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(54) **Title:** ION CONDUCTIVE RANDOM COPOLYMERS

(57) **Abstract:** This invention relates to ion conducting random copolymers that are useful in forming polymer electrolyte membranes used in fuel cells.

ION CONDUCTIVE RANDOM COPOLYMERS

TECHNICAL FIELD

This invention relates to ion conductive random copolymers that are useful in forming polymer electrolyte membranes used in fuel cells.

BACKGROUND OF THE INVENTION

Fuel cells have been projected as promising power sources for portable electronic devices, electric vehicles, and other applications due mainly to their non-polluting nature. Of various fuel cell systems, the polymer electrolyte membrane based fuel cell technology such as direct methanol fuel cells (DMFCs) has attracted much interest thanks to their high power density and high energy conversion efficiency. The “heart” of a polymer electrolyte membrane based fuel cell is the so called “membrane-electrode assembly” (MEA), which comprises a proton conducting polymer electrolyte membrane (PEM), catalyst disposed on the opposite surfaces of the PEM to form a catalyst coated member (CCM) and a pair of electrodes (*i.e.*, an anode and a cathode) disposed to be in electrical contact with the catalyst layer.

Proton-conducting membranes for DMFCs are known, such as Nafion® from the E.I. Dupont De Nemours and Company or analogous products from Dow Chemicals. These perfluorinated hydrocarbon sulfonate ionomer products, however, have serious limitations when used in DMFC's. Nafion® loses conductivity when the operation temperature of the fuel cell is over 80°C. Moreover, Nafion® has a very high methanol crossover rate, which impedes its applications in DMFCs.

U.S. Patent No. 5,773,480, assigned to Ballard Power System, describes a partially fluorinated proton conducting membrane from α , β , β -trifluorostyrene. One disadvantage of this membrane is its high cost of manufacturing due to the complex synthetic processes for monomer α , β , β -trifluorostyrene and the poor sulfonation ability of poly (α , β , β -trifluorostyrene). Another disadvantage of this membrane is that it is very brittle, thus has to be incorporated into a supporting matrix.

U.S. Patent Nos. 6,300,381 and 6,194,474 to Kerrres, et al. describe an acid-base binary polymer blend system for proton conducting membranes, wherein the sulfonated poly(ether sulfone) was made by post-sulfonation of the poly (ether sulfone).

M. Ueda in the Journal of Polymer Science, 31(1993): 853, discloses the use of sulfonated monomers to prepare the sulfonated poly(ether sulfone polymers).

U.S. Patent Application US 2002/0091225A1 to McGrath, et al. used this method to prepare sulfonated polysulfone polymers.

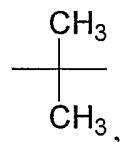
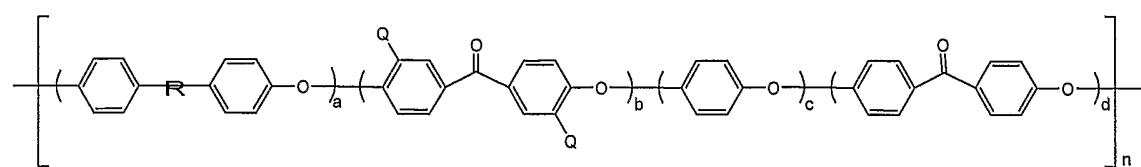
The need for a good membrane for fuel cell operation requires balancing of various properties of the membrane. Such properties included proton conductivity, methanol-resistance, chemical stability and methanol crossover, fast start up of DMFCs, and durability to cell performance. In addition, it is important for the membrane to retain its dimensional stability over the fuel operational temperature range. In DMFC's methanol oxidation generates enough heat to raise the cell temperature. If the membrane swells significantly, it will increase methanol crossover. The membrane thus gradually loses its ability to block methanol crossover, resulting in degradation of cell performance. The dimension changes of the membrane also put a stress on the bonding of the membrane-electrode assembly (MEA). Often this results in delamination of the membrane from the electrode after excessive swelling of the membrane. Therefore, maintaining the dimensional stability over a wide temperature range and avoiding excessive membrane swelling are important for DMFC applications.

SUMMARY OF THE INVENTION

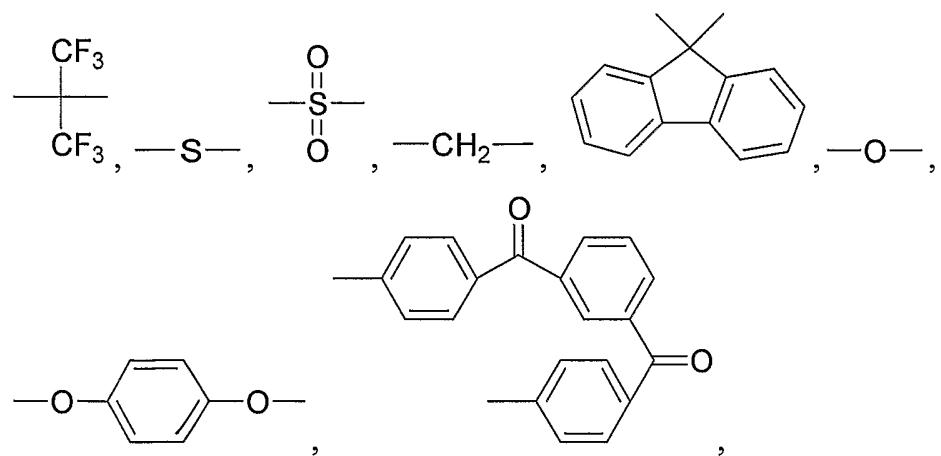
In one aspect, the invention provides sulfonated random copolymer compositions which can be used to fabricate polymer electrolyte membranes (PEM's), catalyst coated membrane (CCM's) and membrane electrode assemblies (MEAs) which are useful in fuel cells.

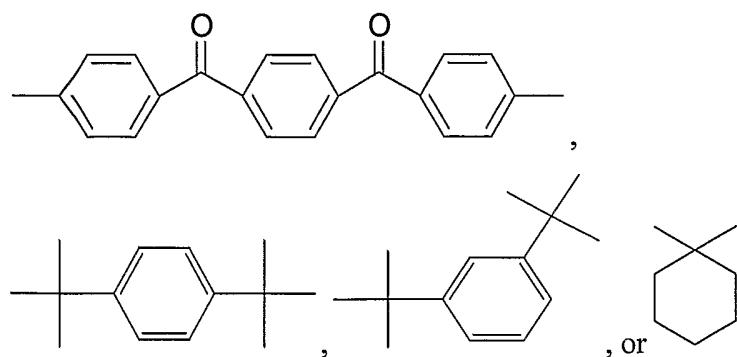
The invention includes three classes of random ion conductive copolymers. Such random polymers are of the following formulas:

Formula I



wherein R is a single bond, a cycloaliphatic of the formula $\text{C}_n\text{H}_{2n-2}$,

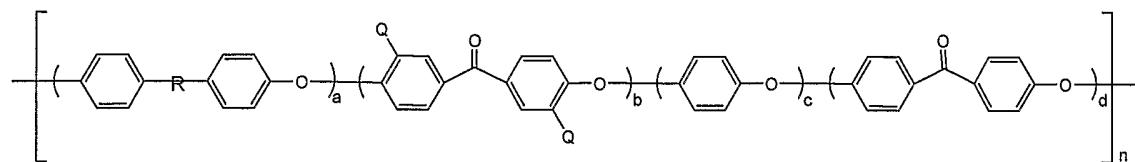




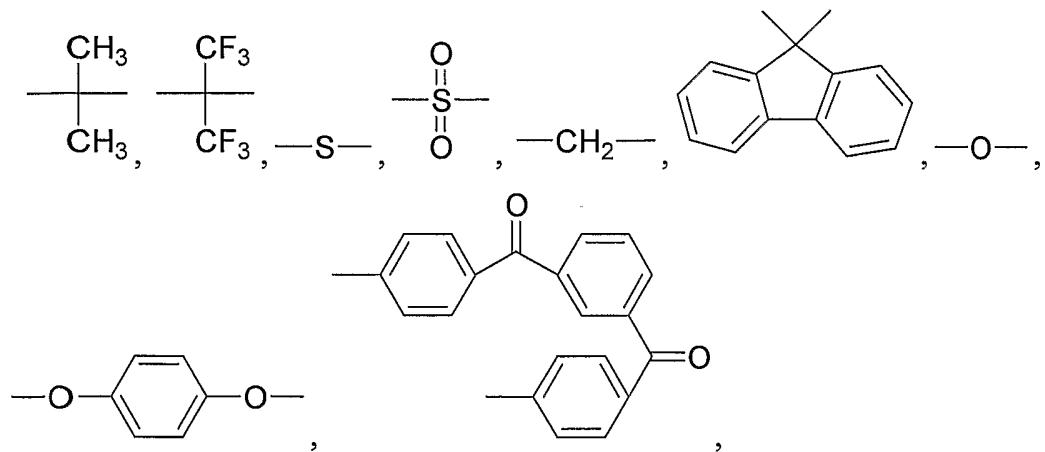
wherein a, b, c and d are mole fractions of the monomer present in the copolymer where each are independently, from 0.01 to 1;

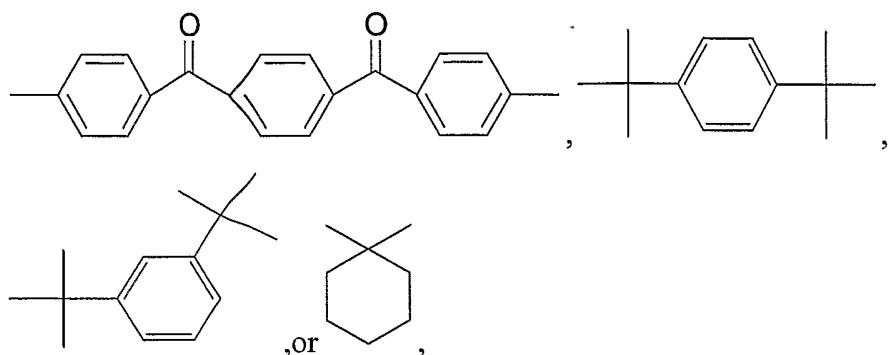
Q is an ion conducting group comprising $-\text{SO}_3\text{X}$, $-\text{COOX}$ $-\text{PO}_3\text{X}$ or $-\text{SO}_2\text{-NH-SO}_2\text{R}_f$, where R_f is a prefluorinated hydrocarbon having 1-20 carbon atoms; and wherein X is a cation or a proton.

Formula II



wherein R1 or R2 are independently a single bond, a cycloaliphatic of the formula $\text{C}_n\text{H}_{2n-2}$,





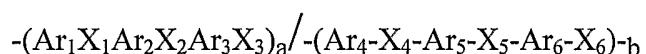
where R3 is aryl ketone, aryl sulfone, aryl nitrile, and substituted aryl nitrile;

wherein a, b, c and d are mole fractions of the monomer present in the copolymer where each are independently, from 0.01 to 1;

Q is an ion conducting group comprising $-\text{SO}_3\text{X}$, $-\text{COOX}$ $-\text{PO}_3\text{X}$ or $-\text{SO}_2\text{-NH-SO}_2\text{R}_f$, and wherein X is a cation or a hydrogen atom.

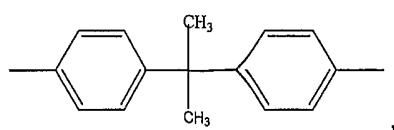
In another embodiment, four comonomers are used to make the ion conductive copolymer, where at least one comonomer is ion conducting. A specific embodiment is set forth in Formula III.

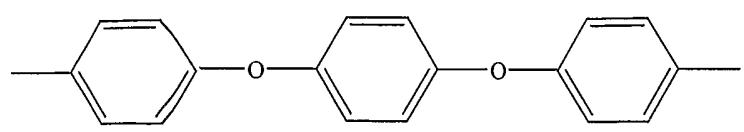
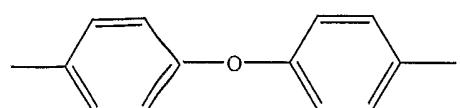
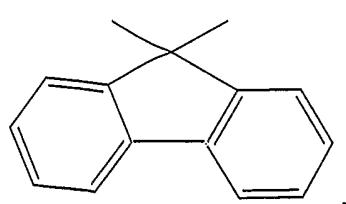
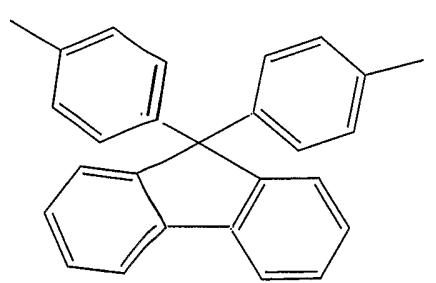
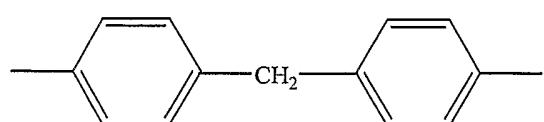
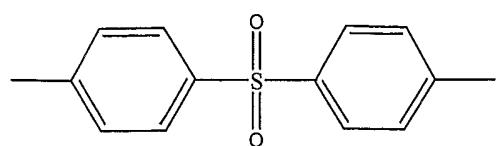
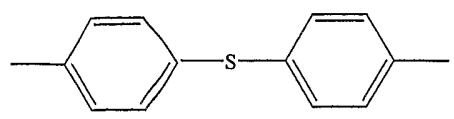
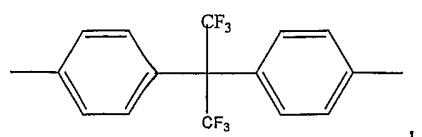
Formula III

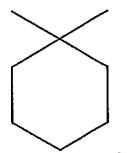
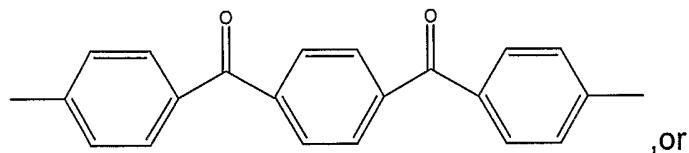
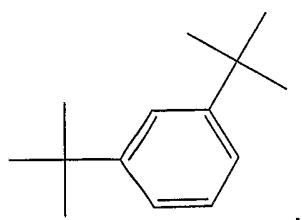


where Ar_1 , Ar_2 , Ar_4 , Ar_5 are independently phenyl, substituted phenyl napthyl, terphenyl, aryl nitrile, substituted aryl nitrile, and Ar_4 and/or Ar_5 further comprise an ion conducting group, X_1 and X_4 are independently $-\text{C}(\text{O})-$ or $-\text{S}(\text{O})_2$, X_2 , X_3 , X_5 and X_6 are independently $-\text{O}-$ or $-\text{S}-$.

Ar_3 and Ar_6 are the same or different from each other and are:





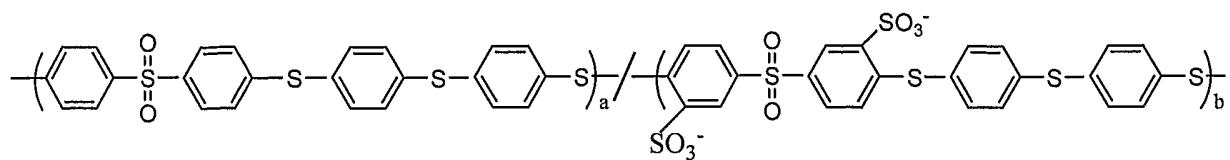


wherein the ion conductive group comprises $-\text{SO}_3\text{H}$, $-\text{COOH}$, $-\text{HPO}_3\text{H}$ or $-\text{SO}_2\text{NH-SO}_2\text{RF}$ where RF is a perfluorinated hydrocarbon having 1-20 carbon atoms and said ion conducting group are pendant to the copolymer backbone;

wherein a is between 0.01 and 0.99, b is between 0.01 and 0.99, $a + b = 1.0$.

In some embodiments, at least one of X_2 , X_3 , X_5 and/or X_6 is S. In some embodiments, X_1 and/or X_4 is $-\text{S}(\text{O})_2\text{-}$. In other embodiments, X_1 and/or X_4 is $-\text{C}(\text{O})\text{-}$. In still other embodiments, X_1 is $-\text{S}(\text{O})_2\text{-}$ and X_4 is $-\text{C}(\text{O})\text{-}$. In other embodiments, A_3 and A_6 are different.

A particularly preferred embodiment is Formula IV:

Formula IV

Where A = 0.60 and B= 0.40

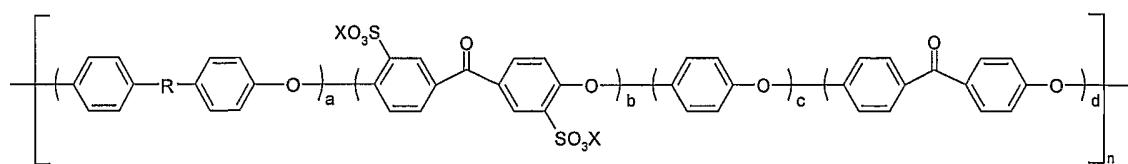
BRIEF DESCRIPTION OF THE DRAWINGS

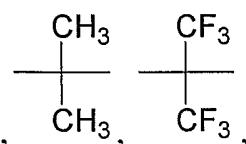
FIG. 1 demonstrates the performance of DMAc containing PEM's made of the copolymers of Example 20, Example 17 and Example 22 as compared between 50 and 100% relative humidity.

DETAILED DESCRIPTION

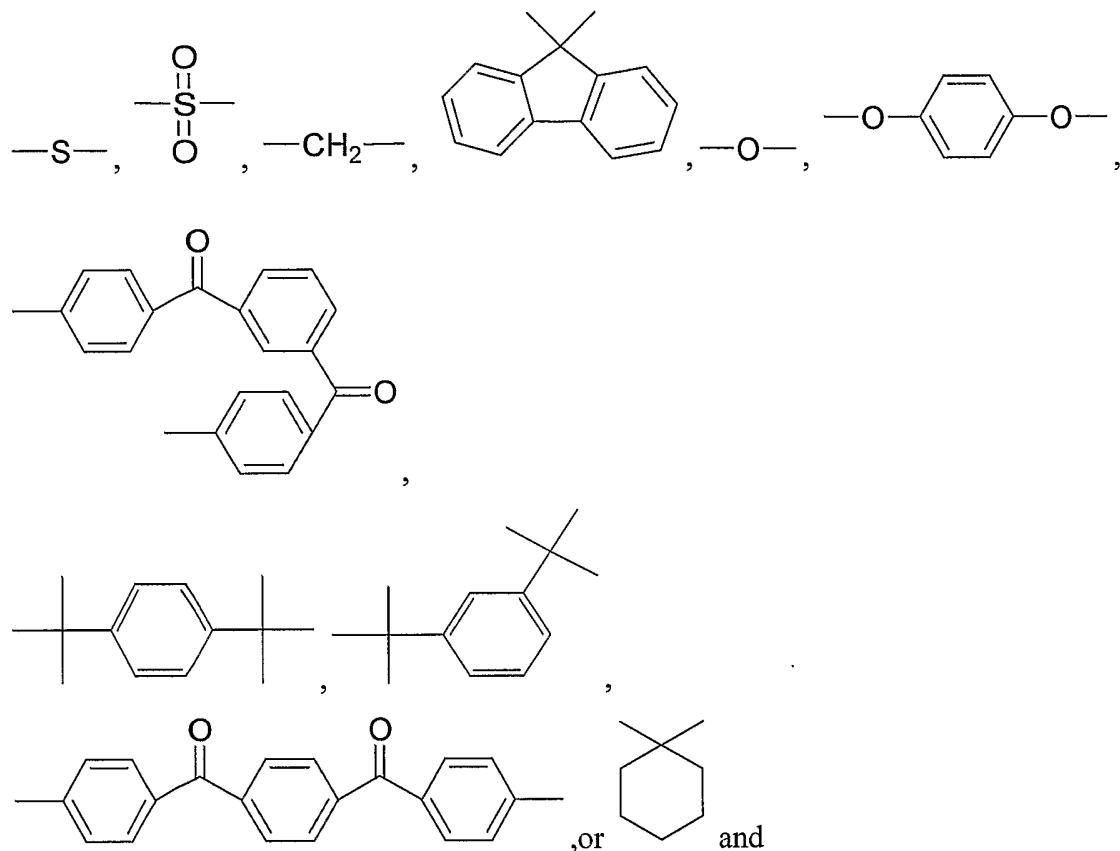
The invention provides random copolymers that are ion conductive. One use of such polymeric material is in the formation of polymer electrolyte membranes (PEMs), catalyst coated membrane (CCM) and membrane electrode assemblies (MCA's), which may be used in fuel DMFC's fuel cells.

In one embodiment, random ion conductive copolymers can be made having the following formula:

Formula V



wherein R is a bond, a cycloaliphatic of the formula CnH_{2n-2} ,



Q is an ion conducting group comprising $-\text{SO}_3\text{X}$, $-\text{COOX}$, $-\text{PO}_3\text{X}$ or $-\text{SO}_2\text{-NH-SO}_2\text{R}_f$ where R_f is a perfluorinated hydrocarbon of 1-20 carbon atoms and where X is a cation or probe.

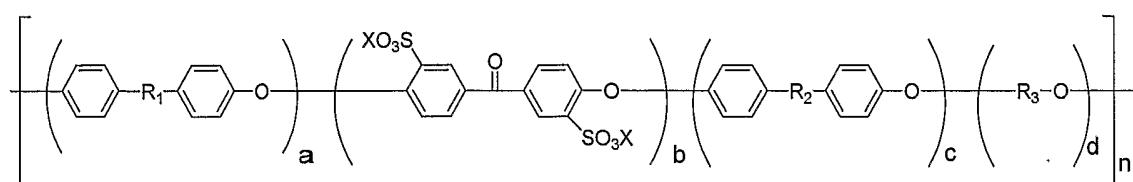
In this copolymer, a, b, c and d are mole fractions of each of the monomers present in the copolymer where each are independently, from 0.01 to about 1. In one particular embodiment, R is isopropylidene, cyclohexylidene, 11.4 diphenylene di-isopropylene.

In general, the sulfonated copolymers include reaction products wherein $(a+c)=(b+d)$, a is from about 0.05 to about 0.95, b is from about 0.01 to about 0.95, c is from about 0 to about 0.95 and d is from about 0 to about 0.99. Preferably, a is from about 0.10 to about 1.00, b is from about 0.05 to about 0.85, c is from about 0 to about 0.90 and d is from about 0.15 to about 0.95. Most preferably, a is from about 0.20 to about 0.9, b is from

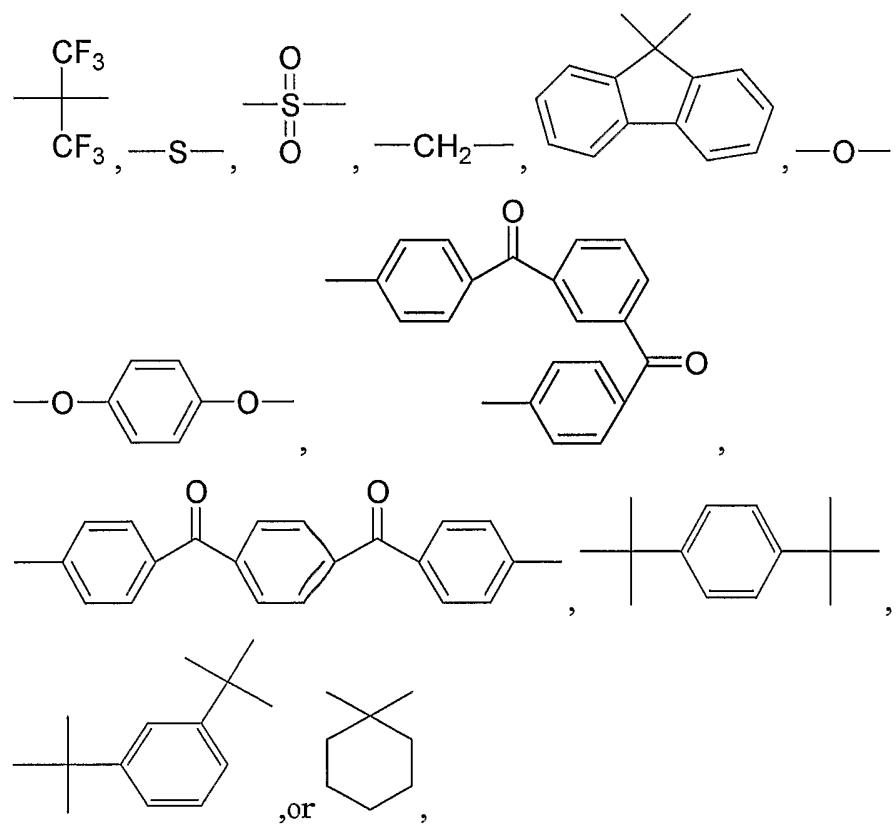
about 0.10 to about 0.45, c is from about 0 to about 0.80 and d is from about 0.55 to about 0.90.

In another embodiment, the invention pertains to random ion conductive copolymers and proton exchange membranes having the formula:

Formula VI



wherein R₁ or R₂ is a single bond, a cycloaliphatic of the formula C_nH_{2n-2},



where R₃ is aryl ketone, aryl sulfone, aryl nitrile, and substituted aryl nitrile.

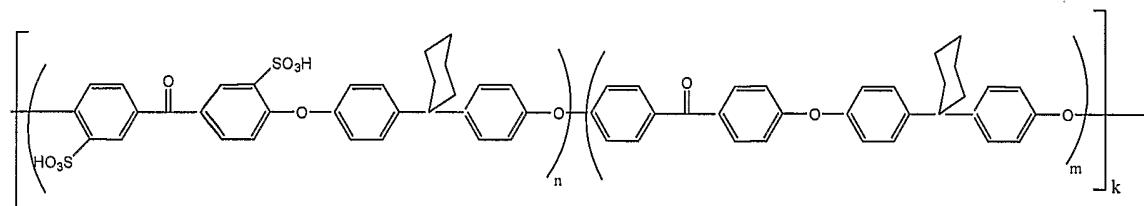
wherein a, b, c and d are mole fractions of the monomer present in the copolymer where each are independently, from 0.01 to 1;

Q is an ion conducting group comprising $-\text{SO}_3\text{X}$, $-\text{COOX}$ $-\text{PO}_3\text{X}$ or $-\text{SO}_2\text{-NH-SO}_2\text{R}_f$, where R_f is a prefluorinated hydrocarbon having 1-20 carbon atoms; and wherein X is a cation or a proton.

In the sulfonated copolymer, a, b, c and d are mole fractions for each monomer present in the copolymer, each independently from 0.01 to about 1 and X is a cation or a hydrogen atom. In a preferred embodiment, R1 is cyclohexyldyl, and R2 is fluorenyl.

In general, the sulfonated copolymers include reaction products wherein $(a+c)=1.00$, $(b+d)=1.00$, a is from about 0.05 to about 1.00, b is from about 0.01 to about 1.00, c is from about 0 to about 0.95 and d is from about 0 to about 0.99. Preferably, a is from about 0.10 to about 1.00, b is from about 0.05 to about 0.85, c is from about 0 to about 0.90 and d is from about 0.15 to about 0.95. Most preferably, a is from about 0.20 to about 1.00, b is from about 0.10 to about 0.45, c is from about 0 to about 0.80 and d is from about 0.55 to about 0.90.

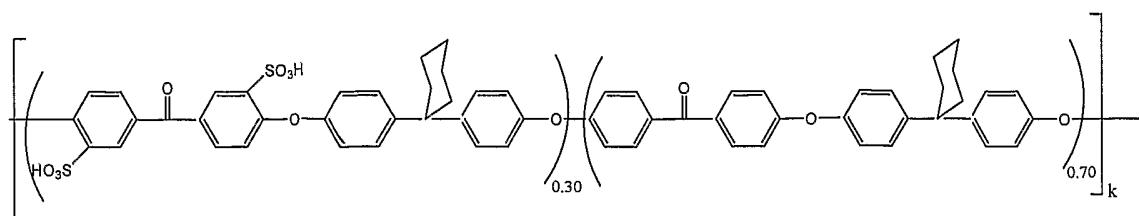
A particularly preferred random copolymer is:



where n and m are mole fractions and, n plus m equals 1,

n is between 0.1 and 0.5, more preferably between 0.2 and 0.4 and most preferably between 0.25 and 0.35, m is 1 minus n, and k is between 40 and 200 more preferably between 50 and 100.

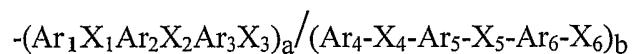
In a particularly preferred polymer, n is 0.3 and m is 0.7 and has the formula:



where k is between 40 and 200.

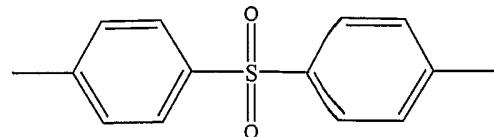
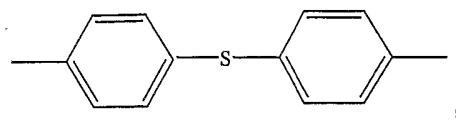
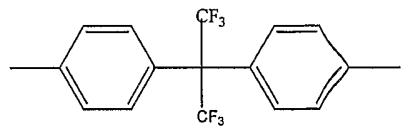
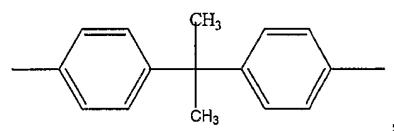
Ion conductive polymers can also be represented by Formula III:

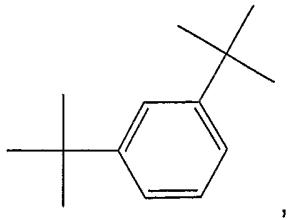
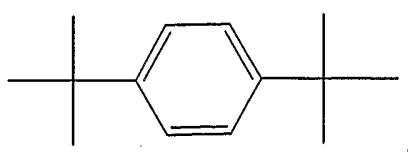
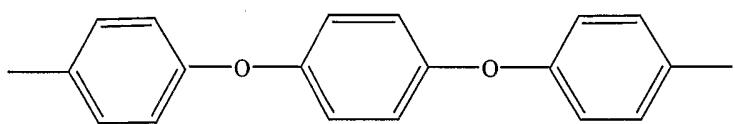
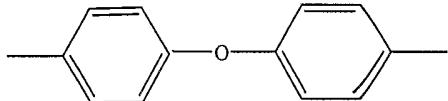
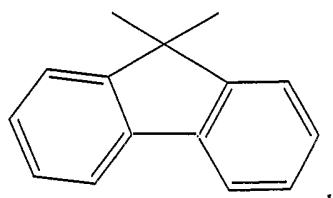
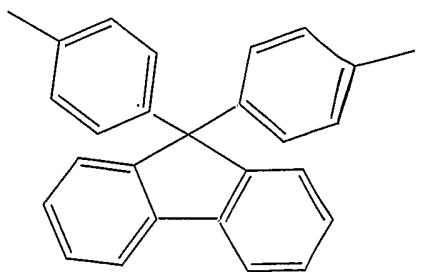
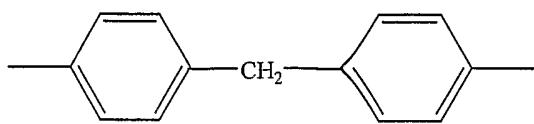
Formula III

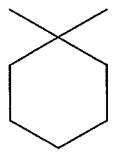
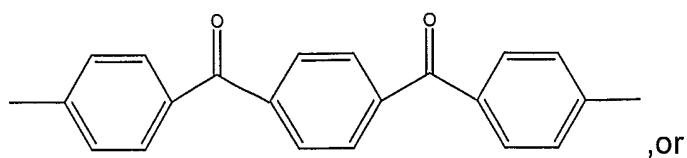


where Ar_1 , Ar_2 , Ar_4 , Ar_5 are independently phenyl, substituted phenyl naphthyl, terphenyl, aryl nitrile, substituted aryl nitrile, and Ar_4 and/or Ar_5 further comprise an ion conducting group, X_1 and X_4 are independently $-C(O)-$ or $-S(O)_2$, X_2 , X_3 , X_5 and X_6 are independently $-O-$ or $-S-$.

Ar_3 and Ar_6 are the same or different from each other and are



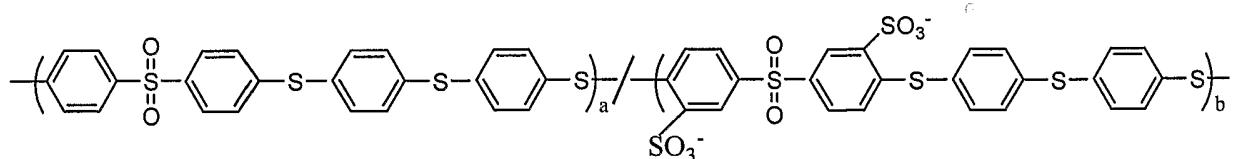




wherein the ion conductive groups comprise SO_3^- , $-\text{COO}^-$, H_2PO_3^- or sulfonimide.

wherein a is between 0.01 and 0.99, b is between 0.01 and 0.99, $a + b = 1.0$.

A particularly preferred embodiment is Formula IV:



Where $A = 0.60$ and $B = 0.40$

Polymer membranes may be fabricated by solution casting of the ion conductive copolymer. Alternatively, the polymer membrane may be fabricated by solution casting the ion conducting polymer the blend of the acid and basic polymer.

When cast into a membrane for use in a fuel cell, it is preferred that the membrane thickness be between 1 to 10 mils, more preferably between 2 and 6 mils, most preferably between 3 and 4 mils.

As used herein, a membrane is permeable to protons if the proton flux is greater than approximately 0.005 S/cm, more preferably greater than 0.01 S/cm, most preferably greater than 0.02 S/cm.

As used herein, a membrane is substantially impermeable to methanol if the methanol transport across a membrane having a given thickness is less than the transfer of methanol across a Nafion membrane of the same thickness. In preferred embodiments the

permeability of methanol is preferably 50% less than that of a Nafion membrane, more preferably 75% less and most preferably greater than 80% less as compared to the Nafion membrane.

After the sulfonated random copolymer has been formed into a membrane (PEM), it may be used to produce a catalyst coated membrane (CCM). As used herein, a CCM comprises a PEM where at least one side and preferably both of the opposing sides of the PEM are partially or completely coated with catalyst layers. The catalyst is preferably a layer made of catalyst and ionomer. Preferred catalysts are Pt and Pt-Ru. Preferred ionomers include Nafion and other ion conductive polymers.

In general, anode and cathode catalysts are applied onto the membrane by well established standard techniques. For direct methanol fuel cells, platinum/ruthenium catalyst is typically used on the anode side while platinum catalyst is applied on the cathode side and platinum is applied on the cathode side. Catalysts may be optionally supported on carbon. The catalyst is initially dispersed in a small amount of water (about 100mg of catalyst in 1 g of water). To this dispersion a 5% Nafion solution in water/alcohol is added (0.25-0.75 g). The resulting dispersion may be directly painted onto the polymer membrane. Alternatively, isopropanol (1-3 g) is added and the dispersion is directly sprayed onto the membrane. The catalyst may also be applied onto the membrane by decal transfer, as described in the open literature (*Electrochimica Acta*, 40: 297 (1995)).

The CCM is used to make MEA's. As used herein, an MEA refers to an ion conducting polymer membrane made from a CCM according to the invention in combination with anode and cathode electrodes positioned to be in electrical contact with the catalyst layer of the CCM.

The electrodes are in electrical contact with a membrane, either directly or indirectly, when they are capable of completing an electrical circuit which includes the polymer membrane and a load to which a electric current is supplied. More particularly, a first catalyst is electrocatalytically associated with the anode side of the membrane so as to facilitate the oxidation of organic fuel. Such oxidation generally results in the formation

of protons, electrons, carbon dioxide and water. Since the membrane is substantially impermeable to organic fuels such as methanol, as well as carbon dioxide, such components remain on the anodic side of the membrane. Electrons formed from the electrocatalytic reaction are transmitted from the cathode to the load and then to the anode. Balancing this direct electron current is the transfer of an equivalent number of protons across the membrane to the anodic compartment. There an electrocatalytic reduction of oxygen in the presence of the transmitted protons occurs to form water. In one embodiment, air is the source of oxygen. In another embodiment, oxygen-enriched air is used.

The membrane electrode assembly is generally used to divide a fuel cell into anodic and cathodic compartments. In such fuel cell systems, an organic fuel such as methanol is added to the anodic compartment while an oxidant such as oxygen or ambient air is allowed to enter the cathodic compartment. Depending upon the particular use of a fuel cell, a number of cells can be combined to achieve appropriate voltage and power output. Such applications include electrical power sources for residential, industrial, commercial power systems and for use in locomotive power such as in automobiles. Other uses to which the invention finds particular use includes the use of fuel cells in portable electronic devices such as cell phones and other telecommunication devices, video and audio consumer electronics equipment, computer laptops, computer notebooks, personal digital assistants and other computing devices, GPS devices and the like. In addition, the fuel cells may be stacked to increase voltage and current capacity for use in high power applications such as industrial and residential services or used to provide locomotion to vehicles. Such fuel cell structures include those disclosed in U.S. Patent Nos. 6,416,895, 6,413,664, 6,106,964, 5,840,438, 5,773,160, 5,750,281, 5,547,776, 5,527,363, 5,521,018, 5,514,487, 5,482,680, 5,432,021, 5,382,478, 5,300,370, 5,252,410 and 5,230,966.

Such CCM and MEM's are generally useful in fuel cells such as those disclosed in U.S. Patent Nos. 5,945,231, 5,773,162, 5,992,008, 5,723,229, 6,057,051, 5,976,725, 5,789,093, 4,612,261, 4,407,905, 4,629,664, 4,562,123, 4,789,917, 4,446,210, 4,390,603, 6,110,613, 6,020,083, 5,480,735, 4,851,377, 4,420,544, 5,759,712, 5,807,412, 5,670,266, 5,916,699, 5,693,434, 5,688,613, 5,688,614, each of which is expressly incorporated herein by reference.

In another aspect, the invention relates to methods for the preparation of the ion conducting (e.g., sulfonate) random copolymers that are useful as polymer electrolyte membranes. In general, the methods to prepare the include combining a first monomer having at least one ion conducting group such as a sulfonate group with a second comonomer. The first monomer should have at least two leaving groups and the second comonomer should have at least two groups that can displace at least one leaving group of the first monomer. A third comonomer is included that has at least two leaving groups, such that at least one of the displacing groups of the second comonomer can displace at least one of the leaving groups of the third comonomer.

In a particular embodiment for the preparation of such polymers, the process further includes the step of combining a fourth comonomer having at least two displacing groups that can react with the leaving groups of either the first comonomer or the third comonomer.

The term “leaving group” is intended to include those functional moieties that can be displaced by a nucleophilic moiety found, typically, in another monomer. Leaving groups are well recognized in the art and include, for example, halides (chloride, fluoride, iodide, bromide), tosyl, mesyl, etc. In certain embodiments, the monomer has at least two leaving groups, which are “para” to each other with respect to the aromatic monomer to which they are attached.

The term “displacing group” is intended to include those functional moieties that can act typically as nucleophiles, thereby displacing a leaving group from a suitable monomer. The result is that the monomer to which the displacing group is attached becomes attached, generally covalently, to the monomer to which the leaving group was associated with. An example of this is the displacement of fluoride groups from aromatic monomers by phenoxide or alkoxide ions associated with aromatic monomers.

EXAMPLES

Table I. Monomers Used

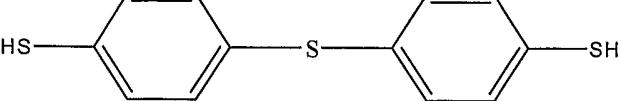
1) Difluoro-end monomers

Acronym	Full name	Molecular weight	Chemical structure
Bis K	4,4'-Difluorobenzophenone	218.20	
Bis SO ₂	4,4'-Difluorodiphenylsulfone	254.25	
S-Bis K	3,3'-disulfonated-4,4'-difluorobenzophenone	422.28	

2) Dihydroxy-end monomers

Bis AF (AF or 6F)	2,2-Bis(4-hydroxyphenyl)hexafluoropropane <i>or</i> 4,4'-(hexafluoroisopropylidene)diphenol	336.24	
BP	Biphenol	186.21	
Bis FL	9,9-Bis(4-hydroxyphenyl)fluorene	350.41	
Bis Z	4,4'-cyclohexylidenebisphenol	268.36	
Bis S	4,4'-thiodiphenol	218.27	

3) Dithiol-end monomers

Acronym	Full name	Molecular weight	Chemical Structure
3S	4,4'-thiol bis benzene thiol		

Example 1

Sulfonated PEEK with Bisphenol A composition

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, Bisphenol A (9.128g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g), anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175 to 180°C for 6h. The reaction mixture was precipitated with acetone or methanol to obtain the crude product, then washed with hot water four times. The dry polymer was dissolved in DMAc for 20% coating solution. The obtained 2mil thick membrane was soaked in 1.5M H₂SO₄ for 16hr (overnight) and then rinsed in DI water for several times until no H₂SO₄ residue was detected.

The polymer membrane was swollen in water at room temperature and the polymer membrane conductivity was measured by AC impedance. The polymer membrane was swollen in an 8M methanol aqueous mixture at 80 °C for 24 hours to measure the dimensional stability.

Methanol crossover was measured in 8M MeOH using H-Cell, and the permeation rate was obtained by gas chromatography analysis.

The membrane conductivity: 0.021S/cm, Swelling at 80C, 8M: 620% by area

8M-MeOH Cross-over : $6.9 \times 10^{-7} \text{ cm}^2/\text{sec.}$

Example 2**Sulfonated PEEK with 50% Bisphenol A and 50% Hydroquinone composition**

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, bisphenol A (4.564g), hydroquinone (2.202g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times. The dry polymer was dissolved in DMAC for 20% coating solution. The obtained 2mil thick membrane was soaked in 1.5M H₂SO₄ for 16hr (overnight) and then rinsed in DI water for several times until no H₂SO₄ residue was detected.

The membrane conductivity: 0.027 S/cm.

Example 3**Sulfonated PEEK with 4,4'-Thiodiphenol composition**

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-thiodiphenol (8.728g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times.

The membrane conductivity: 0.021 S/cm

Example 4**Sulfonated PEEK with 4,4'-(Hexafluoroisopropylidene)diphenol composition**

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-(hexafluoroisopropylidene)diphenol (13.452g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times. The dry polymer was dissolved in DMAC for 20% coating solution. The obtained 2mil thick membrane was soaked in 1.5M H₂SO₄ for 16hr (overnight) and then rinsed in DI water for several times until no H₂SO₄ residue was detected.

The membrane conductivity: 0.020S/cm.

Example 5**Sulfonated PEEK with 50% 4,4'-(Hexafluoroisopropylidene) diphenol and 50% Hydroquinone composition**

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-(hexafluoroisopropylidene)diphenol (6.726g), hydroquinone (2.202g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times. The dry polymer was dissolved in DMAC for 20% coating solution. The obtained 2mil thick membrane was soaked in 1.5M H₂SO₄ for 16hr (overnight) and then rinsed in DI water for several times until no H₂SO₄ residue was detected.

The membrane conductivity: 0.021 S/cm.

Example 6

Sulfonated PEEK with 4,4'-Cyclohexylidenebisphenol - hydroquinone composition (95/5)

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-cyclohexylidenebisphenol (10.1977gg), hydroquinone (0.2202g), 4, 4'-difluorobenzophone (6.1096g), sulfonated 4,4'-difluorobenzophone (5.0664g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times. The dry polymer was dissolved in DMAc for 20% coating solution. The obtained 2mil thick membrane was soaked in 1.5M H₂SO₄ for 16hr (overnight) and then rinsed in DI water for several times until no H₂SO₄ residue was detected.

The membrane conductivity: 0.017S/cm, Swelling at 80C, 8M: 120% by area

8M-MeOH Cross-over : 2.4 x 10⁻⁷ cm²/sec.

Example 7

This example discloses a random copolymer based on 4,4'-Cyclohexylidenebisphenol(BisZ)/Sulfonated Difluorobenzophenone(SBisk)/Difluorobenzophenone(Bisk).

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-cyclohexylidenebisphenol (10.7344gl), 4, 4'-difluorobenzophenone (6.546g), sulfonated 4,4'-difluorobenzophenone (4.222g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C

for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times. The conductivity and water up-take at room temperature are listed in table below.

Example 8

This example discloses a random copolymer based on 4,4'-Cyclohexylidenebisphenol(BisZ)/Sulfonated Difluorobenzophenone(SBisk)/Difluorobenzophenone(Bisk).

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-cyclohexylidenebisphenol (10.7344), 4, 4'-difluorobenzophenone (6.3714g), sulfonated 4,4'-difluorobenzophenone (4.5598g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times. The conductivity and water up-take at room temperature are listed in table below.

Example 9

This example discloses a random copolymer based on 4,4'-Cyclohexylidenebisphenol(BisZ)/Sulfonated Difluorobenzophenone(SBisk)/Difluorobenzophenone(Bisk).

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-cyclohexylidenebisphenol (10.7344g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the

crude product, then washed with hot water four times. The conductivity and water uptake at room temperature are listed in table below.

Molar Composition % (BisZ/SBisk/Bisk)	Conductivity S/cm	Swelling %
Example 7	0.005	25
Example 8	0.007	35
Example 9	0.017	120

Example 10

Sulfonated PEEK with 20% Hydroquinone/80% 4,4'-Cyclohexylidenebisphenol

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, hydroquinone (0.8808g), 4,4'-cyclohexylidenebisphenol (8.5875g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g) and anhydrous potassium carbonate (7.2g) were dissolved in a mixture of DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times.

The membrane conductivity: 0.030 S/cm, Swelling at 80C, 8M: 92 % by area

8M-MeOH Cross-over : 5.4×10^{-7} cm²/sec.

Example 11**Sulfonated PEEK with 50% Hydroquinone/50% 4,4'-Cyclohexylidenebisphenol**

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, hydroquinone (2.202g), 4,4'-cyclohexylidenebisphenol (5.3672g), 4, 4'-difluorobenzophenone (5.6732g), sulfonated 4,4'-difluorobenzophenone (5.9108g), anhydrous potassium carbonate (7.2g) were dissolved in a mixture DMSO and toluene (about 20% solid concentration). The mixture was heated to toluene reflux with stirring, keeping the temperature at 150°C for 4h, then increasing the temperature to 175-180°C for 6h. The reaction mixture was precipitated with acetone or methanol to get the crude product, then washed with hot water four times.

The membrane conductivity: 0.033S/cm, 8M-MeOH Cross-over : $4.3 \times 10^{-7} \text{ cm}^2/\text{sec}$.

Example 12

In a 500 mL three necked round flask, equipped with a mechanical stirrer, a thermometer probe connected with a nitrogen inlet, and a Dean-Stark trap/condenser, bis(4-fluorophenyl)sulfone (BisS, 24.79 g, 0.0975 mol), 3,3'-disulfonated-4,4'-difluorobenzophenone (SbisK, 22.16 g, 0.0525 mol), BisZ (40.25 g, 0.15 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of Toluene. The reaction mixture was slowly stirred under a slow nitrogen stream. After heating at ~85 °C for 1h and at ~120 °C for 1 h, the reaction temperature was raised to ~135 °C for 3 h, and finally to ~170 °C for 2 h. After cooling to ~70 °C with continuing stirring, the viscous solution was dropped into 1L of cooled methanol with a vigorous stirring. The noodle-like precipitates were cut and washed with di-water four times and dried at 80 °C overnight. The sodium form polymer was exchanged to acid form by washing the polymer in hot sulfuric acid solution (0.5 M) twice (1 h each) and in cold di-water twice. The polymer was then dried at 80 °C overnight and at 80 °C under vacuum for 2 days. This polymer has an inherent viscosity of 0.60 dl/g in DMAc (0.25 g/dl). It's one-day swelling in 8M Methanol at 80°C was 142%, cross-over in 8 M methanol was 0.009 mg.mil/cc.min.cm² (boiled), conductivity was 0.013 S/cm (non-boiled) and 0.041 S/cm (boiled).

Example 13

This polymer was synthesized in a similar way as described in example 1, using following compositions: bis(4-fluorophenyl)sulfone (BisS, 22.88 g, 0.090 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SbisK, 25.34 g, 0.060 mol), BisZ (40.25 g, 0.15 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of Toluene. This polymer has an inherent viscosity of 0.67 dl/g in DMAc (0.25 g/dl).

Example 14

This polymer was synthesized in a similar way a described in example 1, using the following compositions: BisK (10.69 g, 0.049 mol), 2,6-difluorobenzonitrile (5.86 g, 0.042 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 20.69 g, 0.049 mol), BisZ (37.57 g, 0.14 mol), and anhydrous potassium carbonate (25.15 g, 0.18 mol), 270 mL of DMSO and 135 mL of toluene. This polymer has an inherent viscosity of 0.86 dl/g in DMAc (0.25 g/dl).

Example 15

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 14.18 g, 0.065 mol), 3,3'-disulfonated-4,4'-difluorobenzophone ((SBisK, 14.78 g, 0.035 mol), 9,9-bis(4-hydroxyphenyl)fluorene (35.04 g, 0.10 mol), anhydrous potassium carbonate (17.97 g, 0.13 mol), anhydrous DMSO (180 mL) and freshly distilled toluene (90 mL). This polymer has an inherent viscosity of 0.88 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 26%, cross-over in 8 M methanol was 0.013 mg.mil/cc.min.cm² (non-boiled) and 0.016 mg.mil/cc.min.cm² (boiled), conductivity was 0.010 S/cm (non-boiled) and 0.019 S/cm (boiled).

Example 16

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 19.64 g, 0.09 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 25.34 g, 0.06 mol), 9,9-bis(4-

hydroxyphenyl)fluorene (52.56 g, 0.15 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of toluene. This polymer has an inherent viscosity of 0.77 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 35%, cross-over in 8 M methanol was 0.016 mg.mil/cc.min.cm² (non-boiled) and 0.016 mg.mil/cc.min.cm² (boiled), conductivity was 0.015 S/cm (non-boiled) and 0.023 S/cm (boiled).

Example 17

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 18.33 g, 0.084 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 23.65 g, 0.056 mol), 1,1-bis(4-hydroxyphenyl)cyclohexane (BisZ, 18.78 g, 0.070 mol), 9,9-bis(4-hydroxyphenyl)fluorene (FL, 24.53 g, 0.070 mol), and anhydrous potassium carbonate (25.15 g, 0.18 mol), 250 mL of DMSO and 125 mL of toluene. This polymer has an inherent viscosity of 0.97 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 54%, cross-over in 8 M methanol was 0.015 mg.mil/cc.min.cm² (non-boiled) and 0.025 mg.mil/cc.min.cm² (boiled), conductivity was 0.018 S/cm (non-boiled) and 0.042 S/cm (boiled).

Example 18

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 21.27 g, 0.0975 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 22.17 g, 0.0525 mol), 9,9-bis(4-hydroxyphenyl)fluorene (FL, 26.28 g, 0.075 mol), 4,4'-dihydroxydiphenyl ether (O, 15.16 g, 0.075 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of toluene. This polymer has an inherent viscosity of 1.21 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 50%, cross-over in 8 M methanol was 0.023 mg.mil/cc.min.cm² (non-boiled), conductivity was 0.030 S/cm (non-boiled) and 0.039 S/cm (boiled).

Example 19

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 21.27 g, 0.0975 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 22.17 g, 0.0525 mol), BisZ (20.12 g, 0.075 mol), 4,4'-dihydroxydiphenyl ether (O, 15.16 g, 0.075 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of toluene. This polymer has an inherent viscosity of 1.61 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 117%, cross-over in 8 M methanol was 0.019 mg.mil/cc.min.cm² (non-boiled), conductivity was 0.026 S/cm (non-boiled) and 0.057 S/cm (boiled).

Example 20

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 19.64 g, 0.09 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 25.34 g, 0.06 mol), 9,9-bis(4-hydroxyphenyl)fluorene (26.28 g, 0.075 mol), 4,4'-dihydroxydiphenyl ether (15.16 g, 0.075 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of toluene. This polymer has an inherent viscosity of 1.50 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 72%, cross-over in 8 M methanol was 0.023 mg.mil/cc.min.cm² (non-boiled), conductivity was 0.026 S/cm (non-boiled) and 0.056 S/cm (boiled).

Example 21

This polymer was synthesized in a similar way as described in example 1, using following compositions: 4,4'-difluorobenzophone (BisK, 21.27 g, 0.0975 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 22.17 g, 0.0525 mol), 4,4'-(Hexafluoroisopropylidene)-diphenol (25.21 g, 0.075 mol), 4,4'-hydroxyphenyl ether (15.16 g, 0.075 mol), and anhydrous potassium carbonate (26.95 g, 0.19 mol), 270 mL of DMSO and 135 mL of toluene. This polymer has an inherent viscosity of 1.10 dl/g in DMAc (0.25 g/dl). Its one-day swelling in 8 M methanol at 80°C was 232%, cross-over in 8 M methanol was 0.020 mg.mil/cc.min.cm² (non-boiled) and 0.079

mg.mil/cc.min.cm² (boiled), conductivity was 0.024 S/cm (non-boiled) and 0.061 S/cm (boiled).

Example 22

This polymer was synthesized in a similar way as described in example 1, using following compositions: BisK (17.02 g, 0.078 mol), 3,3'-disulfonated-4,4'-difluorobenzophone ((SBisK, 17.73 g, 0.042 mol), 2,5-dihydroxy-4'-methylbiphenol (MB, 24.03 g, 0.12 mol), and anhydrous potassium carbonate (21.56 g, 0.156 mol), 216 mL of DMSO and 108 mL of toluene. This polymer has an inherent viscosity of 1.07 dl/g in DMAc (0.25 g/dl).

Example 23

This polymer was synthesized in a similar way as described in example 1, using following compositions: BisK (9.93 g, 0.046 mol), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 10.34 g, 0.024 mol), 4,4'-dihydroxytetraphenylmethane (24.67 g, 0.050 mol), and anhydrous potassium carbonate (12.57 g, 0.091 mol), 126 mL of DMSO and 63 mL of toluene. This polymer has an inherent viscosity of 1.01 dl/g in DMAc (0.25 g/dl).

Example 24

This polymer was synthesized in a similar way as described in example 1, using following compositions: BisK (19.85 g), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 16.47), 9,9-bis(4-hydroxyphenyl)fluorene (22.77 g), Bis Z (17.44 g) and anhydrous potassium carbonate (23.36 g), 240 mL of DMSO and 120 mL of toluene. This polymer has an inherent viscosity of 0.74 dl/g in DMAc (0.25 g/dl).

Example 25

This polymer was synthesized in a similar way as described in example 1, using following compositions: BisK (19.85 g), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 16.47), 9,9-bis(4-hydroxyphenyl)fluorene (11.39 g), Bis Z (26.16 g) and

anhydrous potassium carbonate (23.36 g), 240 mL of DMSO and 120 mL of toluene. This polymer has an inherent viscosity of 0.63 dl/g in DMAc (0.25 g/dl).

Example 26

This polymer was synthesized in a similar way as described in example 1, using following compositions: BisK (19.85 g), 3,3'-disulfonated-4,4'-difluorobenzophone (SBisK, 16.47), 9,9-bis(4-hydroxyphenyl)fluorene (34.16 g), Bis Z (8.72 g) and anhydrous potassium carbonate (23.36 g), 240 mL of DMSO and 120 mL of toluene. This polymer has an inherent viscosity of 1.05 dl/g in DMAc (0.25 g/dl).

Example 27

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-(1,4-phenyldiisopropylidene)bisphenol (17.30g), Bis K(7.0915g), S-Bis K(7.3885g), , anhydrous potassium carbonate (9.0g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring, keeping the temperature at 140°C for 6h, then increase temperature to 173-175°C for 6h. The reaction mixture precipitates from methanol to get the rude product.

Conductivity: 0.0168S/cm (0.0436 S/cm, boiled), swelling by area in 8M methanol: 67%, 8M methanol cross-over: 0.013 mg/min.ml.ml.

Example 28

In a 500ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-(1,4-phenyldiisopropylidene)bisphenol (17.30g), Bis K(7.637g), S-Bis K(6.333g), anhydrous potassium carbonate (9.0g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring, keeping the temperature at 140°C for 6h, then increase temperature to 173-175°C for 6h. The reaction mixture precipitates from methanol to get the rude product.

Conductivity: 0.00786S/cm (0.0315 S/cm, boiled), swelling by area in 8M methanol: 41%, 8M methanol cross-over: 0.011 mg/min.ml.mls.

Example 29

This random copolymer was synthesized in a similar way as described in example 1: BisK (14.18 g), S-BisK (14.78 g), BisAF (33.62 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.82 dl/g in DMAc (0.25 g/dl). IEC is 1.23 meq/g. Conductivity: 0.019 S/cm (0.049 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 27%, water-uptake after boiling the membrane in water 1 hr : 31%

Example 30

This random copolymer was synthesized in a similar way as described in example 1: BisK (13.09 g), S-BisK (16.89 g), BisAF (33.62 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.18 dl/g in DMAc (0.25 g/dl). IEC is 1.38 meq/g. Conductivity: 0.030 S/cm (0.071 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 47%, water-uptake after boiling the membrane in water 1 hr : 53%

Example 31

This random copolymer was synthesized in a similar way as described in example 1: BisK (12.0 g), S-BisK (19.0 g), BisAF (33.62 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.18 dl/g in DMAc (0.25 g/dl). IEC is 1.38 meq/g. Conductivity: 0.045 S/cm (0.088 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 73%, water-uptake after boiling the membrane in water 1 hr : 85%

Example 32

This random copolymer was synthesized in a similar way as described in example 1: BisK (13.09 g), S-BisK (16.89 g), biphenol (18.62 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

IEC is 1.87 meq/g. Conductivity: 0.045 S/cm (0.071 S/cm, boiled in water 1hr), The membrane became mechanically weak (tears easily) after boiling in water, so swelling and water-uptake data were not obtained properly.

Example 33

This random copolymer was synthesized in a similar way as described in example 1: BisK (12.87 g), S-BisK (17.31 g), biphenol (9.81 g), BisAF (16.81 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.30 dl/g in DMAc (0.25 g/dl). IEC is 1.62 meq/g. Conductivity: 0.045 S/cm (0.090 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 47%, water-uptake after boiling the membrane in water 1 hr : 65%

Example 34

This random copolymer was synthesized in a similar way as described in example 1: BisK (11.35 g), S-BisK (20.27 g), biphenol (11.17 g), BisAF (13.45 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.29 dl/g in DMAc (0.25 g/dl). IEC is 1.92 meq/g. Conductivity: 0.063 S/cm (0.103 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 77%, water-uptake after boiling the membrane in water 1 hr : 89%

Example 35

This random copolymer was synthesized in a similar way as described in example 1: BisK (12.87 g), S-BisK (17.31 g), BisFL (7.01 g), BisAF (26.90 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.13 dl/g in DMAc (0.25 g/dl). IEC is 1.41 meq/g. Conductivity: 0.027 S/cm (0.054 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 33%, water-uptake after boiling the membrane in water 1 hr : 40%

Example 36

This random copolymer was synthesized in a similar way as described in example 1: BisSO₂ (15.51 g), S-BisK (16.47 g), BisFL (7.01 g), BisAF (26.90 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.07 dl/g in DMAc (0.25 g/dl). IEC is 1.30 meq/g. Conductivity: 0.018 S/cm (0.048 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 27%, water-uptake after boiling the membrane in water 1 hr : 29%

Example 37

This random copolymer was synthesized in a similar way as described in example 1: BisK (13.09 g), S-BisK (16.89 g), 4,4'-cyclohexylidenebisphenol (BisZ, 26.84 g), and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.01 dl/g in DMAc (0.25 g/dl). IEC is 1.57 meq/g. Conductivity: 0.038 S/cm (0.064 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 33%, water-uptake after boiling the membrane in water 1 hr : 45%

Example 38

This random copolymer was synthesized in a similar way as described in example 1: BisK (13.09 g), S-BisK (16.89 g), BisZ (13.42 g), BisAF (16.81 g) and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.14 dl/g in DMAc (0.25 g/dl). IEC is 1.47 meq/g. Conductivity: 0.027 S/cm (0.075 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 41%, water-uptake after boiling the membrane in water 1 hr : 50%

Example 39

This random copolymer was synthesized in a similar way as described in example 1: BisK (13.09 g), S-BisK (16.89 g), BisZ (5.37 g), BisAF (26.90 g) and anhydrous potassium carbonate (16.59 g) were dissolved in a mixture of DMSO and Toluene (about 20% solid concentration).

This polymer has an inherent viscosity of 1.08 dl/g in DMAc (0.25 g/dl). IEC is 1.42 meq/g. Conductivity: 0.027 S/cm (0.077 S/cm, boiled in water 1hr), swelling by area in boiled water 1 hr: 44%, water-uptake after boiling the membrane in water 1 hr : 55%

Example 40

In a 100ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-Thiolbisbenezenethiol (4.5074g), 4,4'-difluorophenyl sulfone(2.7459g), sulfonated 4,4'-difluorophenyl sulfone (3.2994g), anhydrous potassium carbonate (3.3g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring,

keeping the temperature at 140°C for 4h, then increase temperature to 175°C for 6h. The reaction mixture was filtered and precipitates from methanol to get the rude product, then washed by hot water four times.

The membrane conductivity: 0.088S/cm, Swelling after boiled: 98% by area, water uptake:69%. This formula is that set forth for Formula IIIA where a = 0.6 and c = 0.4

Example 41

In a 100ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-Thiolbisbenezenethiol (4.5074g), 4,4'-difluorophenyl sulfone(2.9747g), sulfonated 4,4'-difluorophenyl sulfone (2.8874g), anhydrous potassium carbonate (3.3g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring, keeping the temperature at 140°C for 4h, then increase temperature to 175°C for 6h. The reaction mixture was filtered and precipitates from methanol to get the rude product, then washed by hot water four times.

The membrane conductivity: 0.056S/cm, Swelling after boiled: 46% by area, water uptake:29%

Example 42

In a 100ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-Thiolbisbenezenethiol (4.5074g), 4,4'-difluorophenyl sulfone(3.3599g), sulfonated 4,4'-difluorophenyl sulfone (3.0933g), anhydrous potassium carbonate (3.3g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring, keeping the temperature at 140°C for 4h, then increase temperature to 175°C for 6h. The reaction mixture was filtered and precipitates from methanol to get the rude product, then washed by hot water four times.

Example 43

In a 100ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-Thiolbisbenezenethiol (4.5074g), 4,4'-difluorophenyl sulfone(2.9747g), sulfonated 4,4'-difluorophenyl sulfone (1.8306g), 2,5-Dichlorophenyl sulfone (1.1441g), anhydrous potassium carbonate (3.3g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring, keeping the temperature at 140°C for 4h, then increase temperature to 175°C for 6h. The reaction mixture was filtered and precipitates from methanol to get the rude product, then washed by hot water four times.

The membrane conductivity: 0.054S/cm, Swelling after boiled: 154% by area, water uptake:209%

Example 44

In a 100ml three necked round flask, equipped with a mechanical stirrer, thermometer, nitrogen inlet and Dean-Stark trap/condenser, 4,4'-Thiolbisbenezenethiol (3.3805g), 2,9-dihydroxyl-fluorene (1.53g), 4,4'-difluorophenyl sulfone (2.9747g), sulfonated 4,4'-difluorophenyl sulfone (2.8874g), anhydrous potassium carbonate (3.3g) were dissolved in a mixture DMSO and Toluene (about 20% solid concentration). The mixture was heated to toluene flux with stirring, keeping the temperature at 140°C for 4h, then increase temperature to 175°C for 6h. The reaction mixture was filtered and precipitates from methanol to get the rude product, then washed by hot water four times.

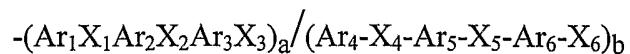
The membrane conductivity: 0.065S/cm, Swelling after boiled: 60% by area, water uptake:84%

All references cited throughout the specification, including those in the background, are specifically incorporated herein by reference in their entirety.

Although the present invention has been described with reference to preferred embodiments, persons skilled in the art will recognize that changes may be made in form and detail without departing from the spirit and scope of the invention.

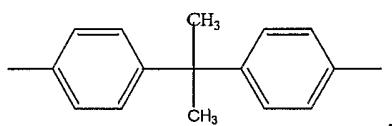
WHAT IS CLAIMED IS:

1. An ion conductive copolymer having the formula:

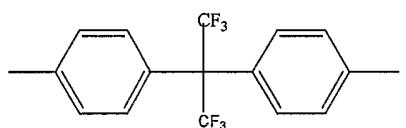


where Ar_1 , Ar_2 , Ar_4 , Ar_5 are independently phenyl, substituted phenyl napthyl, terphenyl, aryl nitrile, substitute aryl nitrile, and Ar_4 and/or Ar_5 further comprise an ion conducting group, X_1 and X_4 are independently $-C(O)-$ or $-S(O)_2$, X_2 , X_3 , X_5 and X_6 are independently $-O-$ or $-S-$ and wherein at least one of X_2 , X_3 , X_5 and X_6 is $-S-$;

10 Ar_3 and Ar_6 are the same or different from each other and are:

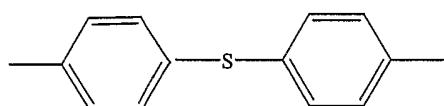


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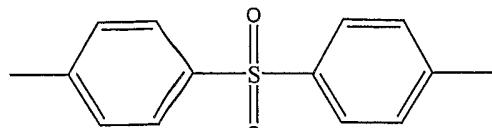


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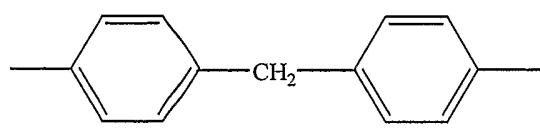


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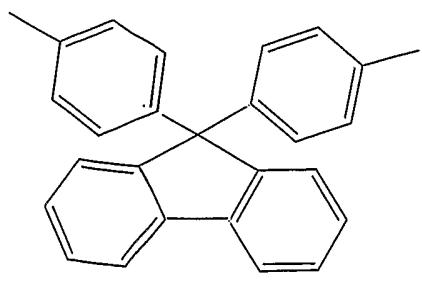


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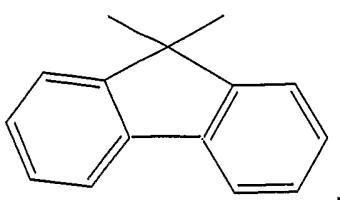
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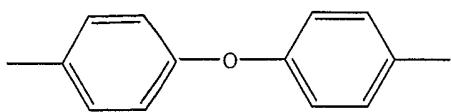
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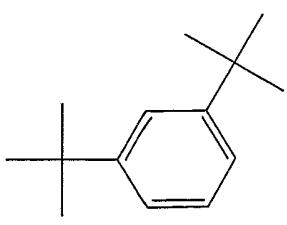
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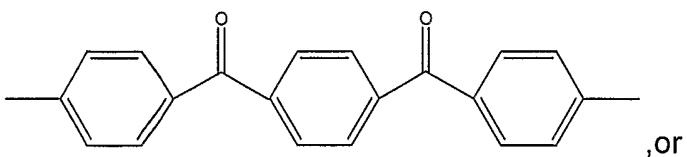


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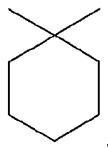


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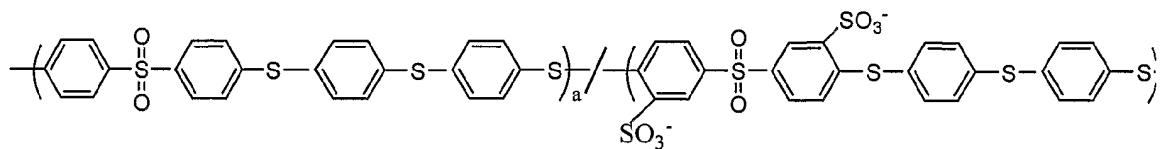
, or



wherein the ion conductive groups comprise SO_3^- , $-\text{COO}^-$, H_2PO_3^- or sulfonimide;

5 wherein a is between 0.01 and 0.99, b is between 0.01 and 0.99, and $a + b = 1.0$.

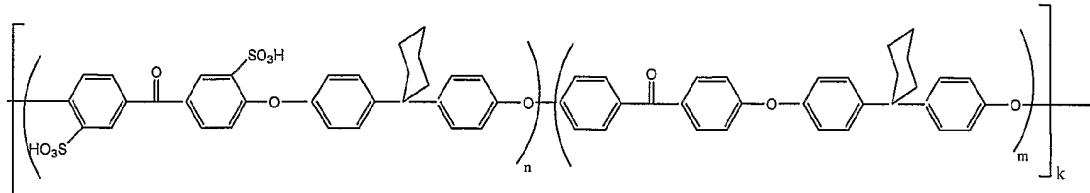
2. An ion conductive copolymer having the formula:



Where $A = 0.60$ and $B = 0.40$

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3. A sulfonated copolymer having the formula



where n and m are mole fractions, n plus m equals 1, n is between 0.1 and 0.5, 15 m is 1 minus n , and k is between 40 and 200.

4. A proton exchange membrane (PEM) comprising the ion conductive random copolymer of claim 1 through 3.

5. A catalyst coated membrane (CCM) comprising the PEM of claim 4 wherein all or part of at least one of the opposing surfaces of said membrane comprises a catalyst layer.
6. A membrane electrode assembly (MEA) comprising the CCM of claim 5.
7. A fuel cell comprising the MEA of claim 6.
8. An electronic device comprising the fuel cell of claim 7.
9. An electric motor comprising the fuel cell of claim 7.

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Fig. . Performance and RH% sensitivity of various random copolymer :
MEA – 0.25mg Pt loading for both electrodes
tested at 80C and 30psig pressure

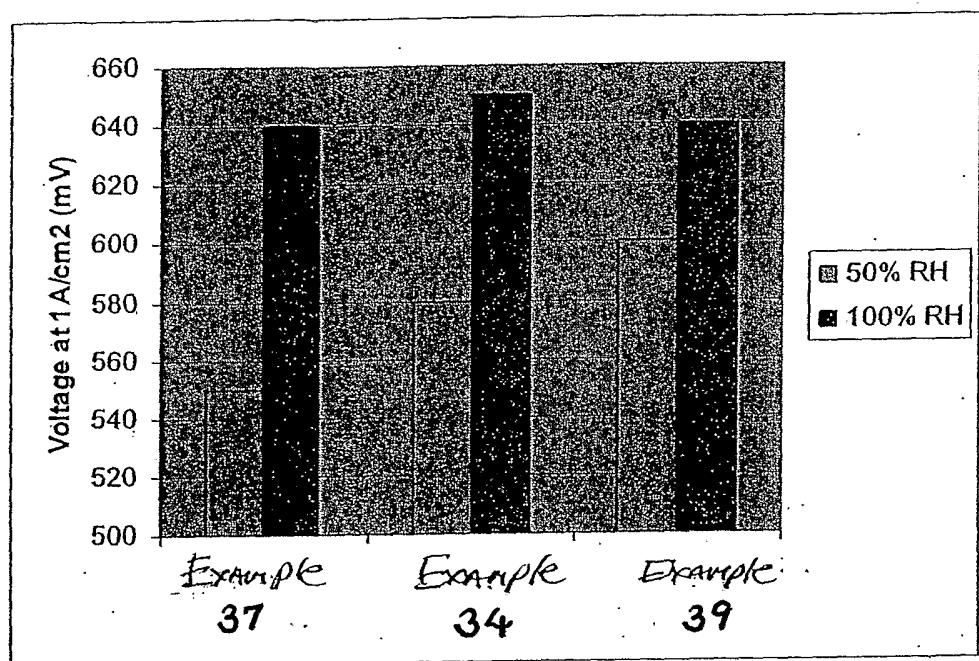


FIG. 1