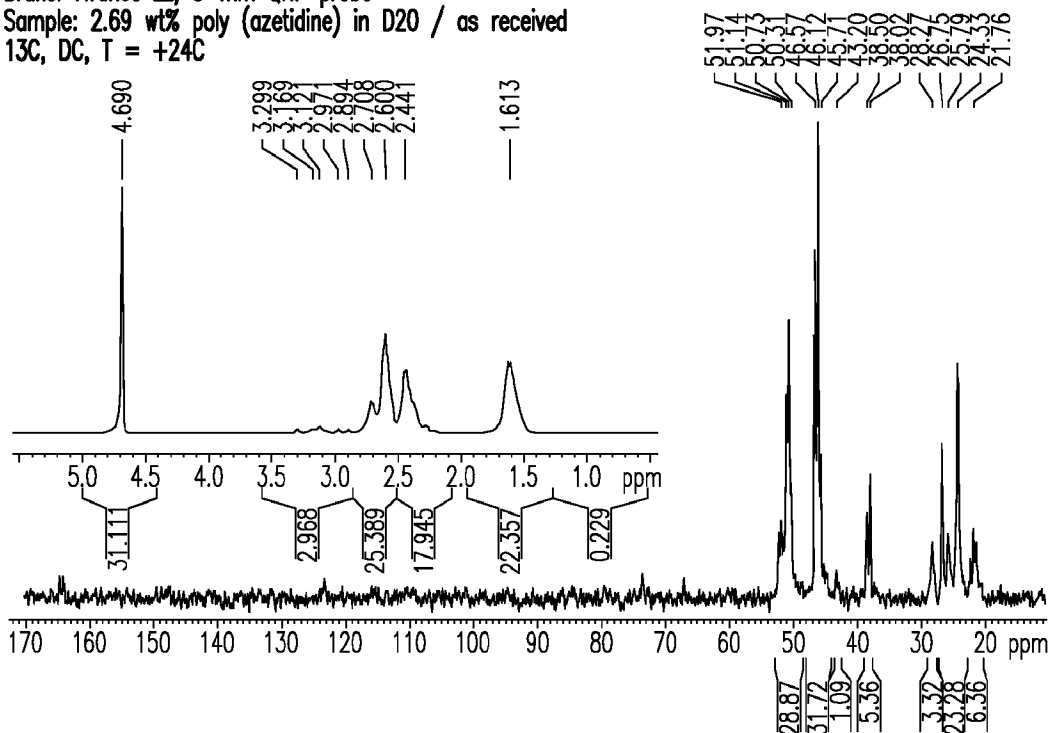


FIG. 7a

Bruker Avance VSP400 BBO,

r.f.: 10-mm 2H, 1H, BB

Sample: 2.69 wt% poly (azetidine) in D_2O / after CO_2 flow

^{13}C , DC, T = +30C

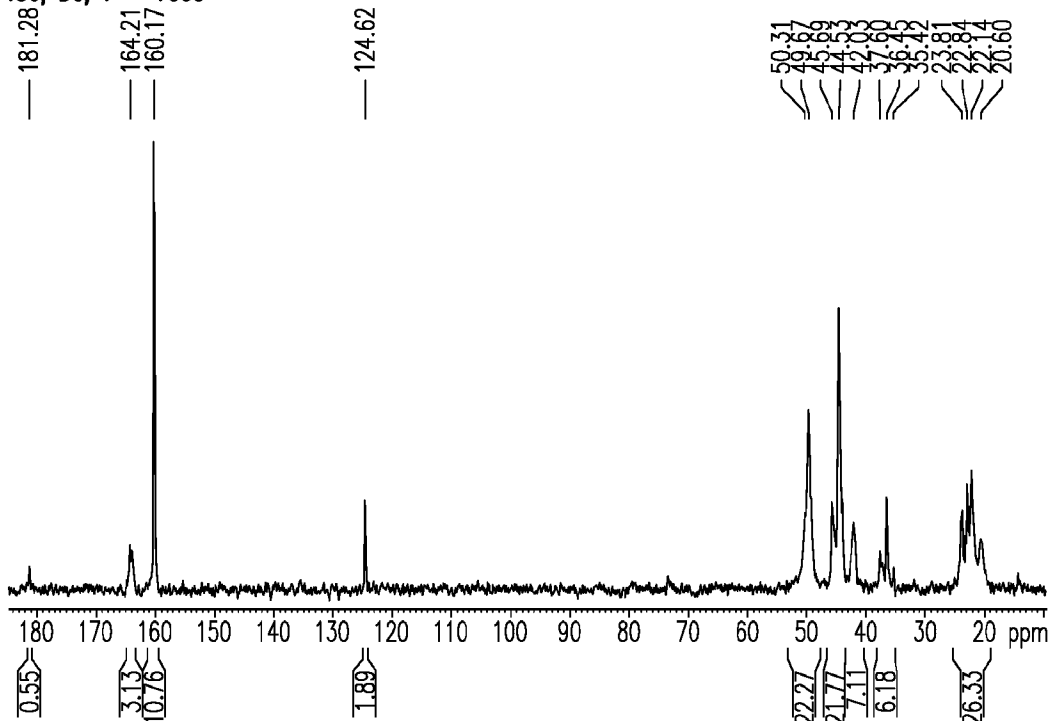


FIG. 7b

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^{13}C NMR for the Aqueous Poly(aziridine) ("PEI") Solution of Example C3
before (Fig. 8a, 24°C) and after (Fig. 8b, 24°C) Treatment with CO_2

Bruker Avance VSP400 BBO,

r.f.: 10-mm 2H, 1H, BB

Sample: 2.7 wt% PEI Mw 10.000 in D₂O / after CO₂ flow

^{13}C , DC, T = +24C

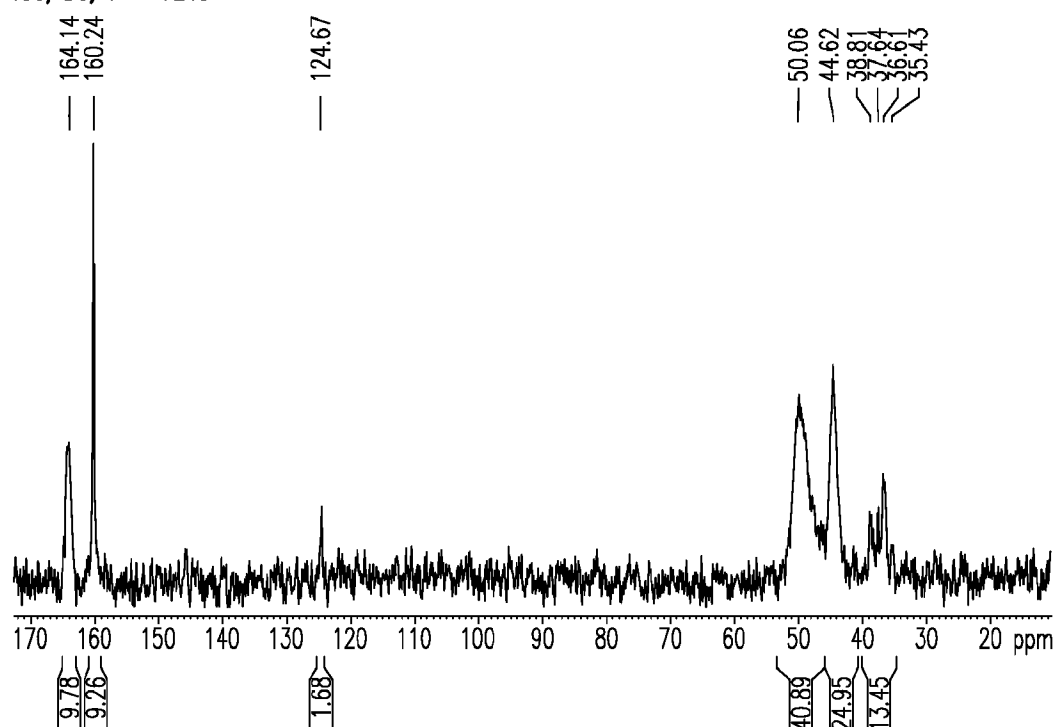


FIG. 8a

Bruker Avance III, 5-mm QNP probe

Sample: 25 wt% PEI Mw 10,000 in D₂O / as received

^{13}C , DC, T = +24C

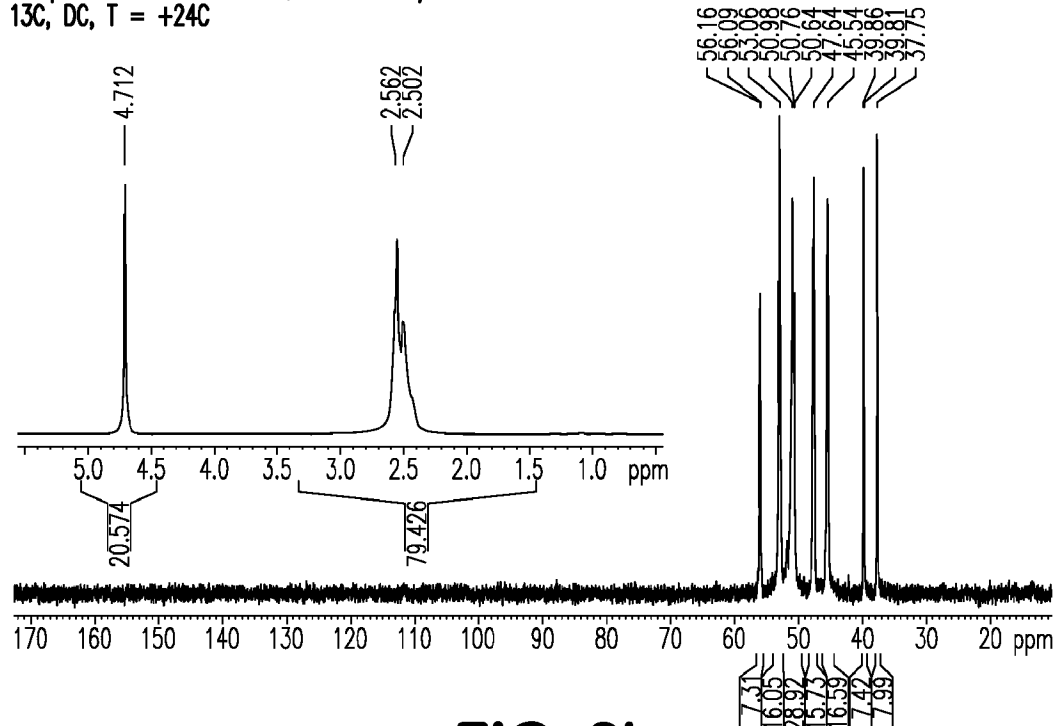


FIG. 8b

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 10/61446

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - B01D 53/02 (2010.01)

USPC - 95/139

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)

IPC(8) - B01D 53/02 (2010.01)

USPC - 95/139

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
Patents, Non-Patent Literature; USPC - 96/153; 423/228 - search term limitedElectronic data base consulted during the international search (name of data base and, where practicable, search terms used)
USPTO - PubWEST; Google; Google Scholar - search terms on extra sheet

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2007/0022877 A1 (Marand et al.) 1 February 2007 (01.02.2007)	1, 2, 4-6, 8, 9, 13-16, 20
---	Abstract; fig 6, 7, 11; para [0015], [0065]-[0069], [0100], [0107], [0153]	-----
Y		3, 7, 10-12, 17-19, 21-28
Y	US 2005/0084474 A1 (Wu et al.) 21 April 2005 (21.04.2005)	3, 10, 17-19, 21, 23-28
	para [0016]-[0018]	
Y	US 3,862,030 A (Goldberg) 21 January 1975 (21.01.1975)	7, 21
	col 3 ln 5-21	
Y	US 6,074,541 A (Srinivasan et al.) 13 June 2000 (13.06.2000)	11
	col 6 ln 48-61; col 7 ln 61 to col 8 ln 13; col 11 ln 58 to col 12 ln 32	
Y	US 2009/0308248 A1 (Siskin et al.) 17 December 2009 (17.12.2009)	22-28
	para [0004]	
Y	US 4,764,572 A (Bean) 16 August 1988 (16.08.1988)	12
	col 6 ln 5-11	
A	US 4,810,266 A (Zinnen et al.) 7 March 1989 (07.03.1989)	1-28
A	US 4,121,946 A (Chuiko et al.) 24 October 1978 (24.10.1978)	1-28



Further documents are listed in the continuation of Box C.



* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

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"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

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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

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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

11 February 2011 (11.02.2011)

Date of mailing of the international search report

16 MAR 2011

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PCT OSP: 571-272-7774

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 10/61446

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5,087,597 A (Leal et al.) 11 February 1992 (11.02.1992)	1-28
A	Pechar et al. "Preparation and characterization of a glassy fluorinated polyimide zeolite-mixed matrix membrane". Desalination 146 (2002) 3-9. Presented at the International Congress on Membranes and Membrane Processes, Toulouse, France. 7 July 2002 (07.02.2002) [downloaded from internet: http://www.desline.com/articoli/4488.pdf on 11 February 2011]	1-28

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 10/61446

Box B continued

search terms

"1,3-propylenimine", "al.sub.2o.sub.3", "co.sub.2", "poly(1,3-propylenimine)", absorb, acetic, acid, adsorb, adsorp\$, al2o3, aluminium, aminat\$, amine, amino, amorphous, anneal, aqueous, area, azacyclobutane, azetidine, bicarbonate, binder, bubbl\$, captur\$, carbamate, carbon, carbonate, co2, complex, crystalline, cyclic, dioxide, dried, dry, drying, exhaust, filter, flue, gas, heterocyclic, imine, initiator, molecular, neutraliz\$, noncrystalline, oxide, perchloric, polyamine, polyamino, polyazacyclobutane, polyazetidine, polymer, polymeric, polymeriz\$, polytrimethylene, polyvinyl, polyvinylpyrrolidone, pvp, pyrimidine, pyrolidine, pyrrolidone, remov\$, scrub, sequeste\$, sieve, silica, silicon, solvent, sparg\$, spray, surface, temperature, trimethylene, wash, water, zeolite