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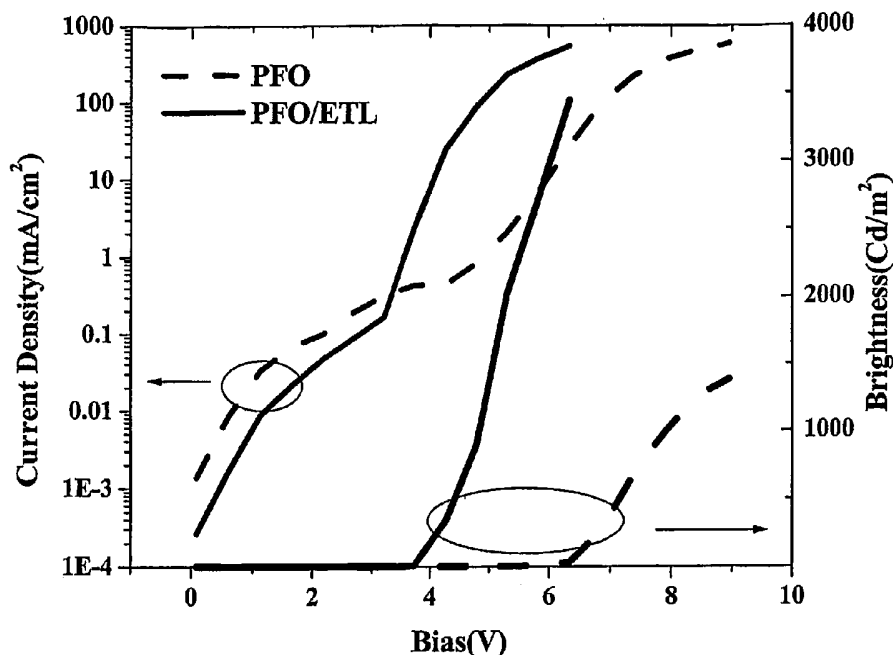
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(54) Title: METHODS AND DEVICES UTILIZING SOLUBLE CONJUGATED POLYMERS



(57) Abstract: Methods, compositions and articles of manufacture involving soluble conjugated polymers are provided. The conjugated polymers have a sufficient density of polar substituents to render them soluble in a polar medium, for example water and/or methanol. The conjugated polymers may desirably comprise monomers which alter their conductivity properties. The different solubility properties of these polymers allow their deposition in solution in multilayer formats with other conjugated polymers. Also provided are articles of manufacture comprising multiple layers of conjugated polymers having differing solubility characteristics. Embodiments of the invention are described further herein.



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METHODS AND DEVICES UTILIZING SOLUBLE CONJUGATED POLYMERS

5 CROSS REFERENCE TO RELATED APPLICATIONS

This application claims the benefit of U.S. Provisional Applications Nos. 60/607,335, filed Sept. 3, 2004 and 60/657,836, filed Mar. 1, 2005.

10 TECHNICAL FIELD

This invention relates to articles comprising one or more layers comprising a soluble conjugated polymer and methods of making them.

BACKGROUND OF THE INVENTION

15 Polymeric semiconductors have been incorporated into a wide array of electronic, optical and optoelectronic materials and devices. One limitation on manufacturing processes involving semiconducting polymers is the difficulties in preparing multilayer materials. Solution processing is one of the simplest, most economical, and most controllable methods for depositing layers of a conjugated polymer of interest. However,
20 because most conjugated polymers are soluble in organic and/or nonpolar media, depositing a solution of one conjugated polymer onto a previously deposited layer of another conjugated polymer can solubilize it and result in interfacial mixing. This can lead to disruption of the desired device orientation/structure/geometry, process irreproducibility, and reduced efficiency of resulting devices. Thus traditional manufacturing methods for
25 multilayer devices typically involve only one solution processing step for depositing polymers, with remaining layers deposited by more problematic methods, including sputtering, thermal vapor deposition, and chemical deposition methods, which can be more costly and less controllable.

There is a need in the art for conjugated polymers having different physical properties, for methods of making and using them, and for compositions, articles of manufacture and machines comprising such compounds.

5

SUMMARY OF THE INVENTION

Methods, compositions and articles of manufacture involving soluble conjugated polymers are provided. The conjugated polymers have a sufficient density of polar substituents to render them soluble in a polar medium, for example water and/or methanol. The conjugated polymers may desirably comprise monomers which alter their conductivity properties. The different solubility properties of these polymers allow their deposition in solution in multilayer formats with other conjugated polymers. Also provided are articles of manufacture comprising multiple layers of conjugated polymers having differing solubility characteristics. Embodiments of the invention are described further herein.

15

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 depicts the HOMO (highest occupied molecular orbital) and LUMO (lowest unoccupied molecular orbital) energy levels of poly(9,9-dioctylfluorenyl-2,7-diyl ("PFO")), poly(9,9-dihexyl-fluorene-co-benzothiadiazole) ("PFO-BT"), poly[2-methoxy-5-(2-ethyl-hexyloxy)-1,4-phenylene vinylene] ("MEH-PPV") and poly{[9,9-bis(6'-(N,N,N-trimethylammonium)hexyl)-fluorene-2,7-diyl]-alt-[2,5-bis(p-phenylene)-1,3,4-oxadiazole]} ("PFON⁺(CH₃)₃I-PBD") compared to the work function of Ba (all referenced with respect to the vacuum).

Figure 2 shows the current density (mA/cm²) vs. applied voltage (V) and luminance (cd/m²) vs. applied voltage (V) for devices made using blue-emitting PFO with and without PFON⁺(CH₃)₃ I-PBD as an electron-transport layer (ETL).

Figure 3 shows the luminous efficiency (cd/A) as a function of current density (mA/cm²) for devices made with (a) PFO, (b) PFO-BT and (c) MEH-PPV with and without ETL. Insets: (a) Power efficiency (lm/W) vs. bias (V) for devices made by PFO with and without ETL; (b) and (c) brightness (cd/m²) vs. current density (mA/cm²) for devices made by PFO-BT and MEH-PPV with and without ETL, respectively.

Figure 4 (a) and (b) are atomic force microscope (AFM) images showing the surface of the ETL and that of the emissive polymer. The ETL layer provides an increased amount of features on the scale shown, providing more effective electron injection simply because of the increased contact area between ETL and cathode.

Fig. 5 shows the highest occupied molecular orbital (HOMO) and the lowest unoccupied molecular orbital (LUMO) energy levels of PFO-ETM, PVK-SO₃Li, t-Bu-PBD-SO₃Na and the work functions of PEDOT:PSS and Ba.

Fig. 6 shows the forward viewing external luminous efficiency (LE_{ext}) versus current density, J (mA/cm²) for devices with poly(3,4-ethylenedioxythiophene):styrene sulfonic acid PEDOT:PSS as the HIL/HTL and t-Bu-PBD-SO₃Na as the ETL, and for devices with PVK-SO₃Li as the HTL and t-Bu-PBD-SO₃Na as the ETL, respectively; and the forward viewing external power efficiency (PE_{ext}, lm/W) versus J (mA/cm²) for Type I devices.

Fig. 7 shows the forward viewing external luminous efficiency (LE_{ext}) versus current density, J (mA/cm²) for the devices with PEDOT:PSS as the HIL/HTL and t-Bu-PBD-SO₃Na as the EIL/ETL, and for devices with PVK-SO₃Li as the HIL/HTL and t-Bu-PBD-SO₃Na as the EIL/ETL, respectively; and the forward viewing external power efficiency (PE_{ext}, lm/W) versus J (mA/cm²) for Type II devices.

DETAILED DESCRIPTION OF THE INVENTION

The inventors have provided conjugated polymers having desirable properties. The conjugated polymers have a sufficient density of polar substituents to render them soluble

in a polar medium. The polymers thus have desirable solubility properties allowing for their use with polymers of differing solubilities in methods involving multiple solution processing steps. The different solubility properties of these polymers allow their deposition in solution in multilayer formats with other conjugated polymers.

5 In some embodiments, the polar substituents can be charged groups, for example cationic or anionic groups. The conjugated polymers may have a sufficient density of solubilizing polar groups to render them soluble in a highly polar solvent such as water and/or methanol. This can be particularly advantageous for preparing multilayer polymeric devices via novel solution processing methods, also provided.

10 The conjugated polymer may desirably comprise monomers which alter its conductivity properties. The conjugated polymer can comprise monomers which improve its ability to inject and/or transport electrons. The conjugated polymer can comprise monomers which improve its ability to inject and/or transport holes. The conductivity of such polymers can be controlled through the type and/or amount of monomer(s) used,
15 which may be selected to match with other materials of interest in electronic devices. The composition of the polymer may also be chosen to prevent conductivity of certain species. For example, the composition of the polymer may be chosen so that it has hole-blocking properties, which can be desirable in certain device configurations, for example in polymer light-emitting diodes (PLEDs).

20 In some embodiments, the inventors have provided cationic conjugated polymers (CCPs) comprising both solubilizing groups and conductive groups, resulting in conductive conjugated polymers soluble in polar media. These conductive polymers are desirably soluble in water and/or lower alcohols, particularly methanol.

 Also provided are articles of manufacture comprising multiple layers of conjugated
25 polymers having differing solubility characteristics. Multiple polymer layers produced by methods described herein can be incorporated in any of a variety of articles and machines.

 Embodiments of the invention can comprise multiplex formats. For example, a plurality of different LEDs can be used simultaneously in a display format. Multiplex

embodiments may employ 2, 3, 4, 5, 10, 15, 20, 25, 50, 100, 200, 400, 1000, 5000, 10000, 50000, 200000, one million or more distinct articles provided by one or more embodiments described herein. Other aspects of the invention are discussed further herein.

Before the present invention is described in further detail, it is to be understood that
5 this invention is not limited to the particular methodology, articles, compositions or apparatuses described, as such methods, articles, compositions or apparatuses can, of course, vary. It is also to be understood that the terminology used herein is for the purpose of describing particular embodiments only, and is not intended to limit the scope of the present invention.

10 Use of the singular forms "a," "an," and "the" include plural references unless the context clearly dictates otherwise. Thus, for example, reference to "a conjugated polymer" includes a plurality of conjugated polymers, reference to "a solvent" includes a plurality of such solvents, reference to "an LED" includes a plurality of LEDs, and the like. Additionally, use of specific plural references, such as "two," "three," etc., read on larger
15 numbers of the same subject unless the context clearly dictates otherwise. The term "or" when used herein as the sole conjunction means "and/or" unless stated otherwise. The term "including" and related terms such as "includes" as used herein are not limiting and allow for the presence of elements in addition to those specifically recited.

Terms such as "connected," "attached," and "linked" are used interchangeably
20 herein and encompass direct as well as indirect connection, attachment, or linkage unless the context clearly dictates otherwise.

Where a range of values is recited, it is to be understood that each intervening integer value, and each fraction thereof, between the recited upper and lower limits of that range is also specifically disclosed, along with each subrange between such values. The
25 upper and lower limits of any range can independently be included in or excluded from the range, and all such ranges are encompassed within the invention. Where a value being discussed has inherent limits, for example where a component can be present at a concentration of from 0 to 100%, or where the pH of an aqueous solution can range from 1

to 14, those inherent limits are specifically disclosed as are ranges based on those inherent limits. Where a value is explicitly recited, it is to be understood that values which are about the same quantity or amount as the recited value are also within the scope of the invention, as are ranges based thereon with any other value as described herein.

5 Where a combination or group of elements is disclosed, each subset of those elements is also specifically disclosed and is within the scope of the invention. Conversely, where different elements or groups of elements are disclosed, combinations thereof are also disclosed.

10 Where any element of an invention is disclosed as having a plurality of alternatives, examples of that invention in which each alternative is excluded singly or in any combination with the other alternatives are also hereby disclosed; more than one element of an invention can have such exclusions, and all combinations of elements having such exclusions are hereby disclosed.

15 Unless defined otherwise or the context clearly dictates otherwise, all technical and scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which this invention belongs. Although any methods and materials similar or equivalent to those described herein can be used in the practice or testing of the invention, the preferred methods and materials are now described.

20 All publications mentioned herein are hereby incorporated by reference for the purpose of disclosing and describing the particular materials and methodologies for which the reference was cited. The publications discussed herein are provided solely for their disclosure prior to the filing date of the present application. Nothing herein is to be construed as an admission that the invention is not entitled to antedate such disclosure by virtue of prior invention.

25

DEFINITIONS

In describing the present invention, the following terms will be employed, and are intended to be defined as indicated below.

“Alkyl” refers to a branched, unbranched or cyclic saturated hydrocarbon group of 1 to 24 carbon atoms optionally substituted at one or more positions, and includes polycyclic compounds. Examples of alkyl groups include optionally substituted methyl, ethyl, n-propyl, isopropyl, n-butyl, s-butyl, t-butyl, n-pentyl, isopentyl, neopentyl, n-hexyl, n-heptyl, n-octyl, n-decyl, hexyloctyl, tetradecyl, hexadecyl, eicosyl, tetracosyl and the like, as well as cycloalkyl groups such as cyclopropyl, cyclobutyl, cyclopentyl, cyclohexyl, cycloheptyl, cyclooctyl, adamantyl, and norbornyl. The term “lower alkyl” refers to an alkyl group of 1 to 6 carbon atoms, preferably 1 to 4 carbon atoms. Exemplary substituents on substituted alkyl groups include hydroxyl, cyano, alkoxy, =O, =S, -NO₂, halogen, haloalkyl, heteroalkyl, carboxyalkyl, amine, amide, thioether and -SH.

“Alkoxy” refers to an “-Oalkyl” group, where alkyl is as defined above. A “lower alkoxy” group intends an alkoxy group containing one to six, more preferably one to four, carbon atoms.

“Alkenyl” refers to an unsaturated branched, unbranched or cyclic hydrocarbon group of 2 to 24 carbon atoms containing at least one carbon-carbon double bond and optionally substituted at one or more positions. Examples of alkenyl groups include ethenyl, 1-propenyl, 2-propenyl (allyl), 1-methylvinyl, cyclopropenyl, 1-butenyl, 2-butenyl, isobutenyl, 1,4-butadienyl, cyclobutenyl, 1-methylbut-2-enyl, 2-methylbut-2-en-4-yl, prenyl, pent-1-enyl, pent-3-enyl, 1,1-dimethylallyl, cyclopentenyl, hex-2-enyl, 1-methyl-1-ethylallyl, cyclohexenyl, heptenyl, cycloheptenyl, octenyl, cyclooctenyl, decenyl, tetradecenyl, hexadecenyl, eicosenyl, tetracosenyl and the like. Preferred alkenyl groups herein contain 2 to 12 carbon atoms. The term “lower alkenyl” intends an alkenyl group of 2 to 6 carbon atoms, preferably 2 to 4 carbon atoms. The term “cycloalkenyl” intends a cyclic alkenyl group of 3 to 8, preferably 5 or 6, carbon atoms. Exemplary substituents on substituted alkenyl groups include hydroxyl, cyano, alkoxy, =O, =S, -NO₂, halogen, haloalkyl, heteroalkyl, amine, thioether and -SH.

“Alkenyloxy” refers to an “-Oalkenyl” group, wherein alkenyl is as defined above.

“Alkylaryl” refers to an alkyl group that is covalently joined to an aryl group. Preferably, the alkyl is a lower alkyl. Exemplary alkylaryl groups include benzyl, phenethyl, phenopropyl, 1-benzylethyl, phenobutyl, 2-benzylpropyl and the like.

“Alkylaryloxy” refers to an “-Oalkylaryl” group, where alkylaryl is as defined above.

“Alkynyl” refers to an unsaturated branched or unbranched hydrocarbon group of 2 to 24 carbon atoms containing at least one $\text{-C}\equiv\text{C-}$ triple bond, optionally substituted at one or more positions. Examples of alkynyl groups include ethynyl, n-propynyl, isopropynyl, propargyl, but-2-ynyl, 3-methylbut-1-ynyl, octynyl, decynyl and the like. Preferred alkynyl groups herein contain 2 to 12 carbon atoms. The term “lower alkynyl” intends an alkynyl group of 2 to 6, preferably 2 to 4, carbon atoms, and one $\text{-C}\equiv\text{C-}$ triple bond. Exemplary substituents on substituted alkynyl groups include hydroxyl, cyano, alkoxy, =O , =S , -NO_2 , halogen, haloalkyl, heteroalkyl, amine, thioether and -SH .

“Amide” refers to -C(O)NR'R'' , where R' and R'' are independently selected from hydrogen, alkyl, aryl, and alkylaryl.

“Amine” refers to an -N(R')R'' group, where R' and R'' are independently selected from hydrogen, alkyl, aryl, and alkylaryl.

“Aryl” refers to an aromatic group that has at least one ring having a conjugated pi electron system and includes carbocyclic, heterocyclic, bridged and/or polycyclic aryl groups, and can be optionally substituted at one or more positions. Typical aryl groups contain 1 to 5 aromatic rings, which may be fused and/or linked. Exemplary aryl groups include phenyl, furanyl, azolyl, thiofuranyl, pyridyl, pyrimidyl, pyrazinyl, triazinyl, biphenyl, indenyl, benzofuranyl, indolyl, naphthyl, quinoliny, isoquinoliny, quinazoliny, pyridopyridiny, pyrrolopyridiny, puriny, tetraliny and the like. Exemplary substituents on optionally substituted aryl groups include alkyl, alkoxy, alkylcarboxy, alkenyl, alkenyloxy, alkenylcarboxy, aryl, aryloxy, alkylaryl, alkylaryloxy, fused saturated or unsaturated optionally substituted rings, halogen, haloalkyl, heteroalkyl, -S(O)R , sulfonyl, $\text{-SO}_3\text{R}$, -SR , -NO_2 , -NRR' , -OH , -CN , -C(O)R , -OC(O)R , -NHC(O)R , $\text{-(CH}_2\text{)}_n\text{CO}_2\text{R}$ or $\text{-(CH}_2\text{)}_n\text{CONRR'}$ where n is 0-4, and wherein R and R' are independently H, alkyl, aryl or alkylaryl.

“Aryloxy” refers to an “-Oaryl” group, where aryl is as defined above.

“Carbocyclic” refers to an optionally substituted compound containing at least one ring and wherein all ring atoms are carbon, and can be saturated or unsaturated.

“Carbocyclic aryl” refers to an optionally substituted aryl group wherein the ring atoms are carbon.

“Halo” or “halogen” refers to fluoro, chloro, bromo or iodo. “Halide” refers to the anionic form of the halogens.

5 “Haloalkyl” refers to an alkyl group substituted at one or more positions with a halogen, and includes alkyl groups substituted with only one type of halogen atom as well as alkyl groups substituted with a mixture of different types of halogen atoms. Exemplary haloalkyl groups include trihalomethyl groups, for example trifluoromethyl.

10 “Heteroalkyl” refers to an alkyl group wherein one or more carbon atoms and associated hydrogen atom(s) are replaced by an optionally substituted heteroatom, and includes alkyl groups substituted with only one type of heteroatom as well as alkyl groups substituted with a mixture of different types of heteroatoms. Heteroatoms include oxygen, sulfur, and nitrogen. As used herein, nitrogen heteroatoms and sulfur heteroatoms include any oxidized form of nitrogen and sulfur, and any form of nitrogen having four covalent
15 bonds including protonated and alkylated forms. An optionally substituted heteroatom refers to a heteroatom having one or more attached hydrogens optionally replaced with alkyl, aryl, alkylaryl and/or hydroxyl.

 “Heterocyclic” refers to a compound containing at least one saturated or unsaturated ring having at least one heteroatom and optionally substituted at one or more positions.
20 Typical heterocyclic groups contain 1 to 5 rings, which may be fused and/or linked, where the rings each contain five or six atoms. Examples of heterocyclic groups include piperidinyl, morpholinyl and pyrrolidinyl. Exemplary substituents for optionally substituted heterocyclic groups are as for alkyl and aryl at ring carbons and as for heteroalkyl at heteroatoms.

25 “Heterocyclic aryl” refers to an aryl group having at least 1 heteroatom in at least one aromatic ring. Exemplary heterocyclic aryl groups include furanyl, thienyl, pyridyl, pyridazinyl, pyrrolyl, N-lower alkyl-pyrrolo, pyrimidyl, pyrazinyl, triazinyl, tetrazinyl, triazolyl, tetrazolyl, imidazolyl, bipyridyl, tripyridyl, tetrapyridyl, phenazinyl, phenanthrolinyl, purinyl and the like.

“Hydrocarbyl” refers to hydrocarbyl substituents containing 1 to about 20 carbon atoms, including branched, unbranched and cyclic species as well as saturated and unsaturated species, for example alkyl groups, alkylidenyl groups, alkenyl groups, alkylaryl groups, aryl groups, and the like. The term “lower hydrocarbyl” intends a hydrocarbyl group of one to six carbon atoms, preferably one to four carbon atoms.

A “substituent” refers to a group that replaces one or more hydrogens attached to a carbon or nitrogen. Exemplary substituents include alkyl, alkylidenyl, alkylcarboxy, alkoxy, alkenyl, alkenylcarboxy, alkenyloxy, aryl, aryloxy, alkylaryl, alkylaryloxy, -OH, amide, carboxamide, carboxy, sulfonyl, =O, =S, -NO₂, halogen, haloalkyl, fused saturated or unsaturated optionally substituted rings, -S(O)R, -SO₃R, -SR, -NRR', -OH, -CN, -C(O)R, -OC(O)R, -NHC(O)R, -(CH₂)_nCO₂R or -(CH₂)_nCONRR' where n is 0-4, and wherein R and R' are independently H, alkyl, aryl or alkylaryl. Substituents also include replacement of a carbon atom and one or more associated hydrogen atoms with an optionally substituted heteroatom.

“Sulfonyl” refers to -S(O)₂R, where R is alkyl, aryl, -C(CN)=C-aryl, -CH₂CN, alkylaryl, or amine.

“Thioamide” refers to -C(S)NR'R'', where R' and R'' are independently selected from hydrogen, alkyl, aryl, and alkylaryl.

“Thioether” refers to -SR, where R is alkyl, aryl, or alkylaryl.

“Multiplexing” herein refers to an assay or other analytical method in which multiple analytes can be assayed simultaneously.

“Optional” or “optionally” means that the subsequently described event or circumstance may or may not occur, and that the description includes instances where said event or circumstance occurs singly or multiply and instances where it does not occur at all. For example, the phrase “optionally substituted alkyl” means an alkyl moiety that may or may not be substituted and the description includes both unsubstituted, monosubstituted, and polysubstituted alkyls.

CONJUGATED POLYMER SOLUBLE IN POLAR MEDIA

Conjugated polymers (CPs) soluble in polar media are provided and can be used in embodiments described herein. The CPs comprise polar groups as solubilizing functionalities linked to polymer subunits to increase polymer solubility in polar media.

- 5 Any or all of the subunits of the CP may comprise one or more pendant solubilizing groups. Exemplary polar groups include those introducing one or more dipole moments to the CP, for example halides, hydroxyls, amines, amides, cyano, carboxylic acids, sulfonic acids and thiols.

Preferably the polar groups are charged groups, more preferably cationic groups.

- 10 Any suitable cationic groups may be incorporated into CCPs. Exemplary cationic groups which may be incorporated include ammonium groups, guanidinium groups, histidines, polyamines, pyridinium groups, and sulfonium groups.

The solubilizing functionality may be linked to the conjugated polymer backbone by a linker, preferably an unconjugated linker, for example alkyl groups, polyethers,

- 15 alkylamines, and/or polyamines.

One synthetic approach to introducing a charged group into a conjugated polymer is as follows. A neutral polymer is first formed by the Suzuki coupling of one or more bis- (or tris- etc.) boronic acid-substituted monomer(s) with one or more monomers that have at least two bromine substitutions on aromatic ring positions. Bromine groups are attached to

20 any or all of the monomers via linkers. Conversion to cationic water-soluble polymers is accomplished by addition of condensed trimethylamine, which replaces the pendant bromines with ammonium groups.

- In some embodiments, the conjugated polymer may desirably comprise conductive monomers which alter the conductivity of the overall polymer, increasing its ability to
- 25 transport an electrical species. For example, the conjugated polymer can comprise monomer(s) which improve its ability to inject and/or transport electrons. The conjugated polymer can comprise monomer(s) which improve its ability to inject and/or transport holes. More than one type of conductive monomer can be incorporated in the conjugated polymer. The conductivity of such polymers can be controlled through the type and/or

amount of monomer(s) used, which can be selected to provide an electronic configuration compatible with other materials of interest in a given electronic device.

The conductive monomers may be electron-deficient monomers or electron-rich monomers. Electron-deficient monomers can be used to increase the ability of the polymer to inject and/or transport electrons, and to improve its ability to serve as an electron-transport layer. Electron-deficient monomers include unsaturated and/or aromatic groups appropriately substituted with electron-withdrawing groups. A number of electron-deficient monomers are known in the art. Exemplary electron-deficient monomers include benzothiadiazole, oxadiazole, quinoxaline, cyano-substituted olefins, squaric acid, and maleimide.

Electron-rich monomers can be used to increase the ability of the polymer to inject and/or transport holes, and to improve its ability to serve as a hole-transport layer. Electron-rich monomers include unsaturated and/or aromatic groups appropriately substituted with electron-donating groups, for example alkyl groups. A number of electron-rich monomers are known in the art. Exemplary electron-rich monomers include 9,9-dialkylfluorenes, 2,5-dimethyl-1,4-phenylidene, 2,5-dioctyloxy-1,4-phenylidene, and terthiophenes.

The composition of the polymer can also be chosen to prevent conductivity of certain species. For example, the composition of the polymer can be chosen so that it has hole-blocking properties, which can be desirable in certain device configurations, for example in polymer light-emitting diodes (PLEDs).

The CP can be a copolymer, and may be a block copolymer, a graft copolymer, or both. The solubilizing functionalities and/or the conductive subunits may be incorporated into the CP randomly, alternately, periodically and/or in blocks.

Exemplary polymers which may form the backbone of the compounds of the present invention include, for example, polypyrroles, polyfluorenes, polyphenylene-vinylenes, polythiophenes, polyisothianaphthenes, polyanilines, poly-p-phenylenes and

copolymers thereof. Other exemplary polymeric subunits and repeating units are shown in the accompanying tables.

Table 1. Typical aromatic repeat units for the construction of conjugated segments and oligomeric structures.

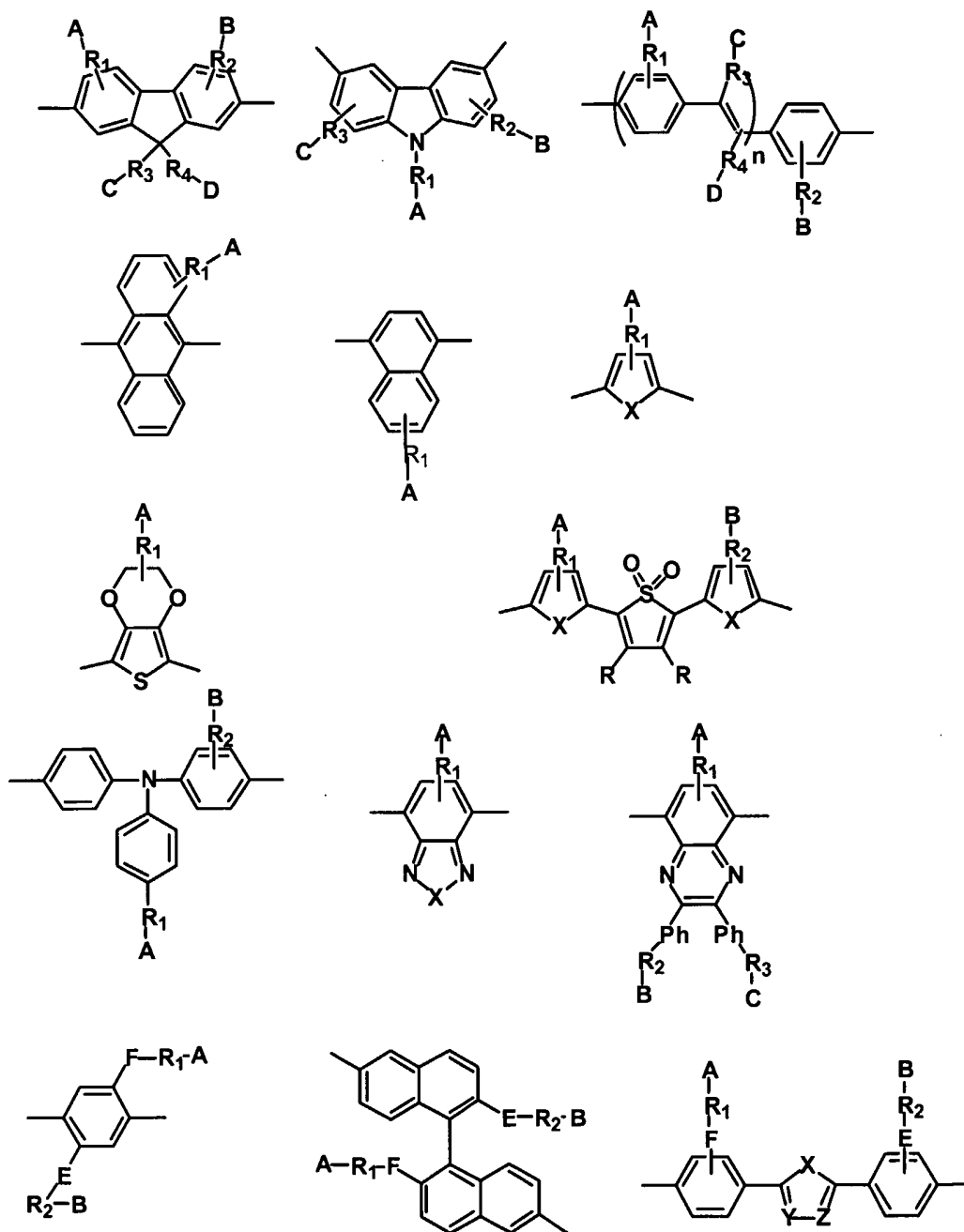
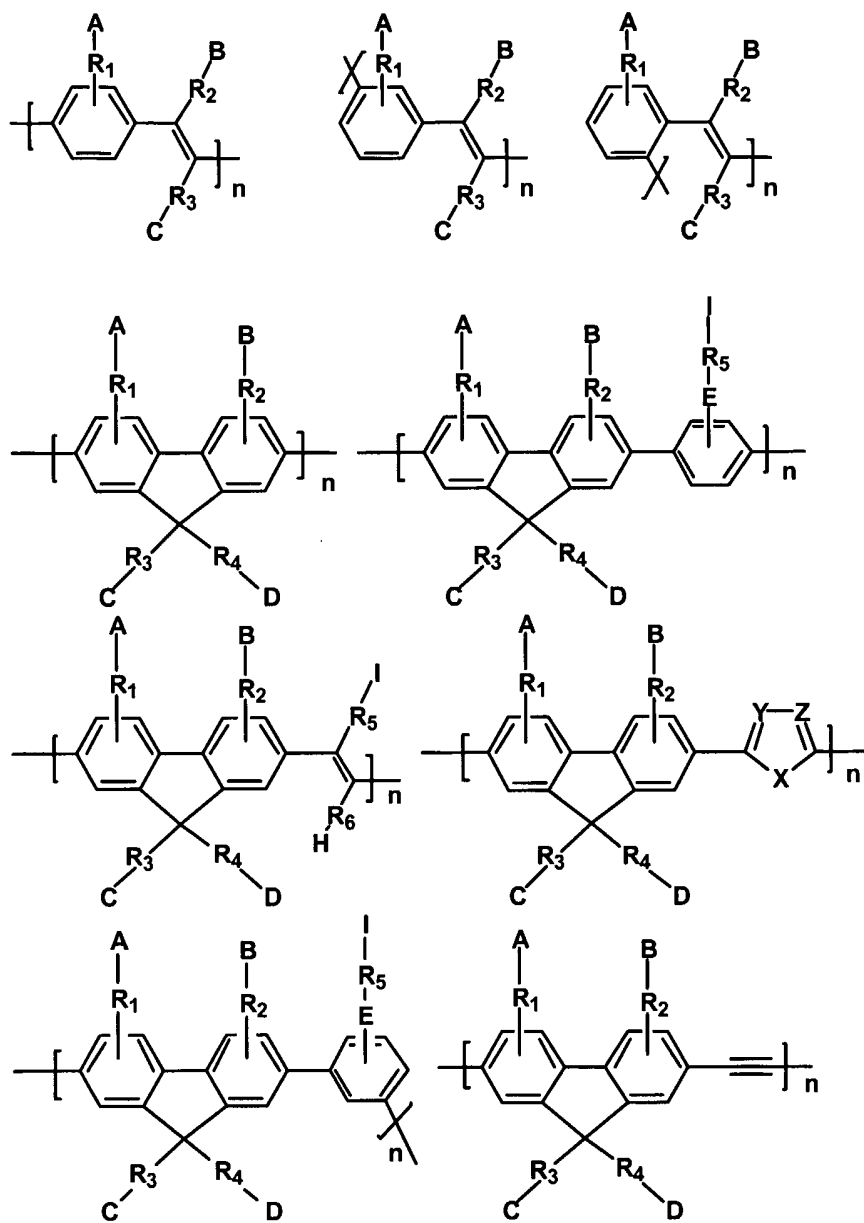
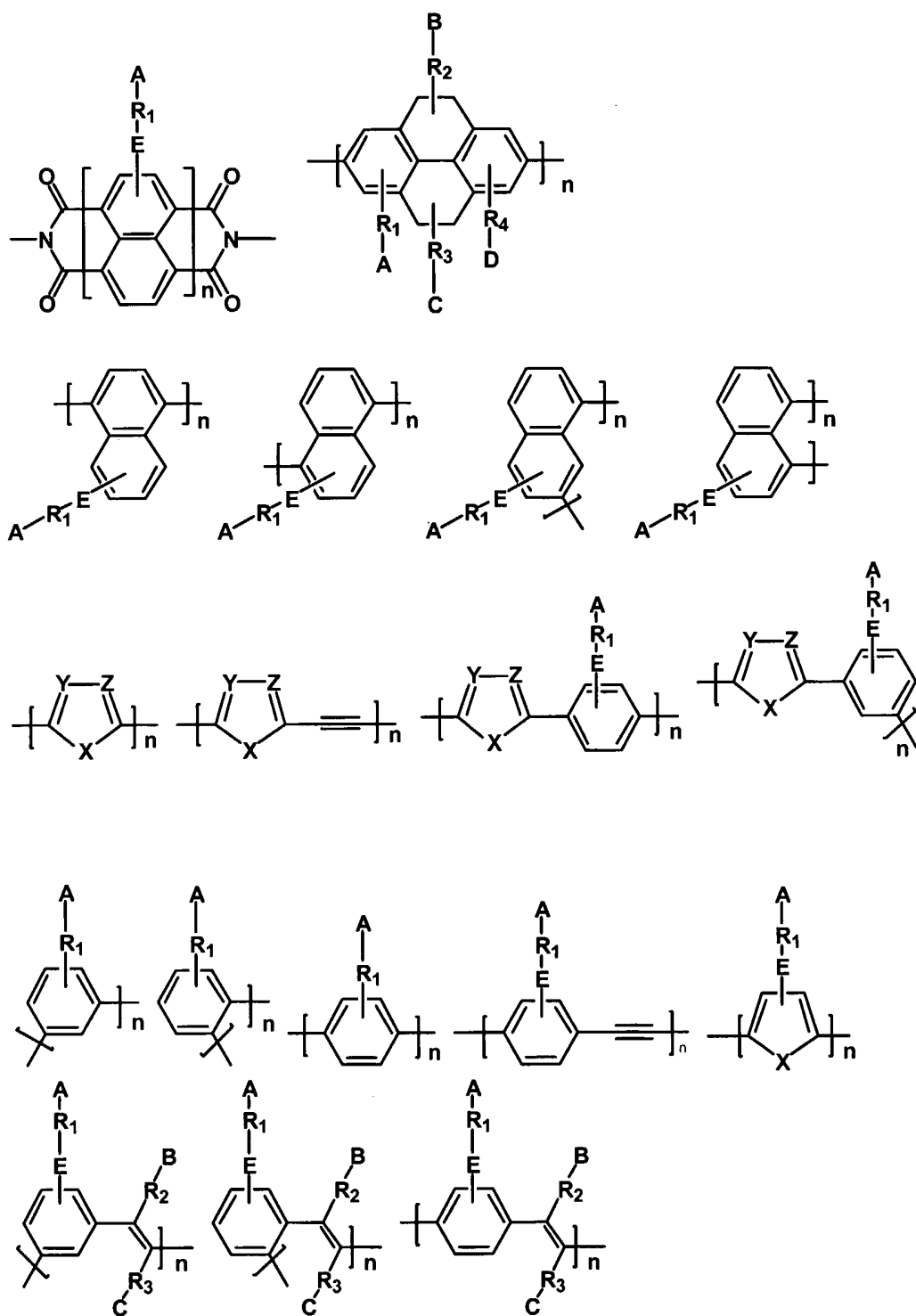
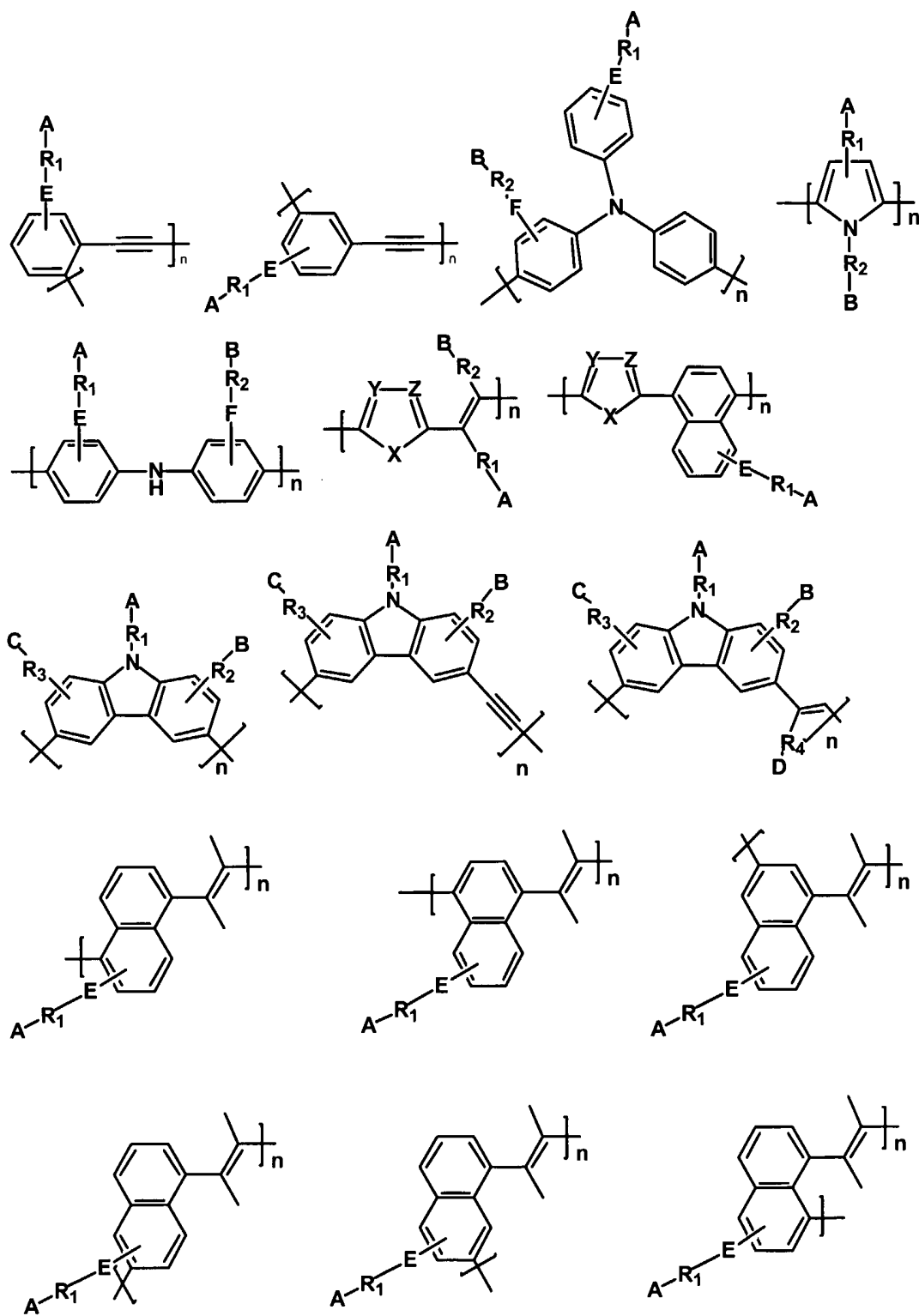
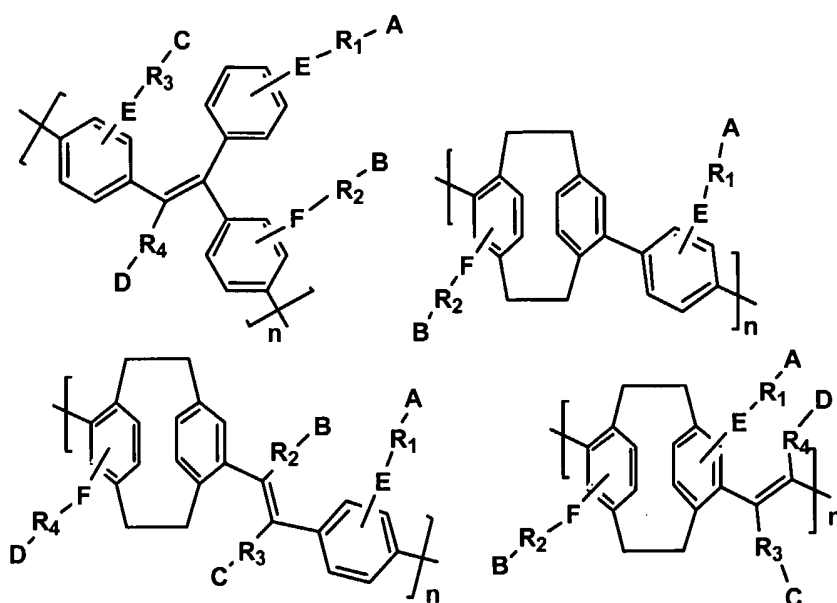


Table 2. Examples of conjugated segments and oligomeric structures of CP









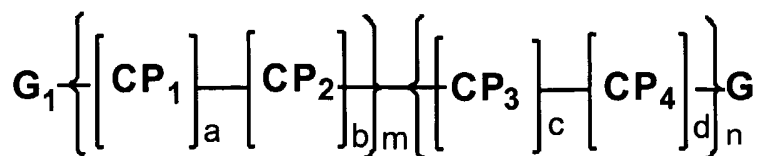
The CP contains a sufficient density of solubilizing functionalities to render the overall polymer soluble in a polar medium. The CP preferably contains at least about 0.01 mol % of the monomers substituted with at least one solubilizing functionality, and may contain at least about 0.02 mol %, at least about 0.05 mol %, at least about 0.1 mol %, at least about 0.2 mol %, at least about 0.5 mol %, at least about 1 mol %, at least about 2 mol %, at least about 5 mol %, at least about 10 mol %, at least about 20 mol %, or at least about 30 mol %. The CP may contain up to 100 mol % of the solubilizing functionality, and may contain about 99 mol % or less, about 90 mol % or less, about 80 mol % or less, about 70 mol % or less, about 60 mol % or less, about 50 mol % or less, or about 40 mol % or less.

The CP preferably contains at least about 0.01 mol % of the conductive monomers, and may contain at least about 0.02 mol %, at least about 0.05 mol %, at least about 0.1 mol %, at least about 0.2 mol %, at least about 0.5 mol %, at least about 1 mol %, at least about 2 mol %, at least about 5 mol %, at least about 10 mol %, at least about 20 mol %, or at least about 30 mol %. The CP may contain up to 100 mol % of the conductive monomers, and may contain about 99 mol % or less, about 90 mol % or less, about 80 mol

% or less, about 70 mol % or less, about 60 mol % or less, about 50 mol % or less, or about 40 mol % or less.

Desirably, the CPs described herein are soluble in aqueous solutions and other highly polar solvents, and preferably are soluble in water. By “water-soluble” is meant that the material exhibits solubility in a predominantly aqueous solution, which, although comprising more than 50% by volume of water, does not exclude other substances from that solution, including without limitation buffers, blocking agents, cosolvents, salts, metal ions and detergents.

In one embodiment, an exemplary CCP is represented by Formula A:



Formula A

wherein:

CP₁, CP₂, CP₃, and CP₄ are optionally substituted conjugated polymer segments or oligomeric structures, and may be the same or different from one another. CP₁, CP₂, CP₃, and CP₄ may be aromatic repeat units, and may be selected from the group consisting of benzene, naphthalene, anthracene, fluorene, thiophene, furan, pyridine, and oxadiazole, each optionally substituted. Typical aromatic repeat units are shown in Table 1 below, and representative polymeric segments and oligomeric structures are shown in Table 2. One or more of CP₁₋₄ may be conductive monomers comprising electron-injecting and/or transporting properties or hole-injecting and/or transporting properties. The conductive monomers may be evenly or randomly distributed along the polymer main chain.

CP₁, CP₂, CP₃ and CP₄ are each optionally substituted at one or more positions with one or more groups selected from -R₁-A, -R₂-B, -R₃-C and -R₄-D, which may be attached through bridging functional groups -E- and -F-, with the proviso that the polymer as a whole must be substituted with a plurality of cationic groups.

R₁, R₂, R₃ and R₄ are independently selected from alkyl, alkenyl, alkoxy, alkynyl, and aryl, alkylaryl, arylalkyl, and polyalkylene oxide, each optionally substituted, which may contain one or more heteroatoms, or may be not present. R₁, R₂, R₃ and R₄ can be independently selected from C₁₋₂₂ alkyl, C₁₋₂₂ alkoxy, C₁₋₂₂ ester, polyalkylene oxide having
 5 from 1 to about 22 carbon atoms, cyclic crown ether having from 1 to about 22 carbon atoms, or not present. Preferably, R₁, R₂, R₃ and R₄ may be selected from straight or branched alkyl groups having 1 to about 12 carbon atoms, or alkoxy groups with 1 to about 12 carbon atoms. It is to be understood that more than one functional group may be appended to the rings as indicated in the formulas at one or more positions.

10 A, B, C and D are independently selected from H, -SiR'R''R''', -N⁺R'R''R''', a guanidinium group, histidine, a polyamine, a pyridinium group, and a sulfonium group. R', R'' and R''' are independently selected from the group consisting of hydrogen, C₁₋₁₂ alkyl and C₁₋₁₂ alkoxy and C₃₋₁₀ cycloalkyl. It is preferred that R', R'' and R''' are lower alkyl or lower alkoxy groups.

15 E and F are independently selected from not present, -O-, -S-, -C(O)-, -C(O)O-, -C(R)(R')-, -N(R')-, and -Si(R')(R''), wherein R' and R'' are as defined above.

X is O, S, Se, -N(R')- or -C(R')(R'')-, and Y and Z are independently selected from -C(R)= and -N=, where R, R' and R'' are as defined above.

m and n are independently 0 to about 10,000, wherein m + n > 1. Preferably m and
 20 n are each independently 0 to about 20 and more preferably from 0 to about 10. Each repeat of m and n may be the same as or different than the other repeats.

a, b, c and d are independently 0 to about 250. At least one of a, b, c and d must be greater than or equal to one.

G and G1 are capping units and may be the same or different. The capping units may be activated units that allow further chemical reaction to extend the polymer chain, or may be nonactivated termination units. G and G1 can be independently selected from hydrogen, optionally substituted aryl, halogen substituted aryl, boronic acid substituted aryl, and boronate radical substituted aryl.

Conjugated polymers may also be provided in purified form. Any available method or combination of methods may be used for purification. Exemplary methods include precipitation, extraction, and sublimation. Solutions of the CP are also provided. Solutions may be provided in a container of any suitable form. Solutions may be packaged in a container designed for incorporation into a solution processing apparatus, for example a printer. In some embodiments, the solution may be provided in an inkjet cartridge designed to be used with an inkjet printer.

THE POLAR SOLVENT

The medium used to dissolve the soluble conjugated polymer is polar, comprising at least one polar solvent. By "polar" is meant having a net dipole moment. Exemplary polar solvents include dimethylsulfoxide, dimethylformamide, formic acid, acetic acid, ethyl acetate, water, alcohols and polyalcohols, particularly lower alcohols (C₁₋₄), particularly methanol. Preferably the polar solvent has a polarity of at least that of ethanol or ethyl acetate. In some embodiments, the polar solvent used to dissolve the CP is selected based on its inability to dissolve a second conjugated polymer onto which the CP is to be deposited.

The polar solvent in certain embodiments and solution formed therefrom in some embodiments is wettable on the surface to which it is to be applied, such that when it is deposited it flows generally uniformly and evenly over the surface, and preferably is controllable in thickness. Combinations of solvents may also be used. Preferably the solvent is sufficiently wettable on the substrate that the solution spreads appropriately when deposited thereon. One or more wetting agents may be included in the solution to improve its ability to wet a surface and/or lowers its surface tension. For example, a solution

comprising water may have an alcohol, a surfactant, or a combination of materials added thereto serving as wetting agents.

METHODS OF USE

5 The CPs described herein can be used in a variety of methods. Methods of particular interest include deposition of the CPs into electronic devices, particularly in devices comprising multiple layers of conjugated polymers. Any of a variety of deposition methods can be used in a given device, including without limitation vacuum sputtering (RF or Magnetron), electron beam evaporation, thermal vapor deposition, chemical deposition, 10 sublimation, and solution processing methods. Any deposition method known or discoverable in the art can be used to deposit the soluble polar polymers provided herein, although solution methods are currently preferred.

 These layers are commonly deposited by spin-coating, drop-casting, sequential spin-casting, formation of Langmuir-Blodgett films or electrostatic adsorption 15 techniques.^[28] Articles of manufacture may be fabricated by stepwise deposition of polymer layers; the water solubility of CPs provided herein allows for the sequential deposition of layers of different materials with different solubilities, providing certain advantages during manufacturing, including for the deposition of thin layers of material.

 In particular embodiments, solution processing methods can be used to incorporate 20 CPs into an article of manufacture. Printing techniques may advantageously be used to deposit the CPs, e.g., inkjet printing, offset printing, etc.

 Where the CPs are used in multilayer devices comprising multiple conjugated polymeric layers, one or more of these layers may comprise nonpolar conjugated polymers which may not be soluble in a polar medium of interest. These include, for example, 25 MEH-PPV, P3ATs [poly(3-alkylthiophenes), where alkyl is from 6 to 16 carbons], such as poly(2,5-dimethoxy-p-phenylene vinylene)-“PDMPV”, and poly(2,5-thienylenevinylene); poly(phenylenevinylene) or “PPV” and alkoxy derivatives thereof; PFO, PFO-BT, and polyanilines. The nonpolar conjugated polymer can be deposited by any suitable technique; in some embodiments it is deposited or cast directly from solution. Typically, 30 organic solvents are used, typically with low polarity. Exemplary organic solvents include:

halohydrocarbons such as methylene chloride, chloroform, and carbon tetrachloride; aromatic hydrocarbons such as xylene, benzene, toluene; and other hydrocarbons including decaline.

Mixed solvents can also be used. The differing solubility properties of nonpolar
5 and polar polymers allow for deposition of multiple polymeric layers via solution processing methods, which can simplify manufacturing and reduce costs. The water-soluble polymers described herein allow for the solution deposition of alternating layers of polymers of differing solubilities to form bilayer or multilayer devices.

When depositing the conjugated polymer on a substrate, the solution can be
10 relatively dilute, such as from 0.1 to 20% w/w in concentration, especially 0.2 to 5% w. In some embodiments, film thicknesses may be at least about 50, 100, or 200 nm. In some embodiments, film thicknesses of less than about 400, 200, or 100 nm can be used.

The polymer solution can be formed into a selected shape if desired, e.g. a fiber, film or the like by any suitable method, for example extrusion.

15 After deposition of a solution comprising a conjugated polymer, the solvent is removed. Any available method or combination of methods may be used for removing the solvent. Exemplary solvent removal methods include evaporation, heating, extraction, and subjecting the solution to a vacuum.

In some embodiments, the conjugated polymer may be deposited on a substrate.
20 The substrate can comprise a wide range of material, either biological, nonbiological, organic, inorganic, or a combination of any of these. In some embodiments, the substrate can be transparent. The substrate can be a rigid material, for example a rigid plastic or a rigid inorganic oxide. The substrate can be a flexible material, for example a transparent organic polymer such as polyethyleneterephthalate or a flexible polycarbonate. The
25 substrate can be conductive or nonconductive.

The CPs can be deposited on a substrate in any of a variety of formats. For example, the substrate may be a polymerized Langmuir Blodgett film, functionalized glass, Si, Ge, GaAs, indium doped GaN, GaP, SiC (Nature 430:1009, 2004), SiO₂, SiN₄, semiconductor nanocrystals, modified silicon, or any of a wide variety of gels or polymers
30 such as (poly)tetrafluoroethylene, (poly)vinylidenedifluoride, polystyrene, cross-linked

polystyrene, polyacrylic, polylactic acid, polyglycolic acid, poly(lactide coglycolide), polyanhydrides, poly(methyl methacrylate), poly(ethylene-co-vinyl acetate), polyethyleneterephthalate, polysiloxanes, polymeric silica, latexes, dextran polymers, epoxies, polycarbonates, agarose, poly(acrylamide) or combinations thereof. Conducting
5 polymers and photoconductive materials can be used. The substrate can take the form of a photodiode, an optoelectronic sensor such as an optoelectronic semiconductor chip or optoelectronic thin-film semiconductor, or a biochip.

The CPs may be used in methods which screen the CPs for any property of interest. For example, the CPs may be tested for binding to a target, for energy transfer to a
10 chromophore, for increased fluorescent efficiency, for decreased self-quenching, for absorbance wavelength, emission wavelength, conductive properties, ability to inject and/or transport electrons, ability to block holes, ability to inject and/or transport holes, and/or work function, etc.

15 ARTICLES OF MANUFACTURE

The CPs can be incorporated into any of various articles of manufacture including optoelectronic or electronic devices, biosensors, diodes, including photodiodes and light-emitting diodes ("LEDs"), optoelectronic semiconductor chips, semiconductor thin-films, and chips, and can be used in array or microarray form. The polymer can be incorporated
20 into a polymeric photoswitch. The polymer can be incorporated into an optical interconnect or a transducer to convert a light signal to an electrical impulse. The CPs can serve as liquid crystal materials. The CPs may be used as electrodes in electrochemical cells, as conductive layers in electrochromic displays, as field effective transistors, and as Schottky diodes.

25 The CPs can be used as lasing materials. Optically pumped laser emission has been reported from MEH-PPV in dilute solution in an appropriate solvent, in direct analogy with conventional dye lasers [D. Moses, Appl. Phys. Lett. 60, 3215 (1992); U.S. Pat. No. 5,237,582]. Semiconducting polymers in the form of neat undiluted films have been demonstrated as active luminescent materials in solid state lasers [F. Hide, M. A. Diaz-
30 Garcia, B. J. Schwartz, M. R. Andersson, Q. Pei, and A. J. Heeger, Science 273, 1833

(1996); N. Tessler, G. J. Denton, and R. H. Friend, *Nature* 382, 695 (1996)]. The use of semiconducting polymers as materials for solid state lasers is disclosed in U.S. Pat. No. 5,881,083 issued Mar. 9, 1999 to Diaz-Garcia et al. and titled "Conjugated Polymers as Materials for Solid State Lasers." In semiconducting polymers, the emission is at longer
5 wavelengths than the onset of significant absorption (the Stokes shift) resulting from inter- and intramolecular energy transfer. Thus there is minimal self-absorption of the emitted radiation [F. Hide et al., *Science* 273, 1833 (1996)], so self-absorption does not make the materials lossy. Moreover, since the absorption and emission are spectrally separated, pumping the excited state via the π to π^* transition does not stimulate emission, and an
10 inverted population can be obtained at relatively low pump power.

Light-emitting diodes can be fabricated incorporating one or more layers of CPs, which may serve as conductive layers. Light can be emitted in various ways, e.g., by using one or more transparent or semitransparent electrodes, thereby allowing generated light to exit from the device.

15 The mechanism of operation of a polymer LED requires that carrier injection be optimized and balanced by matching the electrodes to the electronic structure of the semiconducting polymer. For optimum injection in single layer devices, the work function of the anode should lie at approximately the top of the valence band, E_v , (the π -band or highest occupied molecular orbital, HOMO) and the work function of the cathode should
20 lie at approximately the bottom of the conduction band, E_c , (the π^* -band or lowest unoccupied molecular orbital, LUMO).

LED embodiments include hole-injecting and electron-injecting electrodes. A conductive layer made of a high work function material (above 4.5 eV) may be used as the hole-injecting electrode. Exemplary high work function materials include electronegative
25 metals such as gold or silver, and metal-metal oxide mixtures such as indium-tin oxide. An electron-injecting electrode can be fabricated from a low work function metal or alloy, typically having a work function below 4.3. Exemplary low work function materials include indium, calcium, barium and magnesium. The electrodes can be applied by any suitable method; a number of methods are known to the art (e.g. evaporated, sputtered, or
30 electron-beam evaporation).

In some embodiments, polymer light-emitting diodes have been fabricated using a semiconducting polymer cast from solution in an organic solvent as an emissive layer and a water-soluble (or methanol-soluble) conjugated copolymer as an electron-transport layer (ETL) in the device configuration: ITO(indium tin oxide)/PEDOT(poly(3,4-ethylene dioxothiophene)/emissive polymer/ETL/Ba/Al. The inventors have successfully fabricated multi-layer PLEDs using a semiconducting polymer (red, green or blue emitting), cast from solution in an organic solvent, as the emissive layer and a water-soluble (or methanol-soluble) cationic conjugated copolymer as electron-transport layer.

The examples demonstrate the use of soluble conductive polymers as hole-injecting and/or transporting layers, as well as the use of soluble conductive polymers with electron-injecting and/or transporting properties. The device geometry and deposition order can be selected based on the type of conductive polymer being used. More than one type of conductive polymer can be used in the same multilayer device. A multilayer device may include more than one layer of electron-injecting conjugated polymers, more than one layer of hole-injecting conjugated polymers, or at least one layer of a hole-injecting polymer and at least one layer of an electron-injecting conjugated polymer. The results demonstrate that devices with an ETL, an HTL, or both, have improved characteristics, in particular formats having significantly lower turn-on voltage, higher brightness and improved luminous efficiency.

In PLEDs, the device efficiency is reduced by cathode quenching since the recombination zone is typically located near the cathode.^[20] The addition of an ETL moves the recombination zone away from the cathode and thereby eliminates cathode quenching. In addition, the ETL can serve to block the diffusion of metal atoms, such as barium and calcium, and thereby prevents the generation of quenching centers^[20] during the cathode deposition process.

In some embodiments, the principal criteria when a soluble conjugated polymer is used as an electron transport layer (ETL) in polymer light-emitting diodes (PLEDs) are the following: (1) The lowest unoccupied molecular orbital (LUMO) of the ETL must be at an

energy close to, or even within the π^* -band of the emissive semiconducting polymer (so electrons can be injected); and (2) The solvent used for casting the electron injection material must not dissolve the underlying emissive polymer.

Similarly, the principal criteria for a polymer based hole transport layer (HTL) for use
5 in polymer light-emitting diodes (PLEDs) is that the highest occupied molecular orbital (HOMO) of the HTL must be at an energy close to, or even within the valence band of the emissive semiconducting polymer.

Solubility considerations can dictate the deposition order of the particular CPs and solvents used to produce a desired device configuration. Any number of layers of CPs with
10 different solubilities may be deposited via solution processing by employing these techniques.

The PLEDs comprising CPs described herein can be incorporated in any available display device, including a full color LED display, a cell phone display, a PDA (personal digital assistant), portable combination devices performing multiple functions (phone/PDA/camera/etc.), a flat panel display including a television or a monitor, a computer
15 monitor, a laptop computer, a computer notepad, and an integrated computer-monitor systems. The PLEDs may be incorporated in active or passive matrices.

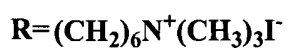
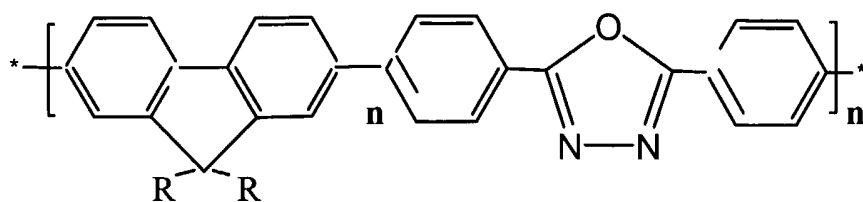
EXAMPLES

The following examples are set forth so as to provide those of ordinary skill in the art
20 with a complete description of how to make and use the present invention, and are not intended to limit the scope of what is regarded as the invention. Efforts have been made to ensure accuracy with respect to numbers used (e.g., amounts, temperature, etc.) but some experimental error and deviation should be accounted for. Unless otherwise indicated, parts are parts by weight, temperature is degree centigrade and pressure is at or near atmospheric,
25 and all materials are commercially available.

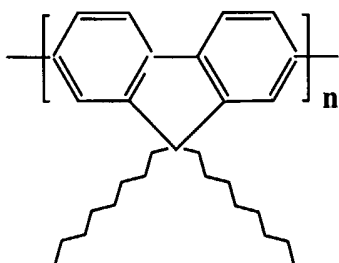
Example 1. Fabrication of PLEDs

In one embodiment, polymer light-emitting diodes (PLEDs) have been fabricated using a semiconducting polymer cast from solution in an organic solvent as an emissive layer and a water-soluble (or methanol-soluble) conjugated copolymer as an electron-transport layer (ETL) in the device configuration: ITO/PEDOT/emissive polymers/ETL/Ba/Al. The results demonstrate that devices with the ETL have significantly lower turn-on voltage, higher brightness and improved luminous efficiency. See figures.

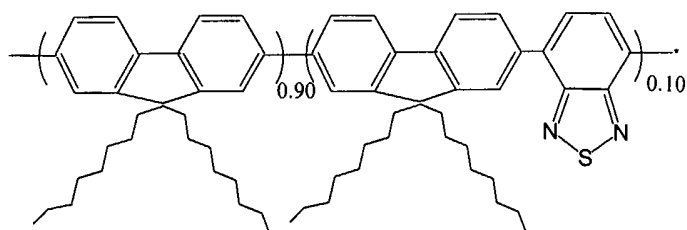
The water soluble conjugated copolymer, poly{[9,9-bis(6'-(N,N,N-trimethylammonium)hexyl)-fluorene-2,7-diyl]-*alt*-[2,5-bis(p-phenylene)-1,3,4-oxadiazole]}(PFON⁺(CH₃)₃I⁻-PBD) was synthesized using the palladium catalyzed Suzuki coupling reaction^[13,14] and used as an electron transport layer (ETL). Poly(9,9-dihexylfluorene-*co*-benzothiadiazole) (PFO-BT) was also synthesized using the Suzuki coupling reaction.^[15] Poly(9,9-dioctylfluorenyl-2,7-diyl) (PFO) and poly[2-methoxy-5-(2-ethylhexyloxy)-1,4-phenylene vinylene] (MEH-PPV) were purchased from American Dye Source, Inc. (Canada). The molecular structures of PFO, PFO-BT, MEH-PPV and PFON⁺(CH₃)₃I⁻-PBD are shown below:



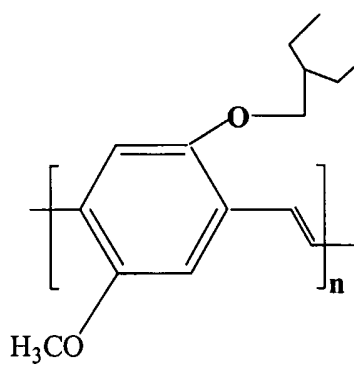
PFON⁺(CH₃)₃I⁻-PBD



PFO



PFO-BT



MEH-PPV

The HOMO (highest occupied molecular orbital) and LUMO energy levels are shown in Figure 1 (the work functions of poly(3,4-ethylene dioxythiophene):poly(styrene sulfonic acid) (PEDOT:PSS) and barium are also shown for comparison). PEDOT:PSS on indium tin oxide (ITO) was used as the hole-injecting bilayer electrode. PLEDs were fabricated with and without the ETL layer in the following device structures: (ITO)/PEDOT:PSS/Emissive polymer/Ba/Al and (ITO)/PEDOT:PSS/Emissive Polymer/ETL/Ba/Al. Details of device fabrication and testing have been reported elsewhere; all fabrication steps were carried out inside a controlled atmosphere dry box under nitrogen atmosphere.^[16, 17] The ETL was deposited on top of the emissive layer by spin-casting from solution in methanol (0.6% wt.-%) to form a PFON⁺(CH₃)₃I⁻-PBD layer with thickness of approximately 30 nm and then annealed at 90°C for 2 hours to remove residual solvent. Hydrophilic methanol was used as the solvent (rather than water) to achieve better inter-layer wetting while maintaining well-defined multi-layers. The term “emissive polymer/ETL” is used to designate devices with an ETL.

Example 2. Characterization of PLEDs Comprising a Water-Soluble CCP

Figure 2 shows the current density vs. voltage and brightness vs. voltage characteristics of devices made using PFO with and without the ETL. The PFO/ETL devices turned on at ~3V (the turn-on voltage is defined as the voltage at the brightness of 0.1 cd/m²), whereas the turn-on voltage is at ~5V for PFO devices made without the ETL.^[18] At 6 V, the luminance (L) obtained from the PFO/ETL devices is L = 3450 cd/m², compared to L = 30 cd/m² for devices without the ETL.

Similar improvements were observed from the devices made with green and red emitting conjugated polymers. For MEH-PPV/ETL devices, L = 5600cd/m² at 5 V compared to L = 3550 cd/m² for similar devices fabricated without the ETL. Therefore, the addition of the ETL results in lower turn-on voltage and higher brightness.

The dramatic improvement in brightness and the reduced turn-on voltage result from improved electron injection (there is a good match of the LUMO of the ETL to the π^* -band of the emissive polymer(s)) and from the hole blocking capability of the ETL (LUMO energy at -6.24 eV relative to the vacuum).

The luminous efficiency (LE in cd/A) vs. current density (J in mA/cm²) for devices with and without the ETL are shown in Figure 3a, 3b and 3c. As shown in Fig. 3, devices with ETL have higher luminous efficiency, higher power efficiency, and correspondingly higher brightness at a given voltage.

5 The improvements in LE and PE can be understood in greater detail by comparing the LUMO energy level of the emissive polymer with that of PFON⁺(CH₃)₃I⁻-PBD and the work-function of barium (see Figure 1). The energy barrier between the LUMO of PFO and the work function of barium is ~ 0.6 eV. Thus, by adding the PFON⁺(CH₃)₃I⁻-PBD layer as the ETL, electron injection is enhanced.

10 For PFO-BT and MEH-PPV, there is no energy barrier for electron injection. However, the hole-blocking feature of the PFON⁺(CH₃)₃I⁻-PBD layer leads to better balanced electron and hole currents. In addition, the enhanced electron injection can also facilitate hole injection.^[21] Therefore, the larger and more nearly balanced electron and hole currents lead to higher luminous efficiencies in the devices with the ETL.

15 Interfacial energetics are known to play an important role in the emission characteristics of organic LEDs.^{[22][23]} By adding the ETL between the cathode and the emissive polymer, the contacts at both interfaces are improved. Atomic force microscope (AFM) images show that the surface of the ETL is more rough than that of the emissive polymer. See Figure 4. As a result, more effective electron injection is achieved simply
20 because of the increased contact area between ETL and cathode.

Results. The water- and methanol-soluble conjugated polymer, PFON⁺(CH₃)₃I⁻-PBD, was used as an electron-transporting layer in multi-layer PLEDs. By casting the ETL from solution in methanol and the emissive layer from solution in an organic solvent, interfacial mixing was avoided. Using blue, green or red emitting semiconducting
25 polymers as the emissive layer and PFON⁺(CH₃)₃I⁻-PBD as the ETL, significant improvements in performance were demonstrated. More importantly, our results indicate that multi-layer PLEDs can be fabricated by deposition of multiple solutions.

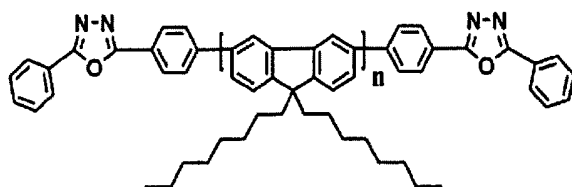
Example 3. Preparation and Characterization of PLEDs Comprising Soluble HTL/HILs and ETL/EILs

Multilayer PLEDs in various configurations comprising HTL/HIL layers, ETL/EIL layers, or both, were prepared and characterized as follows.

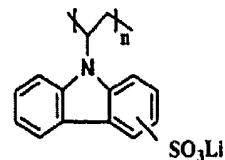
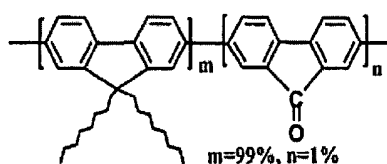
5 Synthesis of PVK-SO₃Li: The sulfonation of PVK was performed by a procedure described in the literature [S. Wang et al., *Macromolecules*, 2000, 33, 3232]. The degree of sulfonation of PVK was about 28 %. The sulfonated PVK was dissolved in a minimum amount of hot ethanol, and the resulting solution was cooled down to room temperature. To this solution was added excess EtOLi solution in ethanol and white precipitate was formed.
10 The precipitate was collected by filtration, washed with cooled ethanol and dried under vacuum to obtain the lithium salt PVK-SO₃Li.

 Synthesis of *t*-Bu-PBD-SO₃Na: *t*-Bu-PBD-SO₃H was synthesized by a procedure described in the literature [T. J. Boyd, R. R. Schrock, *Macromolecules*, 1999, 32, 6608]. A concentrated solution of *t*-Bu-PBD-SO₃H in water/THF(v/v 6:1) was added into a salt brine
15 to afford a white precipitate. The precipitate was extracted into ethanol and the ethanol was removed to obtain the desired sodium salt *t*-Bu-PBD-SO₃Na.

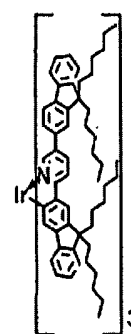
 Emissive layers used in this example comprise a blend (mixture) of one or more emitting polymers (or copolymers) with one or more organometallic emitters. Emitting layers were made from PFO or poly(9,9-dioctylfluorene) end-capped with 5-biphenyl-1, 3,
20 4-oxadiazol (PFO-ETM) blended with tris (2,5-bis-2'-(9',9'-dihexylfluorene) pyridine) iridium (III), (Ir(HFP)₃) and devices made from blends of PFO-ETM with poly(9,9-dioctylfluorene-cofluorenone) with 1 % fluorenone (PFO-F(1%)) and Ir(HFP)₃. The molecular structures of PFO-ETM, PFO-F(1%) and Ir(HFP)₃ are shown below. The synthesis of PFO-ETM has been reported [X. Gong et al., *Adv. Func. Mater.*, 2004, 14,
25 393]. Other emitting polymers including blue-emitting polymers can also be used in the practice of the invention. The synthesis of Ir(HFP)₃ has been reported [J. C. Ostrowski et al., *Chem. Commun.*, 2002, 7, 784]. The synthesis of PFO-F(1 %) was also reported [X. Gong, D. Moses and A. J. Heeger, *Synth. Met.* 2004, 141, 17]. Ir(HFP)₃ is representative of the useful organometallic emitters which are complexes and compounds having Ir, Pr, Os,
30 Ru or Au or the like as a center atom.



PFO-ETM

PVK-SO₃Li

PFO-F (1%)

*t*-Bu-PBD-SO₃NaIr(HFP)₃

Three stock solutions, PFO-ETM, PFO-F (1%) and Ir(HFP)₃ were prepared by dissolving 50mg PFO-ETM, 20mg PFO-F (1%) and 5mg Ir(HFP)₃ into 1 ml toluene, respectively. The resulting 0.5 wt.-% Ir(HFP)₃ solution was diluted to 0.05wt.-% Ir(HFP)₃.

- 5 The mixtures were stirred overnight at 65°C and then cooled to room temperature.

A Type I solution comprising two emissive species was prepared as follows: 2.4 μl of a solution of 0.05 wt.-% Ir(HFP)₃ in toluene and 400 μl of a solution of 5 wt.-% PFO-ETM in toluene were added into 197.6 μl of pure toluene.

A Type II solution comprising three emissive species was prepared as follows:

- 10 19.2 μl of a solution of 0.05 wt.-% Ir(HFP)₃ in toluene and 400 μl of a solution of 5 wt.-% PFO-ETM in toluene were added into 180.8 μl of pure toluene.

A solution of 0.5 wt.-% PVK-SO₃Li in ethanol was prepared and was spin-cast at 5000 rpm in nitrogen atmosphere onto a preformed hole injection layer of PEDOT:PSS and thereafter baked at about 85°C in a vacuum oven for 24 hours to yield a hole transport layer

on top of a hole injection layer. Alternative hole transport layers can be used such as, for example, poly(BTPD-Si-PFCB).

Type I and Type II solutions were then spin-cast at 2000 rpm in nitrogen atmosphere onto PVK-SO₃Li layers prepared as described above, and thereafter baked at
5 65° C in a nitrogen atmosphere for 20 minutes to yield a variety of emissive layers on hole transport layers.

A solution of 0.5 wt.-% *t*-Bu-PBD-SO₃Na in ethanol was prepared and was spin-cast at 5000 rpm in nitrogen atmosphere onto some of the emissive layers and thereafter baked at about 95° C in vacuum oven for 24 hours to yield representative electron transport
10 layers on emissive layers. Alternative electron transport layers can be used such as, for example, PFON⁺(CH₃)₃ I⁻-PBD.

A Ba electrode (for electron injection) was formed with a thickness of approximate 100 angstroms onto the *t*-Bu-PBD-SO₃Na layer and then a protective Al over layer was deposited with a thickness of approximate 2000 angstroms by vapor
15 deposition at 10⁻⁶ Torr. [X. Gong et al., Adv. Mat. 2002, 14, 581; X. Gong et al., Adv. Mat. 2003, 15, 45]. Ca or other low work function metals (and their alloys) can be used for the electron injection layer. The overlayer can be made using any inert metal, for example, silver or gold.

The strong green emission from "blue-emitting" PFO-ETM results from fluorenone defects generated during device fabrication/operation [X. Gong et al., Adv. Func. Mater.,
20 2003, 13, 325]. The broad green emission from PFO-F (1%) originates from excitation energy transfer in the copolymer from the PFO-ETM majority component to the fluorenone minority component. [X. Gong et al., Synthe. Met. 2004, 141, 17]. The red emission with maximum at 600 nm and a shoulder at 620 is the Ir(HFP)₃ triplet emission. [X. Gong et
25 al., Adv. Mat. 2003, 15, 45; J. C. Ostrowski et al., Chem. Commun., 2002, 7, 784].

All Type I devices were found to turn on at approximately 6 V, which is ~ 1 V higher than the devices without PVK-SO₃Li, due to the larger film thickness. Type I devices have $L_{\max} \approx 2.4 \times 10^4$ cd/m² at 16 V.

The Type II devices were found to turn on at approximately 6 V, which is ~ 1 V higher than the devices without PVK-SO₃Li, due to the larger film thickness. Type II devices have $L_{\max} \approx 1.0 \times 10^4$ cd/m² at 25 V.

Fig. 6 shows the forward viewing external luminous efficiency (LE_{ext}) versus current density, J (mA/cm²) for Type I devices with PEDOT:PSS as the HIL/HTL, *t*-Bu-PBD-SO₃Na as the ETL, and PVK-SO₃Li as the HTL and *t*-Bu-PBD-SO₃Na as the ETL, respectively; and the forward viewing external power efficiency (PE_{ext} , lm/W) versus J (mA/cm²).

For display applications, a Lambertian intensity profile was assumed; the forward viewing efficiencies, LE_{ext} and PE_{ext} shown in Fig. 6, were measured with the following results: [K. Mullen, Editor, Electroluminescence-from Synthesis to Devices, Wiley-VCH, 2005 (in press). Type I devices have $LE_{\text{ext}} = 10.4$ cd/A, $L = 2391$ cd/m² and $PE_{\text{ext}} = 3$ lm/W at $J = 23$ mA/cm² ($V = 11$ V). Note that even at $J = 200$ mA/cm², the Type I devices have $L = 19500$ cd/m², $LE_{\text{ext}} = 9.5$ cd/A and $PE_{\text{ext}} = 2$ lm/W. The LE_{ext} and PE_{ext} at 200 mA/cm² are significantly higher than any reported previously for white OLEDs and PLEDs.

As shown in Fig. 6, the LE_{ext} from white PLEDs with *t*-Bu-PBD-SO₃Na as ETL is higher than that without *t*-Bu-PBD-SO₃Na. Similarly, the LE_{ext} from white PLEDs with both PVK-SO₃Na as HTL and *t*-Bu-PBD-SO₃Na as ETL are higher than that with only *t*-Bu-PBD-SO₃Na as ETL. Therefore, these results demonstrate that PLEDs comprising HTL and ETL which reduce the energy barriers for hole and electron injection have the highest LE_{ext} and PE_{ext} and, correspondingly, the highest L at a given J .

Fig. 7 shows the forward viewing external luminous efficiency (LE_{ext}) versus current density, J (mA/cm²) for Type II devices with PEDOT:PSS as the HIL/HTL, *t*-Bu-PBD-SO₃Na as the ETL, and PVK-SO₃Li as the HTL and *t*-Bu-PBD-SO₃Na as the ETL, respectively; and the forward viewing external power efficiency (PE_{ext} , lm/W) versus J (mA/cm²). For Type II devices, $LE_{\text{ext}} = 7.2$ cd/A, $L = 882$ cd/m² and $PE_{\text{ext}} = 1.5$ lm/W at $J = 12$ mA/cm² ($V = 15$ V). Note that even at $J = 200$ mA/cm², Type II devices have $L = 9600$ cd/m², $LE_{\text{ext}} = 4.8$ cd/A and $PE_{\text{ext}} = 0.65$ lm/W. Again, the LE_{ext} and PE_{ext} at 200 mA/cm² are significantly higher than any reported previously for white OLEDs and PLEDs.

As shown in Fig. 7, the LE_{ext} from white Type II PLEDs with *t*-Bu-PBD-SO₃Na as ETL is higher than that without *t*-Bu-PBD-SO₃Na. Similarly, the LE_{ext} from white PLEDs with both PVK SO₃Na as HTL and *t*-Bu-PBD-SO₃Na as ETL are higher than that only with *t*-Bu-PBD-SO₃Na as ETL.

5

Although the invention has been described in some detail with reference to the preferred embodiments, those of skill in the art will realize, in light of the teachings herein, that certain changes and modifications can be made without departing from the spirit and scope of the invention. Accordingly, the invention is limited only by the claims.

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multilayers of water-soluble poly(p-phenylene)s. *Adv. Mater.* 1998, 10, 1452.

CLAIMS

What is claimed is:

1. A multilayer light-emitting device (LED) comprising:
 - an emissive layer comprising a semiconducting conjugated polymer, and
 - an electron injection/transport layer comprising a conjugated polymer having a lowest unoccupied molecular orbital (LUMO) at an energy close to or within the π^* -band of the emissive semiconducting polymer, said electron injection/transport layer disposed to inject and/or transport electrons to the emissive layer, and
 - a hole injection/transport layer comprising a conjugated polymer having a highest occupied molecular orbital (HOMO) at an energy close to or within the valence band of the emissive semiconducting polymer, said hole injection/transport layer disposed to inject and/or transport holes to the emissive layer,

wherein the electron injection/transport layer, the hole injection/transport layer and the emissive layer have solubilities allowing their stepwise deposition via solution processing techniques, wherein each injection/transport layer is soluble in a polar solvent having a polarity at least that of ethyl acetate and the emissive layer is soluble in an organic solvent of low polarity, wherein the first of the injection/transport layers deposited does not dissolve in the solution used to deposit the emissive layer, and wherein the emissive layer does not dissolve in the solution used to deposit the second of the injection/transport layers.
2. The LED of claim 1, wherein the emissive layer emits green light.
3. The LED of claim 2, wherein the emissive comprises poly[2-methoxy-5-(2-ethyl-hexyloxy)-1,4-phenylene vinylene] ("MEH-PPV").
4. The LED of claim 1, wherein the emissive layer emits red light.
5. The LED of claim 4, wherein the emissive layer comprises poly(9,9-dihexyl-fluorene-co-benzothiadiazole) ("PFO-BT").

6. The LED of claim 1, wherein the emissive layer emits blue light.
7. The LED of claim 6, wherein the emissive layer comprises poly(9,9-dioctylfluorenyl-2,7-diyl ("PFO")).
8. A matrix comprising a plurality of LEDs according to claim 1.
9. A display device comprising the LED of claim 1.
10. The display device of claim 9, wherein the display device is a full color display.
11. A method of forming adjacent layers of conjugated polymers on a substrate, comprising:
 - providing a first solution comprising a first conjugated polymer and a polar solvent, said solvent having a polarity at least that of ethyl acetate;
 - providing a second solution comprising a second conjugated polymer and a second solvent;
 - depositing a first layer of one of said first and second solutions onto a substrate and removing the solvent from the first layer;
 - depositing a second layer of the other of said first and second solutions onto the first layer and removing the solvent from the second layer;
 - wherein the polymer deposited in the first layer does not dissolve in the solvent deposited in the second layer, and wherein the first conjugated polymer has a highest occupied molecular orbital (HOMO) at an energy close to or within the valence band of the second conjugated polymer,
12. The method of claim 11, wherein the polar solvent comprises water.
13. The method of claim 11, wherein the polar solvent comprises methanol.
14. The method of claim 11, wherein depositing the first solution comprises printing the first solution onto the substrate.

15. The method of claim 11, wherein depositing the first solution onto the substrate comprises spin-casting.
16. The method of claim 11, wherein depositing the first solution onto the substrate comprises drop-casting.
17. The method of claim 11, wherein at least one of said steps of removing the solvent comprises heating.
18. The method of claim 11, wherein at least one of said steps of removing the solvent comprises reducing the atmospheric pressure.
19. The method of claim 11, wherein at least one of said steps of removing the solvent comprises evaporating.
20. The method of claim 11, wherein the substrate comprises an electrode.
21. The method of claim 11, wherein the substrate is a film.
22. The method of claim 11, wherein the substrate is flexible.
23. The method of claim 11, wherein the substrate is rigid.
24. The method of claim 11, further comprising a plurality of depositions of discrete, separated second layers onto one or more of said first layers.
25. A multilayer light-emitting device (LED) comprising:
 - an emissive layer comprising a semiconducting conjugated polymer, and
 - a hole injection/transport layer comprising a conjugated polymer having a highest occupied molecular orbital (HOMO) at an energy close to or within the valence band of the emissive semiconducting polymer, said hole injection/transport layer disposed to inject and/or transport holes to the emissive layer,wherein the hole injection/transport layer is soluble in a polar solvent having a polarity at least that of ethyl acetate and the emissive layer is soluble in an organic solvent of low polarity.

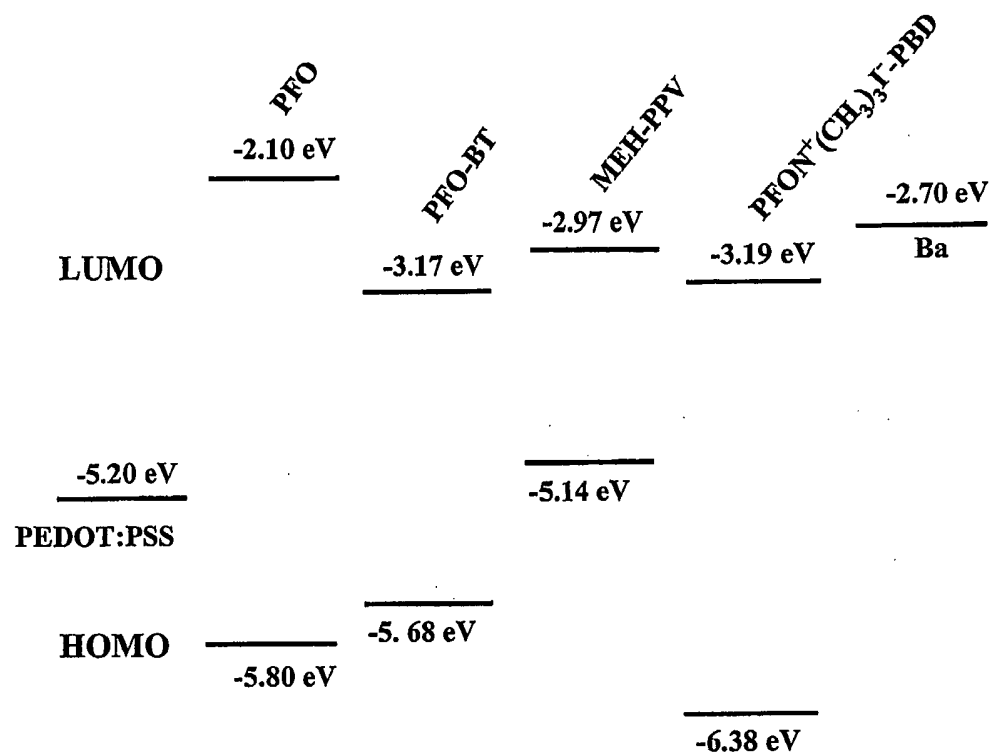


Figure 1

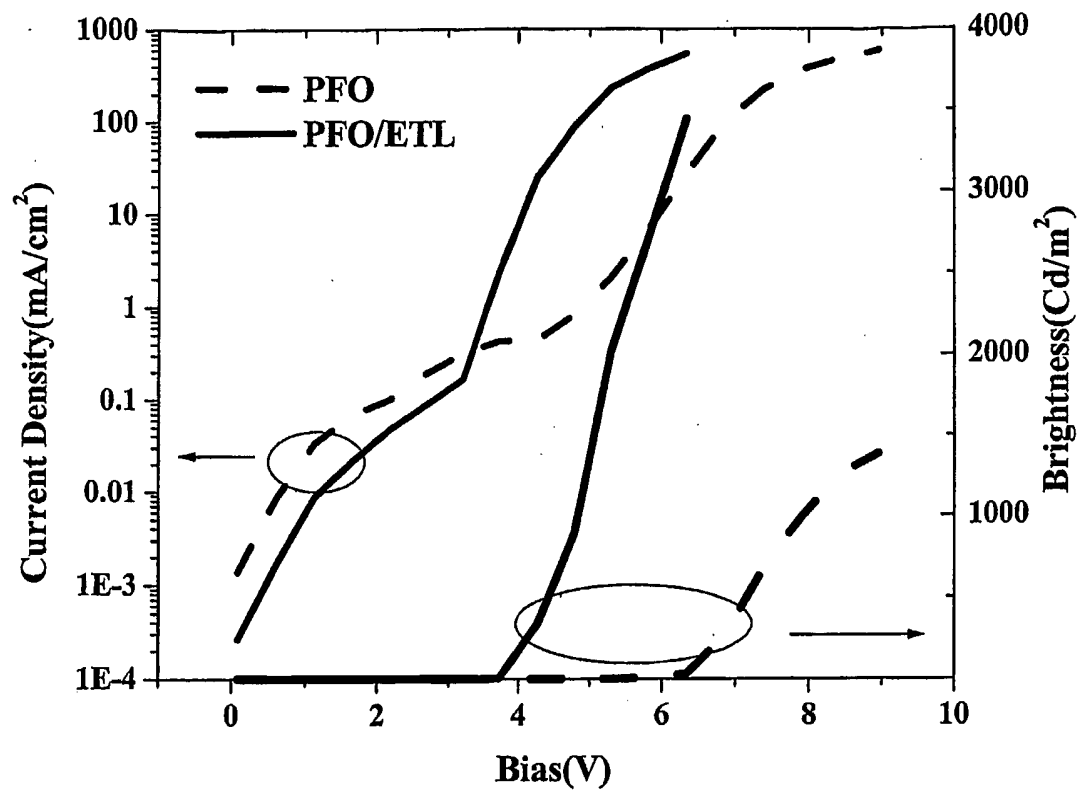


Figure 2

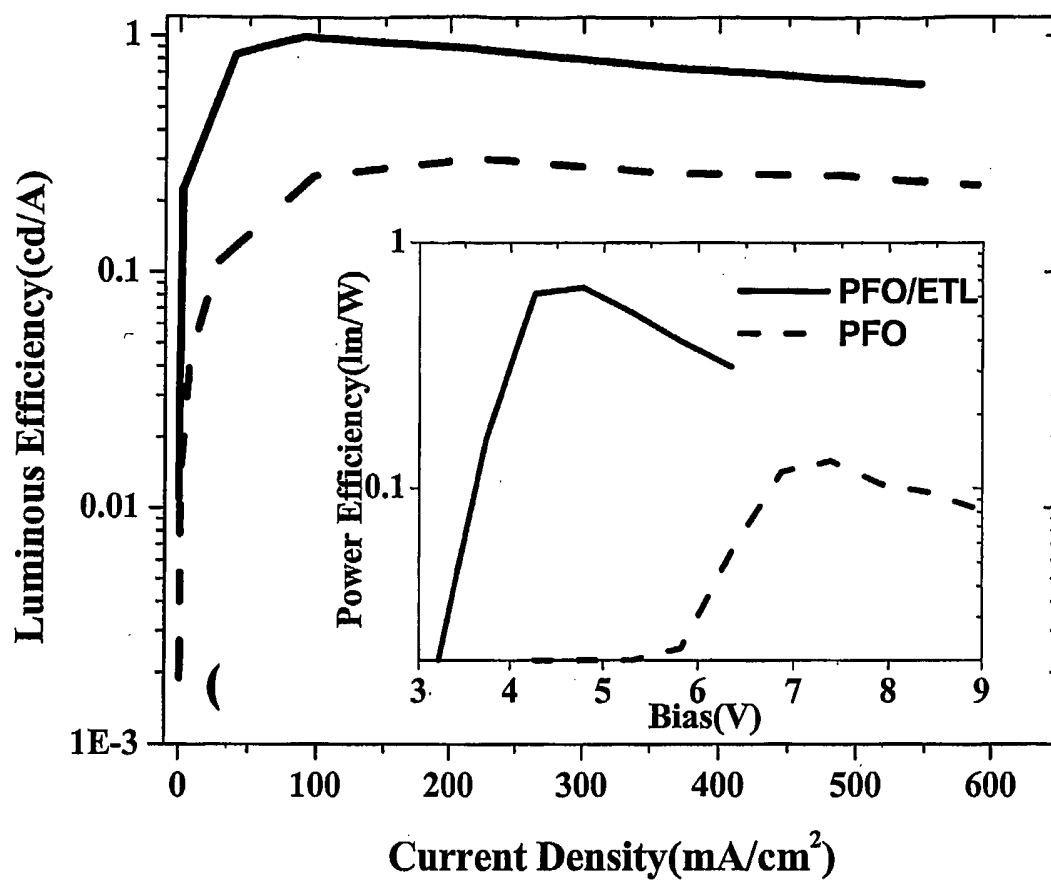


Figure 3(a)

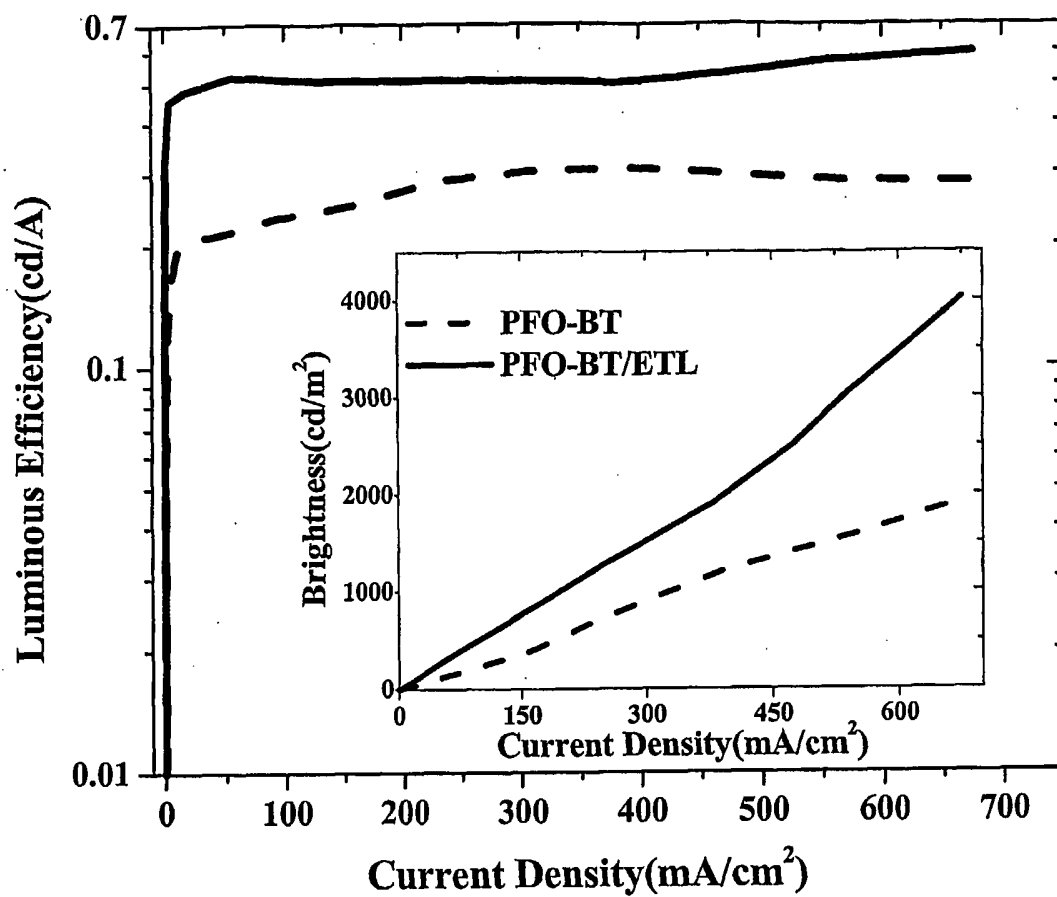


Figure 3(b)

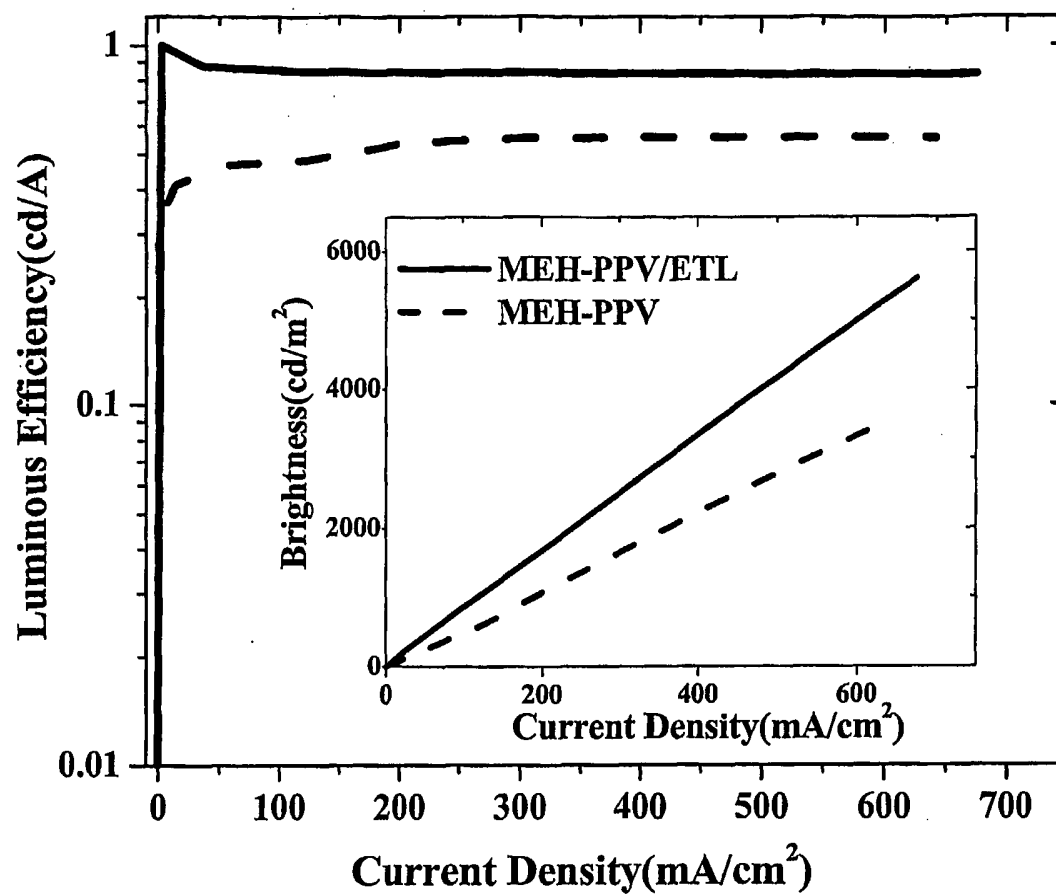
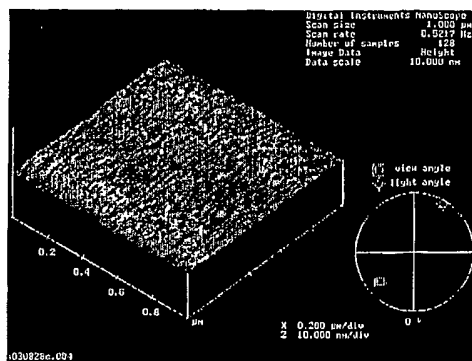
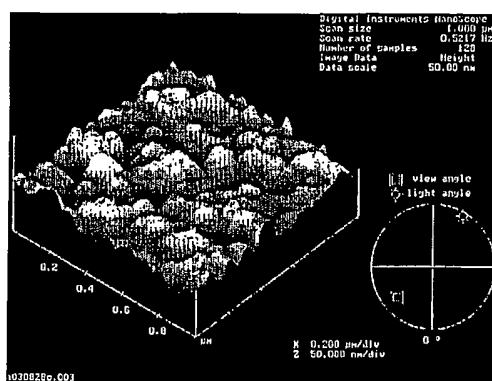


Figure 3(c)

(a) without ETL



(b) with ETL

**Figure 4**

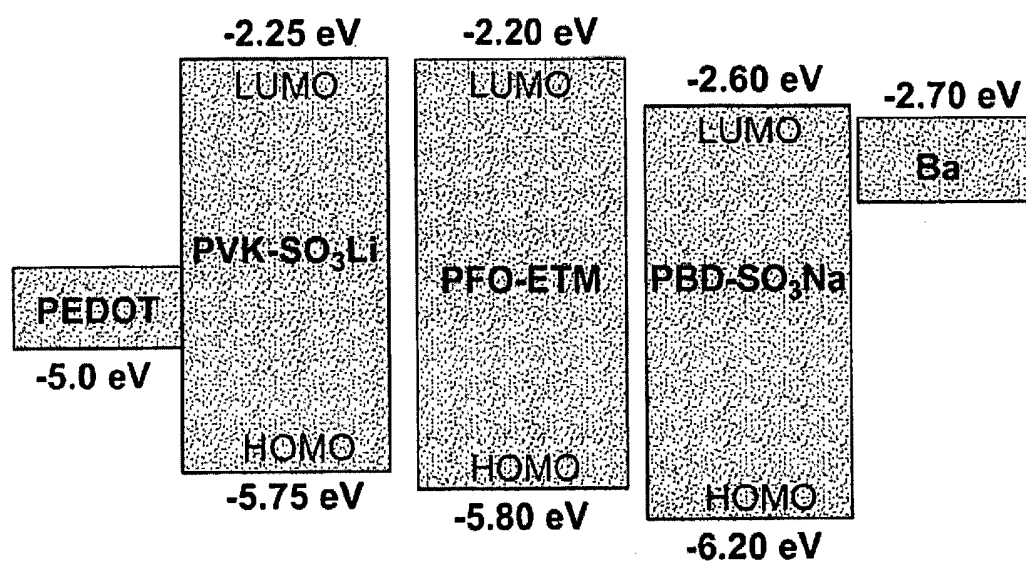


Fig. 5

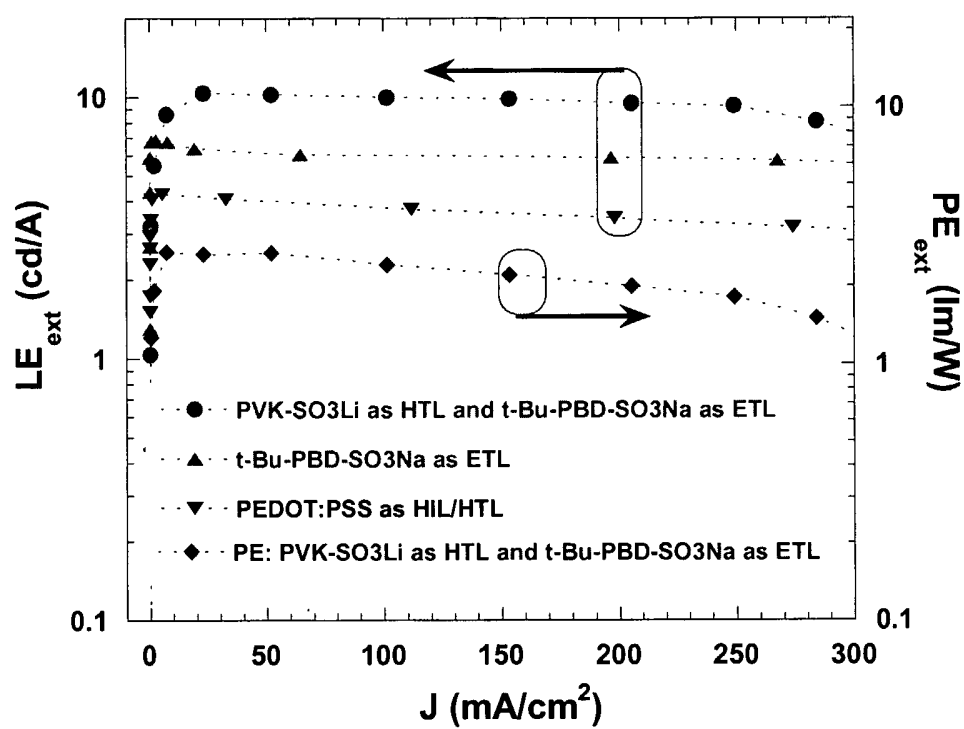


Fig. 6

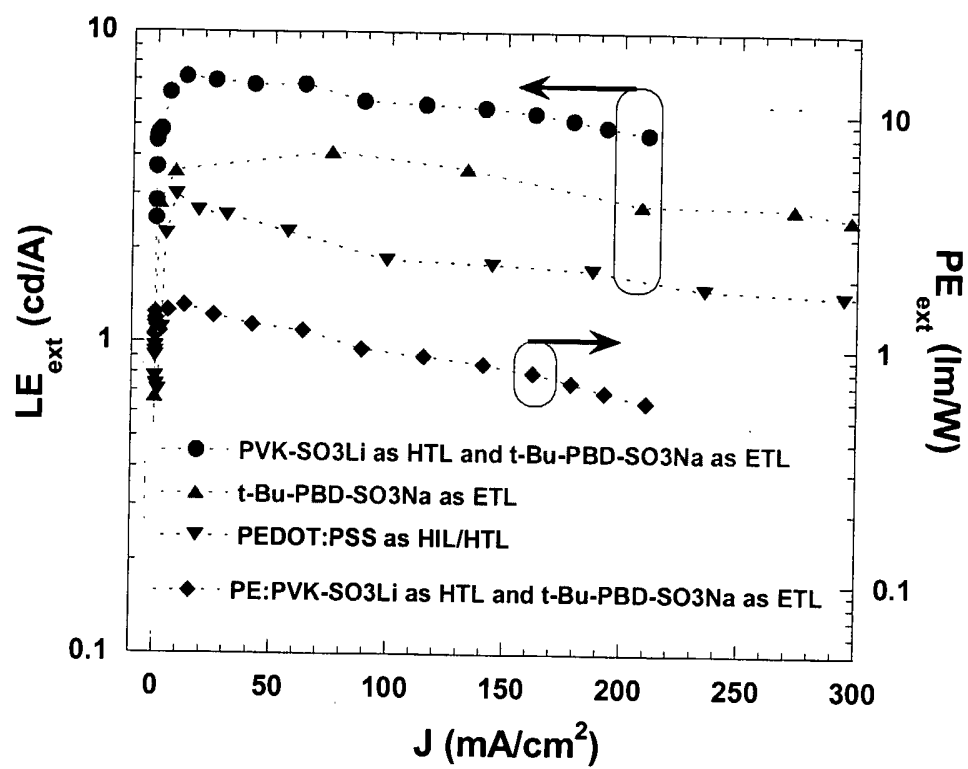


Fig. 7

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US2005/031911

A. CLASSIFICATION OF SUBJECT MATTER C08G73/00 C08G61/00 H01L51/00 C08G73/02 C08G73/08 C08G61/02 C08G61/10 C08G61/12 H01L51/30		
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 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, PAJ		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 2004/037886 A (AGENCY FOR SCIENCE TECHNOLOGY AND RESEARCH; LIU, BIN) 6 May 2004 (2004-05-06) page 1, line 5 - page 14, line 5; claims 1-59; figures; examples 1-10 -----	1-25
X,P	WO 2005/056628 A (THE REGENTS OF THE UNIVERSITY OF CALIFORNIA; BAZAN, GUILLERMO, C; LIU,) 23 June 2005 (2005-06-23) page 1, line 11 - page 27, line 21; claims 1-20; figures; examples 1,2 -----	1-25
X	US 2002/064680 A1 (SPREITZER HUBERT ET AL) 30 May 2002 (2002-05-30) paragraphs '0011! - '0022!; claims 1-20; figures; examples ----- -/--	1-25
☒ Further documents are listed in the continuation of box C. ☒ Patent family members are listed in annex.		
* Special categories of cited documents : * 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 * 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 20 December 2005		Date of mailing of the international search report 05/01/2006
Name and mailing address of the ISA European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040. Tx. 31 651 epo nl, Fax: (+31-70) 340-3016		Authorized officer Kiebooms, R

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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

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Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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