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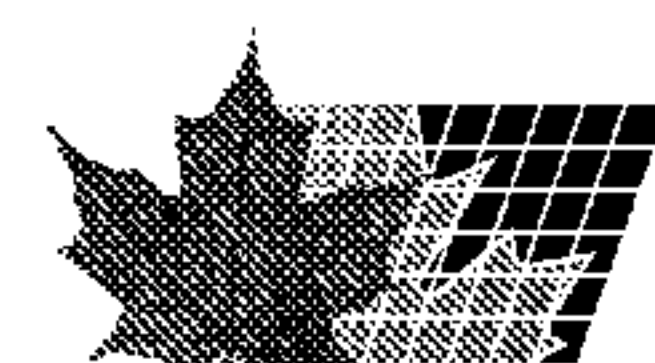
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(54) Title: SUBSTITUTED LITHIUM-MANGANESE METAL PHOSPHATE

(57) **Abrégé/Abstract:**

The present invention relates to a substituted lithium-manganese metal phosphate of formula $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ in which M is a bivalent metal from the group Sn, Pb, Zn, Ca, Sr, Ba, Co, Ti and Cd and wherein: $x < 1$, $y < 0.3$ and $x + y < 1$, a process for producing it as well as its use as cathode material in a secondary lithium-ion battery.

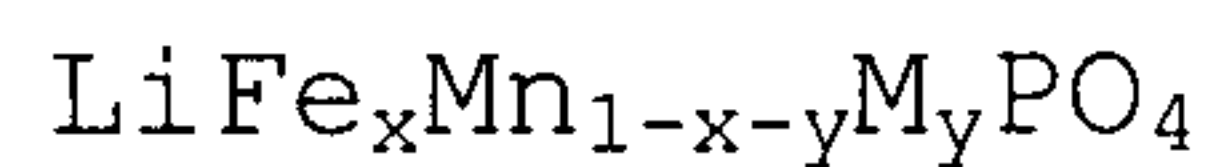


87593-9

Abstract

The present invention relates to a substituted lithium-manganese metal phosphate of formula

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in which M is a bivalent metal from the group Sn, Pb, Zn, Ca, Sr, Ba, Co, Ti and Cd and wherein: $x < 1$, $y < 0.3$ and $x + y < 1$, a process for producing it as well as its use as cathode material in a secondary lithium-ion battery.

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87593-9

1

SUBSTITUTED LITHIUM-MANGANESE METAL PHOSPHATE

The present invention relates to a novel substituted lithium-manganese metal phosphate, a process for producing it as well
5 as its use as cathode material in a secondary lithium-ion battery.

Since the publications by Goodenough et al. (J. Electrochem. Soc., 144, 1188-1194, 1997) there has been significant interest
10 in particular in using lithium iron phosphate as cathode material in rechargeable secondary lithium-ion batteries. Lithium iron phosphate, compared with conventional lithium compounds based on spinels or layered oxides, such as lithium manganese oxide, lithium cobalt oxide and lithium nickel oxide,
15 offers higher safety properties in the delithiated state such as are required in particular for the use of batteries in future in electric cars, electrically powered tools etc.

Pure lithium iron phosphate material was improved by so-called
20 "carbon coating" (Ravet et al., Meeting of Electrochemical Society, Honolulu, 17 - 31 October 1999, EP 1 084 182 B1), as an increased capacity of the carbon-coated material is achieved at room temperature (160 mAh/g).

25 In addition to customary solid-state syntheses (US 5,910,382 C1 or US 6,514,640 C1), a hydrothermal synthesis for lithium iron phosphate with the possibility of controlling the size and morphology of the lithium iron phosphate particles was disclosed in WO 2005/051840.

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87593-9

2

A disadvantage of lithium iron phosphate is in particular its redox couple $\text{Fe}^{3+}/\text{Fe}^{2+}$ which has a much lower redox potential vis-à-vis Li/Li^+ (3.45 V versus Li/Li^+) than for example the redox couple $\text{Co}^{3+}/\text{Co}^{4+}$ in LiCoO_2 (3.9 V versus Li/Li^+).

5

In particular lithium manganese phosphate LiMnPO_4 is of interest in view of its higher $\text{Mn}^{2+}/\text{Mn}^{3+}$ redox couple (4.1 volt) versus Li/Li^+ . LiMnPO_4 was also already disclosed by Goodenough et al., US 5,910,382.

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However, the production of electrochemically active and in particular carbon-coated LiMnPO_4 has proved very difficult.

The electrical properties of lithium manganese phosphate were improved by iron substitution of the manganese sites:

Herle et al. in Nature Materials, Vol. 3, pp. 147-151 (2004) describe lithium-iron and lithium-nickel phosphates doped with zirconium. Morgan et al. describes in Electrochem. Solid State Lett. 7 (2), A30-A32 (2004) the intrinsic lithium-ion conductivity in Li_xMPO_4 ($\text{M} = \text{Mn}, \text{Fe}, \text{Co}, \text{Ni}$) olivines. Yamada et al. in Chem. Mater. 18, pp. 804-813, 2004 deal with the electrochemical, magnetic and structural features of $\text{Li}_x(\text{Mn}_y\text{Fe}_{1-y})\text{PO}_4$, which are also disclosed e.g. in WO2009/009758.

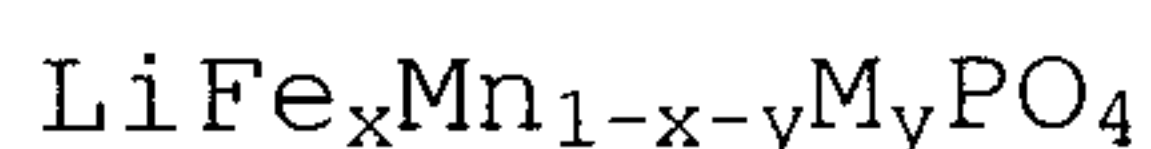
25 Structural variations of $\text{Li}_x(\text{Mn}_y\text{Fe}_{1-y})\text{PO}_4$, i.e. of the lithiophilite-triophyllite series, were described by Losey et al. The Canadian Mineralogist, Vol. 42, pp. 1105-1115 (2004). The practical effects of the latter investigations in respect of the diffusion mechanism of deintercalation in $\text{Li}_x(\text{Mn}_y\text{Fe}_{1-y})\text{PO}_4$

cathode material are found in Molenda et al. Solid State Ionics 177, 2617-2624 (2006).

However, a plateau-like region occurs for the discharge curves at 3.5 volt vis-à-vis lithium (iron plateau), the length of which compared with pure LiMnPO_4 increases as the iron content increases, which results in a loss of energy density (see Yamada et al. in the publication mentioned above). The slow kinetics (charge and discharge kinetics) of manganese-containing metal phosphates, in particular $\text{Li}_x(\text{Mn}_y\text{Fe}_{1-y})\text{PO}_4$ with $y > 0.8$, have so far made the use of these compounds for battery applications largely impossible.

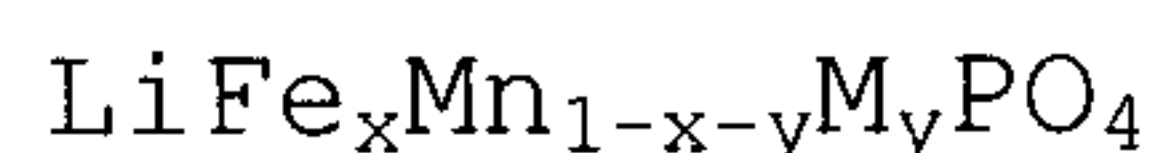
The object of the present invention was therefore to provide suitable lithium-manganese phosphate derivatives which make possible a high energy density when used as cathode material and provide a high redox potential with rapid kinetics in respect of charge and discharge processes.

According to one embodiment, there is disclosed a substituted lithium-manganese metal phosphate of formula



in which M is a bivalent metal, in particular from the group Sn, Pb, Zn, Ca, Sr, Ba, Co, Ti and Cd and wherein: $x < 1$, $y < 0.3$ and $x + y < 1$.

According to one embodiment, there is disclosed a Lithium-manganese metal phosphate of formula



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in which M is a bivalent metal selected from the group consisting of Pb, Zn, Ca, Sr and Cd, and wherein:
 $x + y < 1$, $0 < y < 0.15$, and $0 < x < 0.35$.

In developments of the invention, the bivalent metal is M, Zn, Mg, Ca or combinations thereof, in particular Zn and Ca. It has

87593-9

4

surprisingly been shown within the framework of the present invention that these electrically inactive substitution elements make possible the provision of materials with particularly high energy density when they are used as electrode materials.

It was found that in the case of the substituted lithium metal phosphate of the present invention $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$, the value for y lies in the range of more than 0.07 to 0.20 and is 0.1 in one embodiment.

The substitution (or doping) by the bivalent metal cations that are in themselves electrochemically inactive seems to deliver the very best results at values of $x = 0.1$ and $y = 0.1 - 0.15$, preferably $0.1 - 0.13$, in particular 0.11 ± 0.1 with regard to energy density of the material according to the invention. For the doping with magnesium ($\text{LiMn}_{1-x-y}\text{Mg}_y\text{PO}_4$), values slightly different from Zn and Ca were found. Here, $0.01 \leq x \leq 0.11$ and $0.07 < y < 0.20$, preferably $0.075 \leq y \leq 0.15$ and $x + y$ must be < 0.2 . This means that a high manganese content with a relatively low iron content and a relatively high magnesium content deliver the best results in respect of energy density, which is particularly surprising in view of the electrically inactive character of magnesium. It was found that for compounds according to the invention such as $\text{LiMn}_{0.80}\text{Fe}_{0.10}\text{Zn}_{0.10}\text{PO}_4$, $\text{LiMn}_{0.80}\text{Fe}_{0.10}\text{Zn}_{0.10}\text{PO}_y$ and $\text{LiMn}_{0.80}\text{Fe}_{0.10}\text{Ca}_{0.10}\text{PO}_4$ the specific capacity is exactly as high as for $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ and the 4V plateau is longer, which means an increase in energy density.

87593-9

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In further embodiments of the present invention, the value for x in the mixed lithium metal phosphate according to the invention of general formula $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ is 0.15 - 0.4, particularly preferably 0.05 - 2, quite particularly preferably 0.15 $\pm$ 0.3, in particular 0.33. This value, in particular in conjunction with the above-named value for y of 0.1 gives the most preferred compromise between energy density and current carrying capacity of the material according to the invention. This means that the compound $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ for M = Zn or Ca with x = 0.33 and y = 0.10 has a current carrying capacity up to 20C during discharge comparable with that of LiFePO_4 of the state of the art (e.g. available from Süd-Chemie), but in addition also an increase in energy density (approx. 20% vis-à-vis LiFePO_4 (measured against a lithium titanate ($\text{Li}_4\text{Ti}_5\text{O}_{12}$) anode))).

In further embodiments of the present invention, the substituted lithium-manganese metal phosphate also comprises carbon. The carbon is particularly preferably evenly distributed throughout the substituted lithium-manganese metal phosphate. In other words, the carbon forms a type of matrix in which the lithium-manganese metal phosphate according to the invention is embedded. It makes no difference for the meaning of the term "matrix" used here whether e.g. the carbon particles serve as "nucleation sites" for the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention, i.e. whether these settle on the carbon, or whether, as in a particularly preferred development of the present invention, the individual particles of the lithium-manganese metal phosphate $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ are covered in carbon, i.e. sheathed or in other words coated. Both variants

87593-9

6

are considered equivalent according to the invention and come under the above definition.

Important for the purpose of the present invention is merely
5 that the carbon is evenly distributed in the substituted
lithium-manganese metal phosphate $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to
the invention and forms a type of (three-dimensional) matrix.
In advantageous developments of the present invention, the
presence of carbon or a carbon matrix can make obsolete the
10 further addition of electrically conductive additives such as
e.g. conductive carbon black, graphite etc. when using the
 $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention as electrode material.

In a development of the invention, the proportion of carbon
15 relative to the substituted lithium-manganese metal phosphate
is ≤ 4 wt.-%, in further embodiments ≤ 2.5 wt.-%, in still
further embodiments ≤ 2.2 wt.-% and in still further
embodiments ≤ 2.0 wt.-%. Thus the best energy densities of the
material according to the invention are achieved according to
20 the invention.

The substituted lithium-manganese metal phosphate $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention is preferably contained as
active material in a cathode for a secondary lithium-ion
25 battery. As stated, this cathode can also contain the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention without further addition of a
further conductive material such as e.g. conductive carbon
black, acetylene black, ketjen black, graphite etc. (in other
words be free of added conductive agent), both in the case of

87593-9

7

the carbon-containing $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention and the carbon-free $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$.

In further preferred embodiments, the cathode according to the invention contains a further lithium-metal-oxygen compound. This addition increases the energy density by up to approx. 10 - 15%, depending on the type of the further mixed lithium metal compound compared with cathodes which contain only the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention as sole active material.

The further lithium-metal-oxygen compound is preferably selected from substituted or non-substituted LiCoO_2 , LiMn_2O_4 , $\text{Li}(\text{Ni}, \text{Mn}, \text{Co})\text{O}_2$, $\text{Li}(\text{Ni}, \text{Co}, \text{Al})\text{O}_2$ and LiNiO_2 , as well as LiMnFePO_4 , LiFePO_4 , LiCoPO_4 , LiMnPO_4 and mixtures thereof.

The object is further achieved by a process for producing a mixed lithium-manganese metal phosphate according to the invention comprising the following steps:

a. producing a mixture containing a Li starting compound, a Mn starting compound, an Fe starting compound, a M^{2+} starting compound and a PO_4^{3-} starting compound until a precipitate or a suspension in aqueous solution forms,

b. carrying out a dispersion or grinding treatment of the mixture and/or the suspension. This treatment is preferably carried out until the D_{90} value of the particles in the mixture is less than 50 μm , preferably at most 25 μm ;

87593-9

8

c. obtaining $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$, wherein x and y have the above-named meanings, from the suspension by reaction under hydrothermal conditions.

- 5 By "hydrothermal conditions" is meant here temperatures of 100°C to 200°C, preferably 100°C to 160°C and quite particularly preferably 100°C to 130°C as well as a pressure of 1 bar to 40 bar vapour pressure. In particular, it has surprisingly been shown that the synthesis at the quite
- 10 particularly preferred temperature of 100 - 130°C, in particular at $130 \pm 5^\circ\text{C}$, leads to an increase in the specific capacity of the thus-obtained $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ according to the invention compared with reaction at more than 160°C.
- 15 As stated, the synthesis takes place in aqueous solution/suspension. At the end of the reaction, the pH of the reaction solution is approx. 6, i.e. the reaction itself takes place in non-basic environment.
- 20 The process according to the invention makes possible in particular the production of phase-pure $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ which is free of impurities to be determined by means of XRD.

There is therefore also a further aspect of the present

25 invention in the provision of $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ which can be obtained by means of the process according to the invention.

In preferred developments of the process according to the invention, the dispersion or grinding treatment begins before

87593-9

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or during the suspension formation and is continued until the suspension/precipitation has concluded.

Preferably, the dispersion or grinding treatment starts before
5 the suspension/precipitation of the mixture in order to bring about an increased nucleation and in order to prevent the formation of large crystals and crystal agglomerates.

After the hydrothermal treatment, the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ obtained
10 according to the invention is separated off by filtration and/or centrifuging as well as dried and, in preferred developments of the invention, disagglomerated, e.g. by grinding with an air-jet mill.

15 In developments of the process according to the invention, a carbon-containing material is added during step a) or c). This can be either pure carbon, such as e.g. graphite, acetylene black or ketjen black, or else a carbon-containing precursor compound which then decomposes when exposed to the action of
20 heat to carbon, e.g. starch, gelatine, a polyol, a sugar such as mannose, fructose, sucrose, lactose, galactose, a partially water-soluble polymer such as e.g. a polyacrylate etc.

Alternatively, the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ obtained after the
25 hydrothermal treatment can also be mixed with a carbon-containing material as defined above or impregnated with an aqueous solution of same. This can take place either directly after the isolation (filtration) of the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ or after it has been dried or disagglomerated.

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87593-9

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For example the mixture of $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ and carbon precursor compound (which was added e.g. during the process) or the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ impregnated with the carbon precursor compound is then dried and heated to a temperature between 500°C and 850°C , wherein the carbon precursor compound is pyrolyzed to pure carbon which then wholly or at least partly covers the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ particles as a layer.

The pyrolysis is usually followed by a grinding or disagglomeration treatment.

The $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ obtained according to the invention is preferably dried under protective gas, in air or under vacuum at temperatures of from 50°C to 200°C , preferably under protective gas and the pyrolysis preferably likewise under protective gas, preferably nitrogen.

Within the framework of the process according to the invention, the Li^+ source, the Fe^{2+} and Mn^{2+} sources as well as the M^{2+} source are preferably used in the form of aqueous solutions and the PO_4^{3-} source in the form of a liquid, e.g. as H_3PO_4 or an aqueous solution.

In preferred embodiments of the process according to the invention, the Li^+ source is first dissolved in an aqueous solvent, the Fe^{2+} , the Mn^{2+} and the M^{2+} sources as well as the PO_4^{3-} source are then added and mixed under inert gas atmosphere. The reaction then takes place under hydrothermal conditions and preferably under protective gas.

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87593-9

11

According to the invention, Li_2O , LiCl , LiNO_3 , LiOH or Li_2CO_3 , preferably LiOH or Li_2CO_3 , is used as lithium source.

The Fe source is preferably an Fe^{2+} salt, in particular FeSO_4 ,
5 FeCl_2 , FeNO_3 , $\text{Fe}_3(\text{PO}_4)_2$ or an Fe organyl salt.

The Mn source is preferably a water-soluble manganese (II) salt such as manganese sulphate, manganese acetate, manganese oxalate, manganese chloride, manganese nitrate, manganese
10 hydroxide, manganese carbonate etc.

According to the invention, phosphoric acid, a metal phosphate, hydrogen phosphate or dihydrogen phosphate is preferably used as PO_4^{3-} source.

15

In particular, the corresponding sulphates, in particular of Mg, Zn and Ca, or the corresponding halides, nitrates, acetates, carboxylates come into consideration as source for the bivalent metal cation.

20

The invention is explained in more detail below with reference to examples and drawings which are not, however, to be considered limiting.

25 There are shown in:

Figure 1 discharge curves at 1C for a lithium-manganese iron phosphate $\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ of the state of the art;

87593-9

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Figure 2 discharge curves at 1C for the $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Mg}_{0.10}\text{PO}_4$ according to the invention;

Figure 3 discharge curves at 1C for the $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ according to the invention;

Figure 4 the charge curves of lithium-manganese iron phosphate ($\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$) of the state of the art;

Figure 5 the charge curves of $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ according to the invention;

Figure 6 the discharge curves at different rates for an electrode containing $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ according to the invention;

Figure 7 the discharge curves at different rates for an electrode containing $\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ according to the state of the art;

Figure 8a-b the comparison of the materials according to the invention with LiFePO_4 in full cells versus a lithium titanate anode, at C/10 (Figure 8a) and at 20C (Figure 8b)

Figure 9 the comparison of the specific discharge capacity at C/10 between a lithium-manganese iron phosphate ($\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$) of the state of the art with substituted lithium-manganese metal phosphates according to the invention;

87593-9

13

Figure 10 voltage profiles at 1C after aging of materials
according to the invention vis-à-vis lithium-
manganese iron phosphate ($\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$) of the
state of the art;

Figs. 11a-c the influence of the electrode density on the
discharge rate in the case of material according to
the invention;

Figs. 12a-c the influence of the electrode density in the case
of a cathode containing the material according to
the invention;

Fig. 13 the discharge curve at C/10 for $\text{LiMn}_{0.80}\text{Fe}_{0.10}\text{Zn}_{0.10}\text{PO}_4$
according to the invention;

Fig. 14 the discharge curve at C/10 for $\text{LiMn}_{0.85}\text{Fe}_{0.10}\text{Zn}_{0.05}\text{PO}_4$
according to the invention.

87593-9

14

Embodiment examples*1. Determination of the particle-size distribution:*

5 The particle-size distributions for the mixtures or suspensions and of the produced material is determined using the light-scattering method using devices customary in the trade. This method is known per se to a person skilled in the art, wherein reference is also made in particular to the disclosure in JP
10 2002-151082 and WO 02/083555. In this case, the particle-size distributions were determined with the help of a laser diffraction measurement apparatus (Mastersizer S, Malvern Instruments GmbH, Herrenberg, DE) and the manufacturer's software (version 2.19) with a Malvern Small Volume Sample
15 Dispersion Unit, DIF 2002 as measuring unit. The following measuring conditions were chosen: compressed range; active beam length 2.4 mm; measuring range: 300 RF; 0.05 to 900 μm . The sample preparation and measurement took place according to the manufacturer's instructions.

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The D_{90} value gives the value at which 90% of the particles in the measured sample have a smaller or the same particle diameter. Accordingly, the D_{50} value and the D_{10} value give the value at which 50% and 10% respectively of the particles in the
25 measured sample have a smaller or the same particle diameter.

According to a particularly preferred embodiment according to the invention, the values named in the present description are valid for the D_{10} values, D_{50} values, the D_{90} values as well as
30 the difference between the D_{90} and D_{10} values relative to the

87593-9

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volume proportion of the respective particles in the total volume. Accordingly, according to this embodiment according to the invention, the D_{10} , D_{50} and D_{90} values named here give the values at which 10 volume-% and 50 volume-% and 90 volume-%
5 respectively of the particles in the measured sample have a smaller or the same particle diameter. If these values are preserved, particularly advantageous materials are provided according to the invention and negative influences of relatively coarse particles (with relatively larger volume
10 proportion) on the processability and the electrochemical product properties are avoided. Particularly preferably, the values named in the present description are valid for the D_{10} values, the D_{50} values, the D_{90} values as well as the difference between the D_{90} and the D_{10} values relative to both percentage
15 and volume percent of the particles.

For compositions (e.g. electrode materials) which, in addition to the lithium-manganese iron phosphates according to the invention substituted with bivalent metal cations, contain
20 further components, in particular for carbon-containing compositions, the above light scattering method can lead to misleading results as the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ particles can be joined together by the additional (e.g. carbon-containing) material to form larger agglomerates. However, the particle-
25 size distribution of the material according to the invention can be determined as follows for such compositions using SEM photographs:

A small quantity of the powder sample is suspended in acetone
30 and dispersed with ultrasound for 10 minutes. Immediately

87593-9

16

thereafter, a few drops of the suspension are dropped onto a sample plate of a scanning electron microscope (SEM). The solids concentration of the suspension and the number of drops are measured such that a largely single-ply layer of powder particles (the German terms "Partikel" and "Teilchen" are used synonymously to mean "particle") forms on the support in order to prevent the powder particles from obscuring one another. The drops must be added rapidly before the particles can separate by size as a result of sedimentation. After drying in air, the sample is placed in the measuring chamber of the SEM. In the present example, this is a LEO 1530 apparatus which is operated with a field emission electrode at 1.5 kV excitation voltage and a 4 mm space between samples. At least 20 random sectional magnifications of the sample with a magnification factor of 20,000 are photographed. These are each printed on a DIN A4 sheet together with the inserted magnification scale. On each of the at least 20 sheets, if possible at least 10 free visible particles of the material according to the invention, from which the powder particles are formed together with the carbon-containing material, are randomly selected, wherein the boundaries of the particles of the material according to the invention are defined by the absence of fixed, direct connecting bridges. On the other hand, bridges formed by carbon material are included in the particle boundary. Of each of these selected particles, those with the longest and shortest axis in the projection are measured in each case with a ruler and converted to the actual particle dimensions using the scale ratio. For each measured $\text{LiFe}_x\text{Mn}_{1-x-y}\text{MyPO}_4$ particle, the arithmetic mean from the longest and the shortest axis is defined as particle diameter. The measured $\text{LiFe}_x\text{Mn}_{1-x-y}\text{MyPO}_4$

87593-9

17

particles are then divided analogously to the light-scattering measurement into size classes. The differential particle-size distribution relative to the number of particles is obtained by plotting the number of the associated particles in each case
5 against the size class. The cumulative particle-size distribution from which D_{10} , D_{50} and D_{90} can be read directly on the size axis is obtained by continually totalling the particle numbers from the small to the large particle classes.

10 The described process is also applied to battery electrodes containing the material according to the invention. In this case, however, instead of a powder sample a fresh cut or fracture surface of the electrode is secured to the sample holder and examined under a SEM.

15

Example 1: Production of $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ according to the process according to the invention

When producing the material it is to be borne in mind that the
20 material is precipitated from an aqueous Fe^{2+} precursor solution. The reaction and drying/sintering is therefore preferably to be carried out under protective gas or vacuum in order to avoid a partial oxidation of Fe^{2+} to Fe^{3+} with formation of by-products such as Fe_2O_3 or FePO_4 .

25

Production and precipitation/suspension of a precursor mixture

First, 105.5 g lithium hydroxide $\text{LiOH} \cdot \text{H}_2\text{O}$ was dissolved in 0.9
l distilled water. This solution is called basic solution.

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87593-9

18

77.43 g $\text{FeSO}_4 \times 7 \text{ H}_2\text{O}$, 79.88 g $\text{MnSO}_4 \times \text{H}_2\text{O}$ and 24.27 g $\text{ZnSO}_4 \times 7 \text{ H}_2\text{O}$ were dissolved in approx. 1.5 l distilled water and 103.38 g 80% phosphoric acid added slowly accompanied by stirring. 0.4 l distilled wash water was added. This solution is called acid
5 solution.

The basic solution was introduced into the laboratory autoclave (capacity: 4 litres) at 600 rpm stirrer speed, the autoclave loaded with approx. 6 - 7 bar nitrogen via the dipping tube and
10 relieved again via the vent valve. The procedure was repeated three times.

A disperser (IKA, ULTRATURRAX® UTL 25 Basic Inline with dispersion chamber DK 25.11) was connected to the autoclave
15 between vent valve and bottom outlet valve in order to carry out the dispersion or grinding treatment. The pumping direction of the disperser was bottom outlet valve - disperser - vent valve. The disperser was started on the middle power level (13,500 rpm) according to the manufacturer's instructions.

20

The prepared acid solution was then pumped with a membrane pump via the dipping tube into the autoclave (stroke 100%, 180 strokes/minute; corresponds to the maximum capacity of the pump) and reflushed with approx. 500 to 600 ml distilled water.
25 The pumping-in lasted for approx. 20 minutes, wherein the temperature of the resultant suspension increased to approx. 40°C. After pumping-in of the acid solution, a deposit precipitated out.

87593-9

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The disperser, which was started before the addition of the acid solution, was used for a total of approx. 1 hour for intensive mixing or grinding of the resultant, viscous suspension (after pumping-in of the acid solution at 50°C).

5

The use of a disperser brings about an intensive mixing and the agglomeration of the precipitated viscous pre-mixture. During the precipitation and crystallization of the suspension, a homogeneous mixture of many small, approximately equally-sized crystal nuclei formed in the disperser as a result of the pre-grinding or intensive mixing. These crystal nuclei crystallized during the subsequent hydrothermal treatment (see below) to very uniformly grown crystals of the end-product with a very narrow particle-size distribution. The power and energy input via the dispersion treatment was respectively more than 7 kW/m³ and more than 7 kWh/m³ of the treated precursor mixture/suspension.

Hydrothermal treatment

20

Each freshly produced suspension was subjected to hydrothermal treatment in the laboratory autoclave. Before heating the suspension, the autoclave was flushed with nitrogen in order to expel any air present from the autoclave before the hydrothermal process. The product according to the invention formed starting from hydrothermal temperatures of approximately 100 to 120°C. The hydrothermal treatment was preferably carried out for 2 hours at 130°C.

87593-9

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After switching off and disconnecting the disperser the mixture was heated over 1.5 hours to 130°C, for 2 hours. Cooling to 30°C then took place over 3 hours.

- 5 The $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ according to the invention was then able to be dried in air or in the drying oven for example at mild temperatures (40°C) without visible oxidation.

The thus-obtained material was pumped under nitrogen atmosphere
10 through the bottom outlet valve of the autoclave into a pressure filter (Seitz filter). The membrane pump setting was such that a pressure of 5 bar was not exceeded. The filter cake was subsequently washed with distilled water until the conductivity of the wash water had fallen below 42 $\mu\text{S}/\text{cm}$.

15

Example 2: Production of $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Mg}_{0.10}\text{PO}_4$

The synthesis was carried out as in Example 1, except that
20 20.80 g $\text{MgSO}_4 \cdot 7 \text{H}_2\text{O}$ was used as starting material in the corresponding molar weight quantities instead of ZnSO_4 .

Example 3: Production of $\text{LiMn}_{0.80}\text{Fe}_{0.10}\text{Zn}_{0.10}\text{PO}_4$ according to the process according to the invention

25 The synthesis was carried out as in Example 1, except that 114.12 g $\text{MnSO}_4 \cdot 1 \text{H}_2\text{O}$, 23.46 g $\text{FeSO}_4 \cdot 7 \text{H}_2\text{O}$, 24.27 g $\text{ZnSO}_4 \cdot 7 \text{H}_2\text{O}$, 103.38 g H_3PO_4 , (80%) were used as starting materials in the corresponding molar weight quantities.

87593-9

21

Example 4: Production of $\text{LiMn}_{0.85}\text{Fe}_{0.10}\text{Zn}_{0.05}\text{PO}_4$ according to the process according to the invention

The synthesis was carried out as in Example 1, except that
5 121.26 g $\text{MnSO}_4 \cdot \text{H}_2\text{O}$, 23.46 g $\text{FeSO}_4 \cdot 7 \text{H}_2\text{O}$, 12.14 g $\text{ZnSO}_4 \cdot 7 \text{H}_2\text{O}$,
103.38 g H_3PO_4 (80%) were used as starting materials in the
corresponding molar weight quantities.

Example 5: Carbon coating of the obtained material (variant
10 *1)*

The filter cakes obtained in Examples 1 to 4 were impregnated
with a solution of 24 g lactose in water and then calcined at
750°C for 3 hours under nitrogen.

15

Depending on the quantity of lactose, the proportion of carbon
in the product according to the invention was between 0.2 and 4
wt.-%.

20 Typically 1 kg dry product from Examples 1 and 2 was mixed
intimately with 112 g lactose monohydrate and 330 g deionized
water and dried overnight in a vacuum drying oven at 105°C and
< 100 mbar to a residual moisture of 3%. The brittle drying
product was broken by hand and coarse-ground in a disk mill
25 (Fritsch Pulverisette 13) with a 1 mm space between disks and
transferred in high-grade steel cups into a protective gas
chamber furnace (Linn KS 80-S). The latter was heated to 750°C
within 3 hours at a nitrogen stream of 200 l/h, kept at this
temperature for 3 hours and cooled over 3 hours to room

87593-9

22

temperature. The carbon-containing product was disagglomerated in a jet mill (Hosokawa).

The SEM analysis of the particle-size distribution produced the following values: $D_{50} < 0.5 \mu\text{m}$, difference between D_{90} and D_{10} value: $< 1 \mu\text{m}$.

Example 6: Carbon coating of the material according to the invention (variant 2)

10

The synthesis of the materials according to the invention was carried out as in Examples 1 to 4, except that gelatine was also then added (9 g gelatine per 100 g starting product) during the precipitation step a). The end-product contained approx. 2.3 wt.-% carbon.

15

Example 7: Production of electrodes

20

Thin-film electrodes as disclosed for example in Anderson et al., Electrochem. and Solid State Letters 3 (2) 2000, pages 66-68 were produced. The electrode compositions usually consisted of 90 parts by weight active material, 5 parts by weight Super P carbon and 5% polyvinylidene fluoride as binder or 80 parts by weight active material, 15 wt.-% Super P carbon and 5 parts by weight polyvinylidene fluoride, or 95 parts by weight active material and 5 parts by weight polyvinylidene fluoride.

25

The active material was mixed, together with the binder (or, for the electrodes of the state of the art, with the added conductive agent), in N-methylpyrrolidone, applied to a

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87593-9

23

pretreated (primer) aluminium foil by means of a coating knife and the N-methylpyrrolidone was evaporated at 105°C under vacuum. The electrodes were then cut out (13 mm diameter) and roll-coated with a roller at room temperature. The starting nip
5 width was e.g. 0.1 mm and the desired thickness progressively built up in steps of 5-10 µm. 4 rolled coats were applied at each step and the foil was rotated by 180°. After this treatment, the thickness of the coating was between 20-25 µm. The primer on the aluminium foil consisted of a thin carbon
10 coating which improves the adhesion of the active material particularly when the active material content of the electrode is more than 85 wt.-%.

The electrodes were then dried overnight at 120°C under vacuum
15 and assembled and electrochemically measured against lithium metal in half cells in an argon-filled glovebox.

The electrochemical measurements were carried out against lithium metal using LP30 (Merck, Darmstadt) as electrolyte (EC (ethylene carbonate):DMC (dimethylcarbonate) = 1:1, 1 M LiPF₆).
20

The test procedure was carried out in CCCV mode, i.e. cycles with a constant current at the C/10 rate for the first, and at the C rate for the subsequent, cycles. In some cases, a constant voltage portion followed at the voltage limits (1.0
25 and 2.0 volt versus Li/Li⁺) until the current fell approximately to the C/50 rate, in order to complete the charge/discharge cycle.

Corresponding measurements of the specific capacity and the
30 current carrying capacity were carried out on both

87593-9

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$\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ of the state of the art and materials according to the invention substituted with magnesium and zinc. LiFePO_4 electrodes (available from Süd-Chemie) were likewise also measured.

5

Figure 1 shows the discharge curves at 1C for a $\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ of the state of the art.

After several cycles, an energy loss is recorded in the range of between 20 and 40 mAh/g. In contrast, the magnesium- and
10 zinc-substituted materials according to the invention (Figs. 2 and 3) display almost no energy loss in the range of between 20 and 60 mAh/g even after 180 cycles. Nor is any weakening in the capacity at 140 mAh/g to be ascertained even after extended cycles.

15

Figure 4 shows charge curves of a $\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ material of the state of the art with an electrode density of 1.2 g/cm^3 and a thickness of $20 \text{ }\mu\text{m}$. By way of comparison, the charge curve for the zinc-containing material according to the invention is
20 shown in Figure 5. As can be seen from Figures 4 and 5, the 1C value of the material according to the invention is much better during the charge up to 4.3V than in the case of the comparison material of the state of the art.

25 Figures 6 and 7 show the discharge capacity at different rates of the material according to the invention (Fig. 6) as well as of a lithium-manganese iron phosphate of the state of the art (Figure 7). The electrode density was 1.2 g/cm^3 in the material according to the invention and 1.3 g/cm^3 in the comparison

87593-9

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material at a thickness of approx. 20 μm .

Here also, there is a significant drop in performance after several discharge cycles of the lithium-manganese iron phosphate not substituted with (electrically inactive) bivalent material compared with the lithium-manganese iron phosphate not substituted with a bivalent metal ion. In addition, the polarization at increased current rates is much greater for the lithium-manganese iron phosphate of the state of the art than for a substituted lithium-manganese iron phosphate according to the invention.

Figure 8a - b shows the discharge curves in full-cell configuration versus a lithium titanate ($\text{Li}_4\text{Ti}_5\text{O}_{12}$) anode at D/10 and at 20D for a carbon-coated lithium iron phosphate of the state of the art (available from Süd-Chemie) and for the $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ material according to the invention. The electrode composition was 90 wt.-% active material, 5% Super P graphite and 5 wt.-% polyvinylidene fluoride. The cell was balanced such that the mass of the cathode and the mass of the anode were as similar as possible.

Here it is shown that the $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.1}\text{PO}_4$ material according to the invention has a long 4-volt plateau up to 80 mAh/g and at the same time a specific discharge capacity at D/10 comparable to the (carbon-coated) lithium iron phosphate of the state of the art, which means a clear increase in the energy density vis-à-vis lithium iron phosphate.

87593-9

26

Figure 9 shows the C/10 or discharge capacity of $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ and $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Mg}_{0.10}\text{PO}_4$ materials according to the invention compared with two $\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ materials of the state of the art. Here also it can surprisingly be seen
5 that an increase in the manganese plateau potential is achieved by zinc and magnesium substitutions, although in these cases Mg and zinc are electrically inactive ions and the manganese content is smaller than in the case of the materials of the state of the art.

10

After 20 cycles, the charge and discharge cycles at C/10 and 1D for the $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ and $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Mg}_{0.10}\text{PO}_4$ materials according to the invention and for lithium-manganese iron phosphates of the state of the art (Figure 10) were measured.
15 Here also a stabilization of the length of the 4-volt manganese plateau by the materials according to the invention compared with lithium-manganese iron phosphate of the state of the art is shown.

20

Figures 11a to c show the variation in electrode density relative to the discharge capacities at different rates. In Figure 11a, the density of the material is 1.6 g/cm^3 , in Figure 11b 1.7 g/cm^3 and in Figure 11c 2.0 g/cm^3 .

25

It is shown that it is possible with the materials according to the invention to increase the electrode density while preserving the discharge capacities.

30

Figures 12a to c show the influence of the electrode thickness on the discharge capacities. The thickness of the electrodes in

87593-9

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Figure 12a was 25 μm , in Figure 12b 33 μm and in Figure 12c 51 μm . It is shown here also that the plateau can be kept at 4 volt and the discharge capacity at least up to 5C, and the active matter load can simultaneously be increased.

5

Even higher energy densities can be achieved by increasing the manganese content of these substituted materials according to the invention.

10 Figures 13 and 14 show the discharge capacity at D/10 of the $\text{LiMn}_{0.80}\text{Fe}_{0.10}\text{Zn}_{0.10}\text{PO}_4$ and $\text{LiMn}_{0.85}\text{Fe}_{0.10}\text{Zn}_{0.05}\text{PO}_4$ materials according to the invention (produced according to Examples 2 and 4). It is shown that the 4V manganese plateau is even longer than in the case of $\text{LiMn}_{0.56}\text{Fe}_{0.33}\text{Zn}_{0.10}\text{PO}_4$ according to the invention.

15

In summary, the present invention makes available mixed lithium-manganese iron phosphate materials substituted with bivalent metal ions, which can be produced by means of a hydrothermal process. The specific discharge capacity for room
20 temperature exceeds 140 mAh/g despite the substitution with sometimes 10% electrochemically inactive bivalent metal ions. Very good discharge rates were measured for all the substituted materials.

25 Compared with non-substituted $\text{LiMn}_{0.66}\text{Fe}_{0.33}\text{PO}_4$ it was shown that the discharge voltage profile at 1 D for the bivalently substituted novel materials according to the invention remains unchanged even after several charge and discharge cycles (the length of the Mn plateau at 4 volt remained unchanged).

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87593-9

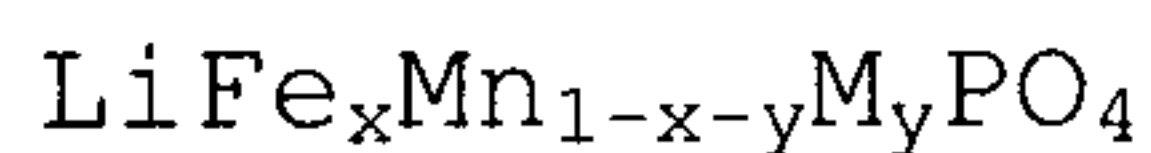
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It was found with respect to the energy density that the substitution with zinc or with magnesium gave the best results compared with copper, titanium and nickel.

5

Claims

1. Lithium-manganese metal phosphate of formula



5 in which M is a bivalent metal selected from the group consisting of Pb, Zn, Ca, Sr and Cd, and wherein: $x + y < 1$, $0 < y < 0.15$, and $0 < x < 0.35$.

2. Lithium-manganese metal phosphate according to claim 1, in which M is Zn or Ca.

10 3. Lithium-manganese metal phosphate according to claim 1 or 2, further comprising carbon.

4. Lithium-manganese metal phosphate according to claim 3, wherein the carbon is evenly distributed throughout the substituted lithium-manganese metal phosphate.

15 5. Lithium-manganese metal phosphate according to claim 3 or 4, wherein the carbon covers the individual particles of the mixed lithium-manganese metal phosphate.

6. Lithium-manganese metal phosphate according to any one of claims 3 to 5, wherein the proportion of carbon
20 relative to the substituted lithium-manganese metal phosphate is ≤ 4 wt.-%.

7. Cathode for a secondary lithium-ion battery containing the lithium-manganese metal phosphate according to any one of claims 1 to 6.

8. Cathode according to claim 7, containing a further lithium-metal-oxygen compound.
9. Cathode according to claim 8, wherein the further lithium-metal-oxygen compound is selected from the group consisting of LiCoO_2 , LiMn_2O_4 , LiNiO_2 , LiCoPO_4 , LiFePO_4 , LiMnPO_4 , LiMnFePO_4 , and any mixtures thereof.
10. Cathode according to any one of claims 7 to 9, which is free of added conductive agents.
11. Process for producing the lithium-manganese metal phosphate according any one of claims 1 to 6, comprising the following steps:
 - a. producing a mixture in aqueous solution containing at least a Li starting compound, a Mn starting compound, an Fe starting compound, a M^{2+} starting compound and a PO_4^{3-} starting compound until a suspension forms,
 - b. carrying out a dispersion or grinding treatment of the mixture and/or the suspension, and
 - c. obtaining $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$, wherein x and y have the above-named meanings, from the suspension by reaction of the suspension under hydrothermal conditions.
12. Process according to claim 11, wherein in step a) or step c) a further, carbon-containing, component is added.

13. Process according to claim 12, wherein the $\text{LiFe}_x\text{Mn}_{1-x-y}\text{M}_y\text{PO}_4$ obtained in step c) is mixed with a carbon-containing component.

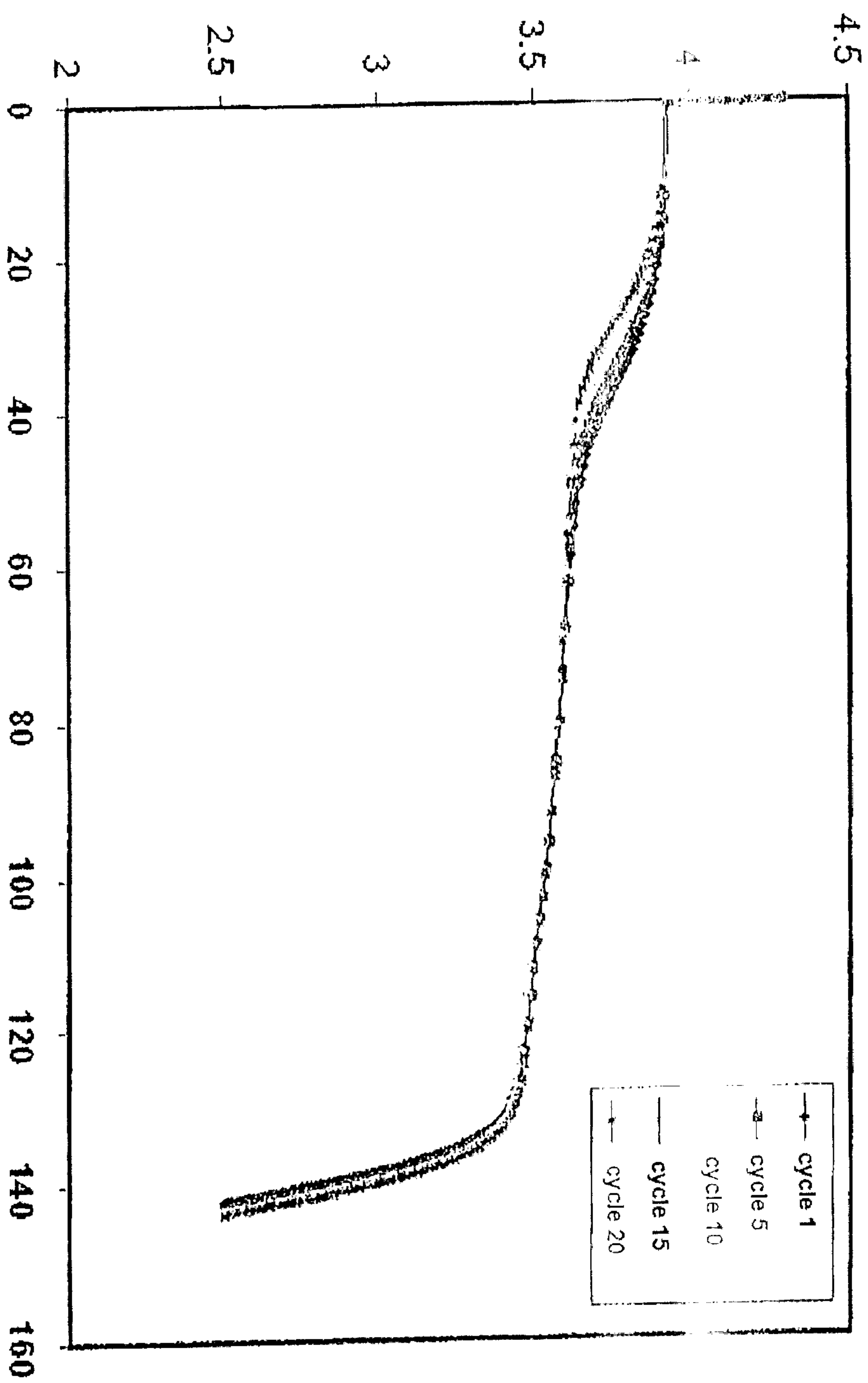
14. Process according to any one of claims 11 to 13, wherein
5 a drying step is then carried out at a temperature of $< 100^\circ\text{C}$ and/or a calcining step at a temperature of more than 200°C .

15. Process according to any one of claims 11 to 14, wherein
10 the reaction is carried out under hydrothermal conditions at temperatures of 100°C to 200°C as well as a pressure of 1 bar to 40 bar vapour pressure.

16. Lithium-manganese metal phosphate which is produced by the process according to any one of claims 11 to 15.

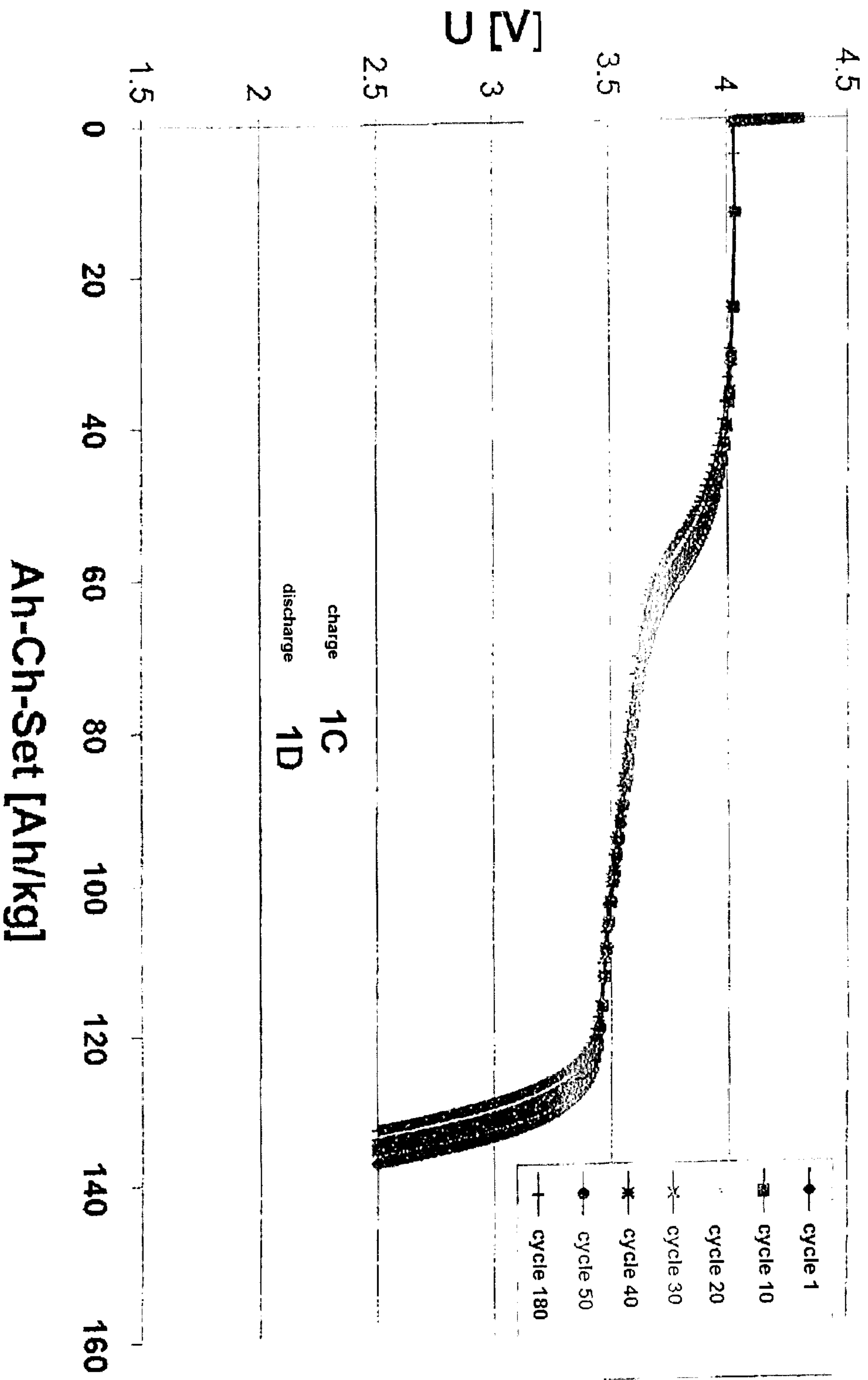
1/19

Figure 1



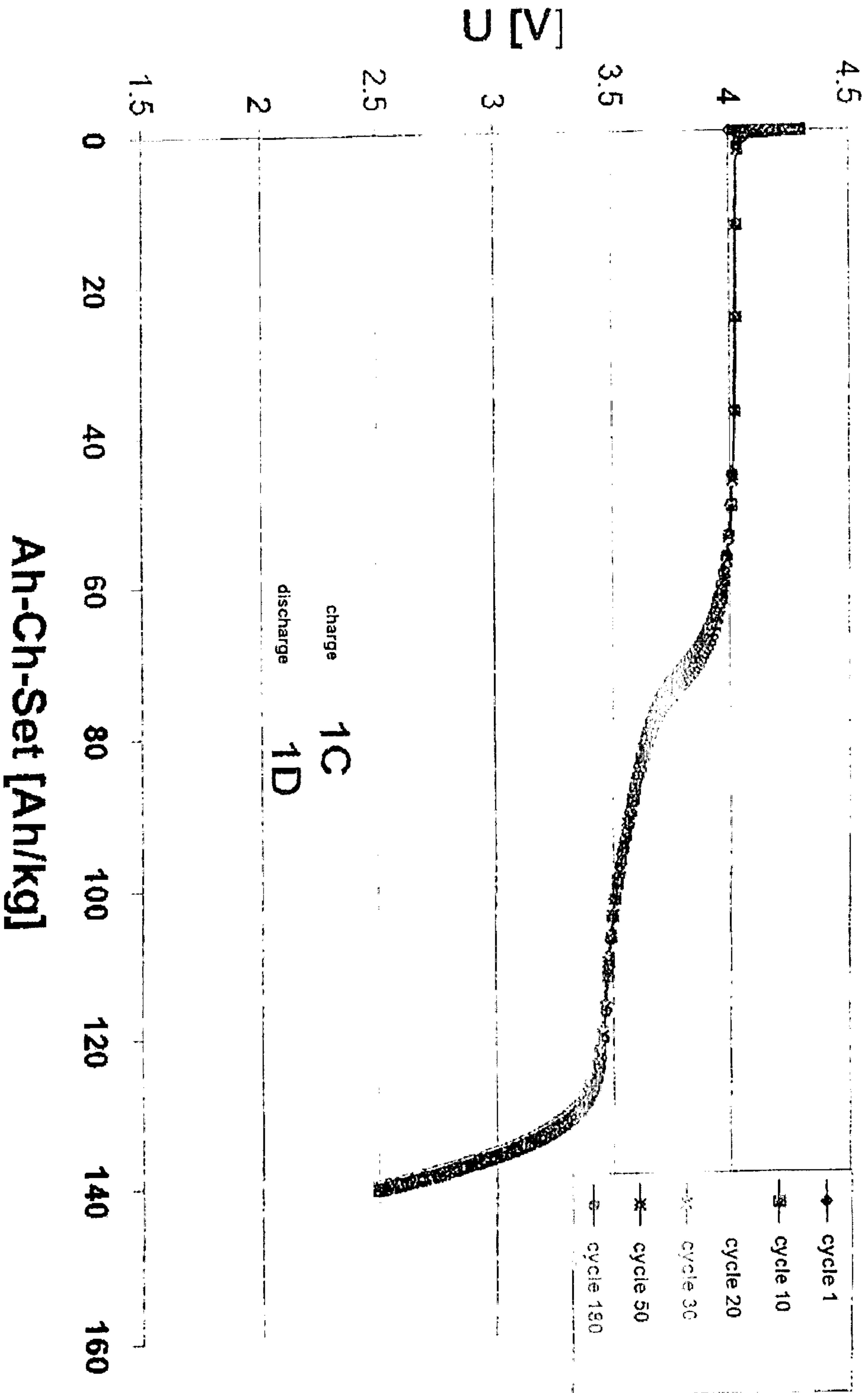
2/19

Figure 2



3/19

Figure 3



4/19

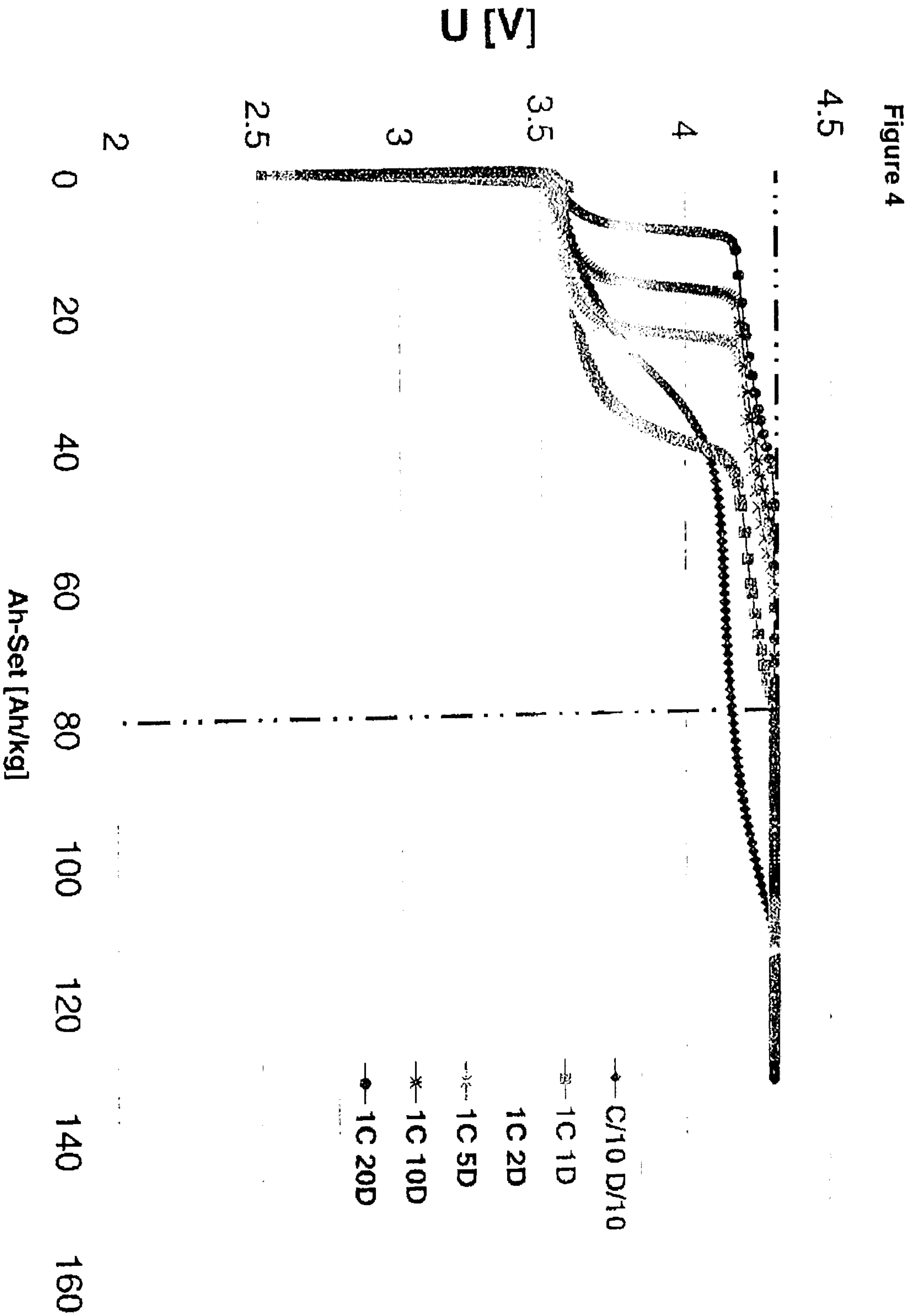
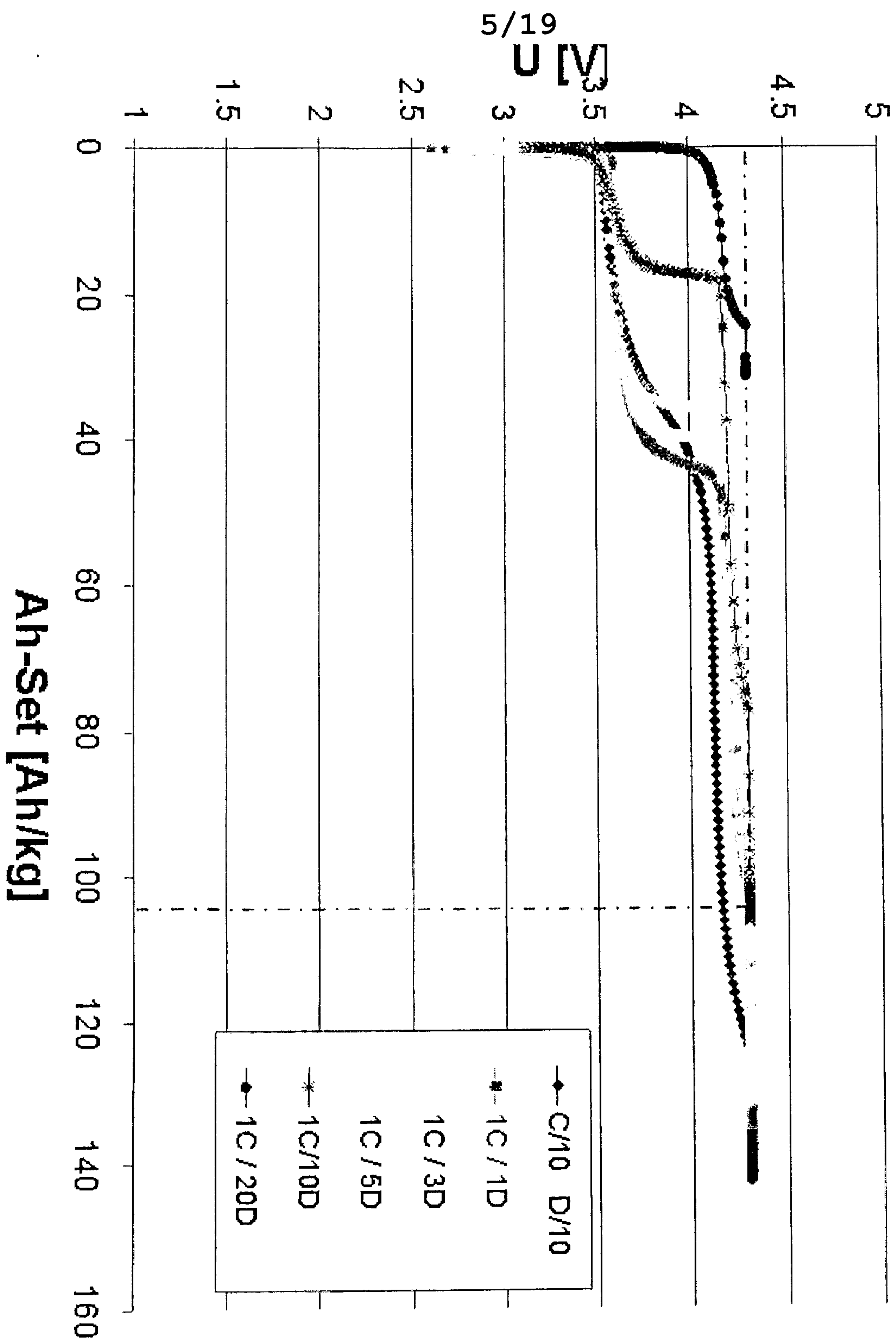
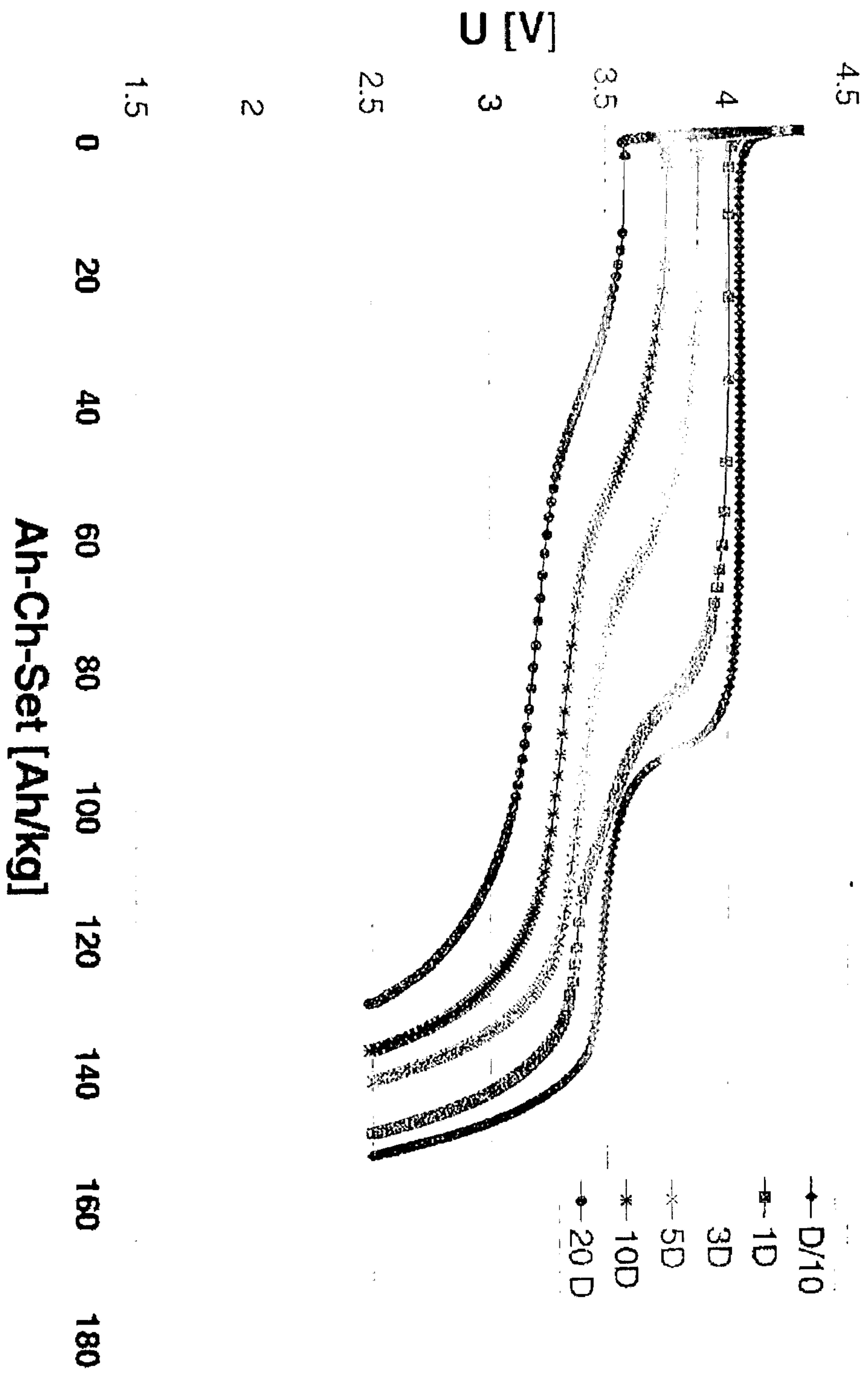


Fig. 5



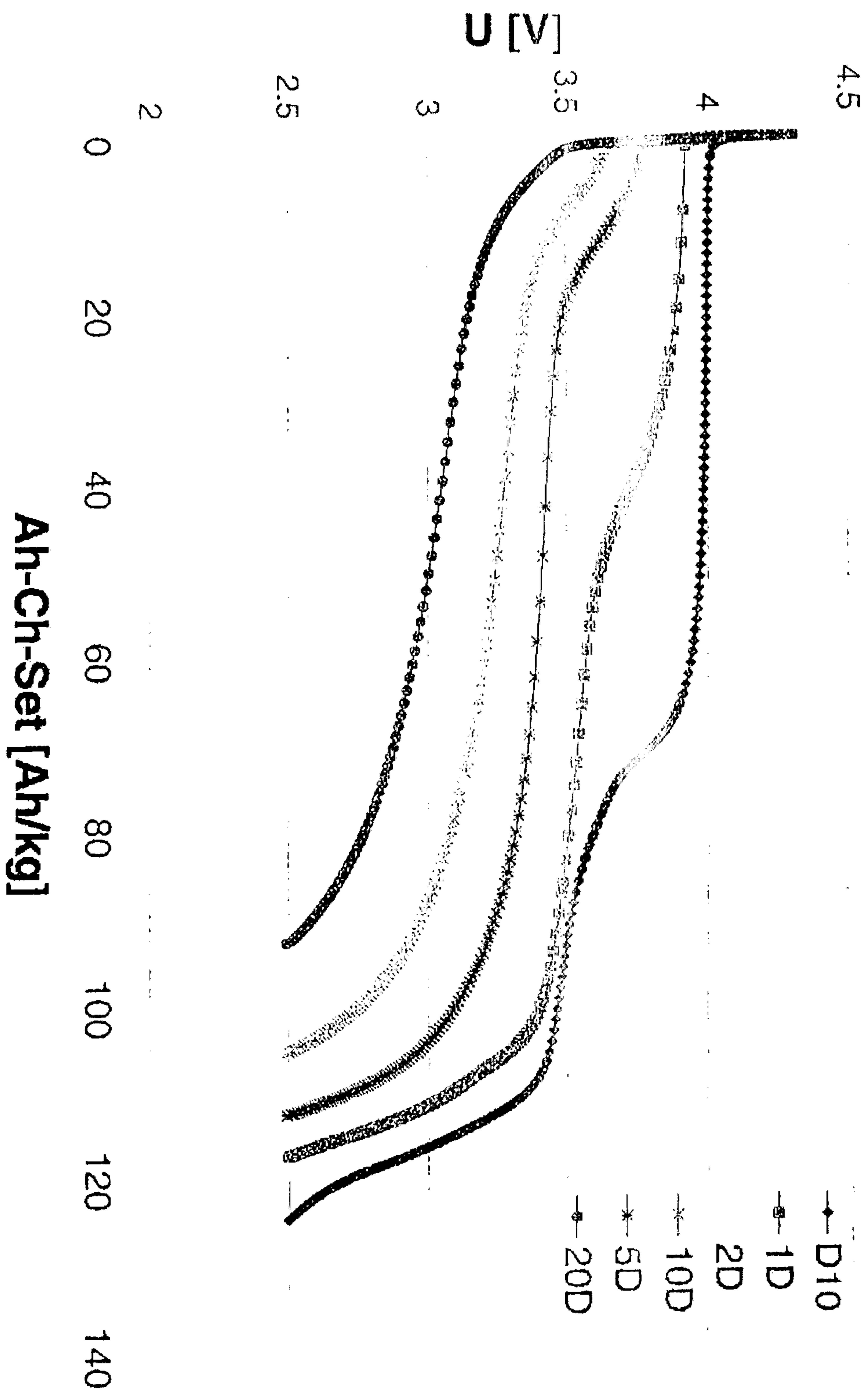
6/19

Figure 6



7/19

Figure 7



8/19

U [V]

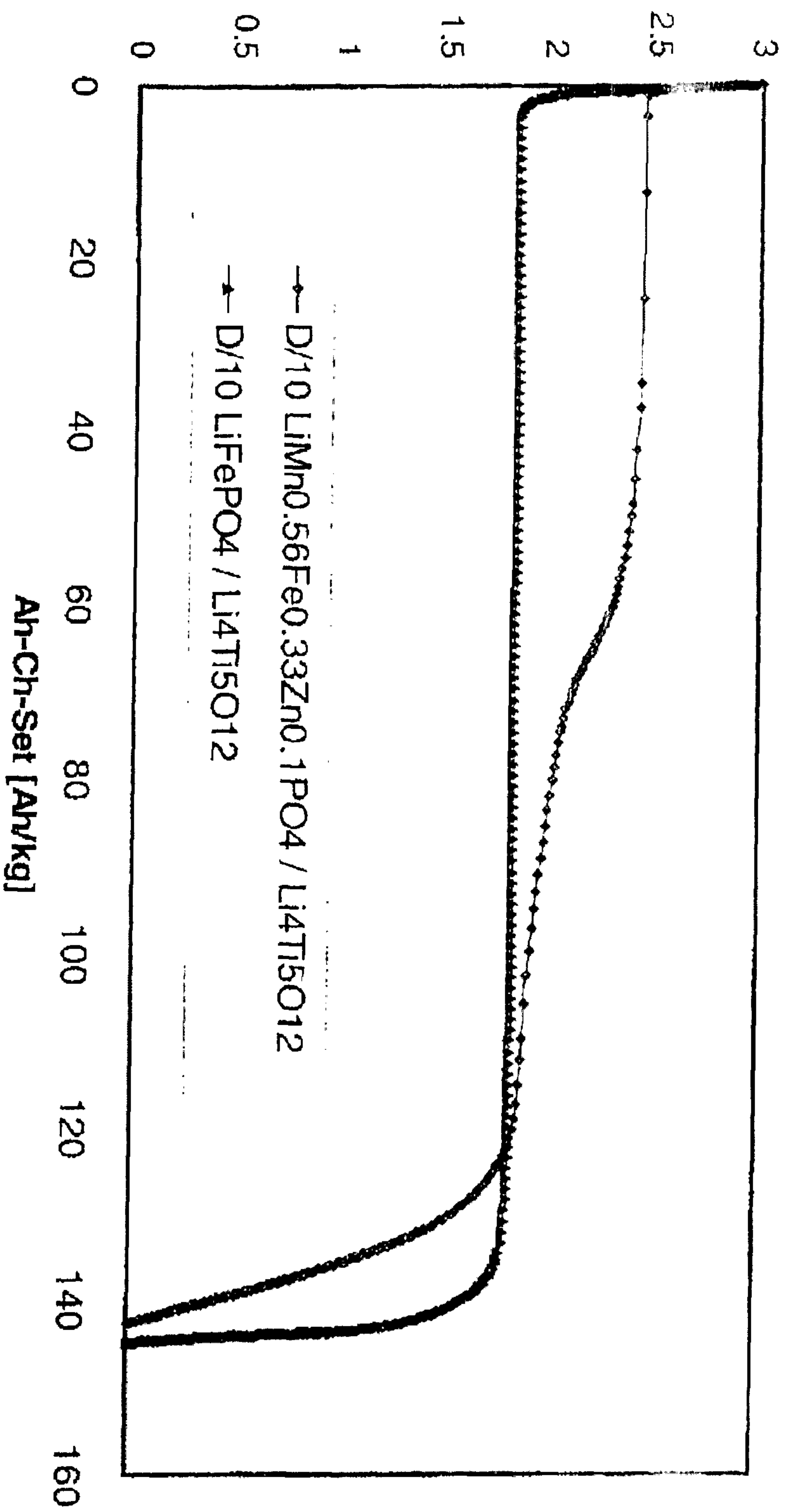
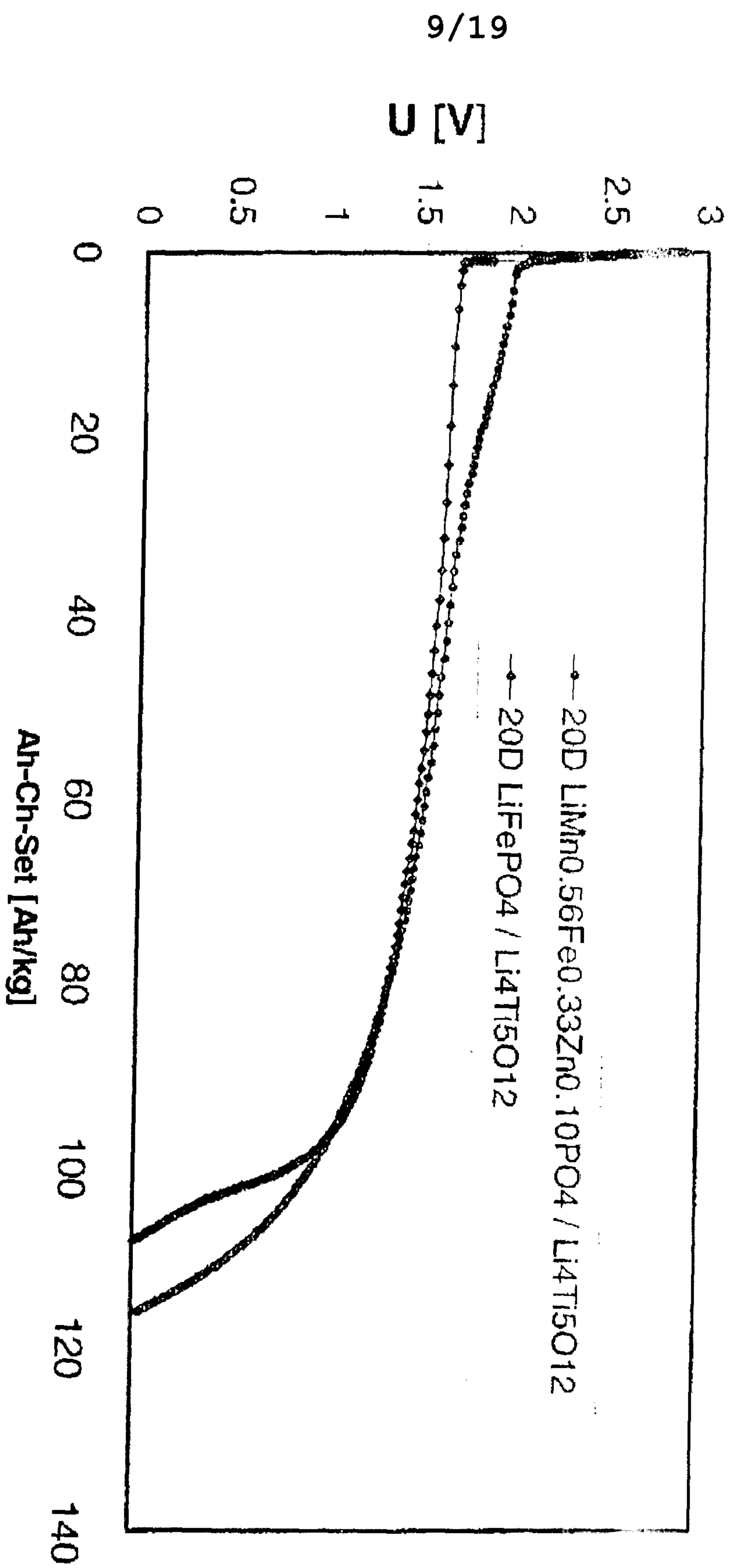
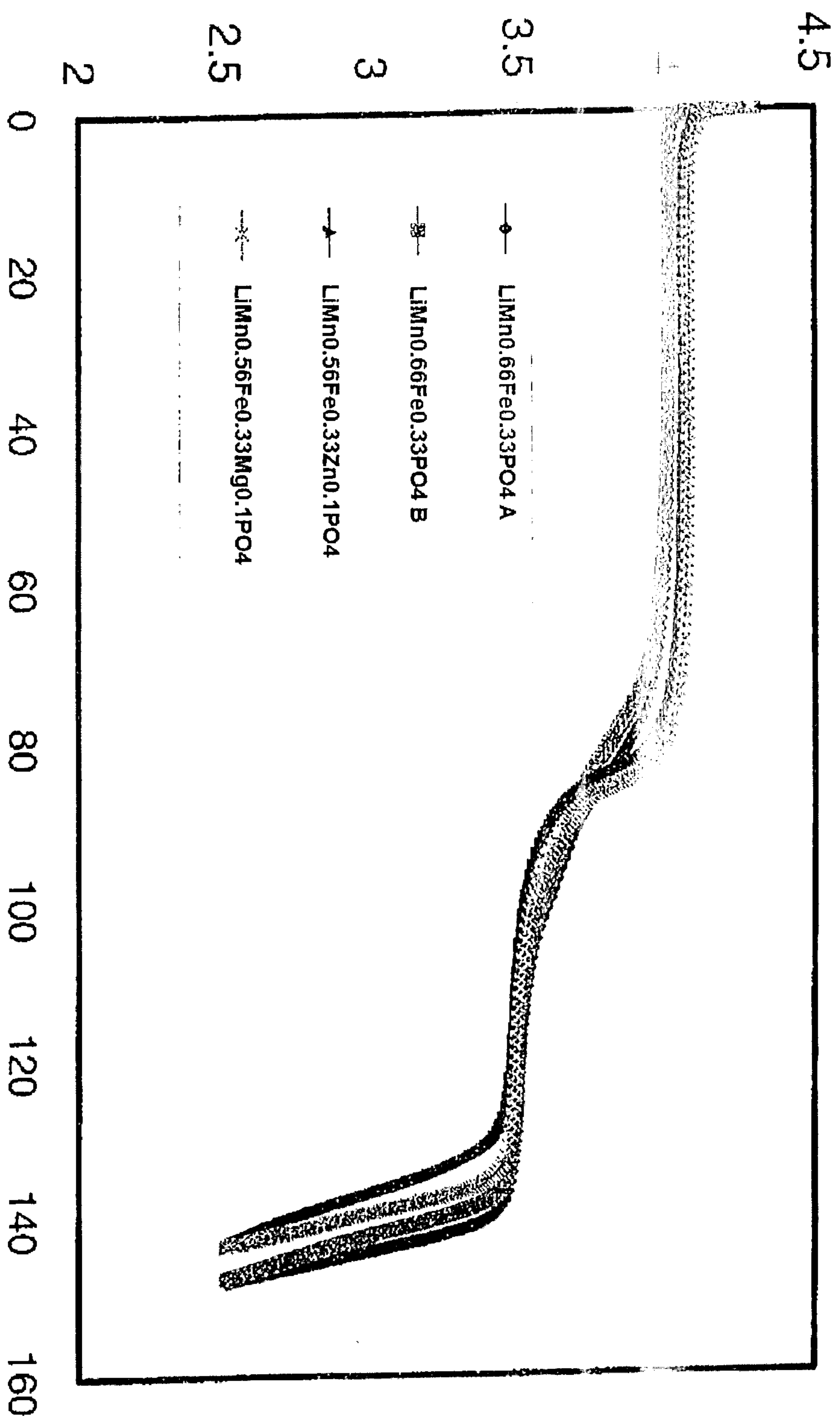


Figure 8B



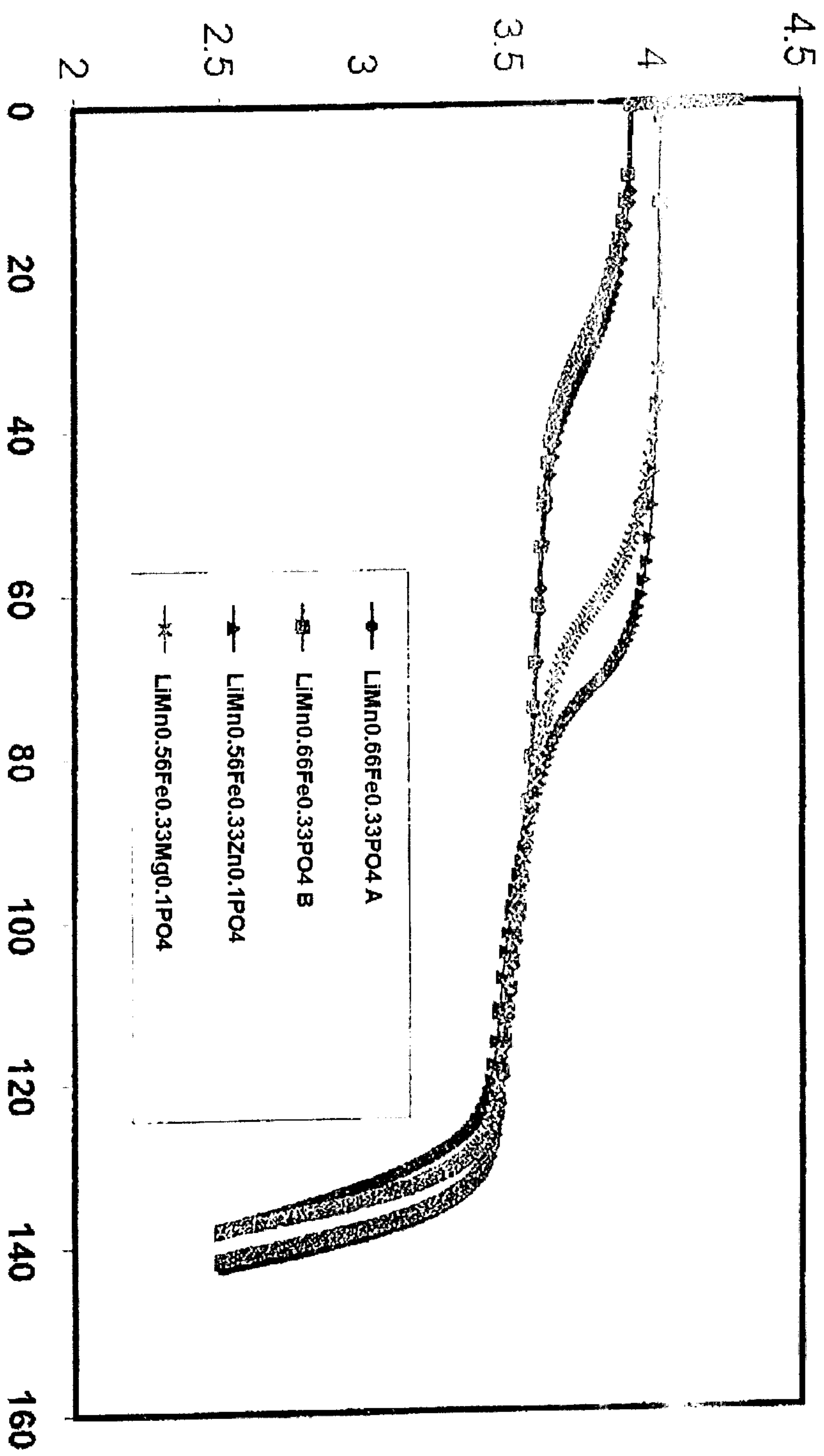
10/19

Figure 9



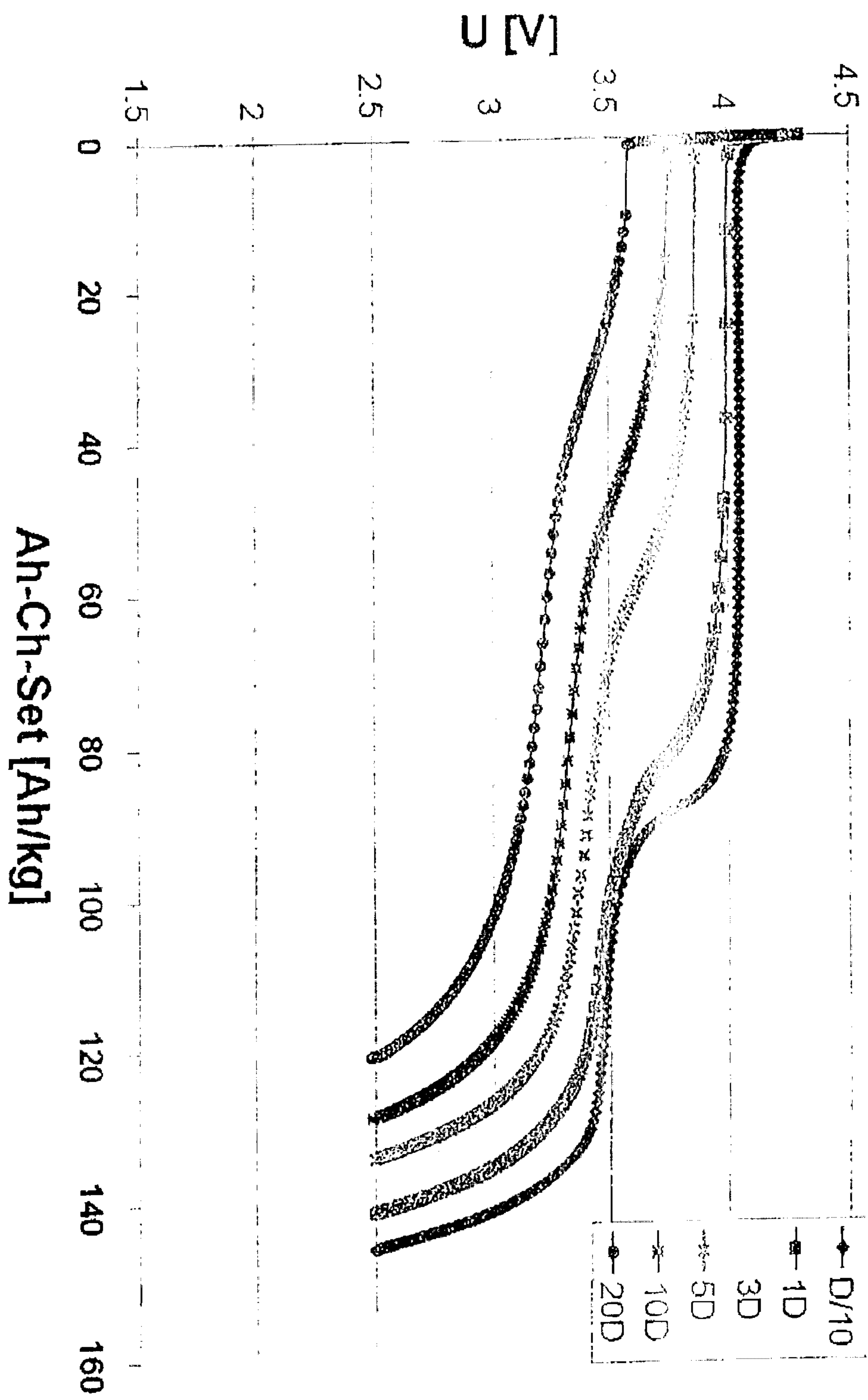
11/19

Figure 10



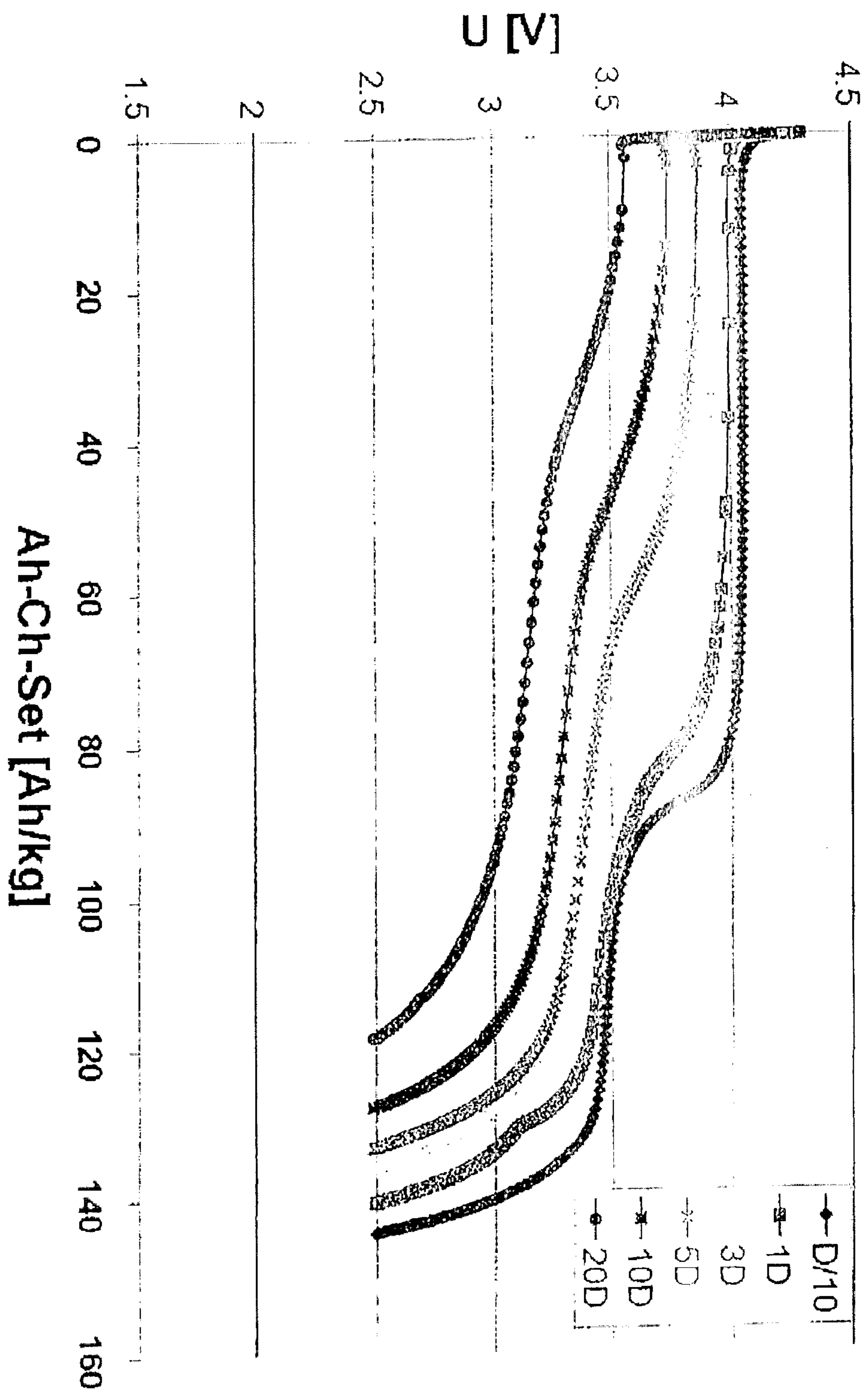
12/19

Figure 11A



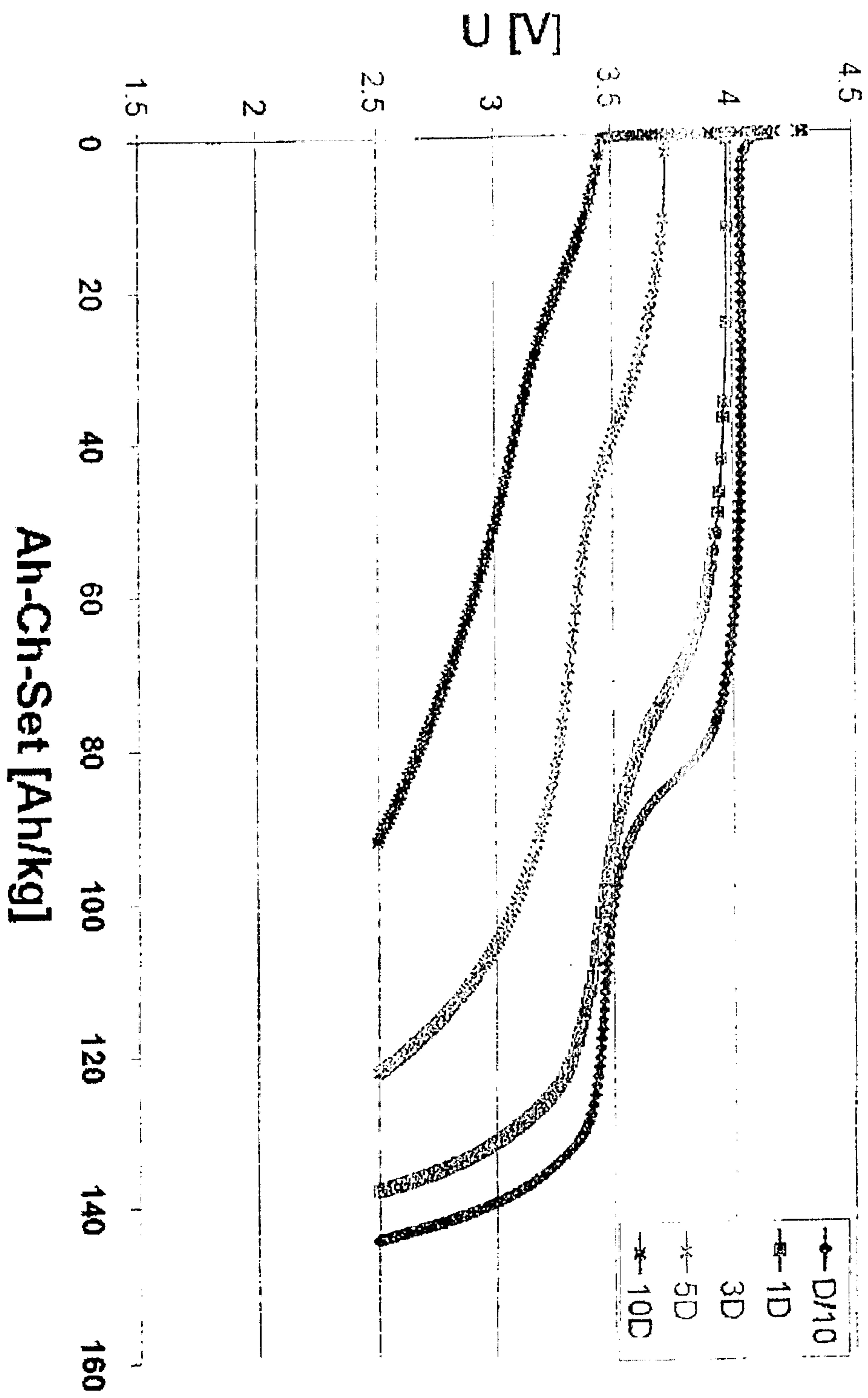
13/19

Figure 11B



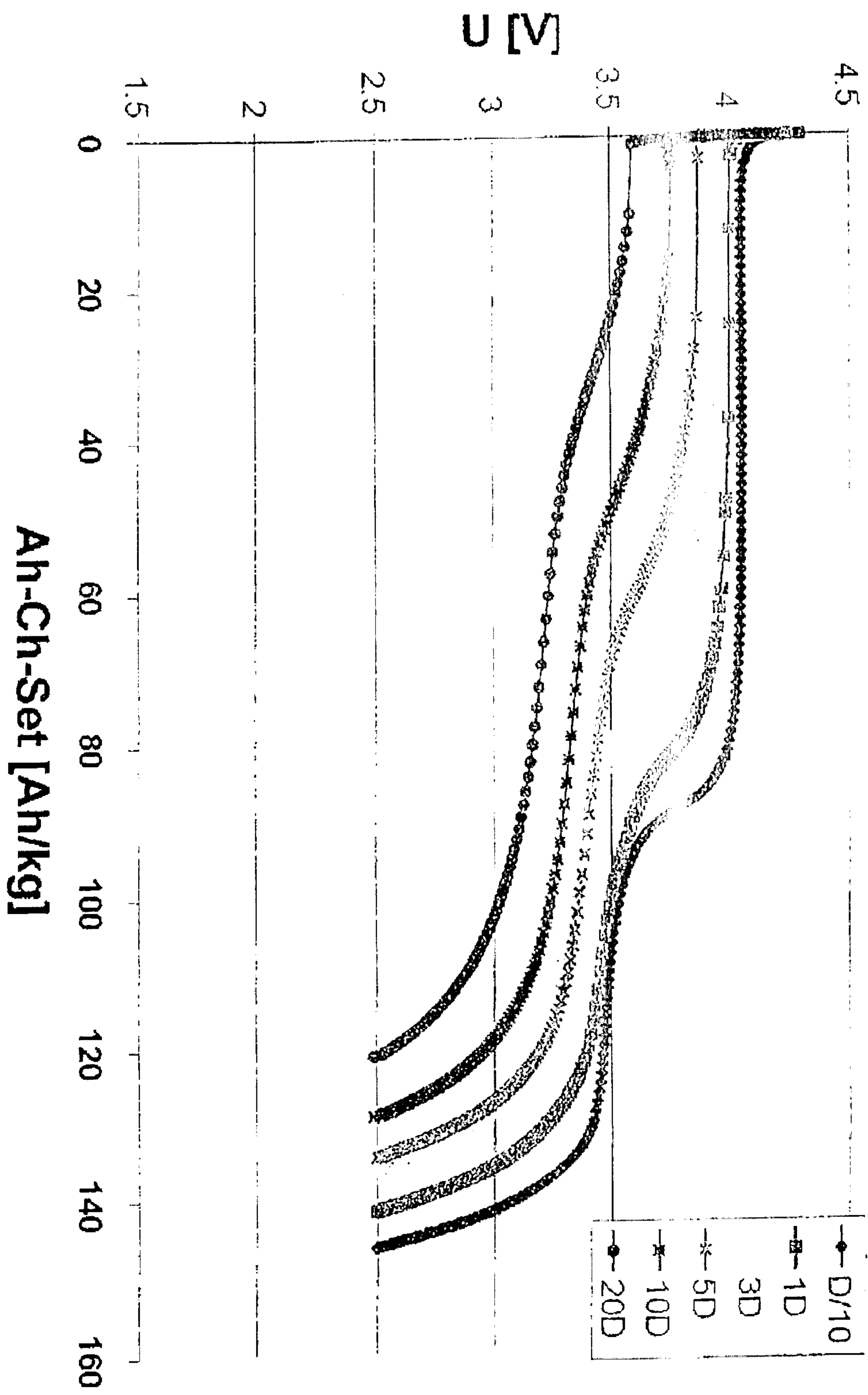
14/19

Figure 11C



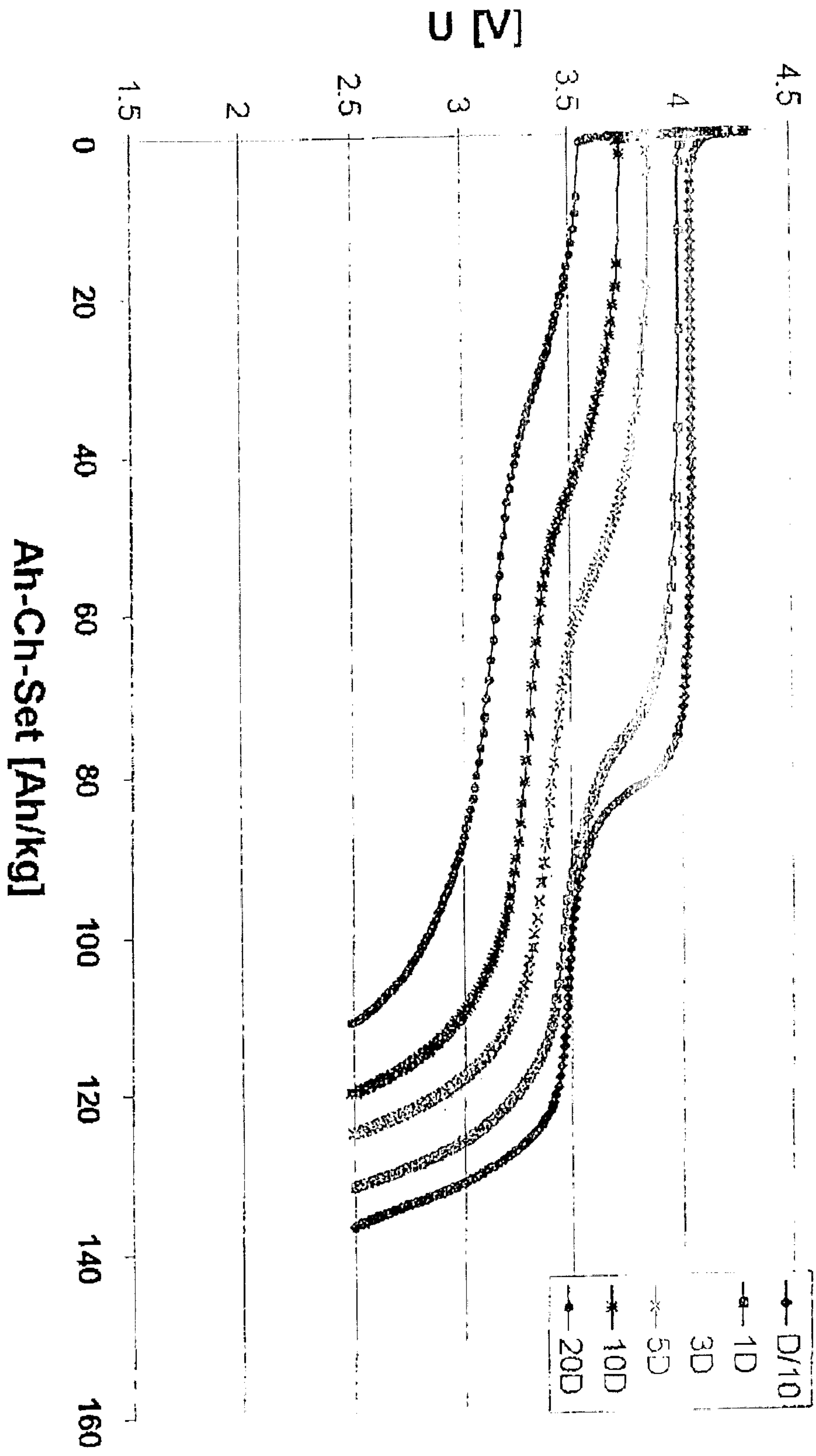
15/19

Figure 12A



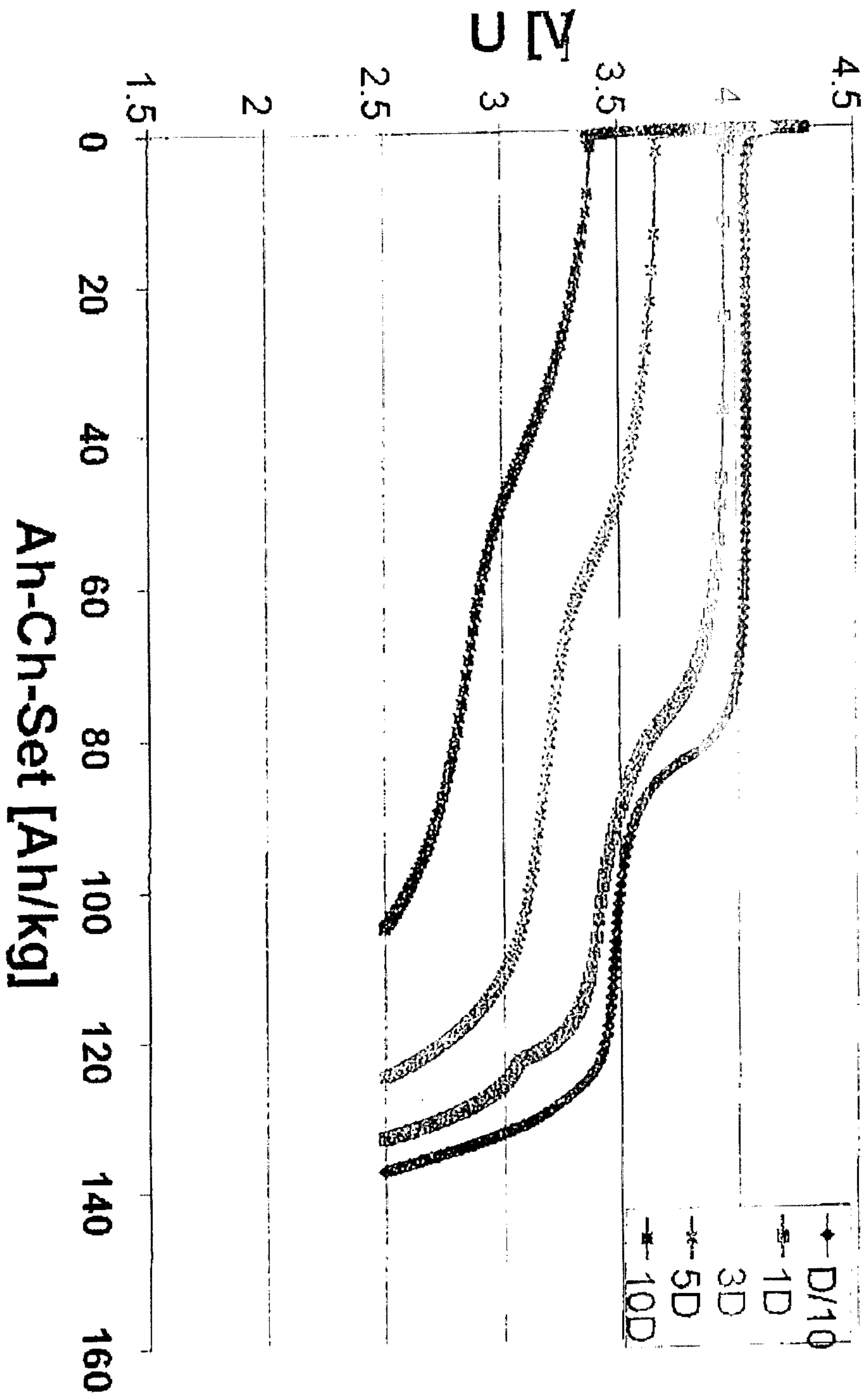
16/19

Figure 12B



17/19

Figure 12C



18/19

Figure 13

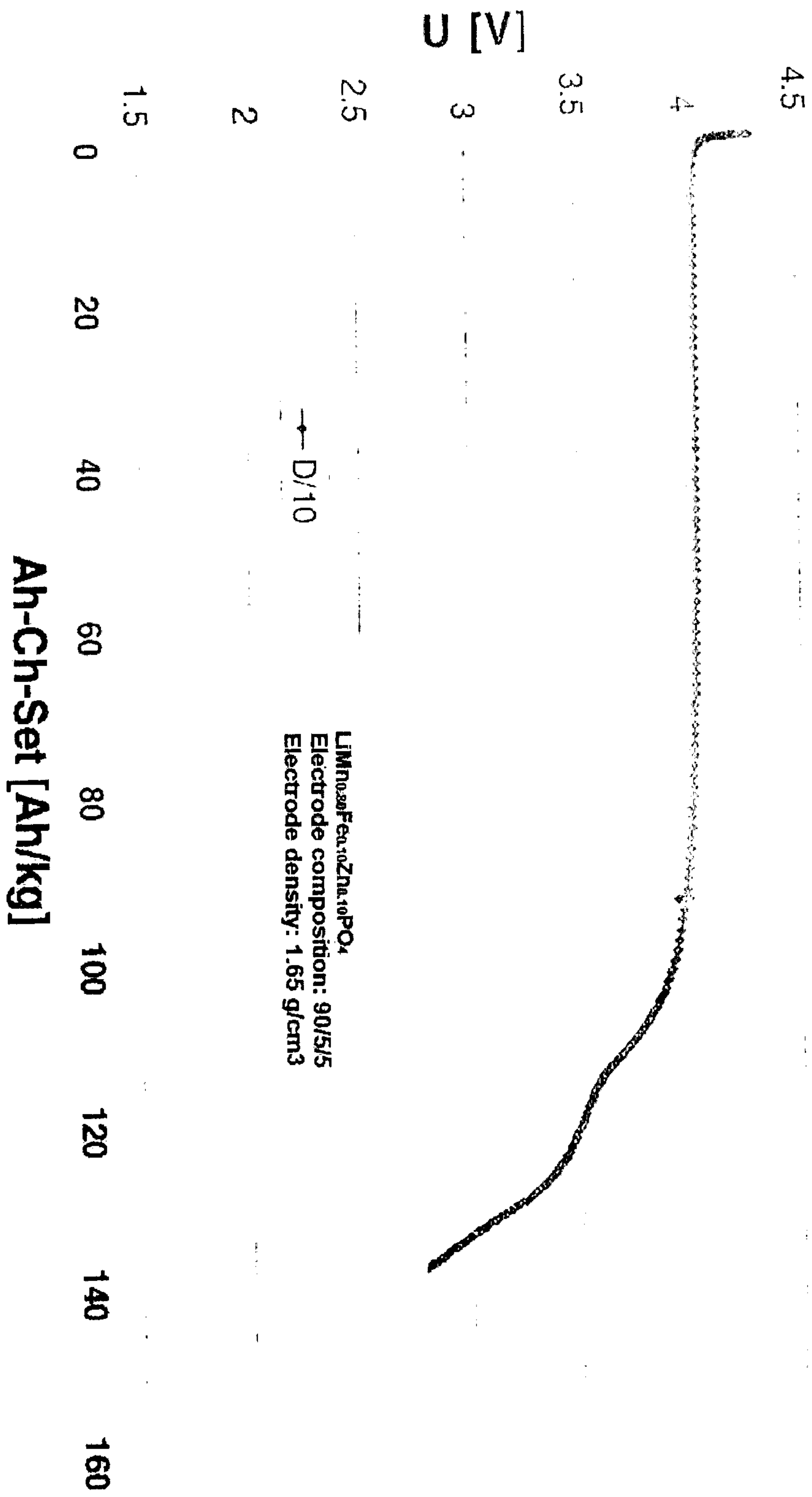


Figure 14

