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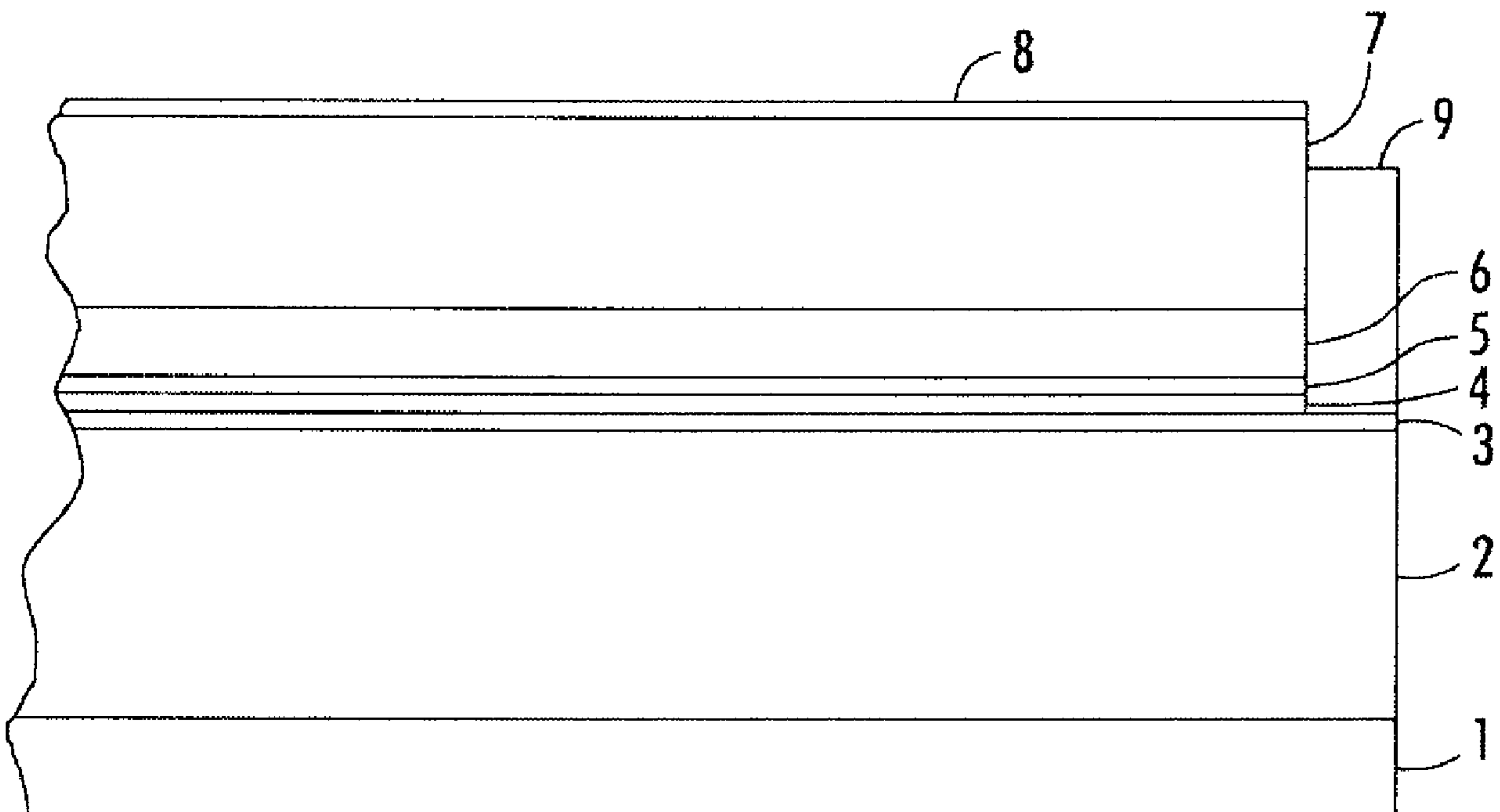
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(54) Titre : ELEMENTS D'IMAGERIE POUR IMPRESSION NUMERIQUE A BASE D'ENCRE COMPORTANT DES FILMS  
ORGANIQUES STRUCTURES

(54) Title: IMAGING MEMBERS FOR INK-BASED DIGITAL PRINTING COMPRISING STRUCTURED ORGANIC FILMS



(57) Abrégé/Abstract:

An imaging member for ink-based digital printing having an outermost layer including a structured organic film (SOF) having a plurality of segments and a plurality of linkers arranged as a covalent organic framework, wherein the structured organic film may be multi-segment thick.



## ABSTRACT

An imaging member for ink-based digital printing having an outermost layer including a structured organic film (SOF) having a plurality of segments and a plurality of linkers arranged as a covalent organic framework, wherein the structured organic film may be multi-segment thick.

**IMAGING MEMBERS FOR INK-BASED DIGITAL PRINTING**  
**COMPRISING STRUCTURED ORGANIC FILMS**

**BACKGROUND OF THE INVENTION**

[0001] In electrophotography, electrophotographic imaging or electrostatographic imaging, the surface of an electrophotographic plate, drum, belt or the like (imaging member or photoreceptor) containing a photoconductive insulating layer on a conductive layer is first uniformly electrostatically charged. The imaging member is then exposed to a pattern of activating electromagnetic radiation, such as light. The radiation selectively dissipates the charge on the illuminated areas of the photoconductive insulating layer while leaving behind an electrostatic latent image on the non-illuminated areas. This electrostatic latent image may then be developed to form a visible image by depositing finely divided electroscopic marking particles on the surface of the photoconductive insulating layer. The resulting visible image may then be transferred from the imaging member directly or indirectly (such as by a transfer or other member) to a print substrate, such as transparency or paper. The imaging process may be repeated many times with reusable imaging members.

**[0003]** An electrophotographic imaging member may be provided in a number of forms. For example, the imaging member may be a homogeneous layer of a single material such as vitreous selenium or it may be a composite layer containing a photoconductor and another material. In addition, the imaging member may be layered. Current layered organic imaging members generally have at least a substrate layer and two active layers. These active layers generally include (1) a charge generating layer containing a light-absorbing material, and (2) a charge transport layer containing electron donor molecules. These layers can be in any order, and sometimes can be combined in a single or mixed layer. The substrate layer may be formed from a conductive material. In addition, a conductive layer can be formed on a nonconductive substrate.

**[0004]** The charge generating layer is capable of photogenerating charge and injecting the photogenerated charge into the charge transport layer. For example, U.S. Patent No. 4,855,203 to Miyaka teaches charge generating layers comprising a resin dispersed pigment. Suitable pigments include photoconductive zinc oxide or cadmium sulfide and organic pigments such as phthalocyanine type pigment, a polycyclic quinone type pigment, a perylene pigment, an azo type pigment and a quinacridone type pigment. Imaging members with perylene charge generating pigments, particularly benzimidazole perylene, show superior performance with extended life.

**[0005]** In the charge transport layer, the electron donor molecules may be in a polymer binder. In this case, the electron donor molecules provide hole or charge transport properties, while the electrically inactive polymer binder provides mechanical properties. Alternatively, the charge transport layer can be made from a charge transporting polymer such as poly(N-vinylcarbazole), polysilylene or polyether carbonate, wherein the charge transport properties are incorporated into the mechanically strong polymer.

**[0006]** Imaging members may also include a charge blocking layer and/or an adhesive layer between the charge generating layer and the conductive layer. In addition, imaging members may contain protective overcoatings. Further, imaging members may include layers to provide special functions such as incoherent reflection

of laser light, dot patterns and/or pictorial imaging or subbing layers to provide chemical sealing and/or a smooth coating surface.

**[0007]** Generally, the above-described electrophotographic systems utilize a dry, powdered pigment material referred to as a toner. These systems generally require that the substrate be charged, and that the toner be fused to the substrate, often by heating the substrate, after transferring the toner from the receptor surface to the substrate. There is, however, a desire for methods and systems for printing with different types of pigment materials and on a wider variety of substrates.

**[0008]** For example, one common family of alternative pigment material are liquid-based inks, such as used in ink-jet and other forms of printing well-known today. In many modern printing applications, the inks used are comprised of charged particles suspended in a solvent carrier.

**[0009]** Such liquid ink-based printing systems are limited because they require relatively low viscosity inks. The viscosity of the ink affects the printing throughput, the function of transferring to and fusing the image on a substrate, the internal operations of the printing system, the cleaning of the printing system and so forth. Thus, these systems generally are limited to using inks with a viscosity of for example less than 100 centipoise (cp). However, there are many applications for which a higher viscosity ink is advantageous. For example, higher viscosity inks may permit the use of a wider variety of inks and substrates, reduced cost, etc.

**[0010]** A number of printing techniques accommodate high viscosity inks. Gravure printing is one example of a well-known printing technology that can accommodate a relatively wider range of ink viscosities. According to this technique, an image carrier (most often a drum) is provided with a pattern of relatively very small recessed areas or cells. An ink is spread over the image carrier such that ink is retained in the cells, but not on the lands between the cells. An image-receiving substrate is brought into pressured contact with the ink-bearing plate or drum. In this type of printing, the ink wicks out of the cells and onto the substrate, where it is dried, thereby imparting a marking onto the substrate. Gravure printing can accommodate higher viscosity inks than current electrophotographic methods, but the image is not

variable from printing to printing – the gravure pattern is a permanent part of the image carrier.

**[0011]** In such printing techniques that accommodate high viscosity inks, ink may be metered into an anilox, or gravure, roller such that the cells, or grooves, are partially filled. To form an image, the ink may be electrostatically pulled out of the cells in an image-wise fashion. Typically, metering rollers are used to meter the amount of ink applied to an anilox roller. An anilox roller may include a cylindrical surface with millions of very fine hollows, shaped as cells or grooves. Anilox and gravure are terms both referring to cylinders with small cells/ grooves on the surface and may be used interchangeably. Technically, the term anilox is used more in flexographic printing and gravure is used in gravure printing. The gravure cells may usually be patterned in an image while the anilox cells may not be. Ink to be metered is filled in the cells. Doctor blades or wiping blades are usually used to clean the lands of the anilox roller. In doctor blade mode, doctor blades may be placed in an angle more than 90 degrees with respect to the blade moving direction. In wiping blade mode, wiping blades may be placed in angles less than 90 degrees with respect to the blade moving direction.

**[0012]** Existing technologies for electrostatic printing using anilox rollers have a number of drawbacks. Traditional cleaning using doctor blades may leave the cells full which leads to the problem of high background printing. The blades may be adjusted, but blades have inherent problems, including particle trapping, non-uniformity, speed limitations and cell pattern restrictions. For example, in a single blade system, there is an inherent conflict between the metering and cleaning requirements of the blade, as it needs to be soft enough to go into the cells or grooves, but hard or stiff enough to effectively wipe off residue ink from the lands. Another technique used a wiping blade mode, but this mode works only at slow speeds, as higher speeds increase the hydrodynamic pressure significantly.

**[0013]** Efforts to combine the above-mentioned different printing technologies include, for example, WO 91/15813 (Swidlery), which discloses an electrostatic image transfer system by which the negative or reverse of a desired image is first

exposed onto the surface of a photoreceptor, then that image is transferred to a toner roller, where the image is reversed to create the desired image on the toner roller. This image on the toner roller may then be transferred to a substrate and fused.

**[0014]** In U.S. Patent No. 3,801,315, a gravure member is used to form an image on a substrate. The gravure member includes a number of evenly spaced cells with interstitial surface lands. A photoconductor is formed on the surface lands only (i.e., no photoconductive material within the cells). Pigment material is deposited within the cells. The photoconductor is exposed to an image, and in the regions of exposure the charge on the photoconductor is dissipated. In cells adjacent charged lands, the pigment material forms a concave meniscus, and in cells adjacent discharged lands the pigment material forms a convex meniscus, due to the electric field effects on the surface tension of the pigment material. The image is then transferred from the gravure member to a conductively backed image-receiving web brought into contact with the gravure member. Where there is a conductive difference between land and conductive backing, and the pigment material is convex within a cell, the pigment material in the cell is transferred to the receiving web. Where the meniscus of the pigment material is concave within a cell and there is no conductive difference between land and web backing, no pigment material is transferred. The image may then be transferred from the web to a substrate. However, due to the meniscus effects, and the fact that electrostatics are required to pull the pigment material out of the cells and onto the receiving web, the pigment material must be of a relatively low viscosity. Furthermore, the reference teaches using a separate photoreceptor and gravure member, requiring cleaning of the ink off of the photoreceptor for every printing pass.

**[0015]** Another application of electrophotography to a gravure-like process is disclosed in U.S. Patent No. 4,493,550. According to this reference, pigment material is disposed in cells and provided with a negative charge. A positively charged photoreceptor is image-wise exposed such that certain regions are discharged and others retain the positive charge. The photoreceptor and the pigment containing cells

are brought proximate one another such that the opposite charge therebetween causes the pigment material to transfer from the cells to the photoreceptor where the photoreceptor retains the positive charge but not where it is discharged. The pigment on the photoreceptor may then be transferred to substrate. Again, however, the pigment material must be of a relatively low viscosity for the electrostatic force to be sufficient to pull the pigment material from the cell to the photoreceptor. This reference also teaches using a separate photoreceptor and gravure member, requiring cleaning of the ink off of the photoreceptor for every printing pass, leading to degradation problems.

**[0016]** As more advanced, higher speed electrophotographic copiers, duplicators and printers have been developed, and as the use of such devices increases in both the home and business environments, degradation of image quality has been encountered during extended cycling. This repetitive cycling leads to a gradual deterioration in the mechanical and electrical characteristics. Moreover, complex, highly sophisticated duplicating and printing systems operating at very high speeds have placed stringent requirements upon component parts, including such constraints as narrow operating limits on the photoreceptors. For example, the numerous layers found in many modern photoconductive imaging members must be highly flexible, adhere well to adjacent layers, and exhibit predictable electrical characteristics within narrow operating limits to provide excellent toner images over many thousands of cycles. One type of multilayered photoreceptor that has been employed for use as a belt or as a roller in electrophotographic imaging systems comprises a substrate, a conductive layer, a blocking layer, an adhesive layer, a charge generating layer, a charge transport layer and a conductive ground strip layer adjacent to one edge of the imaging layers. This photoreceptor may also comprise additional layers such as an anti-curl back coating and an optional overcoating layer.

**[0017]** Imaging members are generally exposed to repetitive electrophotographic cycling, which subjects the exposed charge transport layer thereof to abrasion, chemical attack, heat and multiple exposures to light. This repetitive cycling leads to a gradual deterioration in the mechanical and electrical characteristics of the exposed charge transport layer. Attempts have been made to

overcome these problems. However, the solution of one problem often leads to additional problems.

**[0018]** For example, other image member systems are also known to suffer from a gradual deterioration in the mechanical and electrical characteristics of the exposed regions. For example, U.S. Patent Nos. 2,324,550 and 4,078,927 disclose lithographic ink systems, and U.S. Patent No. 3,801,315 to Grundlach et al. discloses a gravure ink system that suffer from a gradual deterioration in the image transfer region.

**[0019]** An improved system and method to perform variable data printing of viscous inks would permit digital production printing in, among other fields, the commercial graphic arts and packaging markets. The ability to use viscous liquid inks would provide numerous advantages, including use of higher density/viscosity pigment, lower fixing energy (no fusing), larger substrate latitude, and lower ink spreading or dot gain.

**[0020]** Although known processes and materials are suitable for their intended purposes, a need remains for improved imaging members and processes employing improved imaging members. For example, there remains a need in the art for longer-lasting imaging members. Such improved imaging member designs should include increased wear resistance, i.e., low photoreceptor wear, while still providing improved toner transfer, improved cleaning properties, lower toner adhesion, and the like. There is also a need for imaging members that possess acceptable thermal stability, excellent chemical stability, and also have physical and mechanical stability. There is also a need for improved imaging members that may be utilized in dry (or liquid) xerographic imaging and printing systems and processes. Chemical stability as mentioned herein refers, for example, to resistance attack from both dry and liquid toners and developers, view of the contact of the transfer element with liquid, charge additive, charge directors, toner resins, and pigments.

## **SUMMARY OF THE DISCLOSURE**

**[0021]** The present disclosure addresses these and other needs by providing an imaging member for digital printing comprising: a substrate; a charge generating layer; an optional charge transport layer; and an outermost layer; wherein the outermost layer comprises a structured organic film (SOF) comprising a plurality of segments, a plurality of linkers arranged as a covalent organic framework (COF).

**[0022]** The present disclosure also provides an imaging member for digital printing comprising: a substrate, a charge generating layer, and a charge transport layer, wherein an external layer of said imaging member comprises a SOF.

**[0023]** The present disclosure also provides a method for making such an imaging member and a method of forming an image or printing with such an imaging member.

**[0023a]** In accordance with another aspect, there is provided an imaging member for ink-based digital printing comprising:

- a substrate;
- a charge generating layer;
- a charge transport layer; and
- an optional overcoat layer;

wherein an outermost layer of the imaging member is an imaging surface that comprises a structured organic film (SOF) comprising a plurality of segments including at least a first segment type and a plurality of linkers including at least a first linker type arranged as a covalent organic framework (COF), wherein the first segment type and/or the first linker type comprises at least one atom that is not carbon.

**[0023b]** In accordance with a further aspect, there is provided an imaging apparatus for ink-based digital printing, comprising:

an imaging member, wherein an outermost layer of the imaging member comprises a structured organic film (SOF) comprising a plurality of segments including at least a first segment type and a plurality of linkers including at least a first linker type arranged as a covalent organic framework (COF), wherein the first

segment type and/or the first linker type comprises at least one atom that is not carbon;

a charging unit to impart an electrostatic charge on the imaging member;

an exposure unit to create an electrostatic latent image on the imaging member;

an ink delivery unit to create an ink image on the imaging member;

a transfer unit to transfer the ink image from the imaging member; and

an optional cleaning unit.

**[0023c]** In accordance with another aspect, there is provided an imaging member for ink-based digital printing comprising:

a substrate;

a charge generating layer;

a charge transport layer; and

an optional overcoat layer;

wherein an outermost layer of the imaging member is an imaging surface that comprises a structured organic film (SOF) comprising a plurality of segments including at least a first segment type and a plurality of linkers including at least a first linker type arranged as a covalent organic framework (COF), wherein the SOF is a substantially defect-free film, and the first segment type and/or the first linker type comprises a hydrogen.

### **BRIEF DESCRIPTION OF THE DRAWINGS**

**[0024]** Other aspects of the present disclosure will become apparent as the following description proceeds and upon reference to the following figures which represent illustrative embodiments:

**[0025]** FIG. 1 represents a simplified side view of an exemplary photoreceptor that incorporates a SOF of the present disclosure.

**[0026]** FIG. 2 represents a simplified side view of a second exemplary photoreceptor that incorporates a SOF of the present disclosure.

**[0027]** FIG. 3 represents a simplified side view of a third exemplary photoreceptor that incorporates a SOF of the present disclosure.

**[0028]** FIG. 4 is a graphic representation that compares the Fourier transform infrared spectral of the products of control experiments mixtures, wherein only N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine is added to the liquid reaction mixture (top), wherein only benzene-1,4-dimethanol is added to the liquid reaction mixture (middle), and wherein the necessary components needed to form a patterned Type 2 SOF are included into the liquid reaction mixture (bottom).

**[0029]** FIG. 5 is a graphic representation of a Fourier transform infrared spectrum of a free standing SOF comprising N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine segments, p-xylyl segments, and ether linkers.

**[0030]** FIG. 6 is a graphic representation of a Fourier transform infrared spectrum of a free standing SOF comprising N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine segments, n-hexyl segments, and ether linkers.

**[0031]** FIG. 7 is a graphic representation of a Fourier transform infrared spectrum of a free standing SOF comprising N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine segments, 4,4'-(cyclohexane-1,1-diyl)diphenyl, and ether linkers.

**[0032]** FIG. 8 is a graphic representation of a Fourier transform infrared spectrum of a free standing SOF comprising of triphenylamine segments and ether linkers.

**[0033]** FIG. 9 is a graphic representation of a Fourier transform infrared spectrum of a free standing SOF comprising triphenylamine segments, benzene segments, and imine linkers.

**[0034]** FIG. 10. is a graphic representation of a Fourier transform infrared spectrum of a free standing SOF comprising triphenylamine segments, and imine linkers.

**[0035]** FIG. 11 is a graphic representation of a photo-induced discharge curve (PIDC) illustrating the photoconductivity of a Type 1 structured organic film overcoat layer.

**[0036]** FIG. 12 is a graphic representation of a photo-induced discharge curve (PIDC) illustrating the photoconductivity of a Type 1 structured organic film overcoat layer containing wax additives.

**[0037]** FIG. 13 is a graphic representation of a photo-induced discharge curve (PIDC) illustrating the photoconductivity of a Type 2 structured organic film overcoat layer.

**[0038]** FIG. 14 is a graphic representation of two-dimensional X-ray scattering data for the SOFs produced in Examples 26 and 54.

[0039] FIG. 15 is a graphic representation of a photo-induced discharge curve (PIDC) illustrating the photoconductivity of a various overcoat layers.

[0040] FIG. 16 is a graphic representation of cycling data that was acquired for various SOF overcoat layers.

[0041] Unless otherwise noted, the same reference numeral in different Figures refers to the same or similar feature.

#### [0042] DETAILED DESCRIPTION

[0043] This disclosure is generally directed to imaging members, photoreceptors, photoconductors, and the like, which comprise structured organic films (SOFs), such as in the imaging surface thereof, for digital printing applications. More specifically, the present disclosure is directed to rigid or drum photoconductors, and to single or multilayered flexible, belt imaging members, or devices comprised of an optional supporting medium like a substrate, a photogenerating layer, a charge transport layer, and a polymer coating layer, an optional adhesive layer, and an optional hole blocking or undercoat layer that comprise SOFs. The imaging members, photoreceptors, and photoconductors illustrated herein (or imaging surfaces thereof), in embodiments, exhibit no or substantially no physical damage after about 24 hours or more, such as greater than about 48 hours, such as about 72 hours or more, such as about 96 hours, or about 144 hours, of continuous exposure to the ink (the term "physical damage" refers for example damage, which optionally may be visually detected, such as cracking, crazing, crystallization, phase separation and extraction; the term "substantially no physical damage" refers to less than 2% of the surface exhibiting physical damage, such as less than 1% of the surface exhibiting physical damage) have excellent wear resistance; extended lifetimes; provide for the elimination or minimization of imaging member scratches on the surface layer or layers of the member (imaging surface(s)), and which scratches can result in undesirable print failures where, for example, the scratches are visible on the final prints generated; permit excellent electrical properties; minimum cycle up after extended electrical cycling; increased resistance to running deletion; solvent resistance; and mechanical robustness. Additionally, in embodiments the imaging or

photoconductive members (and/or imaging surfaces thereof) disclosed herein possess excellent, and in a number of instances low  $V_r$  (residual potential), and the substantial prevention of  $V_r$  cycle up when appropriate; high sensitivity; low acceptable image ghosting characteristics; and desirable toner cleanability.

**[0044]** Incorporating a structured organic film in the imaging member, such as in the charge transport layer, or other external layer of the imaging member, such as the imaging surface, may provide benefits such as decreased ink or toner adhesion and resultant less aggressive cleaning, improved transfer, and increased wear resistance.

**[0045]** In embodiments, the imaging member is an intermediate transfer belt, sheet, roller, or film useful in xerographic, including digital, apparatuses. However, the imaging members herein comprising a SOF may be useful as belts, rollers, drums (a drum/belt hybrid), and the like, for many different processes and components such as photoreceptors, fusing members, transfix members, bias transfer members, bias charging members, developer members, image bearing members, conveyor members, cleaning members, and other members for contact electrostatic printing applications, xerographic applications, including digital, and the like. Further, the imaging members, herein, can be used for both liquid and dry powder xerographic architectures.

**[0046]** The SOF overcoated photoreceptors exhibit increased mechanical robustness that also allows more pressure to be used for applications like electrostatic proximity printing (SLIC), which relies on the photoreceptor being in physical contact with a metal or ceramic gravure roller. The increased pressure is one way to help make the development nip conditions more uniform, and enable more uniform prints. In embodiments, the pressure may be increased at least about 2 times, such as about 4 times, the pressure generally applied using a belt in tension, or thick foam underneath the photoreceptor.

**[0047]** Also included within the scope of the present disclosure methods of imaging and printing with the imaging members illustrated herein.

**[0048]** As used herein, the term "ink-based digital printing" refers to, for example, a wide number of printing techniques, such as gravure, flexography, and

offset printing, which may accommodate a wide variety of inks. For example, such inks may include liquid inks with a viscosity greater than about 100 cp, such as a liquid ink with a viscosity from about 100 cp to about 200,000 cp.

**[0049]** In this specification and the claims that follow, singular forms such as “a,” “an,” and “the” include plural forms unless the content clearly dictates otherwise.

**[0050]** The term "SOF" generally refers to a covalent organic framework (COF) that is a film at a macroscopic level. The phrase “macroscopic level” refers, for example, to the naked eye view of the present SOFs. Although COFs are a network at the “microscopic level” or “molecular level” (requiring use of powerful magnifying equipment or as assessed using scattering methods), the present SOF is fundamentally different at the “macroscopic level” because the film is for instance orders of magnitude larger in coverage than a microscopic level COF network. SOFs described herein have macroscopic morphologies much different than typical COFs previously synthesized.

**[0051]** Additionally, when a capping unit is introduced into the SOF, the SOF framework is locally ‘interrupted’ where the capping units are present. These SOF compositions are ‘covalently doped’ because a foreign molecule is bonded to the SOF framework when capping units are present. Capped SOF compositions may alter the properties of SOFs without changing constituent building blocks. For example, the mechanical and physical properties of the capped SOF where the SOF framework is interrupted may differ from that of an uncapped SOF.

**[0052]** The SOFs of the present disclosure are at the macroscopic level substantially pinhole-free SOFs or pinhole-free SOFs having continuous covalent organic frameworks that can extend over larger length scales such as for instance much greater than a millimeter to lengths such as a meter and, in theory, as much as hundreds of meters. It will also be appreciated that SOFs tend to have large aspect ratios where typically two dimensions of a SOF will be much larger than the third. SOFs have markedly fewer macroscopic edges and disconnected external surfaces than a collection of COF particles.

[0053] In embodiments, a "substantially pinhole-free SOF" or "pinhole-free SOF" may be formed from a reaction mixture deposited on the surface of an underlying substrate. The term "substantially pinhole-free SOF" refers, for example, to an SOF that may or may not be removed from the underlying substrate on which it was formed and contains substantially no pinholes, pores or gaps greater than the distance between the cores of two adjacent segments per square cm; such as, for example, less than 10 pinholes, pores or gaps greater than about 250 nanometers in diameter per  $\text{cm}^2$ , or less than 5 pinholes, pores or gaps greater than about 100 nanometers in diameter per  $\text{cm}^2$ . The term "pinhole-free SOF" refers, for example, to an SOF that may or may not be removed from the underlying substrate on which it was formed and contains no pinholes, pores or gaps greater than the distance between the cores of two adjacent segments per  $\text{micron}^2$ , such as no pinholes, pores or gaps greater than about 500 Angstroms in diameter per  $\text{micron}^2$ , or no pinholes, pores or gaps greater than about 250 Angstroms in diameter per  $\text{micron}^2$ , or no pinholes, pores or gaps greater than about 100 Angstroms in diameter per  $\text{micron}^2$ .

[0054] In embodiments, the SOF comprises at least one atom of an element that is not carbon, such as at least one atom selected from the group consisting of hydrogen, oxygen, nitrogen, silicon, phosphorous, selenium, fluorine, boron, and sulfur. In further embodiments, the SOF is a boroxine-, borazine-, borosilicate-, and boronate ester-free SOF.

[0055] **Molecular Building Block**

[0056] The SOFs of the present disclosure comprise molecular building blocks having a segment (S) and functional groups (Fg). Molecular building blocks require at least two functional groups ( $x \geq 2$ ) and may comprise a single type or two or more types of functional groups. Functional groups are the reactive chemical moieties of molecular building blocks that participate in a chemical reaction to link together segments during the SOF forming process. A segment is the portion of the molecular building block that supports functional groups and comprises all atoms that are not associated with functional groups. Further, the composition of a molecular building block segment remains unchanged after SOF formation.

**[0057] Functional Group**

**[0058]** Functional groups are the reactive chemical moieties of molecular building blocks that participate in a chemical reaction to link together segments during the SOF forming process. Functional groups may be composed of a single atom, or functional groups may be composed of more than one atom. The atomic compositions of functional groups are those compositions normally associated with reactive moieties in chemical compounds. Non-limiting examples of functional groups include halogens, alcohols, ethers, ketones, carboxylic acids, esters, carbonates, amines, amides, imines, ureas, aldehydes, isocyanates, tosylates, alkenes, alkynes and the like.

**[0059]** Molecular building blocks contain a plurality of chemical moieties, but only a subset of these chemical moieties are intended to be functional groups during the SOF forming process. Whether or not a chemical moiety is considered a functional group depends on the reaction conditions selected for the SOF forming process. Functional groups (Fg) denote a chemical moiety that is a reactive moiety, that is, a functional group during the SOF forming process.

**[0060]** In the SOF forming process the composition of a functional group will be altered through the loss of atoms, the gain of atoms, or both the loss and the gain of atoms; or, the functional group may be lost altogether. In the SOF, atoms previously associated with functional groups become associated with linker groups, which are the chemical moieties that join together segments. Functional groups have characteristic chemistries and those of ordinary skill in the art can generally recognize in the present molecular building blocks the atom(s) that constitute functional group(s). It should be noted that an atom or grouping of atoms that are identified as part of the molecular building block functional group may be preserved in the linker group of the SOF. Linker groups are described below.

**[0061] Capping Unit**

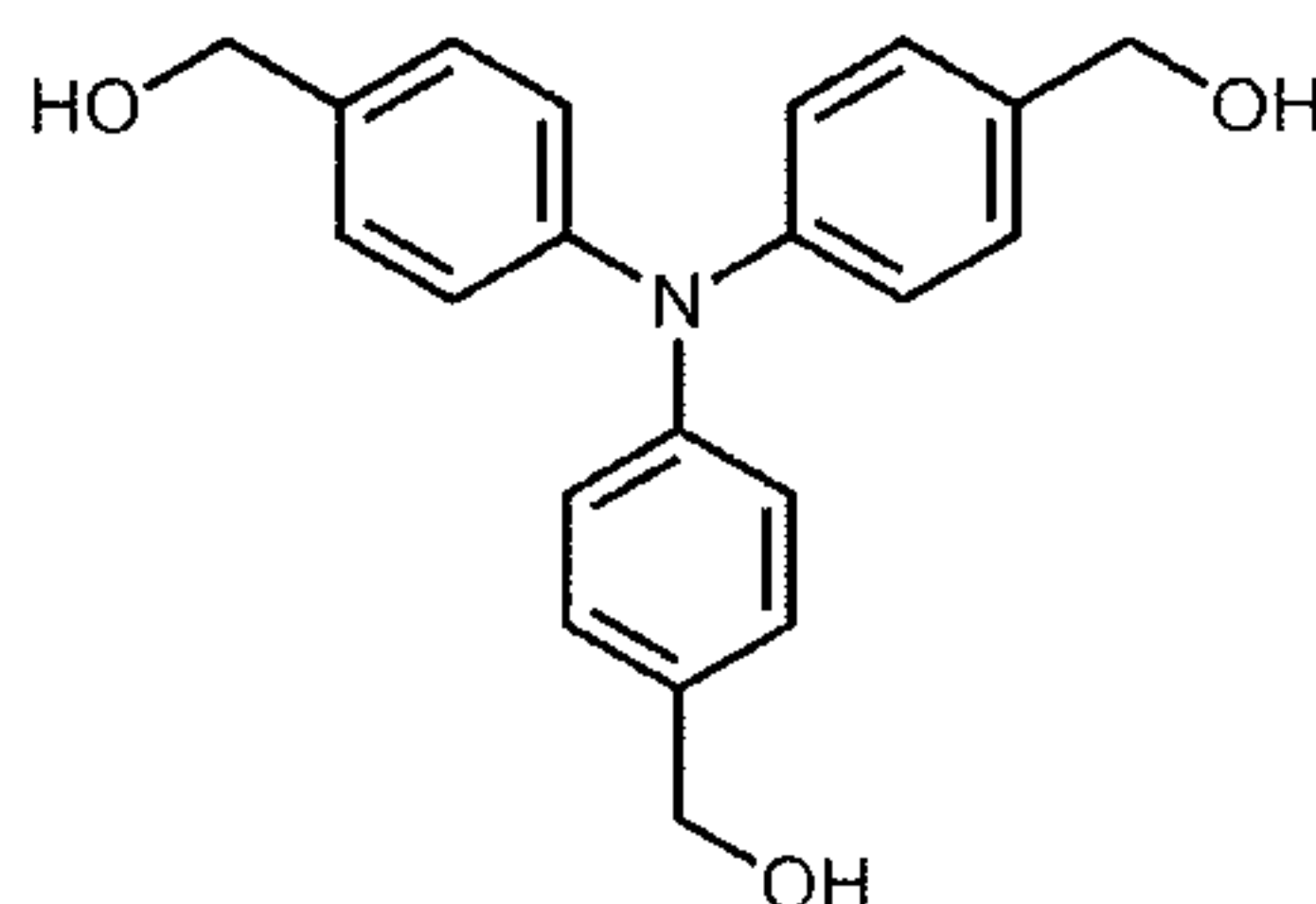
**[0062]** Capping units of the present disclosure are molecules that ‘interrupt’ the regular network of covalently bonded building blocks normally present in an SOF. Capped SOF compositions are tunable materials whose properties can be varied

through the type and amount of capping unit introduced. Capping units may comprise a single type or two or more types of functional groups and/or chemical moieties.

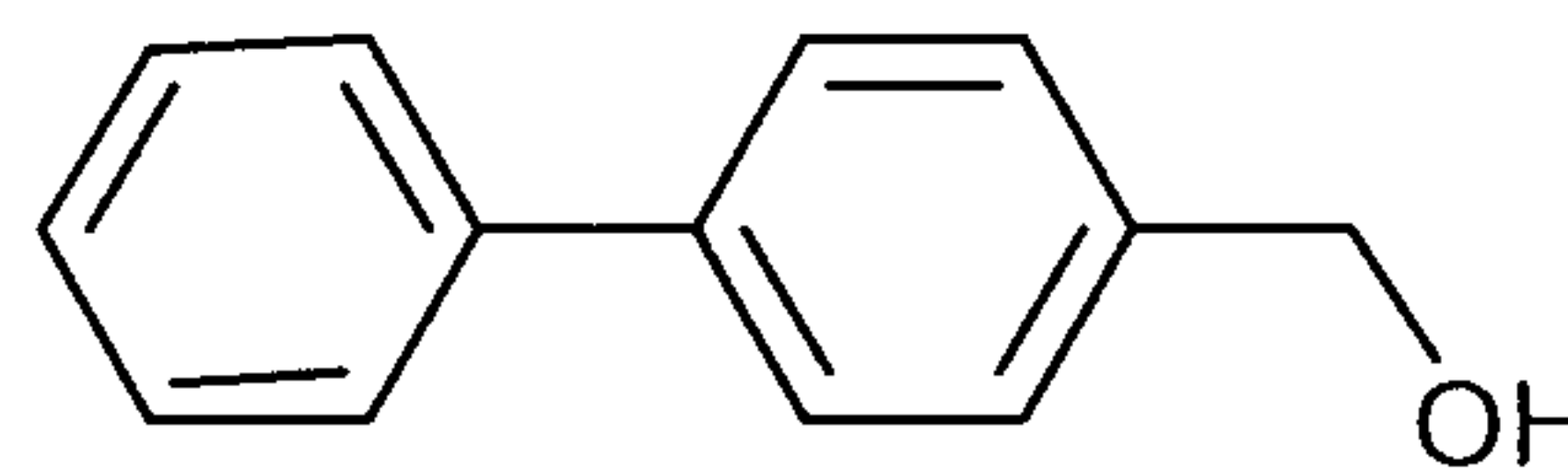
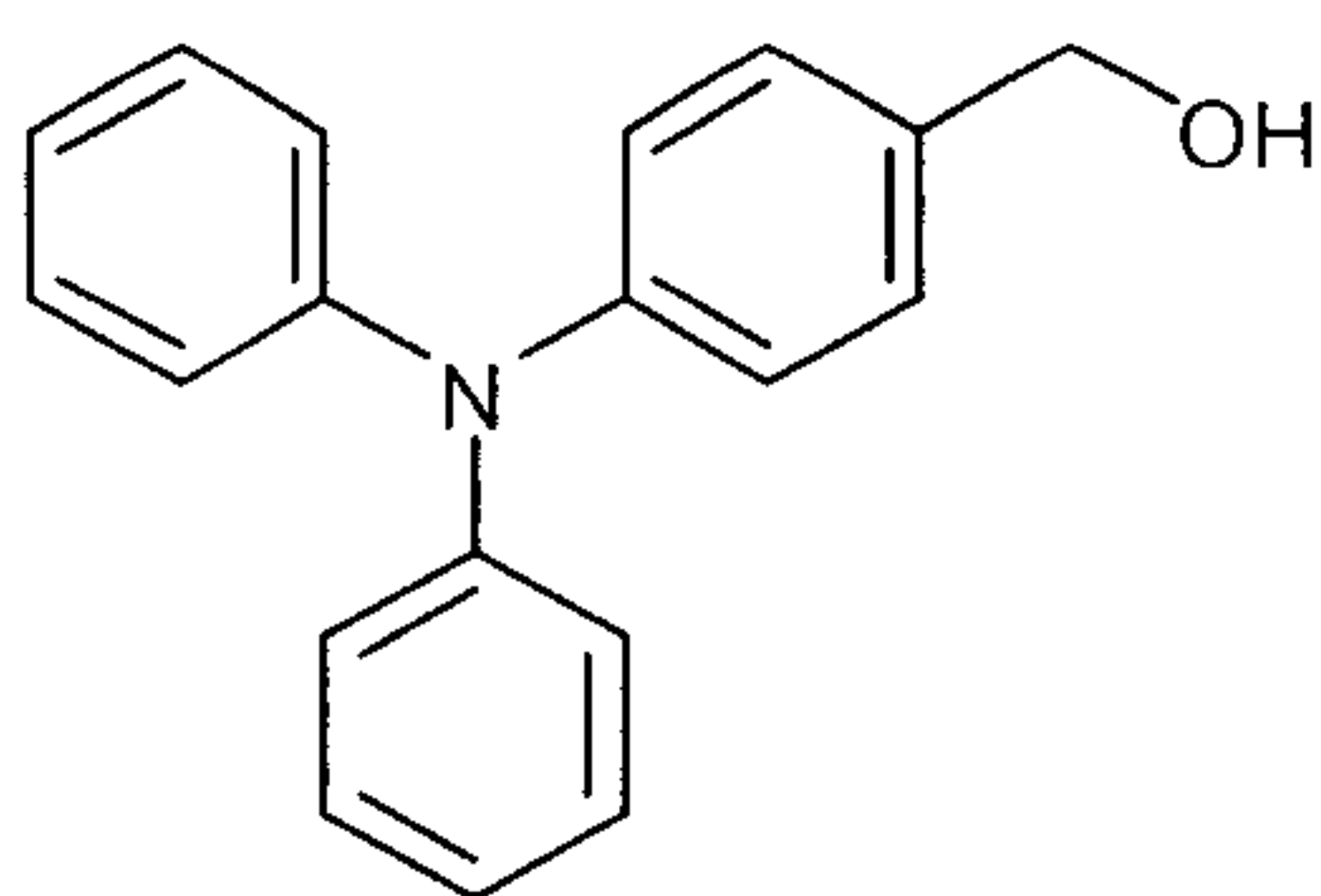
**[0063]** In embodiments, the capping units have a structure that is unrelated to the structure of any of the molecular building blocks that are added into the SOF formulation, which (after film formation) ultimately becomes the SOF.

**[0064]** In embodiments, the capping units have a structure that substantially corresponds to the structure of one of the molecular building blocks (such as the molecular building blocks for SOFs that are detailed in U.S. Patent Application Serial Nos. 12/716,524; 12/716,449; 12/716,706; 12/716,324; 12/716,686; 12/716,571, and 12/815,688) that is added to the SOF formulation, but one or more of the functional groups present on the building block is either missing or has been replaced with a different chemical moiety or functional group that will not participate in a chemical reaction (with the functional group(s) of the building blocks that are initially present) to link together segments during the SOF forming process.

**[0065]** For example, for a molecular building block, such as *tris*-(4-hydroxymethyl)triphenylamine:



among the many possible capping units that may be used, suitable capping units may, for example, include:



and

A capping group having a structure unrelated to the molecular building block may be, for example, an alkyl moiety (for example, a branched or unbranched saturated hydrocarbon group, derived from an alkane and having the general formula  $C_nH_{2n+1}$ , in which  $n$  is a number of 1 or more) in which one of the hydrogen atoms has been replaced by an -OH group. In such a formulation, a reaction between the capping unit and the molecular building block, for example, an acid catalyzed reaction between the alcohol (-OH) groups, would link the capping unit and the molecular building blocks together through the formation of (linking) ether groups.

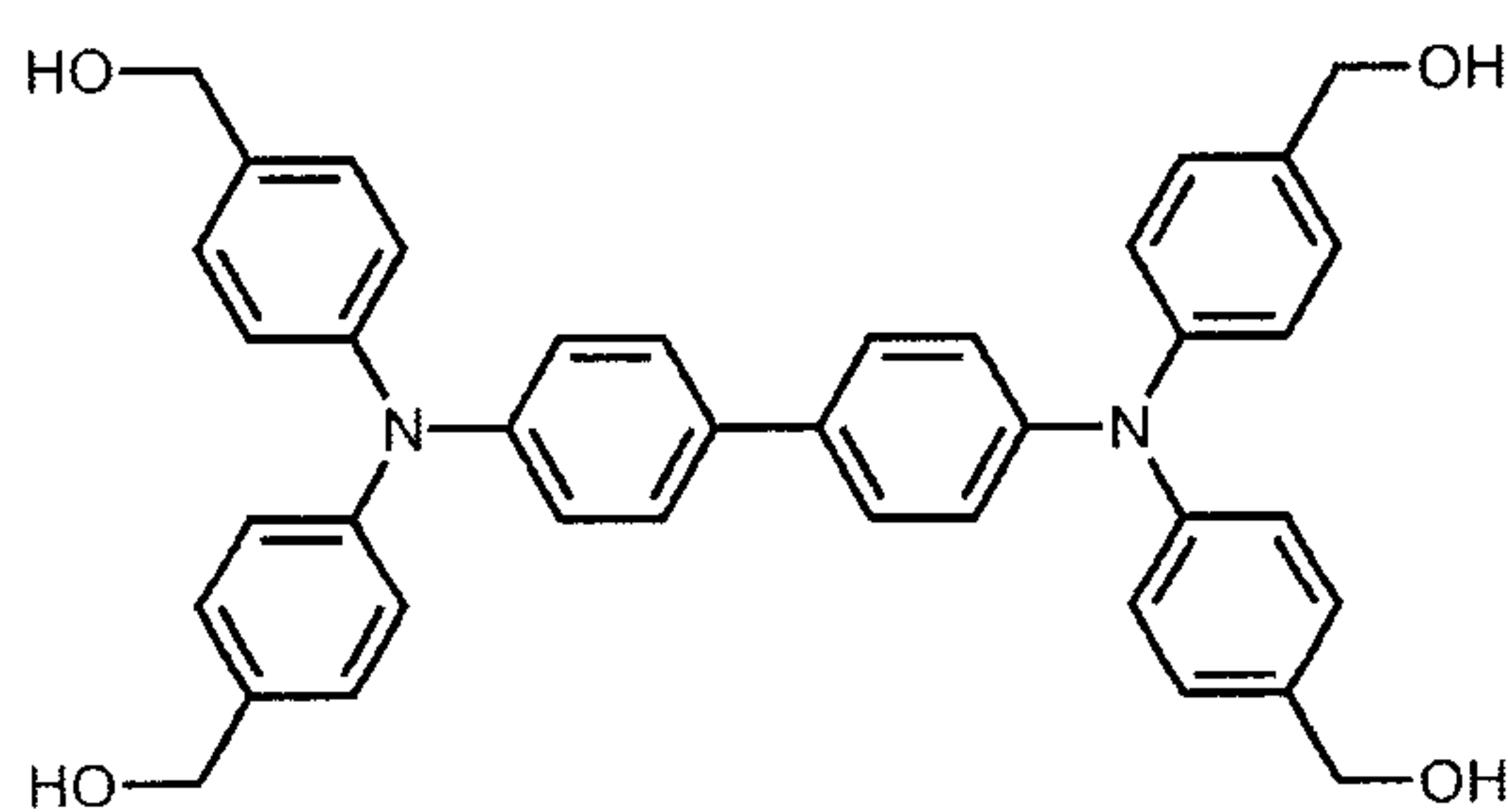
**[0066]** In embodiments, the capping unit molecules may be mono-functionalized. For example, in embodiments, the capping units may comprise only a single suitable or complementary functional group (as described above) that participates in a chemical reaction to link together segments during the SOF forming process and thus cannot bridge any further adjacent molecular building blocks (until a building block with a suitable or complementary functional group is added, such as when an additional SOF is formed on top of a capped SOF base layer and a multilayer SOF is formed).

**[0067]** When such capping units are introduced into the SOF coating formulation, upon curing, interruptions in the SOF framework are introduced. Interruptions in the SOF framework are therefore sites where the single suitable or complementary functional group of the capping units have reacted with the molecular building block and locally terminate (or cap) the extension of the SOF framework and interrupt the regular network of covalently bonded building blocks normally present in an SOF. The type of capping unit (or structure or the capping unit) introduced into the SOF framework may be used to tune the properties of the SOF.

**[0068]** In embodiments, the capping unit molecules may comprise more than one chemical moiety or functional group. For example, the SOF coating formulation, which (after film formation), ultimately becomes bonded in the SOF may comprise a capping unit having at least two or more chemical moieties or functional groups, such as 2, 3, 4, 5, 6 or more chemical moieties or functional groups, where only one of the functional groups is a suitable or complementary functional group (as described above) that participates in a chemical reaction to link together segments during the

SOF forming process. The various other chemical moieties or functional groups present on the molecular building block are chemical moieties or functional groups that are not suitable or complementary to participate in the specific chemical reaction to link together segments initially present during the SOF forming process and thus cannot bridge any further adjacent molecular building blocks. However, after the SOF is formed such chemical moieties and/or functional groups may be available for further reaction (similar to dangling functional groups, as discussed below) with additional components and thus allow for the further refining and tuning of the various properties of the formed SOF, or chemically attaching various other SOF layers in the formation of multilayer SOFs.

**[0069]** In embodiments, the molecular building blocks may have  $x$  functional groups (where  $x$  is three or more) and the capping unit molecules may comprise a capping unit molecule having  $x-1$  functional groups that are suitable or complementary functional group (as described above) and participate in a chemical reaction to link together segments during the SOF forming process. For example,  $x$  would be three for *tris*-(4-hydroxymethyl)triphenylamine (above), and  $x$  would be four for the building block illustrated below, N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine:



**[0070]** A capping unit molecule having  $x-1$  functional groups that are suitable or complementary functional groups (as described above) and participate in a chemical reaction to link together segments during the SOF forming process would have 2 functional groups (for a molecular building block such as *tris*-(4-hydroxymethyl)triphenylamine), and 3 functional groups (for N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine) that are suitable or complementary functional group (as described above) and participate in a chemical

reaction to link together segments during the SOF forming process. The other functional group present may be a chemical moiety or a functional group that is not suitable or complementary to participate in the specific chemical reaction to link together segments during the SOF forming process and thus cannot bridge any further adjacent molecular building blocks. However, after the SOF is formed such functional groups may be available for further reaction with additional components and thus allowing for the further refining and tuning of the various properties of the formed SOF.

**[0071]** In embodiments, the capping unit may comprise a mixture of capping units, such as any combination of a first capping unit, a second capping unit, a third capping unit, a fourth capping unit, etc., where the structure of the capping unit varies. In embodiments, the structure of a capping unit or a combination of multiple capping units may be selected to either enhance or attenuate the chemical and physical properties of SOF; or the identity of the chemical moieties or functional group(s) on that are not suitable or complementary to participate in the chemical reaction to link together segments during the SOF forming process may be varied to form a mixture of capping units. Thus, the type of capping unit introduced into the SOF framework may be selected to introduce or tune a desired property of SOF.

**[0072]** In embodiments, a SOF contains segments, which are not located at the edges of the SOF, that are connected by linkers to at least three other segments and/or capping groups. For example, in embodiments the SOF comprises at least one symmetrical building block selected from the group consisting of ideal triangular building blocks, distorted triangular building blocks, ideal tetrahedral building blocks, distorted tetrahedral building blocks, ideal square building blocks, and distorted square building blocks. In embodiments, Type 2 and 3 SOF contains at least one segment type, which are not located at the edges of the SOF, that are connected by linkers to at least three other segments and/or capping groups. For example, in embodiments the SOF comprises at least one symmetrical building block selected from the group consisting of ideal triangular building blocks, distorted triangular building blocks, ideal tetrahedral building blocks, distorted tetrahedral building blocks, ideal square building blocks, and distorted square building blocks.

**[0073]** In embodiments, the SOF comprises a plurality of segments, where all segments have an identical structure, and a plurality of linkers, which may or may not have an identical structure, wherein the segments that are not at the edges of the SOF are connected by linkers to at least three other segments and/or capping groups. In embodiments, the SOF comprises a plurality of segments where the plurality of segments comprises at least a first and a second segment that are different in structure, and the first segment is connected by linkers to at least three other segments and/or capping groups when it is not at the edge of the SOF.

**[0074]** In embodiments, the SOF comprises a plurality of linkers including at least a first and a second linker that are different in structure, and the plurality of segments either comprises at least a first and a second segment that are different in structure, where the first segment, when not at the edge of the SOF, is connected to at least three other segments and/or capping groups, wherein at least one of the connections is via the first linker, and at least one of the connections is via the second linker; or comprises segments that all have an identical structure, and the segments that are not at the edges of the SOF are connected by linkers to at least three other segments and/or capping groups, wherein at least one of the connections is via the first linker, and at least one of the connections is via the second linker.

**[0075] Segment**

**[0076]** A segment is the portion of the molecular building block that supports functional groups and comprises all atoms that are not associated with functional groups. Further, the composition of a molecular building block segment remains unchanged after SOF formation. In embodiments, the SOF may contain a first segment having a structure the same as or different from a second segment. In other embodiments, the structures of the first and/or second segments may be the same as or different from a third segment, fourth segment, fifth segment, etc. A segment is also the portion of the molecular building block that can provide an inclined property. Inclined properties are described later in the embodiments.

**[0077]** In specific embodiments, the segment of the SOF comprises at least one atom of an element that is not carbon, such as at least one atom selected from the

group consisting of hydrogen, oxygen, nitrogen, silicon, phosphorous, selenium, fluorine, boron, and sulfur.

**[0078]** A description of various exemplary molecular building blocks, linkers, SOF types, strategies to synthesize a specific SOF type with exemplary chemical structures, building blocks whose symmetrical elements are outlined, and classes of exemplary molecular entities and examples of members of each class that may serve as molecular building blocks for SOFs are detailed in U.S. Patent Application Serial Nos. 12/716,524; 12/716,449; 12/716,706; 12/716,324; 12/716,686; and 12/716,571, entitled "Structured Organic Films," "Structured Organic Films Having an Added Functionality," "Mixed Solvent Process for Preparing Structured Organic Films," "Composite Structured Organic Films," "Process For Preparing Structured Organic Films (SOFs) Via a Pre-SOF," "Electronic Devices Comprising Structured Organic Films".

**[0079] Linker**

**[0080]** A linker is a chemical moiety that emerges in a SOF upon chemical reaction between functional groups present on the molecular building blocks and/or capping unit.

**[0081]** A linker may comprise a covalent bond, a single atom, or a group of covalently bonded atoms. The former is defined as a covalent bond linker and may be, for example, a single covalent bond or a double covalent bond and emerges when functional groups on all partnered building blocks are lost entirely. The latter linker type is defined as a chemical moiety linker and may comprise one or more atoms bonded together by single covalent bonds, double covalent bonds, or combinations of the two. Atoms contained in linking groups originate from atoms present in functional groups on molecular building blocks prior to the SOF forming process. Chemical moiety linkers may be well-known chemical groups such as, for example, esters, ketones, amides, imines, ethers, urethanes, carbonates, and the like, or derivatives thereof.

**[0082]** For example, when two hydroxyl (-OH) functional groups are used to connect segments in a SOF via an oxygen atom, the linker would be the oxygen atom, which may also be described as an ether linker. In embodiments, the SOF may contain a first linker having a structure the same as or different from a second linker. In other embodiments, the structures of the first and/or second linkers may be the same as or different from a third linker, etc.

**[0083]** A capping unit may be bonded in the SOF in any desired amount as long as the general SOF framework is sufficiently maintained. For example, in embodiments, a capping unit may be bonded to at least 0.1% of all linkers, but not more than about 40% of all linkers present in an SOF, such as from about 0.5% to about 30%, or from about 2% to about 20%. In embodiments, substantially all segments may be bound to at least one capping unit, where the term "substantially all" refers, for example, to more than about 95%, such as more than about 99% of the segments of the SOF. In the event capping units bond to more than 50% of the available functional groups on the molecular building blocks (from which the linkers emerge), oligomers, linear polymers, and molecular building blocks that are fully capped with capping units may predominately form instead of a SOF.

**[0084]** In specific embodiments, the linker comprises at least one atom of an element that is not carbon, such as at least one atom selected from the group consisting of hydrogen, oxygen, nitrogen, silicon, phosphorous, selenium, fluorine, boron, and sulfur.

**[0085] Metrical Parameters of SOFs**

**[0086]** SOFs have any suitable aspect ratio. In embodiments, SOFs have aspect ratios for instance greater than about 30:1 or greater than about 50:1, or greater than about 70:1, or greater than about 100:1, such as about 1000:1. The aspect ratio of a SOF is defined as the ratio of its average width or diameter (that is, the dimension next largest to its thickness) to its average thickness (that is, its shortest dimension). The term 'aspect ratio,' as used here, is not bound by theory. The longest dimension of a SOF is its length and it is not considered in the calculation of SOF aspect ratio.

[0087] Generally, SOFs have widths and lengths, or diameters greater than about 500 micrometers, such as about 10 mm, or 30 mm. The SOFs have the following illustrative thicknesses: about 10 Angstroms to about 250 Angstroms, such as about 20 Angstroms to about 200 Angstroms, for a mono-segment thick layer and about 20 nm to about 5 mm, about 50 nm to about 10 mm for a multi-segment thick layer.

[0088] SOF dimensions may be measured using a variety of tools and methods. For a dimension about 1 micrometer or less, scanning electron microscopy is the preferred method. For a dimension about 1 micrometer or greater, a micrometer (or ruler) is the preferred method.

[0089] **Multilayer SOFs**

[0090] A SOF may comprise a single layer or a plurality of layers (that is, two, three or more layers). SOFs that are comprised of a plurality of layers may be physically joined (e.g., dipole and hydrogen bond) or chemically joined. Physically attached layers are characterized by weaker interlayer interactions or adhesion; therefore physically attached layers may be susceptible to delamination from each other. Chemically attached layers are expected to have chemical bonds (e.g., covalent or ionic bonds) or have numerous physical or intermolecular (supramolecular) entanglements that strongly link adjacent layers.

[0091] Therefore, delamination of chemically attached layers is much more difficult. Chemical attachments between layers may be detected using spectroscopic methods such as focusing infrared or Raman spectroscopy, or with other methods having spatial resolution that can detect chemical species precisely at interfaces. In cases where chemical attachments between layers are different chemical species than those within the layers themselves it is possible to detect these attachments with sensitive bulk analyses such as solid-state nuclear magnetic resonance spectroscopy or by using other bulk analytical methods.

[0092] In the embodiments, the SOF may be a single layer (mono-segment thick or multi-segment thick) or multiple layers (each layer being mono-segment thick or multi-segment thick). "Thickness" refers, for example, to the smallest dimension

of the film. As discussed above, in a SOF, segments are molecular units that are covalently bonded through linkers to generate the molecular framework of the film. The thickness of the film may also be defined in terms of the number of segments that is counted along that axis of the film when viewing the cross-section of the film. A "monolayer" SOF is the simplest case and refers, for example, to where a film is one segment thick. A SOF where two or more segments exist along this axis is referred to as a "multi-segment" thick SOF.

**[0093]** An exemplary method for preparing physically attached multilayer SOFs includes: (1) forming a base SOF layer that may be cured by a first curing cycle, and (2) forming upon the base layer a second reactive wet layer followed by a second curing cycle and, if desired, repeating the second step to form a third layer, a forth layer and so on. The physically stacked multilayer SOFs may have thicknesses greater than about 20 Angstroms such as, for example, the following illustrative thicknesses: about 20 Angstroms to about 10 cm, such as about 1 nm to about 10 mm, or about 0.1 mm Angstroms to about 5 mm. In principle there is no limit with this process to the number of layers that may be physically stacked.

**[0094]** In embodiments, a multilayer SOF is formed by a method for preparing chemically attached multilayer SOFs by: (1) forming a base SOF layer having functional groups present on the surface (or dangling functional groups) from a first reactive wet layer, and (2) forming upon the base layer a second SOF layer from a second reactive wet layer that comprises molecular building blocks with functional groups capable of reacting with the dangling functional groups on the surface of the base SOF layer. In further embodiments, a capped SOF may serve as the base layer in which the functional groups present that were not suitable or complementary to participate in the specific chemical reaction to link together segments during the base layer SOF forming process may be available for reacting with the molecular building blocks of the second layer to form an chemically bonded multilayer SOF. If desired, the formulation used to form the second SOF layer should comprise molecular building blocks with functional groups capable of reacting with the functional groups from the base layer as well as additional functional groups that will allow for a third layer to be chemically attached to the second layer. The chemically stacked

multilayer SOFs may have thicknesses greater than about 20 Angstroms such as, for example, the following illustrative thicknesses: about 20 Angstroms to about 10 cm, such as about 1 nm to about 10 mm, or about 0.1 mm Angstroms to about 5 mm. In principle there is no limit with this process to the number of layers that may be chemically stacked.

**[0095]** In embodiments, the method for preparing chemically attached multilayer SOFs comprises promoting chemical attachment of a second SOF onto an existing SOF (base layer) by using a small excess of one molecular building block (when more than one molecular building block is present) during the process used to form the SOF (base layer) whereby the functional groups present on this molecular building block will be present on the base layer surface. The surface of base layer may be treated with an agent to enhance the reactivity of the functional groups or to create an increased number of functional groups.

**[0096]** In an embodiment the dangling functional groups or chemical moieties present on the surface of an SOF or capped SOF may be altered to increase the propensity for covalent attachment (or, alternatively, to disfavor covalent attachment) of particular classes of molecules or individual molecules, such as SOFs, to a base layer or any additional substrate or SOF layer. For example, the surface of a base layer, such as an SOF layer, which may contain reactive dangling functional groups, may be rendered pacified through surface treatment with a capping chemical group. For example, a SOF layer having dangling hydroxyl alcohol groups may be pacified by treatment with trimethylsilylchloride thereby capping hydroxyl groups as stable trimethylsilylethers. Alternatively, the surface of base layer may be treated with a non-chemically bonding agent, such as a wax, to block reaction with dangling functional groups from subsequent layers.

**[0097] Molecular Building Block Symmetry**

**[0098]** Molecular building block symmetry relates to the positioning of functional groups (Fgs) around the periphery of the molecular building block segments. Without being bound by chemical or mathematical theory, a symmetric molecular building block is one where positioning of Fgs may be associated with the

ends of a rod, vertexes of a regular geometric shape, or the vertexes of a distorted rod or distorted geometric shape. For example, the most symmetric option for molecular building blocks containing four Fgs are those whose Fgs overlay with the corners of a square or the apexes of a tetrahedron.

**[0099]** Use of symmetrical building blocks is practiced in embodiments of the present disclosure for two reasons: (1) the patterning of molecular building blocks may be better anticipated because the linking of regular shapes is a better understood process in reticular chemistry, and (2) the complete reaction between molecular building blocks is facilitated because for less symmetric building blocks errant conformations/orientations may be adopted which can possibly initiate numerous linking defects within SOFs.

**[00100]** In embodiments, a Type 1 SOF contains segments, which are not located at the edges of the SOF, that are connected by linkers to at least three other segments. For example, in embodiments the SOF comprises at least one symmetrical building block selected from the group consisting of ideal triangular building blocks, distorted triangular building blocks, ideal tetrahedral building blocks, distorted tetrahedral building blocks, ideal square building blocks, and distorted square building blocks. In embodiments, Type 2 and 3 SOF contains at least one segment type, which are not located at the edges of the SOF, that are connected by linkers to at least three other segments. For example, in embodiments the SOF comprises at least one symmetrical building block selected from the group consisting of ideal triangular building blocks, distorted triangular building blocks, ideal tetrahedral building blocks, distorted tetrahedral building blocks, ideal square building blocks, and distorted square building blocks.

**[00101] Practice of Linking Chemistry**

**[00102]** In embodiments linking chemistry may occur wherein the reaction between functional groups produces a volatile byproduct that may be largely evaporated or expunged from the SOF during or after the film forming process or wherein no byproduct is formed. Linking chemistry may be selected to achieve a SOF for applications where the presence of linking chemistry byproducts is not

desired. Linking chemistry reactions may include, for example, condensation, addition/elimination, and addition reactions, such as, for example, those that produce esters, imines, ethers, carbonates, urethanes, amides, acetals, and silyl ethers.

**[00103]** In embodiments the linking chemistry via a reaction between function groups producing a non-volatile byproduct that largely remains incorporated within the SOF after the film forming process. Linking chemistry in embodiments may be selected to achieve a SOF for applications where the presence of linking chemistry byproducts does not impact the properties or for applications where the presence of linking chemistry byproducts may alter the properties of a SOF (such as, for example, the electroactive, hydrophobic or hydrophilic nature of the SOF). Linking chemistry reactions may include, for example, substitution, metathesis, and metal catalyzed coupling reactions, such as those that produce carbon-carbon bonds.

**[00104]** For all linking chemistry the ability to control the rate and extent of reaction between building blocks via the chemistry between building block functional groups is an important aspect of the present disclosure. Reasons for controlling the rate and extent of reaction may include adapting the film forming process for different coating methods and tuning the microscopic arrangement of building blocks to achieve a periodic SOF, as defined in earlier embodiments.

**[00105] Innate Properties of COFs**

**[00106]** COFs have innate properties such as high thermal stability (typically higher than 400 °C under atmospheric conditions); poor solubility in organic solvents (chemical stability), and porosity (capable of reversible guest uptake). In embodiments, SOFs may also possess these innate properties.

**[00107] Added Functionality of SOFs**

**[00108]** Added functionality denotes a property that is not inherent to conventional COFs and may occur by the selection of molecular building blocks wherein the molecular compositions provide the added functionality in the resultant SOF. Added functionality may arise upon assembly of molecular building blocks having an “inclined property” for that added functionality. Added functionality may also arise upon assembly of molecular building blocks having no “inclined property”

for that added functionality but the resulting SOF has the added functionality as a consequence of linking segments (S) and linkers into a SOF. Furthermore, emergence of added functionality may arise from the combined effect of using molecular building blocks bearing an “inclined property” for that added functionality whose inclined property is modified or enhanced upon linking together the segments and linkers into a SOF.

**[00109] An Inclined Property of a Molecular Building Block**

**[00110]** The term “inclined property” of a molecular building block refers, for example, to a property known to exist for certain molecular compositions or a property that is reasonably identifiable by a person skilled in art upon inspection of the molecular composition of a segment. As used herein, the terms “inclined property” and “added functionality” refer to the same general property (e.g., hydrophobic, electroactive, etc.) but “inclined property” is used in the context of the molecular building block and “added functionality” is used in the context of the SOF.

**[00111]** The hydrophobic (superhydrophobic), hydrophilic, lipophobic (superlipophobic), lipophilic, photochromic and/or electroactive (conductor, semiconductor, charge transport material) nature of an SOF are some examples of the properties that may represent an “added functionality” of an SOF. These and other added functionalities may arise from the inclined properties of the molecular building blocks or may arise from building blocks that do not have the respective added functionality that is observed in the SOF.

**[00112]** The term hydrophobic (superhydrophobic) refers, for example, to the property of repelling water, or other polar species such as methanol, it also means an inability to absorb water and/or to swell as a result. Furthermore, hydrophobic implies an inability to form strong hydrogen bonds to water or other hydrogen bonding species. Hydrophobic materials are typically characterized by having water contact angles greater than 90° and superhydrophobic materials have water contact angles greater than 150° as measured using a contact angle goniometer or related device.

**[00113]** The term hydrophilic refers, for example, to the property of attracting, adsorbing, or absorbing water or other polar species, or a surface that is easily wetted by such species. Hydrophilic materials are typically characterized by having less than 20° water contact angle as measured using a contact angle goniometer or related device. Hydrophilicity may also be characterized by swelling of a material by water or other polar species, or a material that can diffuse or transport water, or other polar species, through itself. Hydrophilicity, is further characterized by being able to form strong or numerous hydrogen bonds to water or other hydrogen bonding species.

**[00114]** The term lipophobic (oleophobic) refers, for example, to the property of repelling oil or other non-polar species such as alkanes, fats, and waxes. Lipophobic materials are typically characterized by having oil contact angles greater than 90° as measured using a contact angle goniometer or related device.

**[00115]** The term lipophilic (oleophilic) refers, for example, to the property attracting oil or other non-polar species such as alkanes, fats, and waxes or a surface that is easily wetted by such species. Lipophilic materials are typically characterized by having a low to nil oil contact angle as measured using, for example, a contact angle goniometer. Lipophilicity can also be characterized by swelling of a material by hexane or other non-polar liquids.

**[00116]** The term photochromic refers, for example, to the ability to demonstrate reversible color changes when exposed to electromagnetic radiation. SOF compositions containing photochromic molecules may be prepared and demonstrate reversible color changes when exposed to electromagnetic radiation. These SOFs may have the added functionality of photochromism. The robustness of photochromic SOFs may enable their use in many applications, such as photochromic SOFs for erasable paper, and light responsive films for window tinting/shading and eye wear. SOF compositions may contain any suitable photochromic molecule, such as a difunctional photochromic molecules as SOF molecular building blocks (chemically bound into SOF structure), a monofunctional photochromic molecules as SOF capping units (chemically bound into SOF structure, or unfunctionalized photochromic molecules in an SOF composite (not chemically bound into SOF

structure). Photochromic SOFs may change color upon exposure to selected wavelengths of light and the color change may be reversible.

**[00117]** SOF compositions containing photochromic molecules that chemically bond to the SOF structure are exceptionally chemically and mechanically robust photochromic materials. Such photochromic SOF materials demonstrate many superior properties, such as high number of reversible color change processes, to available polymeric alternatives.

**[00118]** The term electroactive refers, for example, to the property to transport electrical charge (electrons and/or holes). Electroactive materials include conductors, semiconductors, and charge transport materials. Conductors are defined as materials that readily transport electrical charge in the presence of a potential difference. Semiconductors are defined as materials do not inherently conduct charge but may become conductive in the presence of a potential difference and an applied stimuli, such as, for example, an electric field, electromagnetic radiation, heat, and the like. Charge transport materials are defined as materials that can transport charge when charge is injected from another material such as, for example, a dye, pigment, or metal in the presence of a potential difference.

**[00119]** Conductors may be further defined as materials that give a signal using a potentiometer from about 0.1 to about  $10^7$  S/cm.

**[00120]** Semiconductors may be further defined as materials that give a signal using a potentiometer from about  $10^{-6}$  to about  $10^4$  S/cm in the presence of applied stimuli such as, for example an electric field, electromagnetic radiation, heat, and the like. Alternatively, semiconductors may be defined as materials having electron and/or hole mobility measured using time-of-flight techniques in the range of  $10^{-10}$  to about  $10^6 \text{ cm}^2 \text{V}^{-1} \text{s}^{-1}$  when exposed to applied stimuli such as, for example an electric field, electromagnetic radiation, heat, and the like.

**[00121]** Charge transport materials may be further defined as materials that have electron and/or hole mobility measured using time-of-flight techniques in the range of  $10^{-10}$  to about  $10^6 \text{ cm}^2 \text{V}^{-1} \text{s}^{-1}$ . It should be noted that under some circumstances charge transport materials may be also classified as semiconductors.

**[00122]** SOFs with hydrophobic added functionality may be prepared by using molecular building blocks with inclined hydrophobic properties and/or have a rough, textured, or porous surface on the sub-micron to micron scale. A paper describing materials having a rough, textured, or porous surface on the sub-micron to micron scale being hydrophobic was authored by Cassie and Baxter (Cassie, A. B. D.; Baxter, S. *Trans. Faraday Soc.*, **1944**, *40*, 546).

**[00123]** Molecular building blocks comprising or bearing highly-fluorinated segments have inclined hydrophobic properties and may lead to SOFs with hydrophobic added functionality. Highly-fluorinated segments are defined as the number of fluorine atoms present on the segment(s) divided by the number of hydrogen atoms present on the segment(s) being greater than one. Fluorinated segments, which are not highly-fluorinated segments may also lead to SOFs with hydrophobic added functionality.

**[00124]** The above-mentioned fluorinated segments may include, for example, tetrafluorohydroquinone, perfluoroadipic acid hydrate, 4,4'-(hexafluoroisopropylidene)diphthalic anhydride, 4,4'-(hexafluoroisopropylidene)diphenol, and the like.

**[00125]** SOFs having a rough, textured, or porous surface on the sub-micron to micron scale may also be hydrophobic. The rough, textured, or porous SOF surface can result from dangling functional groups present on the film surface or from the structure of the SOF. The type of pattern and degree of patterning depends on the geometry of the molecular building blocks and the linking chemistry efficiency. The feature size that leads to surface roughness or texture is from about 100 nm to about 10  $\mu\text{m}$ , such as from about 500 nm to about 5  $\mu\text{m}$ .

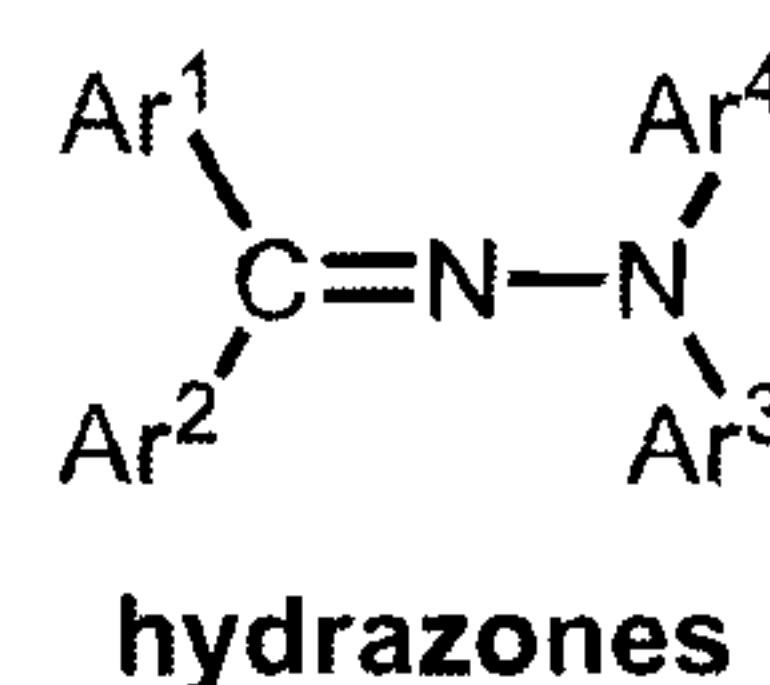
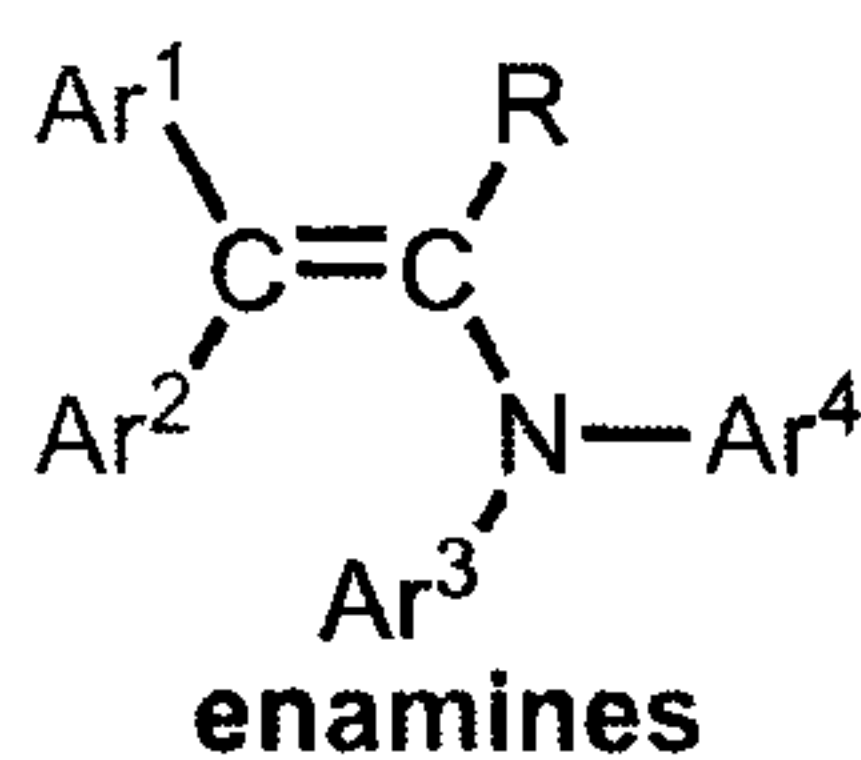
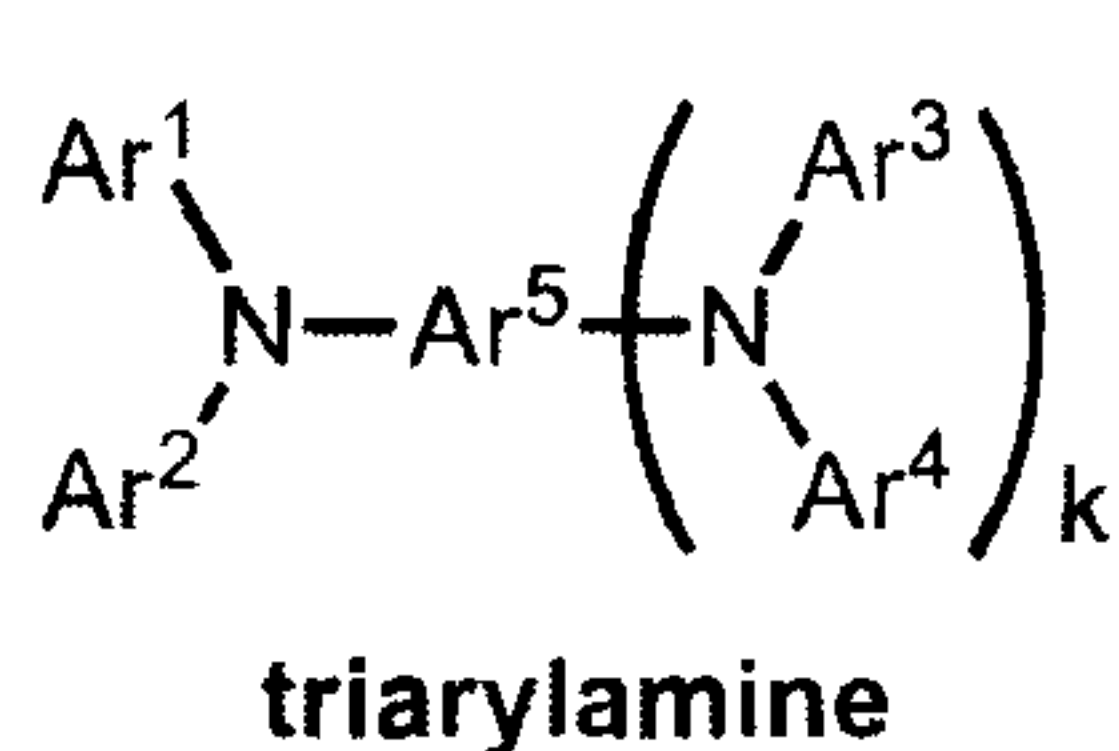
**[00126]** SOFs with hydrophilic added functionality may be prepared by using molecular building blocks with inclined hydrophilic properties and/or comprising polar linking groups.

**[00127]** Molecular building blocks comprising segments bearing polar substituents have inclined hydrophilic properties and may lead to SOFs with hydrophilic added functionality. The term polar substituents refers, for example, to

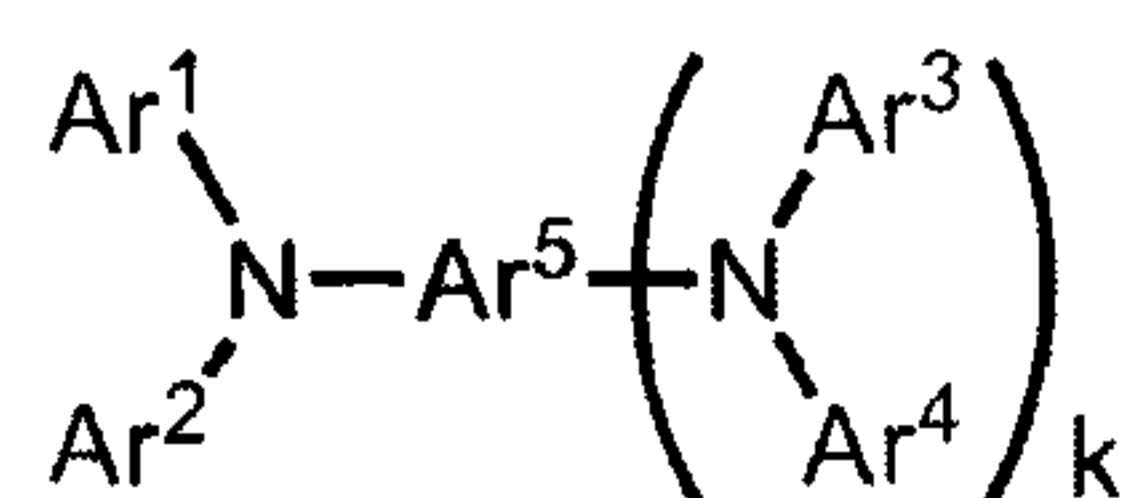
substituents that can form hydrogen bonds with water and include, for example, hydroxyl, amino, ammonium, and carbonyl (such as ketone, carboxylic acid, ester, amide, carbonate, urea).

**[00128]** SOFs with electroactive added functionality may be prepared by using molecular building blocks with inclined electroactive properties and/or be electroactive resulting from the assembly of conjugated segments and linkers. The following sections describe molecular building blocks with inclined hole transport properties, inclined electron transport properties, and inclined semiconductor properties.

**[00129]** SOFs with hole transport added functionality may be obtained by selecting segment cores such as, for example, triarylamine, hydrazones (U.S. Patent No. 7,202,002 B2 to Tokarski et al.), and enamines (U.S. Patent No. 7,416,824 B2 to Kondoh et al.) with the following general structures:



The segment core comprising a triarylamine being represented by the following general formula:

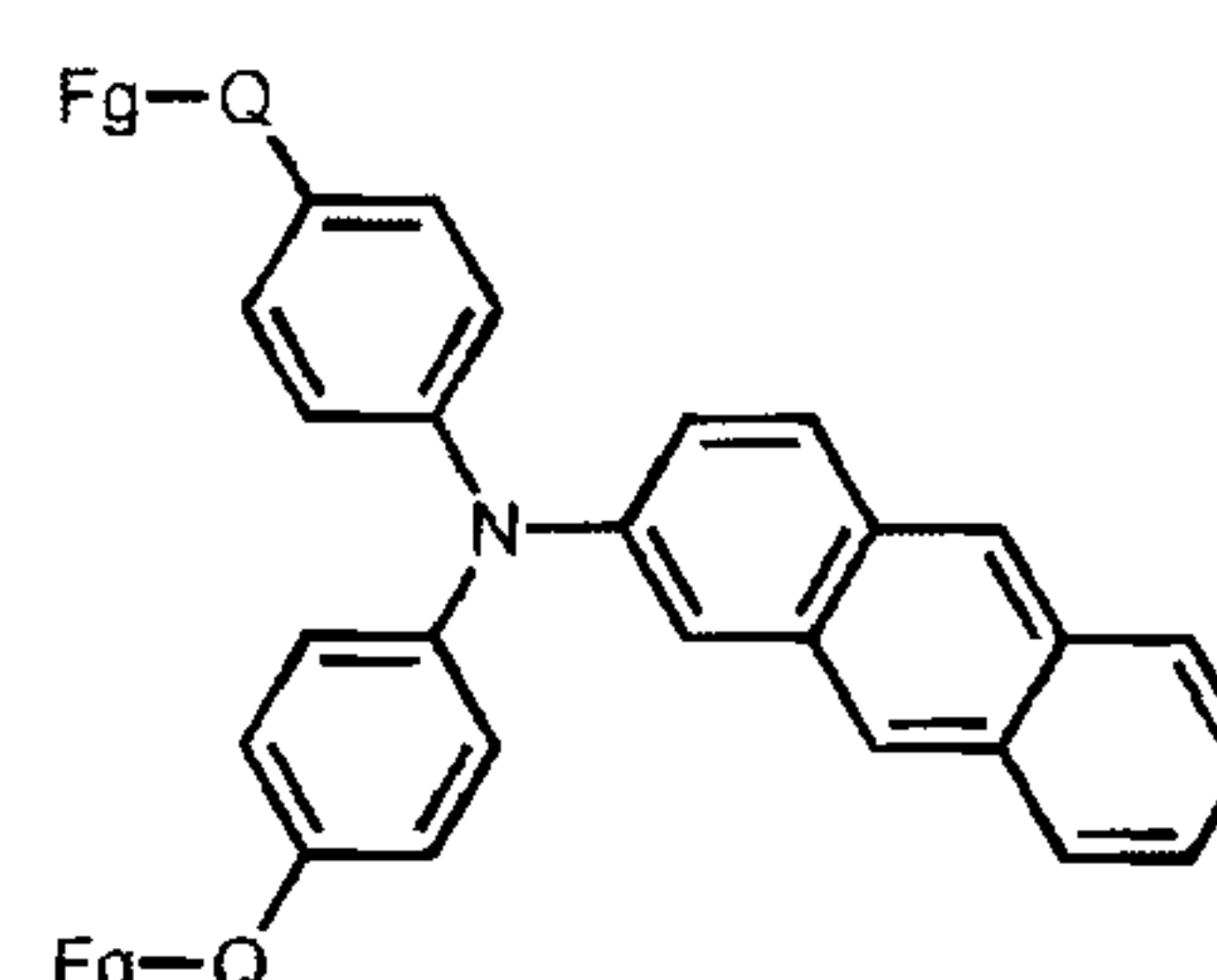
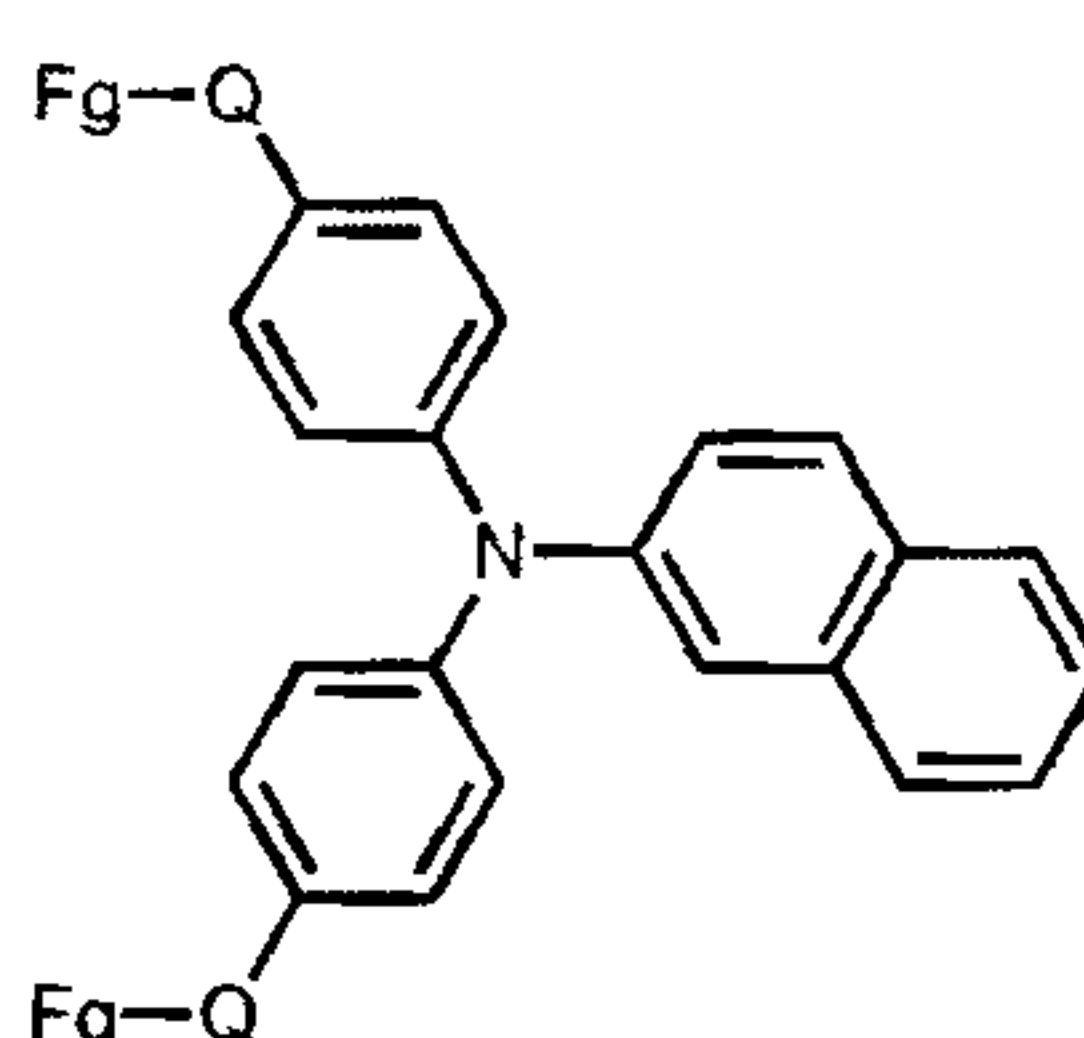
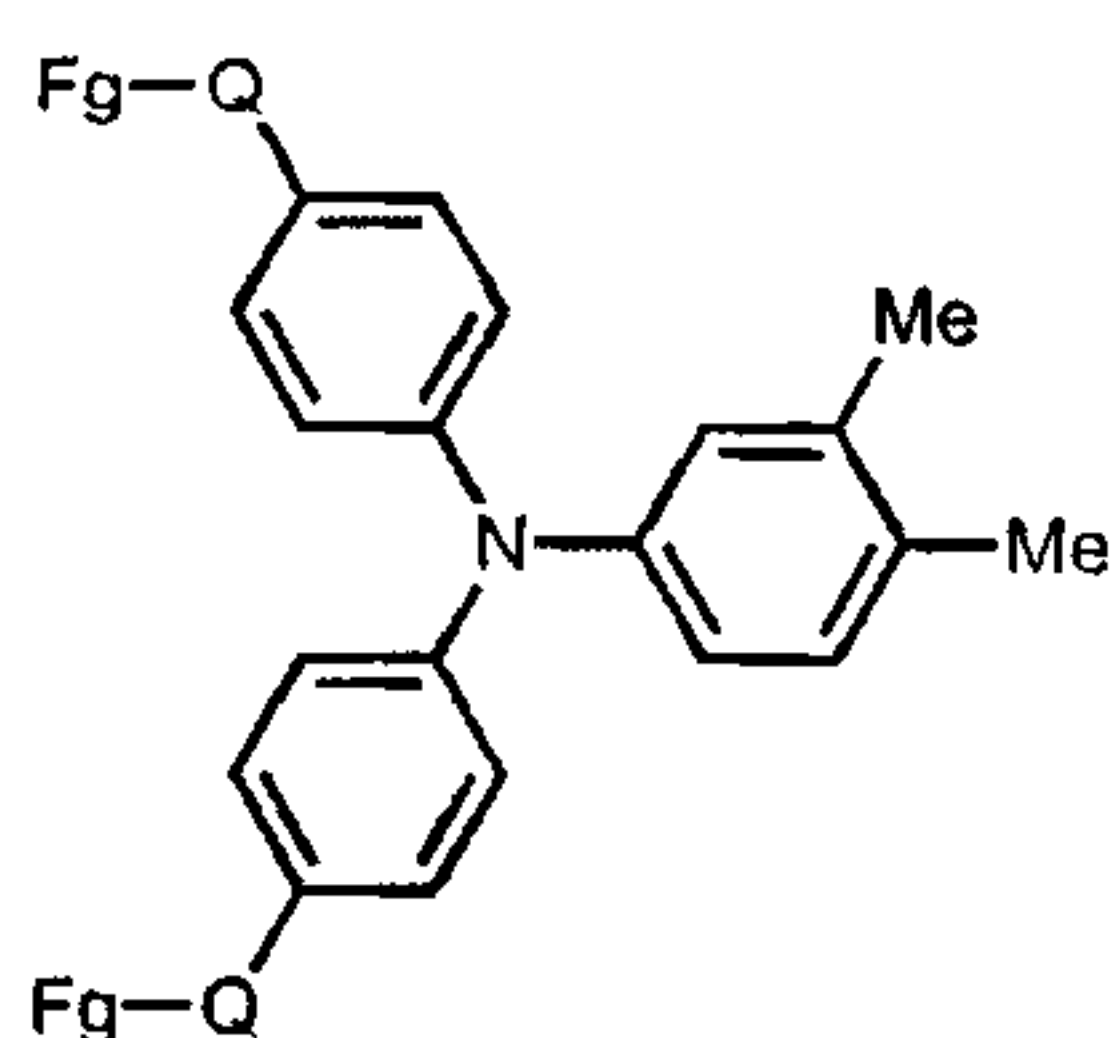
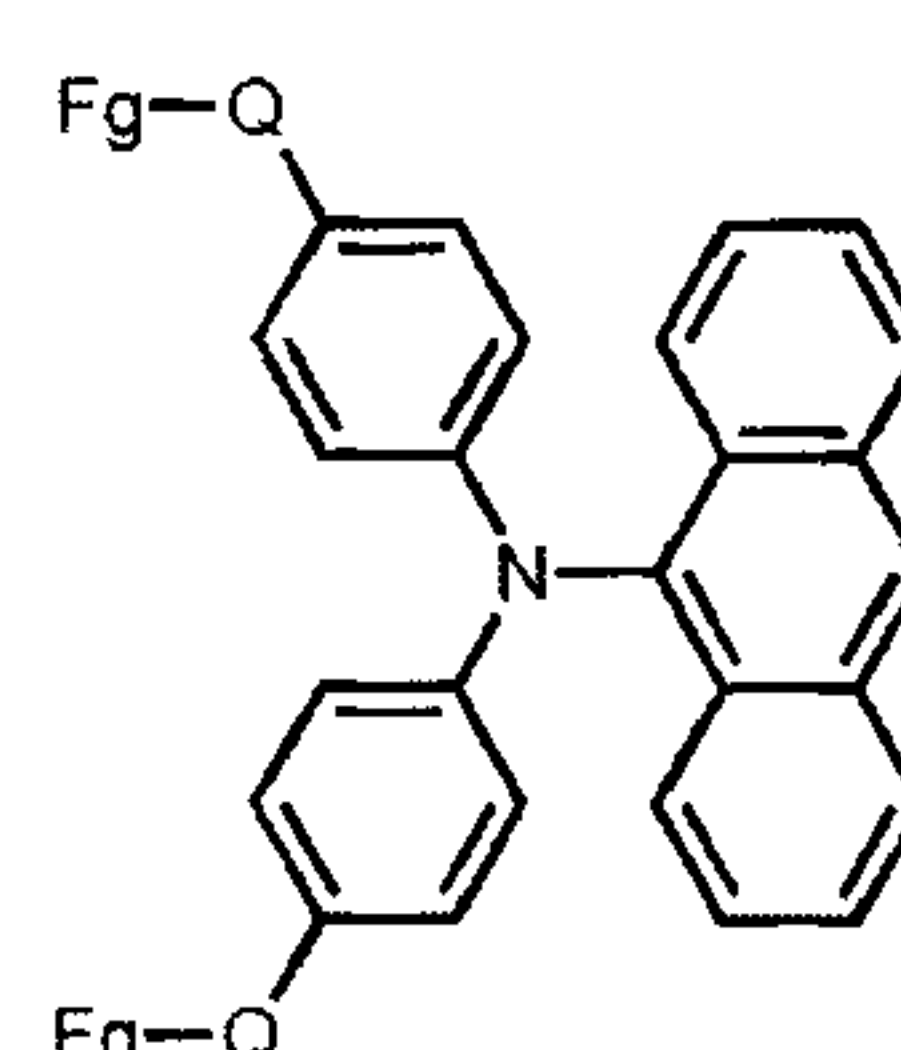
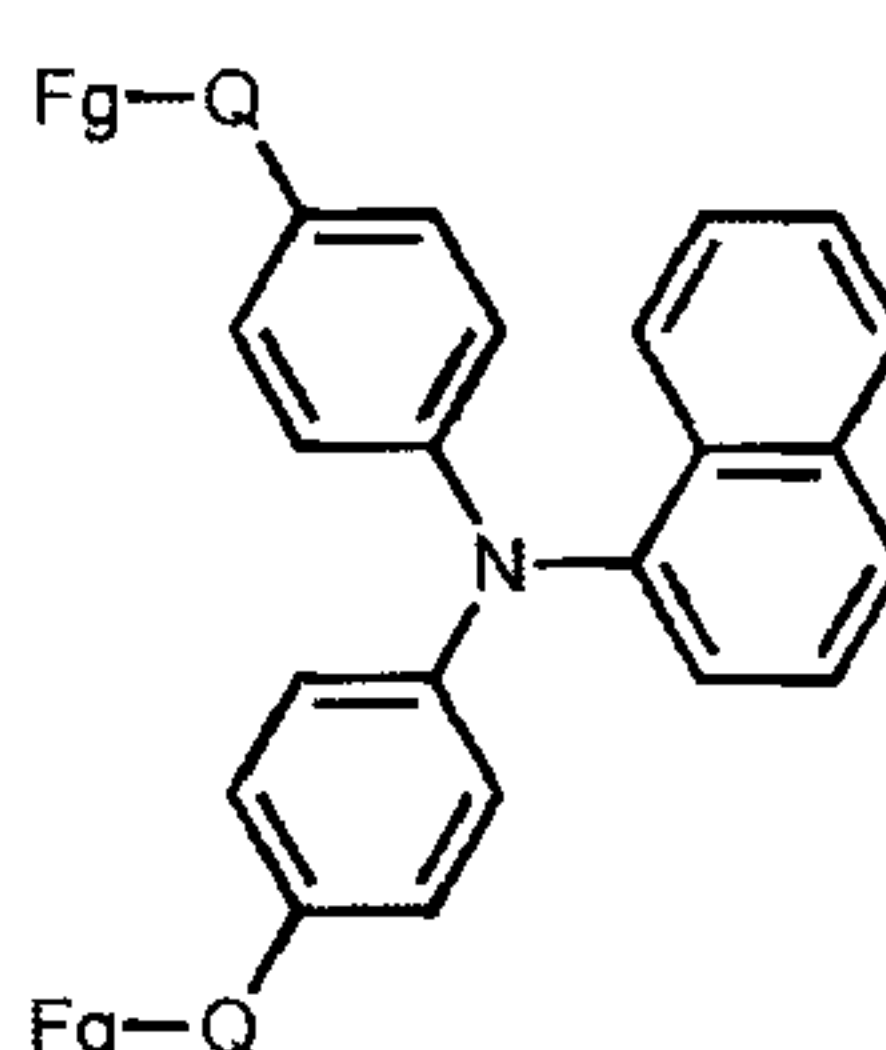
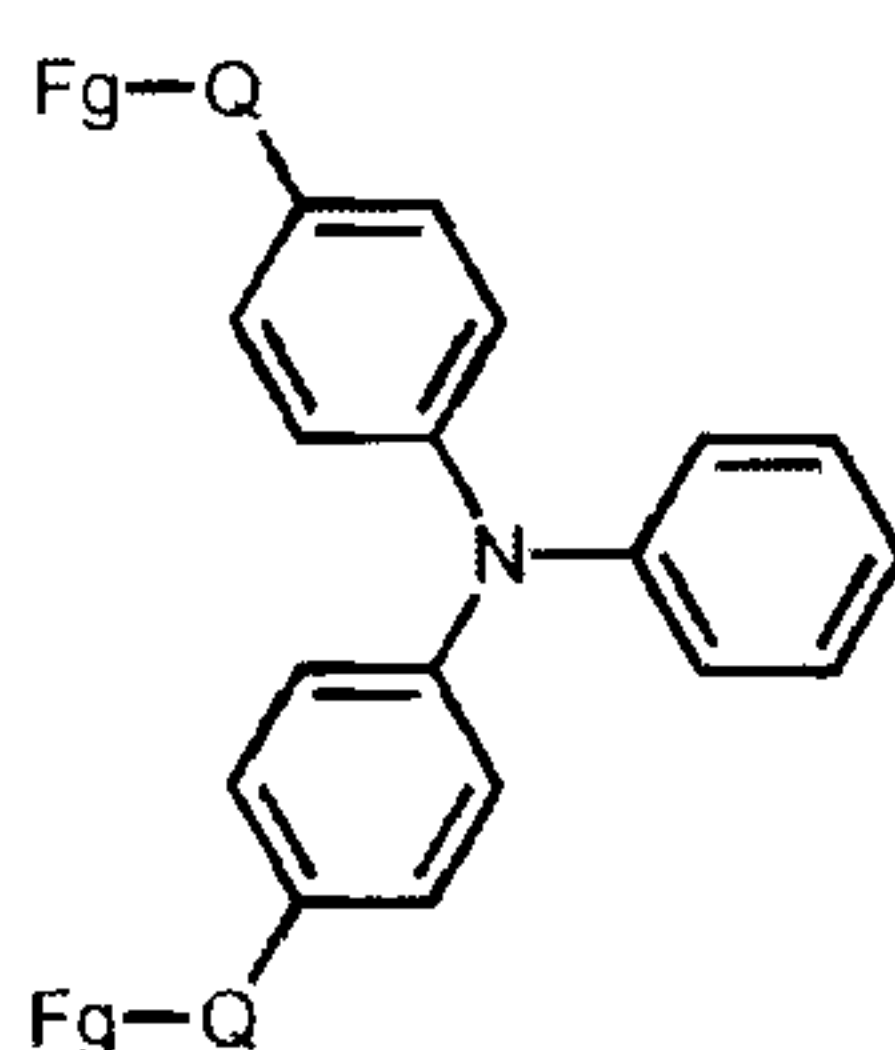
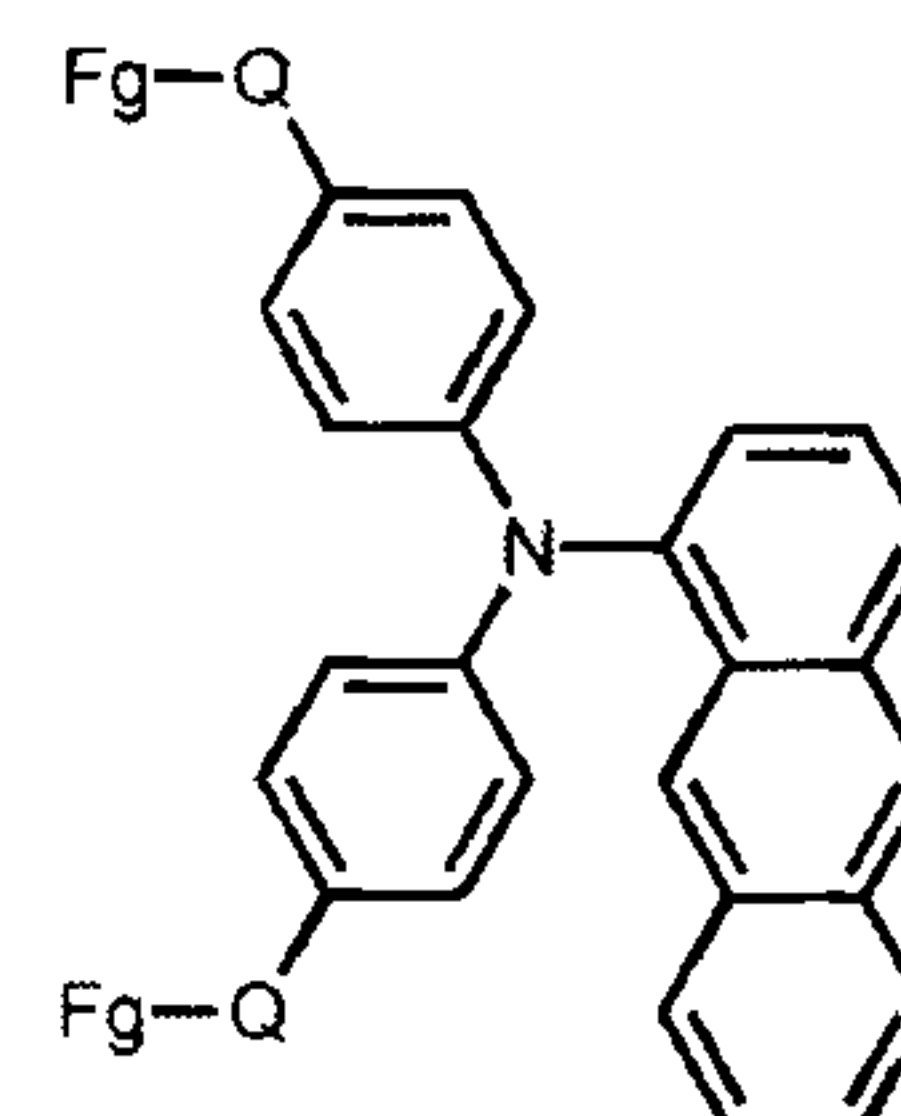
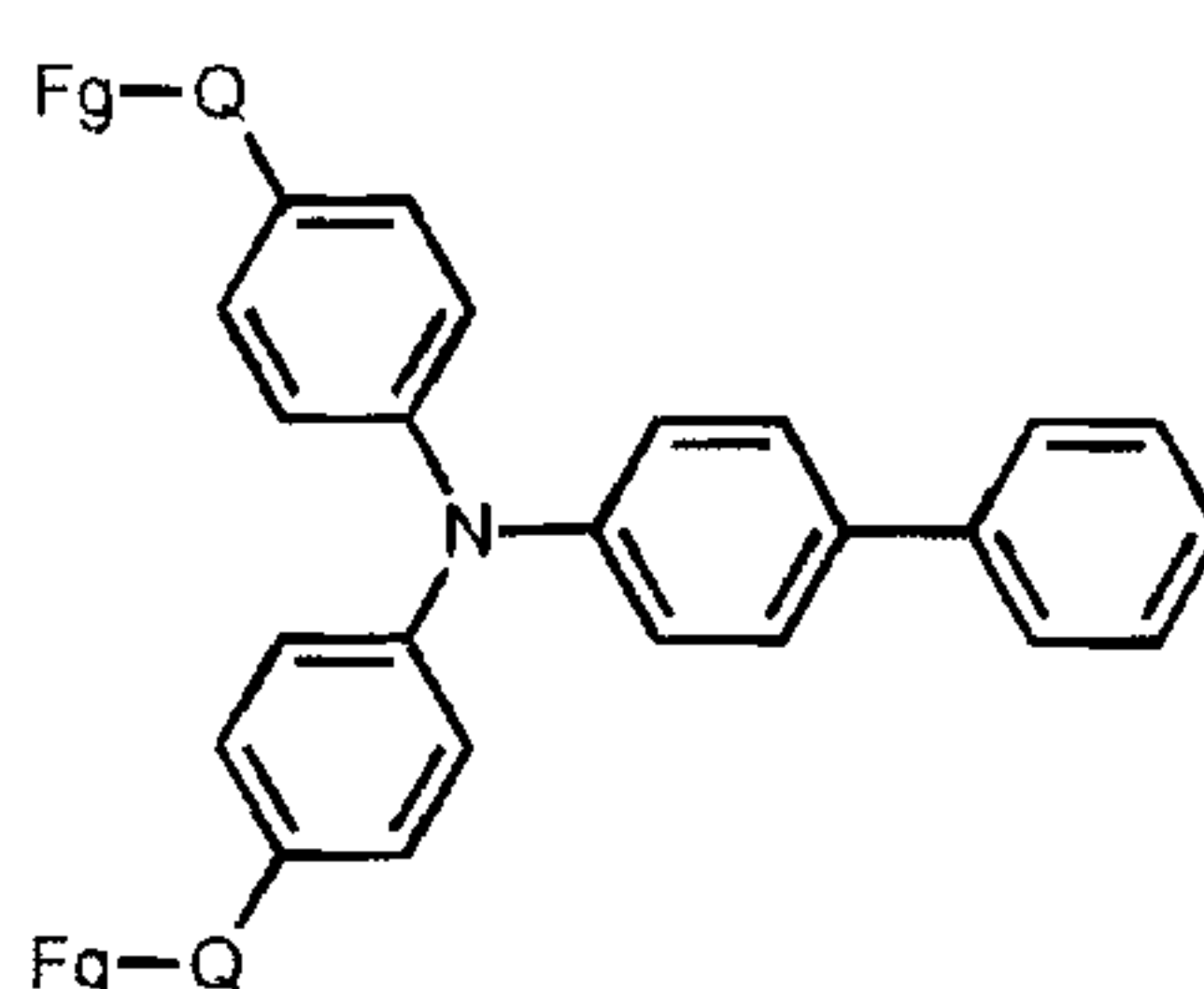
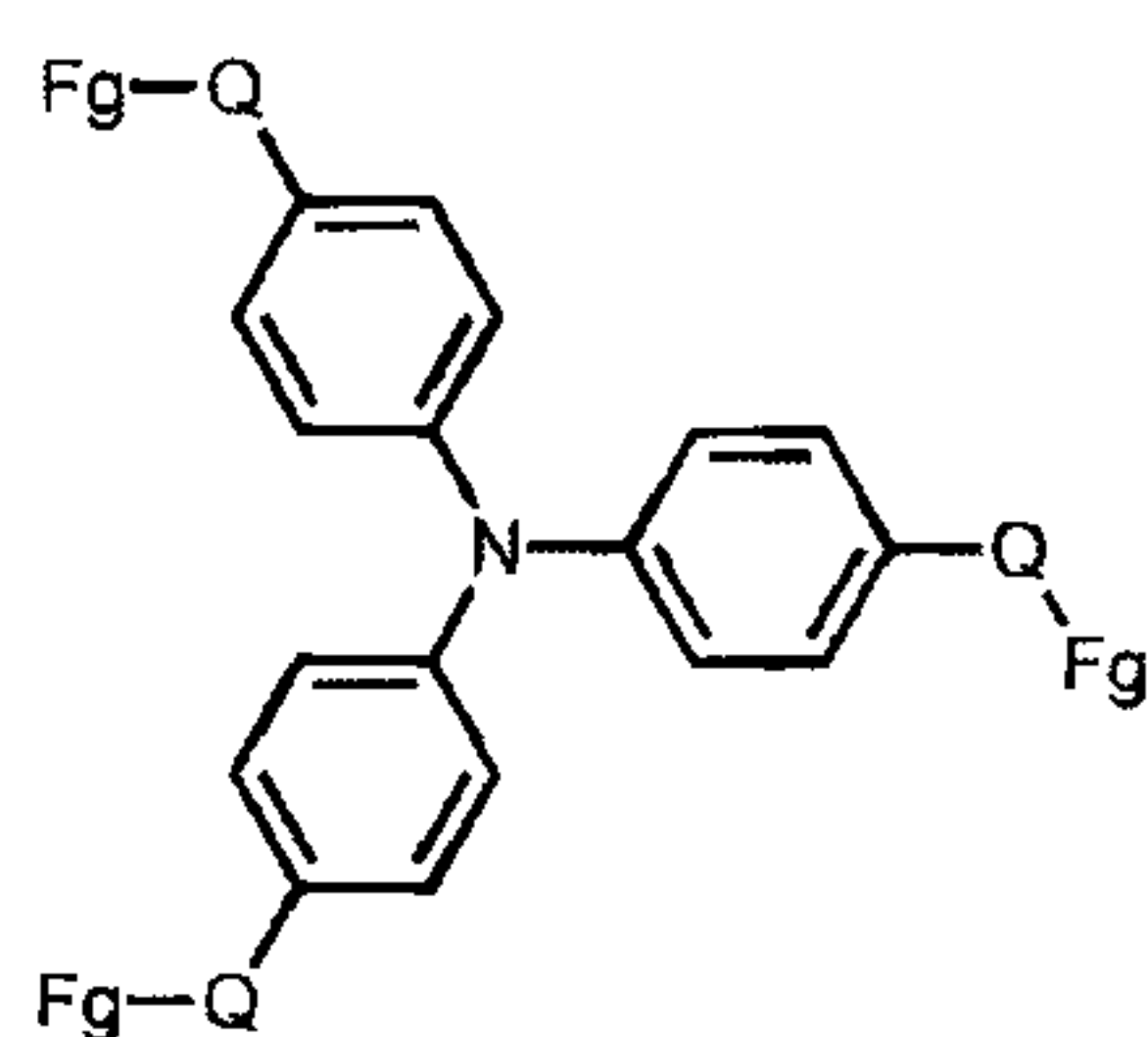


wherein Ar<sup>1</sup>, Ar<sup>2</sup>, Ar<sup>3</sup>, Ar<sup>4</sup> and Ar<sup>5</sup> each independently represents a substituted or unsubstituted aryl group, or Ar<sup>5</sup> independently represents a substituted or unsubstituted arylene group, and k represents 0 or 1, wherein at least two of Ar<sup>1</sup>, Ar<sup>2</sup>, Ar<sup>3</sup>, Ar<sup>4</sup> and Ar<sup>5</sup> comprises a Fg (previously defined). Ar<sup>5</sup> may be further defined as, for example, a substituted phenyl ring, substituted/unsubstituted phenylene, substituted/unsubstituted monovalently linked aromatic rings such as biphenyl, terphenyl, and the like, or substituted/unsubstituted fused aromatic rings such as naphthyl, anthranyl, phenanthryl, and the like.

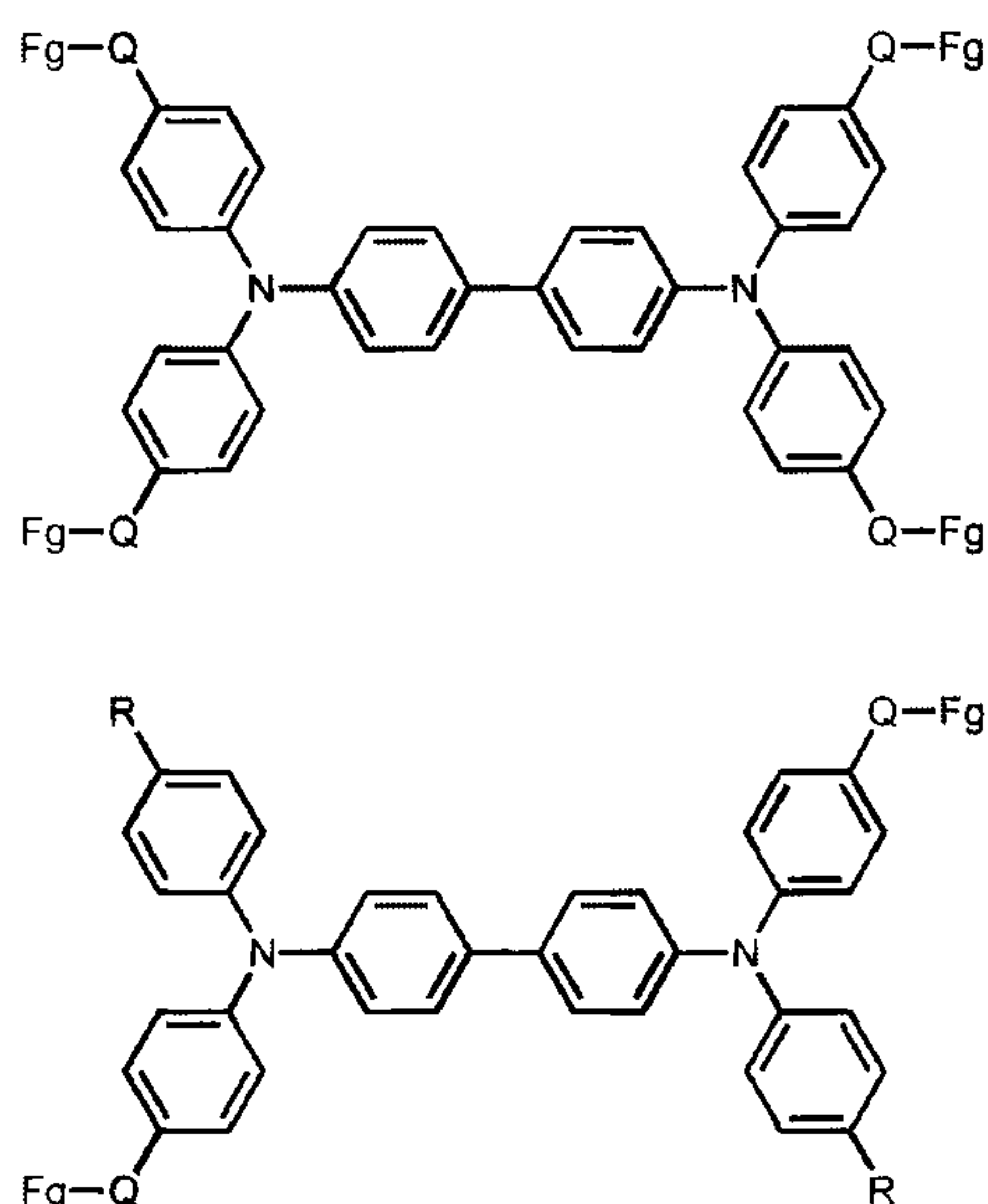
**[00130]** Segment cores comprising arylamines with hole transport added functionality include, for example, aryl amines such as triphenylamine, N,N,N',N'-tetraphenyl-(1,1'-biphenyl)-4,4'-diamine, N,N'-diphenyl-N,N'-bis(3-methylphenyl)-(1,1'-biphenyl)-4,4'-diamine, N,N'-bis(4-butylphenyl)-N,N'-diphenyl-[p-terphenyl]-4,4''-diamine; hydrazones such as N-phenyl-N-methyl-3-(9-ethyl)carbazyl hydrazone and 4-diethyl amino benzaldehyde-1,2-diphenyl hydrazone; and oxadiazoles such as 2,5-bis(4-N,N'-diethylaminophenyl)-1,2,4-oxadiazole, stilbenes, and the like.

**[00131]** Molecular building blocks comprising triarylamine core segments with inclined hole transport properties may be derived from the list of chemical structures including, for example, those listed below:

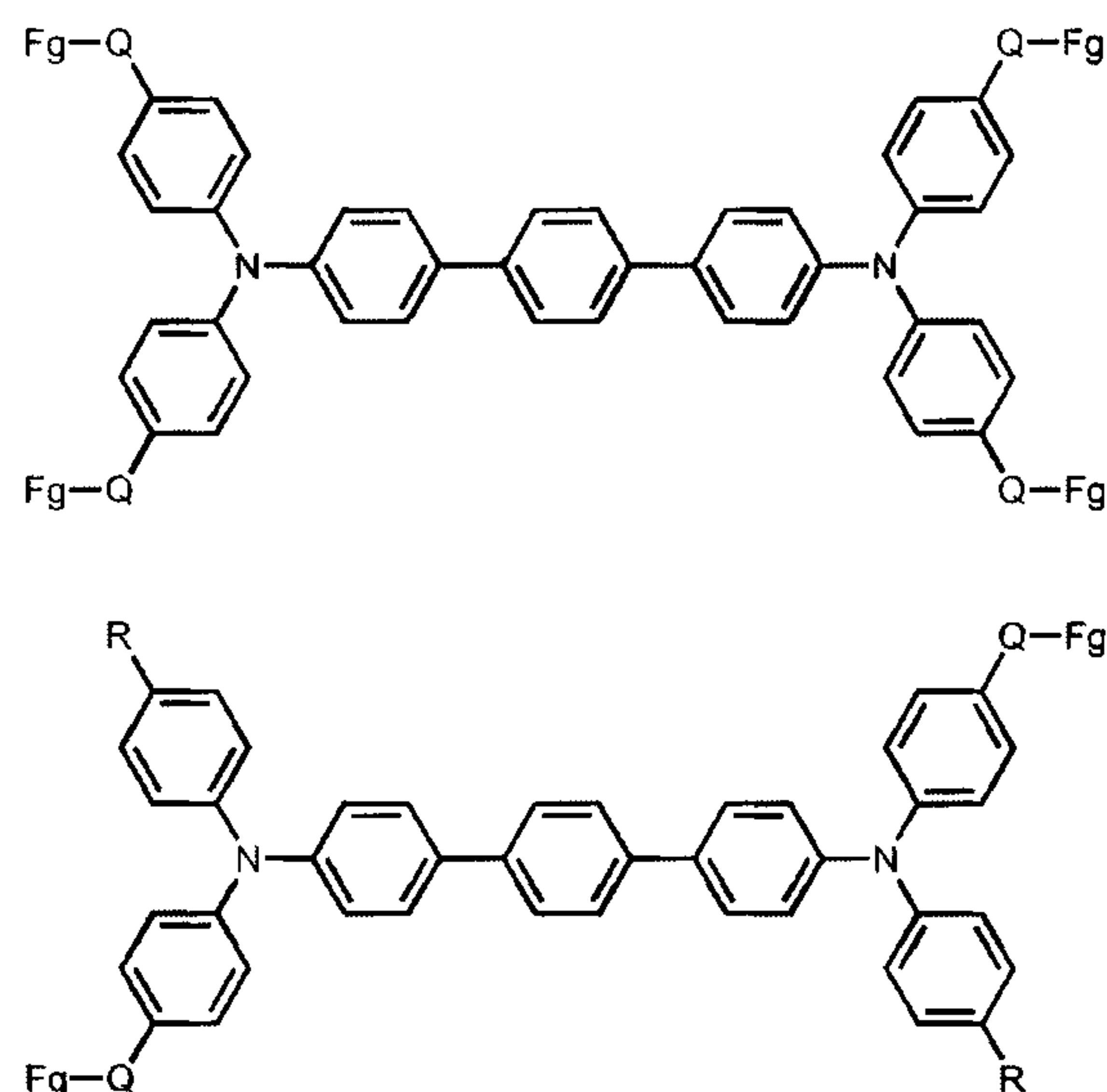
triarylamine cores



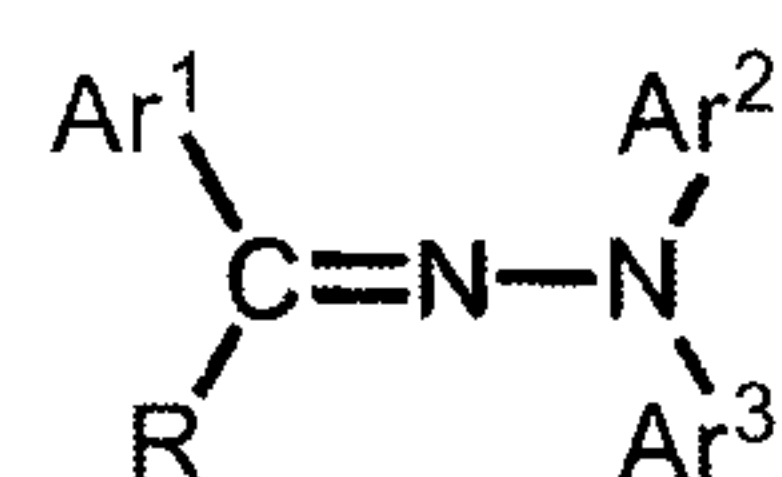
tetraarylbiphenylenediamine (TBD) cores



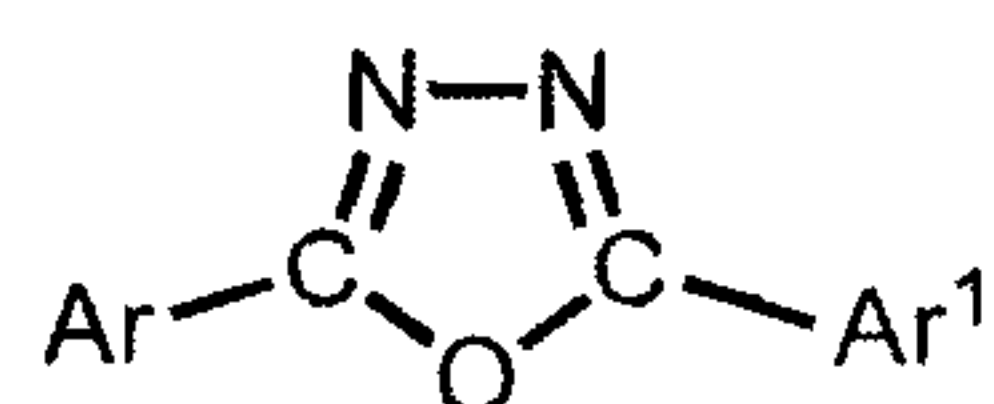
tetraarylterphenylenediamine (TER) cores



**[00132]** The segment core comprising a hydrazone being represented by the following general formula:



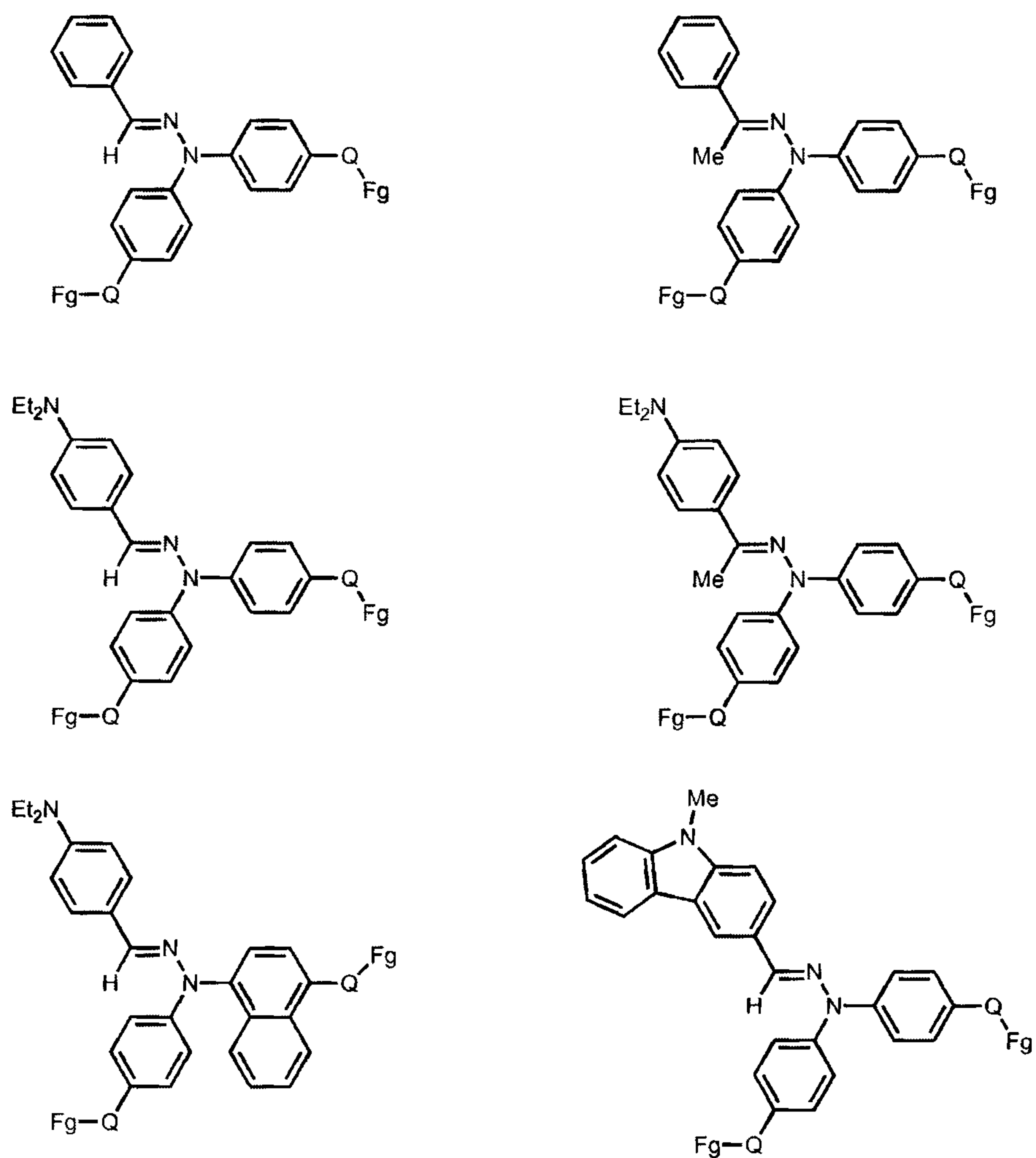
wherein  $\text{Ar}^1$ ,  $\text{Ar}^2$ , and  $\text{Ar}^3$  each independently represents an aryl group optionally containing one or more substituents, and  $\text{R}$  represents a hydrogen atom, an aryl group, or an alkyl group optionally containing a substituent; wherein at least two of  $\text{Ar}^1$ ,  $\text{Ar}^2$ , and  $\text{Ar}^3$  comprises a Fg (previously defined); and a related oxadiazole being represented by the following general formula:



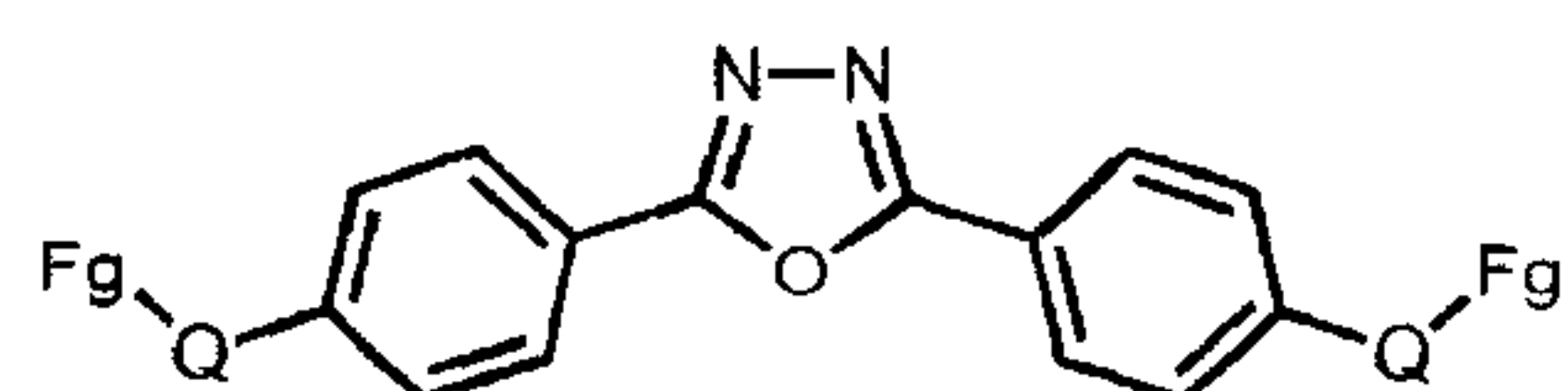
wherein  $\text{Ar}$  and  $\text{Ar}^1$  each independently represent an aryl group that comprises a Fg (previously defined).

**[00133]** Molecular building blocks comprising hydrazone and oxadiazole core segments with inclined hole transport properties may be derived from the list of chemical structures including, for example, those listed below:

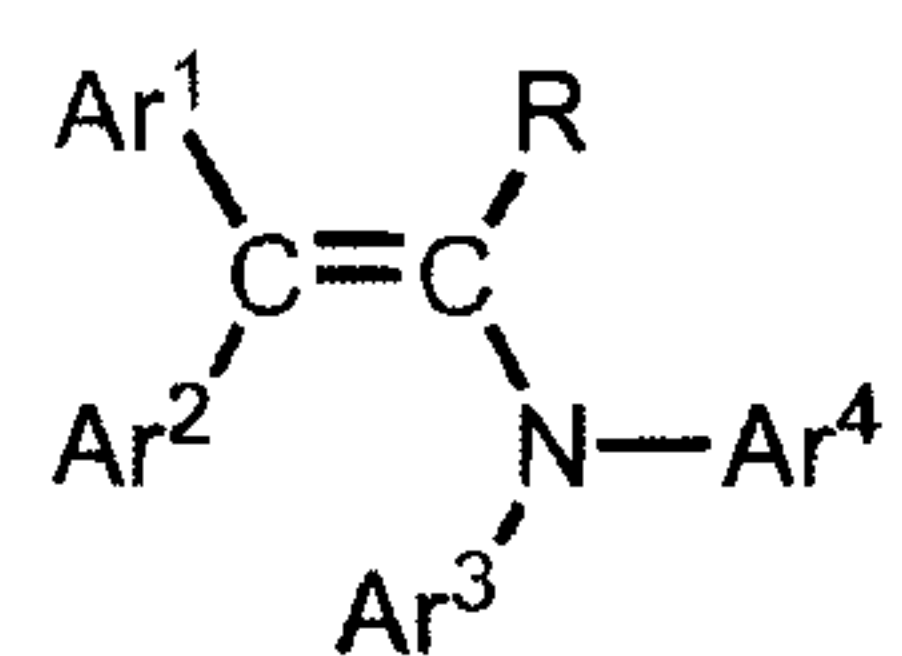
## hydrazone cores



## oxadiazole cores



**[00134]** The segment core comprising an enamine being represented by the following general formula:

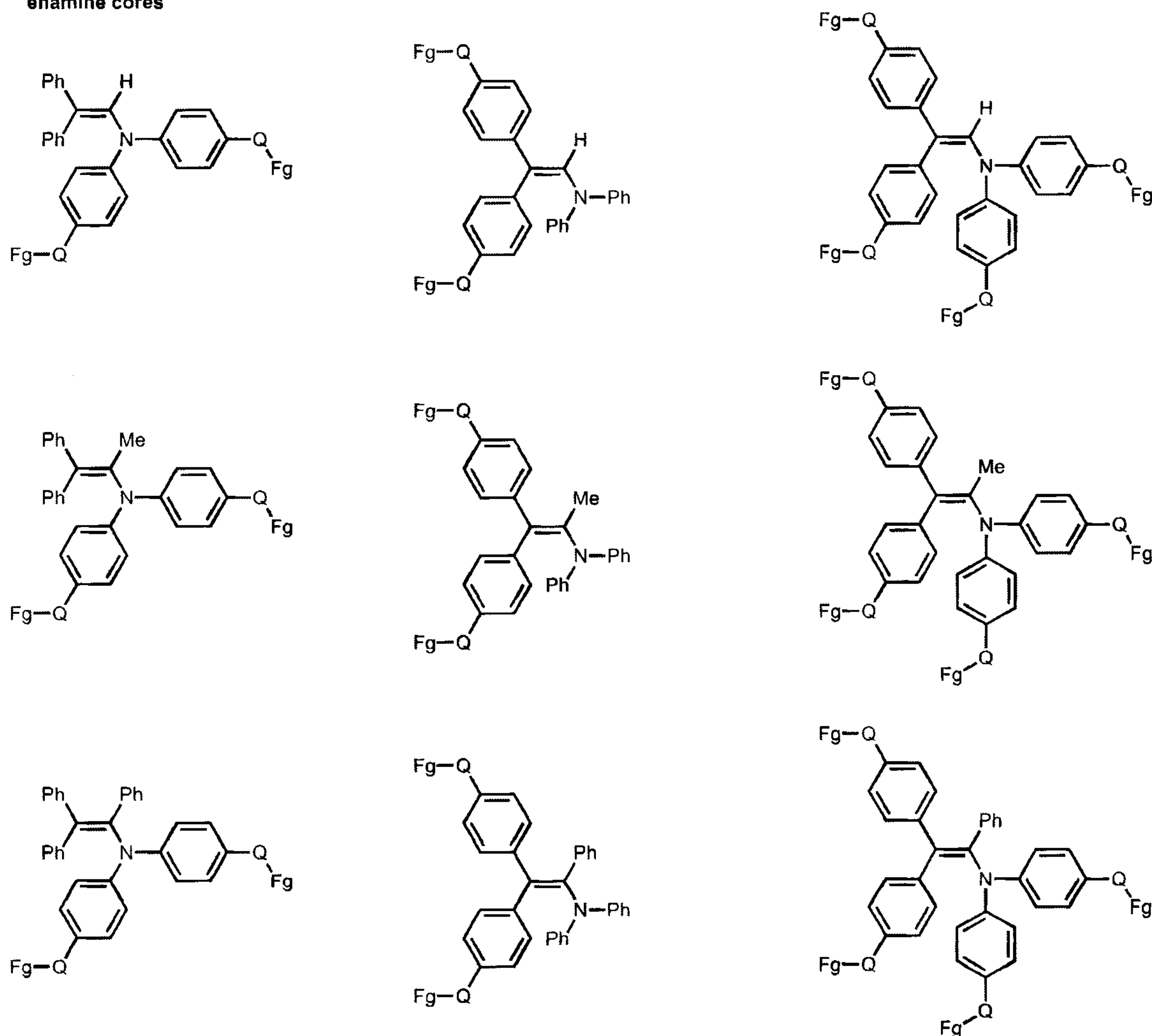


wherein  $Ar^1$ ,  $Ar^2$ ,  $Ar^3$ , and  $Ar^4$  each independently represents an aryl group that optionally contains one or more substituents or a heterocyclic group that optionally

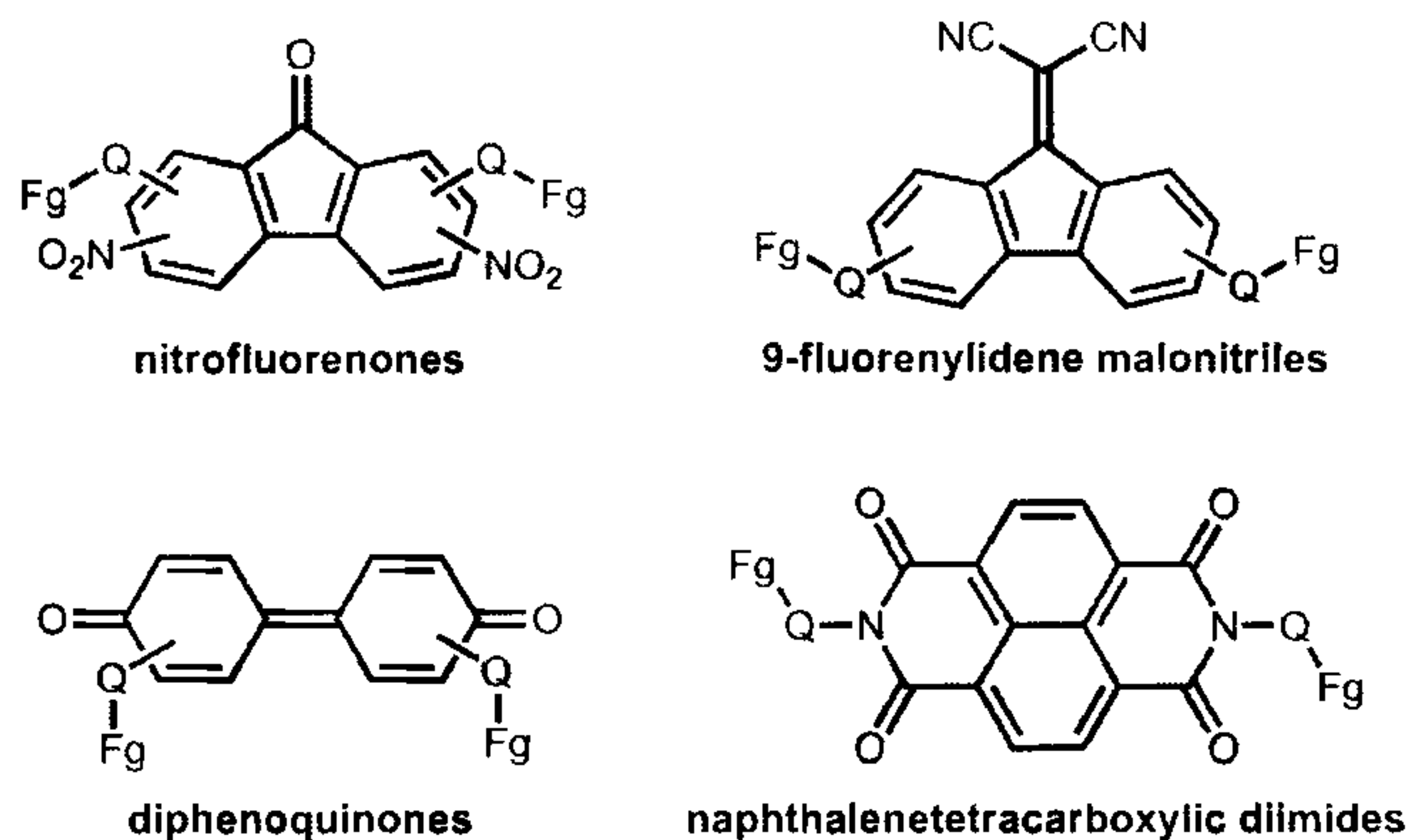
contains one or more substituents, and R represents a hydrogen atom, an aryl group, or an alkyl group optionally containing a substituent; wherein at least two of Ar<sup>1</sup>, Ar<sup>2</sup>, Ar<sup>3</sup>, and Ar<sup>4</sup> comprises a Fg (previously defined).

**[00135]** Molecular building blocks comprising enamine core segments with inclined hole transport properties may be derived from the list of chemical structures including, for example, those listed below:

**enamine cores**

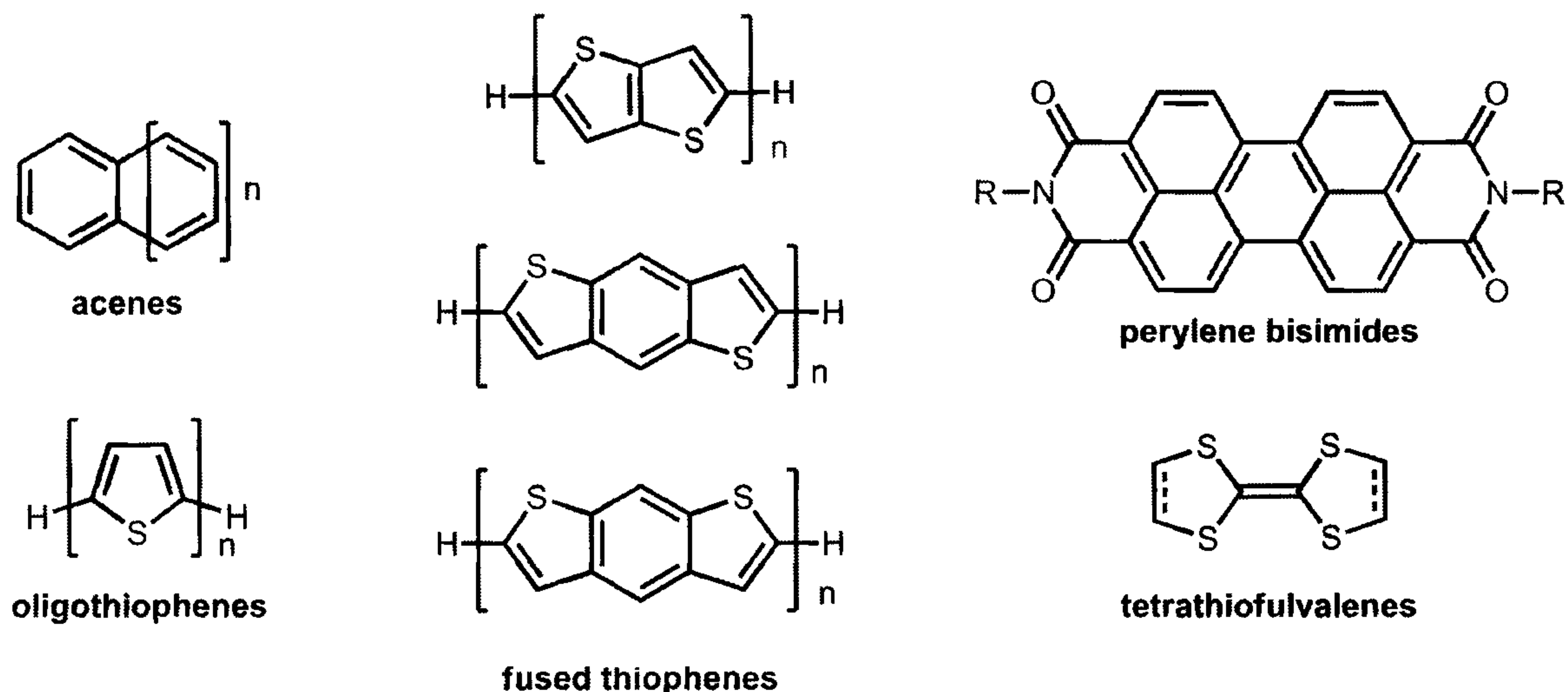


**[00136]** SOFs with electron transport added functionality may be obtained by selecting segment cores comprising, for example, nitrofluorenones, 9-fluorenylidene malonitriles, diphenoquinones, and naphthalenetetracarboxylic diimides with the following general structures:



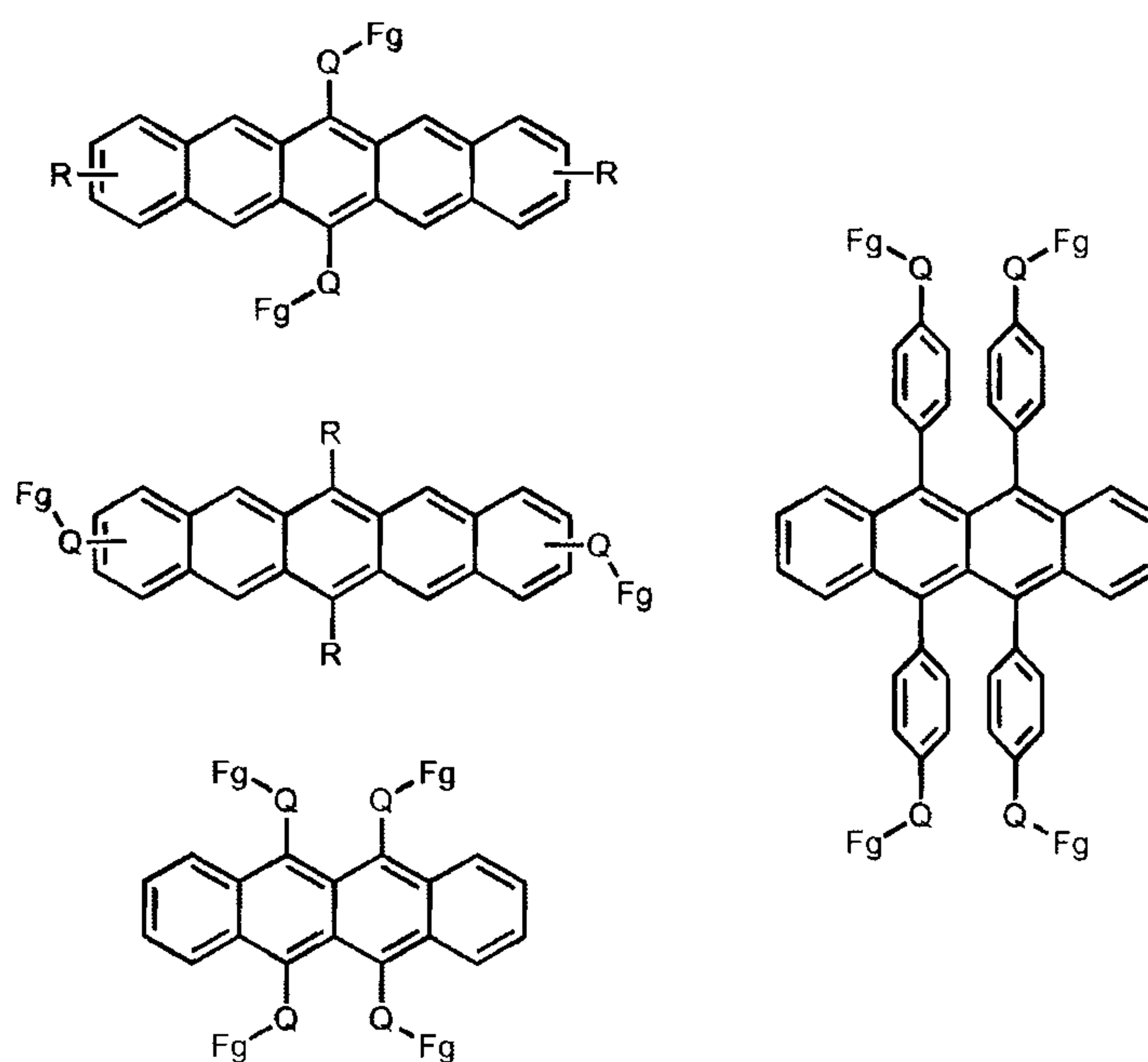
It should be noted that the carbonyl groups of diphenylquinones could also act as Fgs in the SOF forming process.

**[00137]** SOFs with semiconductor added functionality may be obtained by selecting segment cores such as, for example, acenes, thiophenes/oligothiophenes/fused thiophenes, perylene bisimides, or tetrathiofulvalenes, and derivatives thereof with the following general structures:

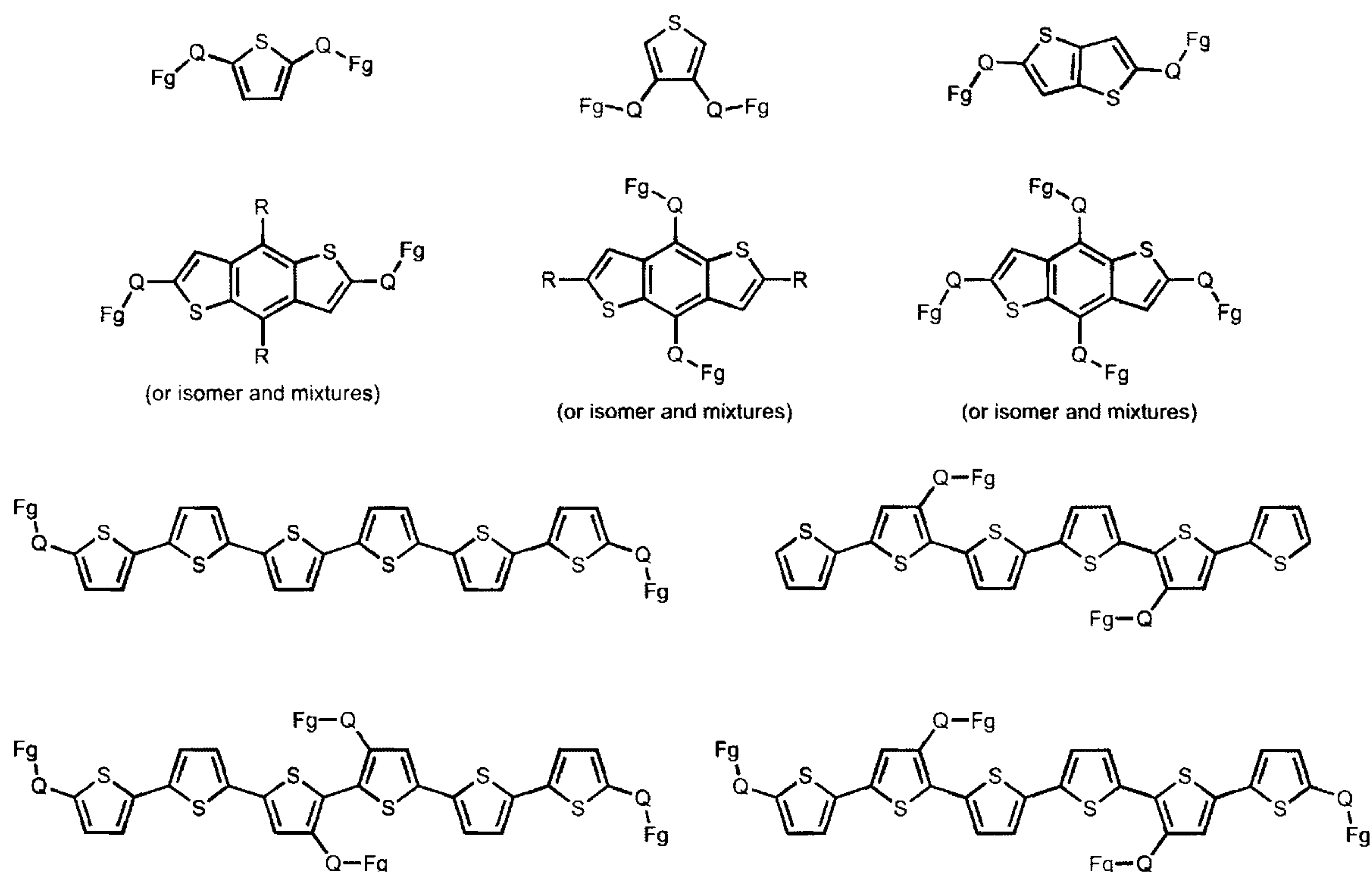


**[00138]** The SOF may be a p-type semiconductor, n-type semiconductor or ambipolar semiconductor. The SOF semiconductor type depends on the nature of the molecular building blocks. Molecular building blocks that possess an electron donating property such as alkyl, alkoxy, aryl, and amino groups, when present in the SOF, may render the SOF a p-type semiconductor. Alternatively, molecular building blocks that are electron withdrawing such as cyano, nitro, fluoro, fluorinated alkyl, and fluorinated aryl groups may render the SOF into the n-type semiconductor.

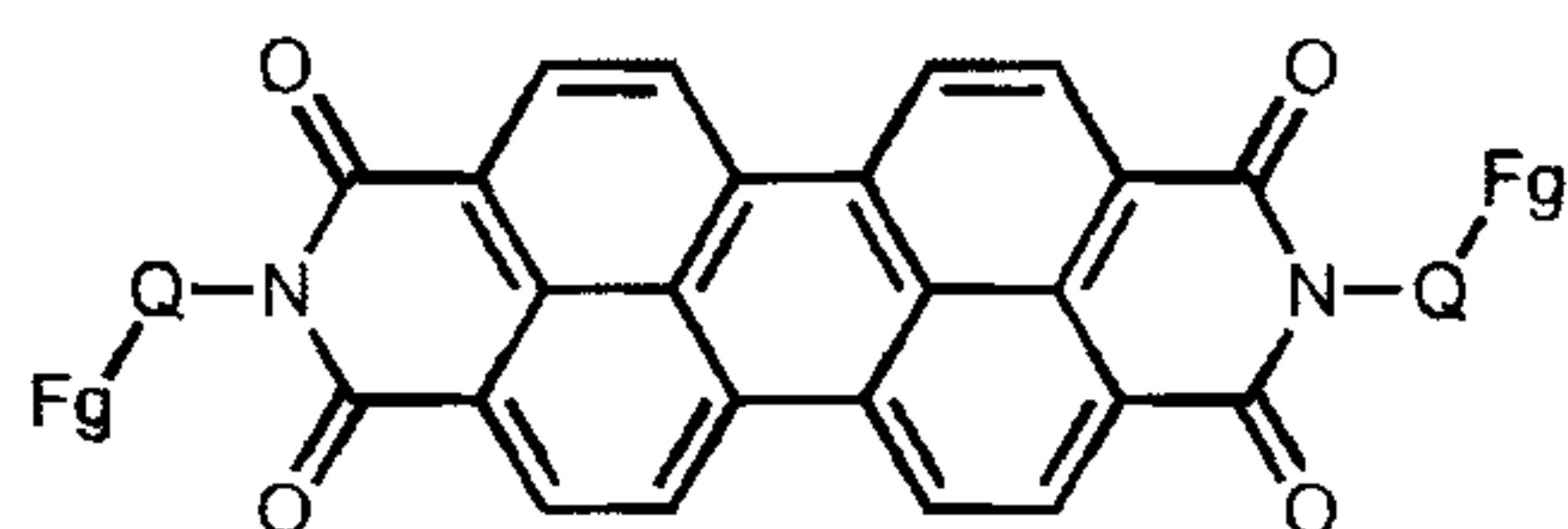
**[00139]** Molecular building blocks comprising acene core segments with inclined semiconductor properties may be derived from the list of chemical structures including, for example, those listed below:



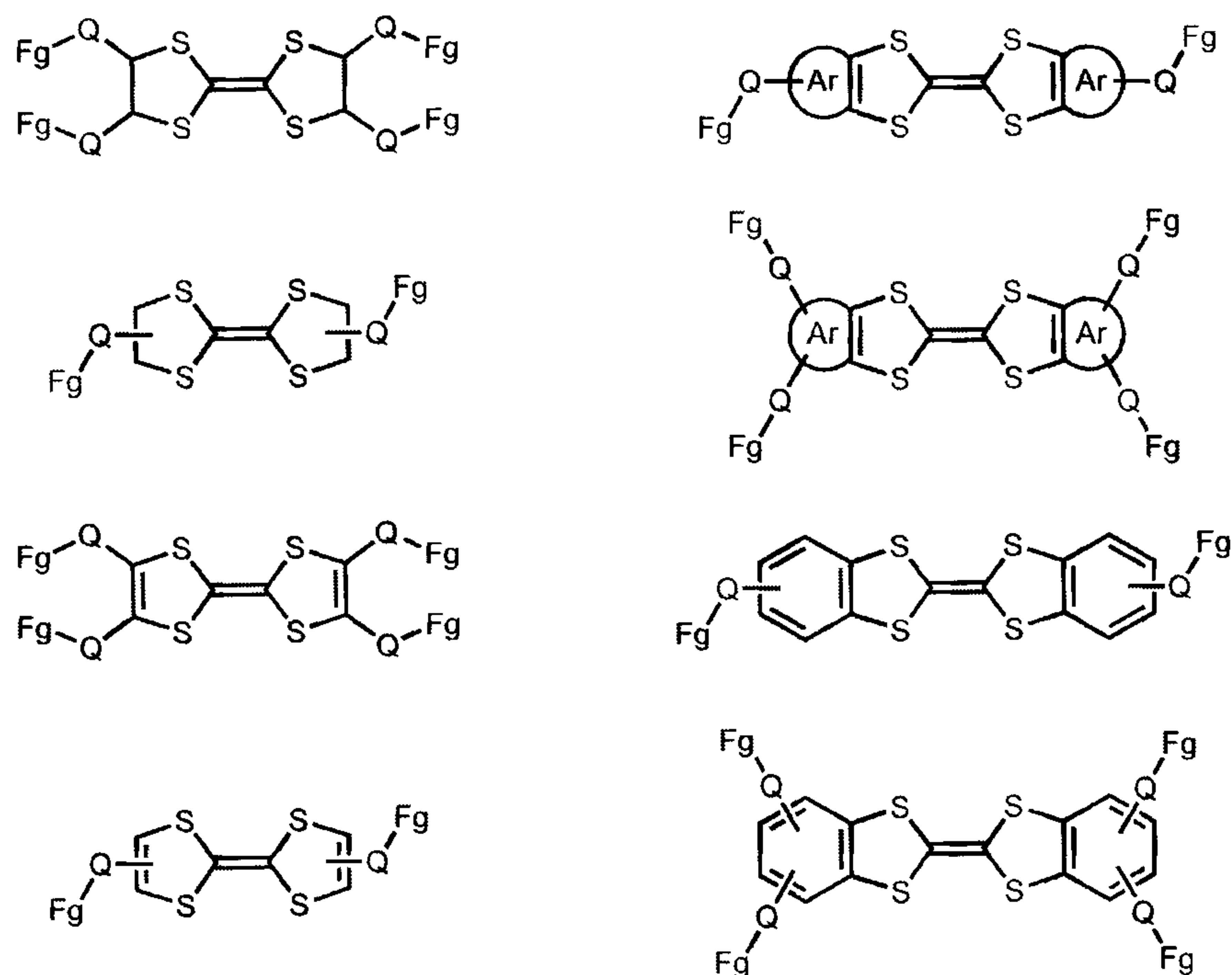
**[00140]** Molecular building blocks comprising thiophene/oligothiophene/fused thiophene core segments with inclined semiconductor properties may be derived from the list of chemical structures including, for example, those listed below:



**[00141]** Examples of molecular building blocks comprising perylene bisimide core segments with inclined semiconductor properties may be derived from the chemical structure below:



**[00142]** Molecular building blocks comprising tetrathiofulvalene core segments with inclined semiconductor properties may be derived from the list of chemical structures including, for example, those listed below:



wherein Ar each independently represents an aryl group that optionally contains one or more substituents or a heterocyclic group that optionally contains one or more substituents.

**[00143]** Similarly, the electroactivity of SOFs prepared by these molecular building blocks will depend on the nature of the segments, nature of the linkers, and how the segments are orientated within the SOF. Linkers that favor preferred orientations of the segment moieties in the SOF are expected to lead to higher electroactivity.

**[00144] Process for Preparing a Structured Organic Film**

**[00145]** The process for making SOFs typically comprises a number of activities or steps (set forth below) that may be performed in any suitable sequence or where two or more activities are performed simultaneously or in close proximity in time:

A process for preparing a structured organic film comprising:

(a) preparing a liquid-containing reaction mixture comprising a plurality of molecular building blocks each comprising a segment and a number of functional groups, and a pre-SOF;

(b) depositing the reaction mixture as a wet film;

(c) promoting a change of the wet film including the molecular building blocks to a dry film comprising the SOF comprising a plurality of the segments and a plurality of linkers arranged as a covalent organic framework, wherein at a macroscopic level the covalent organic framework is a film;

(d) optionally removing the SOF from the coating substrate to obtain a free-standing SOF;

(e) optionally processing the free-standing SOF into a roll;

(f) optionally cutting and seaming the SOF into a belt; and

(g) optionally performing the above SOF formation process(es) upon an SOF (which was prepared by the above SOF formation process(es)) as a substrate for subsequent SOF formation process(es).

**[00146]** The process for making capped SOFs and/or composite SOFs typically comprises a similar number of activities or steps (set forth above) that are used to make a non-capped SOF. The capping unit and/or secondary component may be added during either step a, b or c, depending the desired distribution of the capping unit in the resulting SOF. For example, if it is desired that the capping unit and/or secondary component distribution is substantially uniform over the resulting SOF, the capping unit may be added during step a. Alternatively, if, for example, a more heterogeneous distribution of the capping unit and/or secondary component is desired, adding the capping unit and/or secondary component (such as by spraying it on the film formed during step b or during the promotion step of step c) may occur during steps b and c.

**[00147]** The above activities or steps may be conducted at atmospheric, super atmospheric, or subatmospheric pressure. The term "atmospheric pressure" as used herein refers to a pressure of about 760 torr. The term "super atmospheric" refers to pressures greater than atmospheric pressure, but less than 20 atm. The term "subatmospheric pressure" refers to pressures less than atmospheric pressure. In an embodiment, the activities or steps may be conducted at or near atmospheric pressure.

Generally, pressures of from about 0.1 atm to about 2 atm, such as from about 0.5 atm to about 1.5 atm, or 0.8 atm to about 1.2 atm may be conveniently employed.

**[00148] Process Action A: Preparation of the Liquid-Containing Reaction Mixture**

**[00149]** The reaction mixture comprises a plurality of molecular building blocks that are dissolved, suspended, or mixed in a liquid. The plurality of molecular building blocks may be of one type or two or more types. When one or more of the molecular building blocks is a liquid, the use of an additional liquid is optional. Catalysts may optionally be added to the reaction mixture to enable pre-SOF formation and/or modify the kinetics of SOF formation during Action C described above. The term "pre-SOF" may refer to, for example, at least two molecular building blocks that have reacted and have a molecular weight higher than the starting molecular building block and contain multiple functional groups capable of undergoing further reactions with functional groups of other building blocks or pre-SOFs to obtain a SOF, which may be a substantially defect-free or defect-free SOF, and/or the 'activation' of molecular building block functional groups that imparts enhanced or modified reactivity for the film forming process. Activation may include dissociation of a functional group moiety, pre-association with a catalyst, association with a solvent molecule, liquid, second solvent, second liquid, secondary component, or with any entity that modifies functional group reactivity. In embodiments, pre-SOF formation may include the reaction between molecular building blocks or the 'activation' of molecular building block functional groups, or a combination of the two. The formation of the "pre-SOF" may be achieved by in a number of ways, such as heating the reaction mixture, exposure of the reaction mixture to UV radiation, or any other means of partially reacting the molecular building blocks and/or activating functional groups in the reaction mixture prior to deposition of the wet layer on the substrate. Additives or secondary components may optionally be added to the reaction mixture to alter the physical properties of the resulting SOF.

**[00150]** The reaction mixture components (molecular building blocks, optionally a liquid, optionally catalysts, and optionally additives) are combined in a vessel. The order of addition of the reaction mixture components may vary; however,

typically when a process for preparing a SOF includes a pre-SOF or formation of a pre-SOF, the catalyst, when present, may be added to the reaction mixture before depositing the reaction mixture as a wet film. In embodiments, the molecular building blocks may be reacted actinically, thermally, chemically or by any other means with or without the presence of a catalyst to obtain a pre-SOF. The pre-SOF and the molecular building blocks formed in the absence of catalyst may be may be heated in the liquid in the absence of the catalyst to aid the dissolution of the molecular building blocks and pre-SOFs. In embodiments, the pre-SOF and the molecular building blocks formed in the presence of catalyst may be may be heated at a temperature that does not cause significant further reaction of the molecular building blocks and/or the pre-SOFs to aid the dissolution of the molecular building blocks and pre-SOFs. The reaction mixture may also be mixed, stirred, milled, or the like, to ensure even distribution of the formulation components prior to depositing the reaction mixture as a wet film.

**[00151]** In embodiments, the reaction mixture may be heated prior to being deposited as a wet film. This may aid the dissolution of one or more of the molecular building blocks and/or increase the viscosity of the reaction mixture by the partial reaction of the reaction mixture prior to depositing the wet layer to form pre-SOFs. For example, the weight percent of molecular building blocks in the reaction mixture that are incorporated into pre-reacted molecular building blocks pre-SOFs may be less than 20%, such as about 15% to about 1%, or 10% to about 5%. In embodiments, the molecular weight of the 95% pre-SOF molecules is less than 5,000 daltons, such as 2,500 daltons, or 1,000 daltons. The preparation of pre-SOFs may be used to increase the loading of the molecular building blocks in the reaction mixture.

**[00152]** In the case of pre-SOF formation via functional group activation, the molar percentage of functional groups that are activated may be less than 50 %, such as about 30 % to about 10 %, or about 10 % to about 5 %.

**[00153]** In embodiments, the two methods of pre-SOF formation (pre-SOF formation by the reaction between molecular building blocks or pre-SOF formation by the ‘activation’ of molecular building block functional groups) may occur in combination and the molecular building blocks incorporated into pre-SOF structures

may contain activated functional groups. In embodiments, pre-SOF formation by the reaction between molecular building blocks and pre-SOF formation by the 'activation' of molecular building block functional groups may occur simultaneously.

**[00154]** In embodiments, the duration of pre-SOF formation lasts about 10 seconds to about 48 hours, such as about 30 seconds to about 12 hours, or about 1 minute to 6 hours.

**[00155]** In particular embodiments, the reaction mixture needs to have a viscosity that will support the deposited wet layer. Reaction mixture viscosities range from about 10 to about 50,000 cps, such as from about 25 to about 25,000 cps or from about 50 to about 1000 cps.

**[00156]** The molecular building block and capping unit loading or "loading" in the reaction mixture is defined as the total weight of the molecular building blocks and optionally the capping units and catalysts divided by the total weight of the reaction mixture. Building block loadings may range from about 3 to 100%, such as from about 5 to about 50%, or from about 15 to about 40%. In the case where a liquid molecular building block is used as the only liquid component of the reaction mixture (i.e. no additional liquid is used), the building block loading would be about 100%. The capping unit loading may be chosen, so as to achieve the desired loading of the capping group. For example, depending on when the capping unit is to be added to the reaction mixture, capping unit loadings may range, by weight, from about 3 to 80%, such as from about 5 to about 50%, or from about 15 to about 40% by weight.

**[00157]** In embodiments, the theoretical upper limit for capping unit loading is the molar amount of capping units that reduces the number of available linking groups to 2 per molecular building block in the liquid SOF formulation. In such a loading, substantial SOF formation may be effectively inhibited by exhausting (by reaction with the respective capping group) the number of available linkable functional groups per molecular building block. For example, in such a situation (where the capping unit loading is in an amount sufficient to ensure that the molar excess of available linking groups is less than 2 per molecular building block in the liquid SOF

formulation), oligomers, linear polymers, and molecular building blocks that are fully capped with capping units may predominately form instead of an SOF.

**[00158]** In embodiments, the pre-SOF may be made from building blocks with one or more of the added functionality selected from the group consisting of hydrophobic added functionality, superhydrophobic added functionality, hydrophilic added functionality, lipophobic added functionality, superlipophobic added functionality, lipophilic added functionality, photochromic added functionality, and electroactive added functionality. In embodiments, the inclined property of the molecular building blocks is the same as the added functionality of the pre-SOF. In embodiments, the added functionality of the SOF is not an inclined property of the molecular building blocks.

**[00159]** Liquids used in the reaction mixture may be pure liquids, such as solvents, and/or solvent mixtures. Liquids are used to dissolve or suspend the molecular building blocks and catalyst/modifiers in the reaction mixture. Liquid selection is generally based on balancing the solubility/dispersion of the molecular building blocks and a particular building block loading, the viscosity of the reaction mixture, and the boiling point of the liquid, which impacts the promotion of the wet layer to the dry SOF. Suitable liquids may have boiling points from about 30 to about 300 °C, such as from about 65 °C to about 250 °C, or from about 100 °C to about 180 °C.

**[00160]** Liquids can include molecule classes such as alkanes (hexane, heptane, octane, nonane, decane, cyclohexane, cycloheptane, cyclooctane, decalin); mixed alkanes (hexanes, heptanes); branched alkanes (isooctane); aromatic compounds (toluene, *o*-, *m*-, *p*-xylene, mesitylene, nitrobenzene, benzonitrile, butylbenzene, aniline); ethers (benzyl ethyl ether, butyl ether, isoamyl ether, propyl ether); cyclic ethers (tetrahydrofuran, dioxane), esters (ethyl acetate, butyl acetate, butyl butyrate, ethoxyethyl acetate, ethyl propionate, phenyl acetate, methyl benzoate); ketones (acetone, methyl ethyl ketone, methyl isobutylketone, diethyl ketone, chloroacetone, 2-heptanone), cyclic ketones (cyclopentanone, cyclohexanone), amines (1°, 2°, or 3° amines such as butylamine, diisopropylamine, triethylamine, diisopropylethylamine; pyridine); amides (dimethylformamide, *N*-methylpyrrolidinone, *N,N*-

dimethylformamide); alcohols (methanol, ethanol, *n*-, *i*-propanol, *n*-, *i*-, *t*-butanol, 1-methoxy-2-propanol, hexanol, cyclohexanol, 3-pentanol, benzyl alcohol); nitriles (acetonitrile, benzonitrile, butyronitrile), halogenated aromatics (chlorobenzene, dichlorobenzene, hexafluorobenzene), halogenated alkanes (dichloromethane, chloroform, dichloroethylene, tetrachloroethane); and water.

**[00161]** Mixed liquids comprising a first solvent, second solvent, third solvent, and so forth may also be used in the reaction mixture. Two or more liquids may be used to aid the dissolution/dispersion of the molecular building blocks; and/or increase the molecular building block loading; and/or allow a stable wet film to be deposited by aiding the wetting of the substrate and deposition instrument; and/or modulate the promotion of the wet layer to the dry SOF. In embodiments, the second solvent is a solvent whose boiling point or vapor-pressure curve or affinity for the molecular building blocks differs from that of the first solvent. In embodiments, a first solvent has a boiling point higher than that of the second solvent. In embodiments, the second solvent has a boiling point equal to or less than about 100°C, such as in the range of from about 30°C to about 100°C, or in the range of from about 40°C to about 90°C, or about 50°C to about 80°C.

**[00162]** In embodiments, the first solvent, or higher boiling point solvent, has a boiling point equal to or greater than about 65°C, such as in the range of from about 80°C to about 300°C, or in the range of from about 100°C to about 250°C, or about 100°C to about 180°C. The higher boiling point solvent may include, for example, the following (the value in parentheses is the boiling point of the compound): hydrocarbon solvents such as amylbenzene (202°C.), isopropylbenzene (152°C.), 1,2-diethylbenzene (183°C.), 1,3-diethylbenzene (181°C.), 1,4-diethylbenzene (184°C.), cyclohexylbenzene (239°C.), dipentene (177°C.), 2,6-dimethylnaphthalene (262°C.), *p*-cymene (177°C.), camphor oil (160-185°C.), solvent naphtha (110-200°C.), *cis*-decalin (196°C.), *trans*-decalin (187°C.), decane (174°C.), tetralin (207°C.), turpentine oil (153-175°C.), kerosene (200-245°C.), dodecane (216°C.), dodecylbenzene (branched), and so forth; ketone and aldehyde solvents such as acetophenone (201.7°C.), isophorone (215.3°C.), phorone (198-199°C.), methylcyclohexanone (169.0-170.5°C.), methyl *n*-heptyl ketone (195.3°C.), and so forth; ester solvents such

as diethyl phthalate (296.1°C.), benzyl acetate (215.5°C.),  $\gamma$ -butyrolactone (204°C.), dibutyl oxalate (240°C.), 2-ethylhexyl acetate (198.6°C.), ethyl benzoate (213.2°C.), benzyl formate (203°C.), and so forth; diethyl sulfate (208°C.), sulfolane (285°C.), and halohydrocarbon solvents; etherified hydrocarbon solvents; alcohol solvents; ether/acetal solvents; polyhydric alcohol solvents; carboxylic anhydride solvents; phenolic solvents; water; and silicone solvents.

**[00163]** The ratio of the mixed liquids may be established by one skilled in the art. The ratio of liquids a binary mixed liquid may be from about 1:1 to about 99:1, such as from about 1:10 to about 10:1, or about 1:5 to about 5:1, by volume. When  $n$  liquids are used, with  $n$  ranging from about 3 to about 6, the amount of each liquid ranges from about 1% to about 95% such that the sum of each liquid contribution equals 100%.

**[00164]** In embodiments, the mixed liquid comprises at least a first and a second solvent with different boiling points. In further embodiments, the difference in boiling point between the first and the second solvent may be from about nil to about 150 °C, such as from nil to about 50 °C. For example, the boiling point of the first solvent may exceed the boiling point of the second solvent by about 1 °C to about 100°C, such as by about 5°C to about 100°C, or by about 10°C to about 50°C. The mixed liquid may comprise at least a first and a second solvent with different vapor pressures, such as combinations of high vapor pressure solvents and/or low vapor pressure solvents. The term "high vapor pressure solvent" refers to, for example, a solvent having a vapor pressure of at least about 1 kPa, such as about 2 kPa, or about 5 kPa. The term "low vapor pressure solvent" refers to, for example, a solvent having a vapor pressure of less than about 1 kPa, such as about 0.9 kPa, or about 0.5 kPa. In embodiments, the first solvent may be a low vapor pressure solvent such as, for example, terpineol, diethylene glycol, ethylene glycol, hexylene glycol, N-methyl-2-pyrrolidone, and tri(ethylene glycol) dimethyl ether. A high vapor pressure solvent allows rapid removal of the solvent by drying and/or evaporation at temperatures below the boiling point. High vapor pressure solvents may include, for example, acetone, tetrahydrofuran, toluene, xylene, ethanol, methanol, 2-butanone and water.

**[00165]** In embodiments where mixed liquids comprising a first solvent, second solvent, third solvent, and so forth are used in the reaction mixture, promoting the change of the wet film and forming the dry SOF may comprise, for example, heating the wet film to a temperature above the boiling point of the reaction mixture to form the dry SOF film; or heating the wet film to a temperature above the boiling point of the second solvent (below the temperature of the boiling point of the first solvent) in order to remove the second solvent while substantially leaving the first solvent and then after substantially removing the second solvent, removing the first solvent by heating the resulting composition at a temperature either above or below the boiling point of the first solvent to form the dry SOF film; or heating the wet film below the boiling point of the second solvent in order to remove the second solvent (which is a high vapor pressure solvent) while substantially leaving the first solvent and, after removing the second solvent, removing the first solvent by heating the resulting composition at a temperature either above or below the boiling point of the first solvent to form the dry SOF film.

**[00166]** The term "substantially removing" refers to, for example, the removal of at least 90% of the respective solvent, such as about 95% of the respective solvent. The term "substantially leaving" refers to, for example, the removal of no more than 2% of the respective solvent, such as removal of no more than 1% of the respective solvent.

**[00167]** These mixed liquids may be used to slow or speed up the rate of conversion of the wet layer to the SOF in order to manipulate the characteristics of the SOFs. For example, in condensation and addition/elimination linking chemistries, liquids such as water, 1°, 2°, or 3° alcohols (such as methanol, ethanol, propanol, isopropanol, butanol, 1-methoxy-2-propanol, tert-butanol) may be used.

**[00168]** Optionally a catalyst may be present in the reaction mixture to assist the promotion of the wet layer to the dry SOF. Selection and use of the optional catalyst depends on the functional groups on the molecular building blocks. Catalysts may be homogeneous (dissolved) or heterogeneous (undissolved or partially dissolved) and include Brönsted acids (HCl (aq), acetic acid, p-toluenesulfonic acid, amine-protected p-toluenesulfonic acid such as pyrridium p-toluenesulfonate,

trifluoroacetic acid); Lewis acids (boron trifluoroetherate, aluminum trichloride); Brönsted bases (metal hydroxides such as sodium hydroxide, lithium hydroxide, potassium hydroxide; 1°, 2°, or 3° amines such as butylamine, diisopropylamine, triethylamine, diisopropylethylamine); Lewis bases (*N,N*-dimethyl-4-aminopyridine); metals (Cu bronze); metal salts (FeCl<sub>3</sub>, AuCl<sub>3</sub>); and metal complexes (ligated palladium complexes, ligated ruthenium catalysts). Typical catalyst loading ranges from about 0.01% to about 25%, such as from about 0.1% to about 5% of the molecular building block loading in the reaction mixture. The catalyst may or may not be present in the final SOF composition.

**[00169]** Optionally additives or secondary components, such as dopants, may be present in the reaction mixture and wet layer. Such additives or secondary components may also be integrated into a dry SOF. Additives or secondary components can be homogeneous or heterogeneous in the reaction mixture and wet layer or in a dry SOF. The terms "additive" or "secondary component," refer, for example, to atoms or molecules that are not covalently bound in the SOF, but are randomly distributed in the composition. In embodiments, secondary components such as conventional additives may be used to take advantage of the known properties associated with such conventional additives. Such additives may be used to alter the physical properties of the SOF such as electrical properties (conductivity, semiconductivity, electron transport, hole transport), surface energy (hydrophobicity, hydrophilicity), tensile strength, and thermal conductivity; such additives may include impact modifiers, reinforcing fibers, lubricants, antistatic agents, coupling agents, wetting agents, antifogging agents, flame retardants, ultraviolet stabilizers, antioxidants, biocides, dyes, pigments, odorants, deodorants, nucleating agents and the like.

**[00170]** In embodiments, the SOF may contain antioxidants as a secondary component to protect the SOF from oxidation. Examples of suitable antioxidants include (1) *N,N'*-hexamethylene bis(3,5-di-*tert*-butyl-4-hydroxy hydrocinnamamide) (IRGANOX 1098, available from Ciba-Geigy Corporation), (2) 2,2-bis(4-(2-(3,5-di-*tert*-butyl-4-hydroxyhydrocinnamoyloxy) )ethoxyphenyl) propane (TOPANOL-205, available from ICI America Corporation), (3) tris(4-*tert*-butyl-3-hydroxy-2,6-dimethyl

benzyl) isocyanurate (CYANOX 1790, 41,322-4, LTDP, Aldrich D12,840-6), (4) 2,2'-ethylidene bis(4,6-di-tert-butylphenyl) fluoro phosphonite (ETHANOX-398, available from Ethyl Corporation), (5) tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenyl diphosphonite (ALDRICH 46,852-5; hardness value 90), (6) pentaerythritol tetrastearate (TCI America #PO739), (7) tributylammonium hypophosphite (Aldrich 42,009-3), (8) 2,6-di-tert-butyl-4-methoxyphenol (Aldrich 25,106-2), (9) 2,4-di-tert-butyl-6-(4-methoxybenzyl) phenol (Aldrich 23,008-1), (10) 4-bromo-2,6-dimethylphenol (Aldrich 34,951-8), (11) 4-bromo-3,5-dimethylphenol (Aldrich B6,420-2), (12) 4-bromo-2-nitrophenol (Aldrich 30,987-7), (13) 4-(diethyl aminomethyl)-2,5-dimethylphenol (Aldrich 14,668-4), (14) 3-dimethylaminophenol (Aldrich D14,400-2), (15) 2-amino-4-tert-amylphenol (Aldrich 41,258-9), (16) 2,6-bis(hydroxymethyl)-p-cresol (Aldrich 22,752-8), (17) 2,2'-methylenediphenol (Aldrich B4,680-8), (18) 5-(diethylamino)-2-nitrosophenol (Aldrich 26,951-4), (19) 2,6-dichloro-4-fluorophenol (Aldrich 28,435-1), (20) 2,6-dibromo fluoro phenol (Aldrich 26,003-7), (21)  $\alpha$  trifluoro-o-cresol (Aldrich 21,979-7), (22) 2-bromo-4-fluorophenol (Aldrich 30,246-5), (23) 4-fluorophenol (Aldrich F1,320-7), (24) 4-chlorophenyl-2-chloro-1,1,2-tri-fluoroethyl sulfone (Aldrich 13,823-1), (25) 3,4-difluoro phenylacetic acid (Aldrich 29,043-2), (26) 3-fluorophenylacetic acid (Aldrich 24,804-5), (27) 3,5-difluoro phenylacetic acid (Aldrich 29,044-0), (28) 2-fluorophenylacetic acid (Aldrich 20,894-9), (29) 2,5-bis (trifluoromethyl) benzoic acid (Aldrich 32,527-9), (30) ethyl-2-(4-(4-(trifluoromethyl) phenoxy) phenoxy) propionate (Aldrich 25,074-0), (31) tetrakis (2,4-di-tert-butyl phenyl)-4,4'-biphenyl diphosphonite (Aldrich 46,852-5), (32) 4-tert-amyl phenol (Aldrich 15,384-2), (33) 3-(2H-benzotriazol-2-yl)-4-hydroxy phenethylalcohol (Aldrich 43,071-4), NAUGARD 76, NAUGARD 445, NAUGARD 512, and NAUGARD 524 (manufactured by Uniroyal Chemical Company), and the like, as well as mixtures thereof. The antioxidant, when present, may be present in the SOF composite in any desired or effective amount, such as from about 0.25 percent to about 10 percent by weight of the SOF or from about 1 percent to about 5 percent by weight of the SOF.

**[00171]** In embodiments, the SOF may further comprise any suitable polymeric material known in the art as a secondary component, such as polycarbonates, acrylate

polymers, vinyl polymers, cellulose polymers, polyesters, polysiloxanes, polyamides, polyurethanes, polystyrenes, polystyrene, polyolefins, fluorinated hydrocarbons (fluorocarbons), and engineered resins as well as block, random or alternating copolymers thereof. The SOF composite may comprise homopolymers, higher order polymers, or mixtures thereof, and may comprise one species of polymeric material or mixtures of multiple species of polymeric material, such as mixtures of two, three, four, five or more multiple species of polymeric material. In embodiments, suitable examples of the about polymers include, for example, crystalline and amorphous polymers, or a mixtures thereof. In embodiments, the polymer is a fluoroelastomer.

**[00172]** Suitable fluoroelastomers are those described in detail in U.S. Patents Nos. 5,166,031, 5,281,506, 5,366,772, 5,370,931, 4,257,699, 5,017,432 and 5,061,965. The amount of fluoroelastomer compound present in the SOF, in weight percent total solids, is from about 1 to about 50 percent, or from about 2 to about 10 percent by weight of the SOF. Total solids, as used herein, includes the amount of secondary components and SOF.

**[00173]** In embodiments, examples of styrene-based monomer and acrylate-based monomers include, for example, poly(styrene-alkyl acrylate), poly(styrene-1,3-diene), poly(styrene-alkyl methacrylate), poly(styrene-alkyl acrylate-acrylic acid), poly(styrene-1,3-diene-acrylic acid), poly(styrene-alkyl methacrylate-acrylic acid), poly(alkyl methacrylate-alkyl acrylate), poly(alkyl methacrylate-aryl acrylate), poly(aryl methacrylate-alkyl acrylate), poly(alkyl methacrylate-acrylic acid), poly(styrene-alkyl acrylate-acrylonitrile-acrylic acid), poly(styrene-1,3-diene-acrylonitrile-acrylic acid), poly(alkyl acrylate-acrylonitrile-acrylic acid), poly(styrene-butadiene), poly(methylstyrene-butadiene), poly(methyl methacrylate-butadiene), poly(ethyl methacrylate-butadiene), poly(propyl methacrylate-butadiene), poly(butyl methacrylate-butadiene), poly(methyl acrylate-butadiene), poly(ethyl acrylate-butadiene), poly(propyl acrylate-butadiene), poly(butyl acrylate-butadiene), poly(styrene-isoprene), poly(methylstyrene-isoprene), poly(methyl methacrylate-isoprene), poly(ethyl methacrylate-isoprene), poly(propyl methacrylate-isoprene), poly(butyl methacrylate-isoprene), poly(methyl acrylate-isoprene), poly(ethyl

acrylate-isoprene), poly(propyl acrylate-isoprene), and poly(butyl acrylate-isoprene); poly(styrene-propyl acrylate), poly(styrene-butyl acrylate), poly(styrene-butadiene-acrylic acid), poly(styrene-butadiene-methacrylic acid), poly(styrene-butadiene-acrylonitrile-acrylic acid), poly(styrene-butyl acrylate-acrylic acid), poly(styrene-butyl acrylate-methacrylic acid), poly(styrene-butyl acrylate-acrylonitrile), poly(styrene-butyl acrylate-acrylonitrile-acrylic acid), and other similar polymers.

**[00174]** Further examples of the various polymers that are suitable for use as a secondary component in SOFs include polyethylene terephthalate, polybutadienes, polysulfones, polyarylethers, polyarylsulfones, polyethersulfones, polycarbonates, polyethylenes, polypropylenes, polydecene, polydodecene, polytetradecene, polyhexadecene, polyoctadene, and polycyclododecene, polyolefin copolymers, mixtures of polyolefins, functional polyolefins, acidic polyolefins, branched polyolefins, polymethylpentenes, polyphenylene sulfides, polyvinyl acetates, polyvinylbutyrals, polysiloxanes, polyacrylates, polyvinyl acetals, polyamides, polyimides, polystyrene and acrylonitrile copolymers, polyvinylchlorides, polyvinyl alcohols, poly-N-vinylpyrrolidinone)s, vinylchloride and vinyl acetate copolymers, acrylate copolymers, poly(amideimide), styrene-butadiene copolymers, vinylidenechloride-vinylchloride copolymers, vinylacetate-vinylidenechloride copolymers, polyvinylcarbazoles, polyethylene-terephthalate, polypropylene-terephthalate, polybutylene-terephthalate, polypentylene-terephthalate, polyhexalene-terephthalate, polyheptadene-terephthalate, polyoctalene-terephthalate, polyethylene-sebacate, polypropylene sebacate, polybutylene-sebacate, polyethylene-adipate, polypropylene-adipate, polybutylene-adipate, polypentylene-adipate, polyhexalene-adipate, polyheptadene-adipate, polyoctalene-adipate, polyethylene-glutarate, polypropylene-glutarate, polybutylene-glutarate, polypentylene-glutarate, polyhexalene-glutarate, polyheptadene-glutarate, polyoctalene-glutarate polyethylene-pimelate, polypropylene-pimelate, polybutylene-pimelate, polypentylene-pimelate, polyhexalene-pimelate, polyheptadene-pimelate, poly(propoxylated bisphenol-fumarate), poly(propoxylated bisphenol-succinate), poly(propoxylated bisphenol-adipate), poly(propoxylated bisphenol-glutarate), SPAR<sup>TM</sup> (Dixie Chemicals), BECKOSOL<sup>TM</sup> (Reichhold Chemical Inc), ARAKOTE<sup>TM</sup> (Ciba-Geigy Corporation),

HETRON<sup>TM</sup> (Ashland Chemical), PARAPLEX<sup>TM</sup> (Rohm & Hass), POLYLITE<sup>TM</sup> (Reichhold Chemical Inc), PLASTHALL<sup>TM</sup> (Rohm & Hass), CYGAL<sup>TM</sup> (American Cyanamide), ARMCO<sup>TM</sup> (Armco Composites), ARPOL<sup>TM</sup> (Ashland Chemical), CELANEX<sup>TM</sup> (Celanese Eng), RYNITE<sup>TM</sup> (DuPont), STYPOL<sup>TM</sup> (Freeman Chemical Corporation) mixtures thereof and the like.

**[00175]** In embodiments, the secondary components, including polymers may be distributed homogeneously, or heterogeneously, such as in a linear or nonlinear gradient in the SOF. In embodiments, the polymers may be incorporated into the SOF in the form of a fiber, or a particle whose size may range from about 50 nm to about 2 mm. The polymers, when present, may be present in the SOF composite in any desired or effective amount, such as from about 1 percent to about 50 percent by weight of the SOF or from about 1 percent to about 15 percent by weight of the SOF.

**[00176]** In embodiments, the SOF may further comprise carbon nanotubes or nanofiber aggregates, which are microscopic particulate structures of nanotubes, as described in U.S. Patent Nos. 5,165,909; 5,456,897; 5,707,916; 5,877,110; 5,110,693; 5,500,200 and 5,569,635.

**[00177]** In embodiments, the SOF may further comprise metal particles as a secondary component; such metal particles include noble and non-noble metals and their alloys. Examples of suitable noble metals include, aluminum, titanium, gold, silver, platinum, palladium and their alloys. Examples of suitable non-noble metals include, copper, nickel, cobalt, lead, iron, bismuth, zinc, ruthenium, rhodium, rubidium, indium, and their alloys. The size of the metal particles may range from about 1 nm to 1 mm and their surfaces may be modified by stabilizing molecules or dispersant molecules or the like. The metal particles, when present, may be present in the SOF composite in any desired or effective amount, such as from about 0.25 percent to about 70 percent by weight of the SOF or from about 1 percent to about 15 percent by weight of the SOF.

**[00178]** In embodiments, the SOF may further comprise oxides and sulfides as a secondary components. Examples of suitable metal oxides include, titanium dioxide (titania, rutile and related polymorphs), aluminum oxide including alumina,

hydradated alumina, and the like, silicon oxide including silica, quartz, cristobalite, and the like, aluminosilicates including zeolites, talcs, and clays, nickel oxide, iron oxide, cobalt oxide. Other examples of oxides include glasses, such as silica glass, borosilicate glass, aluminosilicate glass and the like. Examples of suitable sulfides include nickel sulfide, lead sulfide, cadmium sulfide, tin sulfide, and cobalt sulfide. The diameter of the oxide and sulfide materials may range from about 50 nm to 1 mm and their surfaces may be modified by stabilizing molecules or dispersant molecules or the like. The oxides, when present, may be present in the SOF composite in any desired or effective amount, such as from about 0.25 percent to about 20 percent by weight of the SOF or from about 1 percent to about 15 percent by weight of the SOF.

**[00179]** In embodiments, the SOF may further comprise metalloid or metal-like elements from the periodic table. Examples of suitable metalloid elements include, silicon, selenium, tellurium, tin, lead, germanium, gallium, arsenic, antimony and their alloys or intermetallics. The size of the metal particles may range from about 10 nm to 1 mm and their surfaces may be modified by stabilizing molecules or dispersant molecules or the like. The metalloid particles, when present, may be present in the SOF composite in any desired or effective amount, such as from about 0.25 percent to about 10 percent by weight of the SOF or from about 1 percent to about 5 percent by weight of the SOF.

**[00180]** In embodiments, the SOF may further comprise hole transport molecules or electron acceptors as a secondary component, such charge transport molecules include for example a positive hole transporting material selected from compounds having in the main chain or the side chain a polycyclic aromatic ring such as anthracene, pyrene, phenanthrene, coronene, and the like, or a nitrogen-containing hetero ring such as indole, carbazole, oxazole, isoxazole, thiazole, imidazole, pyrazole, oxadiazole, pyrazoline, thiadiazole, triazole, and hydrazone compounds. Typical hole transport materials include electron donor materials, such as carbazole; N-ethyl carbazole; N-isopropyl carbazole; N-phenyl carbazole; tetraphenylpyrene; 1-methyl pyrene; perylene; chrysene; anthracene; tetraphene; 2-phenyl naphthalene; azopyrene; 1-ethyl pyrene; acetyl pyrene; 2,3-benzochrysene; 2,4-benzopyrene; 1,4-bromopyrene; poly (N-vinylcarbazole); poly(vinylpyrene); poly(vinyltetraphene);

poly(vinyltetracene) and poly(vinylperylene). Suitable electron transport materials include electron acceptors such as 2,4,7-trinitro-9-fluorenone; 2,4,5,7-tetranitro-fluorenone; dinitroanthracene; dinitroacridene; tetracyanopyrene; dinitroanthraquinone; and butylcarbonylfluorenemalononitrile, see U.S. Patent No. 4,921,769. Other hole transporting materials include arylamines described in U.S. Patent No. 4,265,990, such as N,N'-diphenyl-N,N'-bis(alkylphenyl)-(1,1'-biphenyl)-4,4'-diamine wherein alkyl is selected from the group consisting of methyl, ethyl, propyl, butyl, hexyl, and the like. Hole transport molecules of the type described in, for example, U.S. Patents Nos. 4,306,008; 4,304,829; 4,233,384; 4,115,116; 4,299,897; 4,081,274, and 5,139,910. Other known charge transport layer molecules may be selected, reference for example U.S. Patent Nos. 4,921,773 and 4,464,450. The hole transport molecules or electron acceptors, when present, may be present in the SOF composite in any desired or effective amount, such as from about 0.25 percent to about 50 percent by weight of the SOF or from about 1 percent to about 20 percent by weight of the SOF.

**[00181]** In embodiments, the SOF may further comprise biocides as a secondary component. Biocides may be present in amounts of from about 0.1 to about 1.0 percent by weight of the SOF. Suitable biocides include, for example, sorbic acid, 1-(3-chloroallyl)-3,5,7-triaza-1-azoniaadamantane chloride, commercially available as DOWICIL 200 (Dow Chemical Company), vinylene-bis thiocyanate, commercially available as CYTOX 3711 (American Cyanamid Company), disodium ethylenebis-dithiocarbamate, commercially available as DITHONE D14 (Rohm & Haas Company), bis(trichloromethyl)sulfone, commercially available as BIOCID N-1386 (Stauffer Chemical Company), zinc pyridinethione, commercially available as zinc omadine (Olin Corporation), 2-bromo-t-nitropropane-1,3-diol, commercially available as ONYXIDE 500 (Onyx Chemical Company), BOSQUAT MB50 (Louza, Inc.), and the like.

**[00182]** In embodiments, the SOF may further comprise small organic molecules as a secondary component; such small organic molecules include those discussed above with respect to the first and second solvents. The small organic molecules, when present, may be present in the SOF in any desired or effective amount, such as from about 0.25 percent to about 50 percent by weight of the SOF or from about 1 percent to about 10 percent by weight of the SOF.

**[00183]** When present, the secondary components or additives may each, or in combination, be present in the composition in any desired or effective amount, such as from about 1 percent to about 50 percent by weight of the composition or from about 1 percent to about 20 percent by weight of the composition.

**[00184]** SOFs may be modified with secondary components (dopants and additives, such as, hole transport molecules (mTBD), polymers (polystyrene), nanoparticles (C60 Buckminster fullerene), small organic molecules (biphenyl), metal particles (copper micropowder), and electron acceptors (quinone)) to give composite structured organic films. Secondary components may be introduced to the liquid formulation that is used to generate a wet film in which a change is promoted to form the SOF. Secondary components (dopants, additives, etc.) may either be dissolved or undissolved (suspended) in the reaction mixture. Secondary components are not bonded into the network of the film. For example, a secondary component may be added to a reaction mixture that contains a plurality of building blocks having four methoxy groups (-OMe) on a segment, such as N4,N4,N4',N4'-tetra-*p*-tolylbiphenyl-4,4'-diamine, which upon promotion of a change in the wet film, exclusively react with the two alcohol (-OH) groups on a building block, such as 1,4-benzenedimethanol, which contains a *p*-xylyl segment. The chemistry that is occurring to link building blocks is an acid catalyzed transesterification reaction. Because -OH groups will only react with -OMe groups (and vice versa) and not with the secondary component, these molecular building blocks can only follow one pathway. Therefore, the SOF is programmed to order molecules in a way that leaves the secondary component incorporated within and/or around the SOF structure. This ability to pattern molecules and incorporate secondary components affords superior

performance and unprecedented control over properties compared to conventional polymers and available alternatives.

**[00185]** Optionally additives or secondary components, such as dopants, may be present in the reaction mixture and wet layer. Such additives or secondary components may also be integrated into a dry SOF. Additives or secondary components can be homogeneous or heterogeneous in the reaction mixture and wet layer or in a dry SOF. In contrast to capping units, the terms "additive" or "secondary component," refer, for example, to atoms or molecules that are not covalently bound in the SOF, but are randomly distributed in the composition. Suitable secondary components and additives are described in U.S. Patent Application Serial No. 12/716,324, entitled "Composite Structured Organic Films".

**[00186]** In embodiments, the secondary components may have similar or disparate properties to accentuate or hybridize (synergistic effects or ameliorative effects as well as the ability to attenuate inherent or inclined properties of the capped SOF) the intended property of the capped SOF to enable it to meet performance targets. For example, doping the capped SOFs with antioxidant compounds will extend the life of the capped SOF by preventing chemical degradation pathways. Additionally, additives maybe added to improve the morphological properties of the capped SOF by tuning the reaction occurring during the promotion of the change of the reaction mixture to form the capped SOF.

**[00187]      **Process Action B: Depositing the Reaction Mixture as a Wet Film****

**[00188]** The reaction mixture may be applied as a wet film to a variety of substrates using a number of liquid deposition techniques. The thickness of the SOF is dependant on the thickness of the wet film and the molecular building block loading in the reaction mixture. The thickness of the wet film is dependent on the viscosity of the reaction mixture and the method used to deposit the reaction mixture as a wet film.

**[00190]** Substrates include, for example, polymers, papers, metals and metal alloys, doped and undoped forms of elements from Groups III-VI of the periodic

table, metal oxides, metal chalcogenides, and previously prepared SOFs or capped SOFs. Examples of polymer film substrates include polyesters, polyolefins, polycarbonates, polystyrenes, polyvinylchloride, block and random copolymers thereof, and the like. Examples of metallic surfaces include metallized polymers, metal foils, metal plates; mixed material substrates such as metals patterned or deposited on polymer, semiconductor, metal oxide, or glass substrates. Examples of substrates comprised of doped and undoped elements from Groups III-VI of the periodic table include, aluminum, silicon, silicon n-doped with phosphorous, silicon p-doped with boron, tin, gallium arsenide, lead, gallium indium phosphide, and indium. Examples of metal oxides include silicon dioxide, titanium dioxide, indium tin oxide, tin dioxide, selenium dioxide, and alumina. Examples of metal chalcogenides include cadmium sulfide, cadmium telluride, and zinc selenide. Additionally, it is appreciated that chemically treated or mechanically modified forms of the above substrates remain within the scope of surfaces which may be coated with the reaction mixture.

**[00190]** In embodiments, the substrate may be composed of, for example, silicon, glass plate, plastic film or sheet. For structurally flexible devices, a plastic substrate such as polyester, polycarbonate, polyimide sheets and the like may be used. The thickness of the substrate may be from around 10 micrometers to over 10 millimeters with an exemplary thickness being from about 50 to about 100 micrometers, especially for a flexible plastic substrate, and from about 1 to about 10 millimeters for a rigid substrate such as glass or silicon.

**[00191]** The reaction mixture may be applied to the substrate using a number of liquid deposition techniques including, for example, spin coating, blade coating, web coating, dip coating, cup coating, rod coating, screen printing, ink jet printing, spray coating, stamping and the like. The method used to deposit the wet layer depends on the nature, size, and shape of the substrate and the desired wet layer thickness. The thickness of the wet layer can range from about 10 nm to about 5 mm, such as from about 100 nm to about 1 mm, or from about 1  $\mu\text{m}$  to about 500  $\mu\text{m}$ .

**[00192]** In embodiments, the capping unit and/or secondary component may be introduced following completion of the above described process action B. The

incorporation of the capping unit and/or secondary component in this way may be accomplished by any means that serves to distribute the capping unit and/or secondary component homogeneously, heterogeneously, or as a specific pattern over the wet film. Following introduction of the capping unit and/or secondary component subsequent process actions may be carried out resuming with process action C.

**[00193]** For example, following completion of process action B (i.e., after the reaction mixture may be applied to the substrate), capping unit(s) and/or secondary components (dopants, additives, etc.) may be added to the wet layer by any suitable method, such as by distributing (e.g., dusting, spraying, pouring, sprinkling, etc, depending on whether the capping unit and/or secondary component is a particle, powder or liquid) the capping unit(s) and/or secondary component on the top the wet layer. The capping units and/or secondary components may be applied to the formed wet layer in a homogeneous or heterogeneous manner, including various patterns, wherein the concentration or density of the capping unit(s) and/or secondary component is reduced in specific areas, such as to form a pattern of alternating bands of high and low concentrations of the capping unit(s) and/or secondary component of a given width on the wet layer. In embodiments, the application of the capping unit(s) and/or secondary component to the top of the wet layer may result in a portion of the capping unit(s) and/or secondary component diffusing or sinking into the wet layer and thereby forming a heterogeneous distribution of capping unit(s) and/or secondary component within the thickness of the SOF, such that a linear or nonlinear concentration gradient may be obtained in the resulting SOF obtained after promotion of the change of the wet layer to a dry SOF. In embodiments, a capping unit(s) and/or secondary component may be added to the top surface of a deposited wet layer, which upon promotion of a change in the wet film, results in an SOF having an heterogeneous distribution of the capping unit(s) and/or secondary component in the dry SOF. Depending on the density of the wet film and the density of the capping unit(s) and/or secondary component, a majority of the capping unit(s) and/or secondary component may end up in the upper half (which is opposite the substrate) of the dry SOF or a majority of the capping unit(s) and/or secondary component may end up in the lower half (which is adjacent to the substrate) of the dry SOF.

**[00194] Process Action C: Promoting the Change of Wet Film to the Dry SOF**

**[00195]** The term “promoting” refers, for example, to any suitable technique to facilitate a reaction of the molecular building blocks and/or pre-SOFs, such as a chemical reaction of the functional groups of the building blocks and/or pre-SOFs. In the case where a liquid needs to be removed to form the dry film, “promoting” also refers to removal of the liquid. Reaction of the molecular building blocks and/or pre-SOFs and removal of the liquid can occur sequentially or concurrently. In certain embodiments, the liquid is also one of the molecular building blocks and is incorporated into the SOF. The term “dry SOF” refers, for example, to substantially dry SOFs, for example, to a liquid content less than about 5% by weight of the SOF, or to a liquid content less than 2% by weight of the SOF.

**[00196]** In embodiments, the dry SOF or a given region of the dry SOF (such as the surface to a depth equal to of about 10% of the thickness of the SOF or a depth equal to of about 5% of the thickness of the SOF, the upper quarter of the SOF, or the regions discussed above) has a molar ratio of capping units to segments of from about 1:100 to about 1:1, such as from about 1:50 to about 1:2, or from about 1:20 to 1:4.

**[00197]** Promoting the wet layer to form a dry SOF may be accomplished by any suitable technique. Promoting the wet layer to form a dry SOF typically involves thermal treatment including, for example, oven drying, infrared radiation (IR), and the like with temperatures ranging from 40 to 350°C and from 60 to 200°C and from 85 to 160°C. The total heating time can range from about four seconds to about 24 hours, such as from one minute to 120 minutes, or from three minutes to 60 minutes.

**[00198]** IR promotion of the wet layer to the COF film may be achieved using an IR heater module mounted over a belt transport system. Various types of IR emitters may be used, such as carbon IR emitters or short wave IR emitters (available from Heraerus). Additional exemplary information regarding carbon IR emitters or short wave IR emitters is summarized in the following Table (Table 1).

**Table 1: Information regarding carbon IR emitters or short wave IR emitters**

| <b>IR lamp</b>    | <b>Peak Wavelength</b>  | <b>Number of lamps</b> | <b>Module Power (kW)</b> |
|-------------------|-------------------------|------------------------|--------------------------|
| <b>Carbon</b>     | <b>2.0 micron</b>       | <b>2 – twin tube</b>   | <b>4.6</b>               |
| <b>Short wave</b> | <b>1.2 – 1.4 micron</b> | <b>3 – twin tube</b>   | <b>4.5</b>               |

**[00199] Process Action D: Optionally removing the SOF from the coating substrate to obtain a free-standing SOF**

**[00200]** In embodiments, a free-standing SOF is desired. Free-standing SOFs may be obtained when an appropriate low adhesion substrate is used to support the deposition of the wet layer. Appropriate substrates that have low adhesion to the SOF may include, for example, metal foils, metalized polymer substrates, release papers and SOFs, such as SOFs prepared with a surface that has been altered to have a low adhesion or a decreased propensity for adhesion or attachment. Removal of the SOF from the supporting substrate may be achieved in a number of ways by someone skilled in the art. For example, removal of the SOF from the substrate may occur by starting from a corner or edge of the film and optionally assisted by passing the substrate and SOF over a curved surface.

**[00201] Process Action E: Optionally processing the free-standing SOF into a roll**

**[00202]** Optionally, a free-standing SOF or a SOF supported by a flexible substrate may be processed into a roll. The SOF may be processed into a roll for storage, handling, and a variety of other purposes. The starting curvature of the roll is selected such that the SOF is not distorted or cracked during the rolling process.

**[00203] Process Action F: Optionally cutting and seaming the SOF into a shape, such as a belt**

**[00204]** The method for cutting and seaming the SOF is similar to that described in U.S. Patent No. 5,455,136 issued on October 3<sup>rd</sup>, 1995 (for polymer films). An SOF belt may be fabricated from a single SOF, a multi layer SOF or an SOF sheet cut from

a web. Such sheets may be rectangular in shape or any particular shape as desired. All sides of the SOF(s) may be of the same length, or one pair of parallel sides may be longer than the other pair of parallel sides. The SOF(s) may be fabricated into shapes, such as a belt by overlap joining the opposite marginal end regions of the SOF sheet. A seam is typically produced in the overlapping marginal end regions at the point of joining. Joining may be affected by any suitable means. Typical joining techniques include, for example, welding (including ultrasonic), gluing, taping, pressure heat fusing and the like. Methods, such as ultrasonic welding, are desirable general methods of joining flexible sheets because of their speed, cleanliness (no solvents) and production of a thin and narrow seam.

**[00205] Process Action G: Optionally Using a SOF as a Substrate for Subsequent SOF Formation Processes**

**[00206]** A SOF may be used as a substrate in the SOF forming process to afford a multi-layered structured organic film. The layers of a multi-layered SOF may be chemically bound in or in physical contact. Chemically bound, multi-layered SOFs are formed when functional groups present on the substrate SOF surface can react with the molecular building blocks present in the deposited wet layer used to form the second structured organic film layer. Multi-layered SOFs in physical contact may not chemically bound to one another.

**[00207]** A SOF substrate may optionally be chemically treated prior to the deposition of the wet layer to enable or promote chemical attachment of a second SOF layer to form a multi-layered structured organic film.

**[00208]** Alternatively, a SOF substrate may optionally be chemically treated prior to the deposition of the wet layer to disable chemical attachment of a second SOF layer (surface pacification) to form a physical contact multi-layered SOF.

**[00209]** Other methods, such as lamination of two or more SOFs, may also be used to prepare physically contacted multi-layered SOFs.

**[00210] Applications of SOFs**

**[00211] Application A: SOFs in Photoreceptor Layers for ink-based digital printing**

**[00212]** Representative structures of an electrophotographic imaging member (e.g., a photoreceptor) for ink-based digital printing are shown in FIGS. 1-3. These imaging members are provided with an anti-curl layer 1, a supporting substrate 2, an electrically conductive ground plane 3, a charge blocking layer 4, an adhesive layer 5, a charge generating layer 6, a charge transport layer 7, an overcoating layer 8 (or in this exemplary embodiment the outermost layer and imaging surface), and a ground strip 9. In FIG. 3, imaging layer 10 (containing both charge generating material and charge transport material) takes the place of separate charge generating layer 6 and charge transport layer 7.

**[00213]** As seen in the figures, in fabricating a photoreceptor, a charge generating material (CGM) and a charge transport material (CTM) may be deposited onto the substrate surface either in a laminate type configuration where the CGM and CTM are in different layers (e.g., FIGS. 1 and 2) or in a single layer configuration where the CGM and CTM are in the same layer (e.g., FIG. 3). In embodiments, the photoreceptors may be prepared by applying over the electrically conductive layer the charge generation layer 6 and, optionally, a charge transport layer 7. In embodiments, the charge generation layer and, when present, the charge transport layer, may be applied in either order.

**[00214] Anti Curl Layer**

**[00215]** For some applications, an optional anti-curl layer 1, which comprises film-forming organic or inorganic polymers that are electrically insulating or slightly semi-conductive, may be provided. The anti-curl layer provides flatness and/or abrasion resistance.

**[00216]** Anti-curl layer 1 may be formed at the back side of the substrate 2, opposite the imaging layers. The anti-curl layer may include, in addition to the film-forming resin, an adhesion promoter polyester additive. Examples of film-forming resins useful as the anti-curl layer include, but are not limited to, polyacrylate,

polystyrene, poly(4,4'-isopropylidene diphenylcarbonate), poly(4,4'-cyclohexylidene diphenylcarbonate), mixtures thereof and the like.

**[00217]** Additives may be present in the anti-curl layer in the range of about 0.5 to about 40 weight percent of the anti-curl layer. Additives include organic and inorganic particles that may further improve the wear resistance and/or provide charge relaxation property. Organic particles include Teflon powder, carbon black, and graphite particles. Inorganic particles include insulating and semiconducting metal oxide particles such as silica, zinc oxide, tin oxide and the like. Another semiconducting additive is the oxidized oligomer salts as described in U.S. Patent No. 5,853,906. The oligomer salts are oxidized N, N, N', N'-tetra-p-tolyl-4,4'-biphenyldiamine salt.

**[00218]** Typical adhesion promoters useful as additives include, but are not limited to, duPont 49,000 (duPont), Vitel PE-100, Vitel PE-200, Vitel PE-307 (Goodyear), mixtures thereof and the like. Usually from about 1 to about 15 weight percent adhesion promoter is selected for film-forming resin addition, based on the weight of the film-forming resin.

**[00219]** The thickness of the anti-curl layer is typically from about 3 micrometers to about 35 micrometers, such as from about 10 micrometers to about 20 micrometers, or about 14 micrometers.

**[00220]** The anti-curl coating may be applied as a solution prepared by dissolving the film-forming resin and the adhesion promoter in a solvent such as methylene chloride. The solution may be applied to the rear surface of the supporting substrate (the side opposite the imaging layers) of the photoreceptor device, for example, by web coating or by other methods known in the art. Coating of the overcoat layer and the anti-curl layer may be accomplished simultaneously by web coating onto a multilayer photoreceptor comprising a charge transport layer, charge generation layer, adhesive layer, blocking layer, ground plane and substrate. The wet film coating is then dried to produce the anti-curl layer 1.

**[00221]**      The Supporting Substrate

**[00222]**      As indicated above, the photoreceptors are prepared by first providing a substrate 2, i.e., a support. The substrate may be opaque or substantially transparent and may comprise any additional suitable material(s) having given required mechanical properties, such as those described in U.S. Patent Nos. 4,457,994; 4,871,634; 5,702,854; 5,976,744; and 7,384,717.

**[00223]**      The substrate may comprise a layer of electrically non-conductive material or a layer of electrically conductive material, such as an inorganic or organic composition. If a non-conductive material is employed, it may be necessary to provide an electrically conductive ground plane over such non-conductive material. If a conductive material is used as the substrate, a separate ground plane layer may not be necessary.

**[00224]**      The substrate may be flexible or rigid and may have any of a number of different configurations, such as, for example, a sheet, a scroll, an endless flexible belt, a web, a cylinder, and the like. The photoreceptor may be coated on a rigid, opaque, conducting substrate, such as an aluminum drum.

**[00225]**      Various resins may be used as electrically non-conducting materials, including, for example, polyesters, polycarbonates, polyamides, polyurethanes, and the like. Such a substrate may comprise a commercially available biaxially oriented polyester known as MYLAR™, available from E. I. duPont de Nemours & Co., MELINEX™, available from ICI Americas Inc., or HOSTAPHAN™, available from American Hoechst Corporation. Other materials of which the substrate may be comprised include polymeric materials, such as polyvinyl fluoride, available as TEDLAR™ from E. I. duPont de Nemours & Co., polyethylene and polypropylene, available as MARLEX™ from Phillips Petroleum Company, polyphenylene sulfide, RYTON™ available from Phillips Petroleum Company, and polyimides, available as KAPTON™ from E. I. duPont de Nemours & Co. The photoreceptor may also be coated on an insulating plastic drum, provided a conducting ground plane has

previously been coated on its surface, as described above. Such substrates may either be seamed or seamless.

**[00226]** When a conductive substrate is employed, any suitable conductive material may be used. For example, the conductive material can include, but is not limited to, metal flakes, powders or fibers, such as aluminum, titanium, nickel, chromium, brass, gold, stainless steel, carbon black, graphite, or the like, in a binder resin including metal oxides, sulfides, silicides, quaternary ammonium salt compositions, conductive polymers such as polyacetylene or its pyrolysis and molecular doped products, charge transfer complexes, and polyphenyl silane and molecular doped products from polyphenyl silane. A conducting plastic drum may be used, as well as the conducting metal drum made from a material such as aluminum.

**[00227]** The thickness of the substrate depends on numerous factors, including the required mechanical performance and economic considerations. The thickness of the substrate is typically within a range of from about 65 micrometers to about 150 micrometers, such as from about 75 micrometers to about 125 micrometers for optimum flexibility and minimum induced surface bending stress when cycled around small diameter rollers, e.g., 19 mm diameter rollers. The substrate for a flexible belt may be of substantial thickness, for example, over 200 micrometers, or of minimum thickness, for example, less than 50 micrometers, provided there are no adverse effects on the final photoconductive device. Where a drum is used, the thickness should be sufficient to provide the necessary rigidity. In embodiments, this may be from about 1 mm to about 6 mm.

**[00228]** The surface of the substrate to which a layer is to be applied may be cleaned to promote greater adhesion of such a layer. Cleaning may be effected, for example, by exposing the surface of the substrate layer to plasma discharge, ion bombardment, and the like. Other methods, such as solvent cleaning, may also be used.

**[00229]** Regardless of any technique employed to form a metal layer, a thin layer of metal oxide generally forms on the outer surface of most metals upon exposure to air. Thus, when other layers overlying the metal layer are characterized as

"contiguous" layers, it is intended that these overlying contiguous layers may, in fact, contact a thin metal oxide layer that has formed on the outer surface of the oxidizable metal layer.

**[00230]**      The Electrically Conductive Ground Plane

**[00231]**      As stated above, in embodiments, the photoreceptors prepared comprise a substrate that is either electrically conductive or electrically non-conductive. When a non-conductive substrate is employed, an electrically conductive ground plane 3 must be employed, and the ground plane acts as the conductive layer. When a conductive substrate is employed, the substrate may act as the conductive layer, although a conductive ground plane may also be provided.

**[00232]**      If an electrically conductive ground plane is used, it is positioned over the substrate. Suitable materials for the electrically conductive ground plane include, for example, aluminum, zirconium, niobium, tantalum, vanadium, hafnium, titanium, nickel, stainless steel, chromium, tungsten, molybdenum, copper, and the like, and mixtures and alloys thereof. In embodiments, aluminum, titanium, and zirconium may be used.

**[00233]**      The ground plane may be applied by known coating techniques, such as solution coating, vapor deposition, and sputtering. A method of applying an electrically conductive ground plane is by vacuum deposition. Other suitable methods may also be used.

**[00234]**      In embodiments, the thickness of the ground plane may vary over a substantially wide range, depending on the optical transparency and flexibility desired for the electrophotoconductive member. For example, for a flexible photoresponsive imaging device, the thickness of the conductive layer may be between about 20 angstroms and about 750 angstroms; such as, from about 50 angstroms to about 200 angstroms for an optimum combination of electrical conductivity, flexibility, and light transmission. However, the ground plane can, if desired, be opaque.

**[00235]**      The Charge Blocking Layer

**[00236]** After deposition of any electrically conductive ground plane layer, a charge blocking layer 4 may be applied thereto. Electron blocking layers for positively charged photoreceptors permit holes from the imaging surface of the photoreceptor to migrate toward the conductive layer. For negatively charged photoreceptors, any suitable hole blocking layer capable of forming a barrier to prevent hole injection from the conductive layer to the opposite photoconductive layer may be utilized.

**[00237]** If a blocking layer is employed, it may be positioned over the electrically conductive layer. The term "over," as used herein in connection with many different types of layers, should be understood as not being limited to instances wherein the layers are contiguous. Rather, the term "over" refers, for example, to the relative placement of the layers and encompasses the inclusion of unspecified intermediate layers.

**[00238]** The blocking layer 4 may include polymers such as polyvinyl butyral, epoxy resins, polyesters, polysiloxanes, polyamides, polyurethanes, and the like; nitrogen-containing siloxanes or nitrogen-containing titanium compounds, such as trimethoxysilyl propyl ethylene diamine, N-beta(aminoethyl) gamma-aminopropyl trimethoxy silane, isopropyl 4-aminobenzene sulfonyl titanate, di(dodecylbenzene sulfonyl) titanate, isopropyl di(4-aminobenzoyl)isostearoyl titanate, isopropyl tri(N-ethyl amino) titanate, isopropyl trianthranil titanate, isopropyl tri(N,N-dimethyl-ethyl amino) titanate, titanium-4-amino benzene sulfonate oxyacetate, titanium 4-aminobenzoate isostearate oxyacetate, gamma-aminobutyl methyl dimethoxy silane, gamma-aminopropyl methyl dimethoxy silane, and gamma-aminopropyl trimethoxy silane, as disclosed in U.S. Patent Nos. 4,338,387; 4,286,033; and 4,291,110.

**[00239]** The blocking layer may be continuous and may have a thickness ranging, for example, from about 0.01 to about 10 micrometers, such as from about 0.05 to about 5 micrometers.

**[00240]** The blocking layer 4 may be applied by any suitable technique, such as spraying, dip coating, draw bar coating, gravure coating, silk screening, air knife

coating, reverse roll coating, vacuum deposition, chemical treatment, and the like. For convenience in obtaining thin layers, the blocking layer may be applied in the form of a dilute solution, with the solvent being removed after deposition of the coating by conventional techniques, such as by vacuum, heating, and the like. Generally, a weight ratio of blocking layer material and solvent of between about 0.5:100 to about 30:100, such as about 5:100 to about 20:100, is satisfactory for spray and dip coating.

**[00241]** The present disclosure further provides a method for forming the electrophotographic photoreceptor, in which the charge blocking layer is formed by using a coating solution composed of the grain shaped particles, the needle shaped particles, the binder resin and an organic solvent.

**[00242]** The organic solvent may be a mixture of an azeotropic mixture of C<sub>1-3</sub> lower alcohol and another organic solvent selected from the group consisting of dichloromethane, chloroform, 1,2-dichloroethane, 1,2-dichloropropane, toluene and tetrahydrofuran. The azeotropic mixture mentioned above is a mixture solution in which a composition of the liquid phase and a composition of the vapor phase are coincided with each other at a certain pressure to give a mixture having a constant boiling point. For example, a mixture consisting of 35 parts by weight of methanol and 65 parts by weight of 1,2-dichloroethane is an azeotropic solution. The presence of an azeotropic composition leads to uniform evaporation, thereby forming a uniform charge blocking layer without coating defects and improving storage stability of the charge blocking coating solution.

**[00243]** The binder resin contained in the blocking layer may be formed of the same materials as that of the blocking layer formed as a single resin layer. Among them, polyamide resin may be used because it satisfies various conditions required of the binder resin such as (i) polyamide resin is neither dissolved nor swollen in a solution used for forming the imaging layer on the blocking layer, and (ii) polyamide resin has an excellent adhesiveness with a conductive support as well as flexibility. In the polyamide resin, alcohol soluble nylon resin may be used, for example, copolymer nylon polymerized with 6-nylon, 6,6-nylon, 610-nylon, 11-nylon, 12-nylon and the like; and nylon which is chemically denatured such as N-alkoxy methyl denatured

nylon and N-alkoxy ethyl denatured nylon. Another type of binder resin that may be used is a phenolic resin or polyvinyl butyral resin.

**[00244]** The charge blocking layer is formed by dispersing the binder resin, the grain shaped particles, and the needle shaped particles in the solvent to form a coating solution for the blocking layer; coating the conductive support with the coating solution and drying it. The solvent is selected for improving dispersion in the solvent and for preventing the coating solution from gelation with the elapse of time. Further, the azeotropic solvent may be used for preventing the composition of the coating solution from being changed as time passes, whereby storage stability of the coating solution may be improved and the coating solution may be reproduced.

**[00245]** The phrase “n-type” refers, for example, to materials which predominately transport electrons. Typical n-type materials include dibromoanthanthrone, benzimidazole perylene, zinc oxide, titanium oxide, azo compounds such as chlorodiane Blue and bisazo pigments, substituted 2,4-dibromotriazines, polynuclear aromatic quinones, zinc sulfide, and the like.

**[00246]** The phrase “p-type” refers, for example, to materials which transport holes. Typical p-type organic pigments include, for example, metal-free phthalocyanine, titanyl phthalocyanine, gallium phthalocyanine, hydroxy gallium phthalocyanine, chlorogallium phthalocyanine, copper phthalocyanine, and the like.

**[00247]** The Adhesive Layer

**[00248]** An intermediate layer 5 between the blocking layer and the charge generating layer may, if desired, be provided to promote adhesion. However, in embodiments, a dip coated aluminum drum may be utilized without an adhesive layer.

**[00249]** Additionally, adhesive layers may be provided, if necessary, between any of the layers in the photoreceptors to ensure adhesion of any adjacent layers. Alternatively, or in addition, adhesive material may be incorporated into one or both of the respective layers to be adhered. Such optional adhesive layers may have thicknesses of about 0.001 micrometer to about 0.2 micrometer. Such an adhesive layer may be applied, for example, by dissolving adhesive material in an appropriate solvent, applying by hand, spraying, dip coating, draw bar coating, gravure coating,

silk screening, air knife coating, vacuum deposition, chemical treatment, roll coating, wire wound rod coating, and the like, and drying to remove the solvent. Suitable adhesives include, for example, film-forming polymers, such as polyester, dupont 49,000 (available from E. I. duPont de Nemours & Co.), Vitel PE-100 (available from Goodyear Tire and Rubber Co.), polyvinyl butyral, polyvinyl pyrrolidone, polyurethane, polymethyl methacrylate, and the like. The adhesive layer may be composed of a polyester with a  $M_w$  of from about 50,000 to about 100,000, such as about 70,000, and a  $M_n$  of about 35,000.

**[00250]**      The Imaging Layer(s)

**[00251]**      The imaging layer refers to a layer or layers containing charge generating material, charge transport material, or both the charge generating material and the charge transport material. In embodiments, the imaging surface may be the imaging layer or a particular component thereof. In embodiments, the outermost layer or outer layer of the imaging member may be the imaging layer or a particular component thereof.

**[00252]**      Either a n-type or a p-type charge generating material may be employed in the present photoreceptor.

**[00253]**      In the case where the charge generating material and the charge transport material are in different layers - for example a charge generation layer and a charge transport layer – the charge transport layer may comprise a SOF. Further, in the case where the charge generating material and the charge transport material are in the same layer, this layer may comprise a SOF.

**[00254]**      Charge Generation Layer

**[00255]**      Illustrative organic photoconductive charge generating materials include azo pigments such as Sudan Red, Dian Blue, Janus Green B, and the like; quinone pigments such as Algol Yellow, Pyrene Quinone, Indanthrene Brilliant Violet RRP, and the like; quinocyanine pigments; perylene pigments such as benzimidazole perylene; indigo pigments such as indigo, thioindigo, and the like; bisbenzoimidazole pigments such as Indofast Orange, and the like; phthalocyanine pigments such as copper phthalocyanine, aluminochloro-phthalocyanine, hydroxygallium

phthalocyanine, chlorogallium phthalocyanine, titanyl phthalocyanine and the like; quinacridone pigments; or azulene compounds. Suitable inorganic photoconductive charge generating materials include for example cadmium sulfide, cadmium sulfoselenide, cadmium selenide, crystalline and amorphous selenium, lead oxide and other chalcogenides. In embodiments, alloys of selenium may be used and include for instance selenium-arsenic, selenium-tellurium-arsenic, and selenium-tellurium.

**[00256]** Any suitable inactive resin binder material may be employed in the charge generating layer. Typical organic resinous binders include polycarbonates, acrylate polymers, methacrylate polymers, vinyl polymers, cellulose polymers, polyesters, polysiloxanes, polyamides, polyurethanes, epoxies, polyvinylacetals, and the like.

**[00257]** To create a dispersion useful as a coating composition, a solvent is used with the charge generating material. The solvent may be for example cyclohexanone, methyl ethyl ketone, tetrahydrofuran, alkyl acetate, and mixtures thereof. The alkyl acetate (such as butyl acetate and amyl acetate) can have from 3 to 5 carbon atoms in the alkyl group. The amount of solvent in the composition ranges for example from about 70% to about 98% by weight, based on the weight of the composition.

**[00258]** The amount of the charge generating material in the composition ranges for example from about 0.5% to about 30% by weight, based on the weight of the composition including a solvent. The amount of photoconductive particles (i.e., the charge generating material) dispersed in a dried photoconductive coating varies to some extent with the specific photoconductive pigment particles selected. For example, when phthalocyanine organic pigments such as titanyl phthalocyanine and metal-free phthalocyanine are utilized, satisfactory results are achieved when the dried photoconductive coating comprises between about 30 percent by weight and about 90 percent by weight of all phthalocyanine pigments based on the total weight of the dried photoconductive coating. Because the photoconductive characteristics are affected by the relative amount of pigment per square centimeter coated, a lower pigment loading may be utilized if the dried photoconductive coating layer is thicker.

Conversely, higher pigment loadings are desirable where the dried photoconductive layer is to be thinner.

**[00259]** Generally, satisfactory results are achieved with an average photoconductive particle size of less than about 0.6 micrometer when the photoconductive coating is applied by dip coating. The average photoconductive particle size may be less than about 0.4 micrometer. In embodiments, the photoconductive particle size is also less than the thickness of the dried photoconductive coating in which it is dispersed.

**[00260]** In a charge generating layer, the weight ratio of the charge generating material ("CGM") to the binder ranges from 30 (CGM):70 (binder) to 70 (CGM):30 (binder).

**[00261]** For multilayered photoreceptors comprising a charge generating layer (also referred herein as a photoconductive layer) and a charge transport layer, satisfactory results may be achieved with a dried photoconductive layer coating thickness of between about 0.1 micrometer and about 10 micrometers, such as from about 1 to about 10 microns thick. In embodiments, the photoconductive layer thickness is between about 0.2 micrometer and about 4 micrometers. However, these thicknesses also depend upon the pigment loading. Thus, higher pigment loadings permit the use of thinner photoconductive coatings. Thicknesses outside these ranges may be selected providing the objectives of the present invention are achieved.

**[00262]** Any suitable technique may be utilized to disperse the photoconductive particles in the binder and solvent of the coating composition. Typical dispersion techniques include, for example, ball milling, roll milling, milling in vertical attritors, sand milling, and the like. Typical milling times using a ball roll mill is between about 4 and about 6 days.

**[00263]** Charge transport materials include an organic polymer, a non-polymeric material, or a SOF capable of supporting the injection of photoexcited holes or transporting electrons from the photoconductive material and allowing the transport of these holes or electrons through the organic layer to selectively dissipate a surface charge.

**[00264]**      Organic Polymer Charge Transport Layer

**[00265]**      Illustrative charge transport materials include for example a positive hole transporting material selected from compounds having in the main chain or the side chain a polycyclic aromatic ring such as anthracene, pyrene, phenanthrene, coronene, and the like, or a nitrogen-containing hetero ring such as indole, carbazole, oxazole, isoxazole, thiazole, imidazole, pyrazole, oxadiazole, pyrazoline, thiadiazole, triazole, and hydrazone compounds. Typical hole transport materials include electron donor materials, such as carbazole; N-ethyl carbazole; N-isopropyl carbazole; N-phenyl carbazole; tetraphenylpyrene; 1-methyl pyrene; perylene; chrysene; anthracene; tetraphene; 2-phenyl naphthalene; azopyrene; 1-ethyl pyrene; acetyl pyrene; 2,3-benzochrysene; 2,4-benzopyrene; 1,4-bromopyrene; poly (N-vinylcarbazole); poly(vinylpyrene); poly(vinyltetraphene); poly(vinyltetracene) and poly(vinylperylene). Suitable electron transport materials include electron acceptors such as 2,4,7-trinitro-9-fluorenone; 2,4,5,7-tetranitro-fluorenone; dinitroanthracene; dinitroacridene; tetracyanopyrene; dinitroanthraquinone; and butylcarbonylfluorenemalononitrile, see U.S. Patent No. 4,921,769. Other hole transporting materials include arylamines described in U.S. Patent No. 4,265,990, such as N,N'-diphenyl-N,N'-bis(alkylphenyl)-(1,1'-biphenyl)-4,4'-diamine wherein alkyl is selected from the group consisting of methyl, ethyl, propyl, butyl, hexyl, and the like. Other known charge transport layer molecules may be selected, reference for example U.S. Patent Nos. 4,921,773 and 4,464,450.

**[00266]**      Any suitable inactive resin binder may be employed in the charge transport layer. Typical inactive resin binders soluble in methylene chloride include polycarbonate resin, polyvinylcarbazole, polyester, polyarylate, polystyrene, polyacrylate, polyether, polysulfone, and the like. Molecular weights can vary from about 20,000 to about 1,500,000.

**[00267]** In a charge transport layer, the weight ratio of the charge transport material ("CTM") to the binder ranges from 30 (CTM):70 (binder) to 70 (CTM):30 (binder).

**[00268]** Any suitable technique may be utilized to apply the charge transport layer and the charge generating layer to the substrate. Typical coating techniques include dip coating, roll coating, spray coating, rotary atomizers, and the like. The coating techniques may use a wide concentration of solids. The solids content is between about 2 percent by weight and 30 percent by weight based on the total weight of the dispersion. The expression "solids" refers, for example, to the charge transport particles and binder components of the charge transport coating dispersion. These solids concentrations are useful in dip coating, roll, spray coating, and the like. Generally, a more concentrated coating dispersion may be used for roll coating. Drying of the deposited coating may be effected by any suitable conventional technique such as oven drying, infra-red radiation drying, air drying and the like. Generally, the thickness of the transport layer is between about 5 micrometers to about 100 micrometers, but thicknesses outside these ranges can also be used. In general, the ratio of the thickness of the charge transport layer to the charge generating layer is maintained, for example, from about 2:1 to 200:1 and in some instances as great as about 400:1.

**[00269]** SOF Charge Transport Layer

**[00270]** Illustrative charge transport SOFs include for example a positive hole transporting material selected from compounds having a segment containing a polycyclic aromatic ring such as anthracene, pyrene, phenanthrene, coronene, and the like, or a nitrogen-containing hetero ring such as indole, carbazole, oxazole, isoxazole, thiazole, imidazole, pyrazole, oxadiazole, pyrazoline, thiadiazole, triazole, and hydrazone compounds. Typical hole transport SOF segments include electron donor materials, such as carbazole; N-ethyl carbazole; N-isopropyl carbazole; N-phenyl carbazole; tetraphenylpyrene; 1-methyl pyrene; perylene; chrysene; anthracene; tetraphene; 2-phenyl naphthalene; azopyrene; 1-ethyl pyrene; acetyl pyrene; 2,3-benzochrysene; 2,4-benzopyrene; and 1,4-bromopyrene. Suitable electron transport SOF segments include electron acceptors such as 2,4,7-trinitro-9-

fluorenone; 2,4,5,7-tetranitro-fluorenone; dinitroanthracene; dinitroacridene; tetracyanopyrene; dinitroanthraquinone; and butylcarbonylfluorenemalononitrile, see U.S. Patent No. 4,921,769. Other hole transporting SOF segments include arylamines described in U.S. Patent No. 4,265,990, such as N,N'-diphenyl-N,N'-bis(alkylphenyl)-(1,1'-biphenyl)-4,4'-diamine wherein alkyl is selected from the group consisting of methyl, ethyl, propyl, butyl, hexyl, and the like. Other known charge transport SOF segments may be selected, reference for example U.S. Patent Nos. 4,921,773 and 4,464,450.

**[00271]** The SOF charge transport layer may be prepared by

- (a) preparing a liquid-containing reaction mixture comprising a plurality of molecular building blocks with inclined charge transport properties each comprising a segment and a number of functional groups;
- (b) depositing the reaction mixture as a wet film; and
- (c) promoting a change of the wet film including the molecular building blocks to a dry film comprising the SOF comprising a plurality of the segments and a plurality of linkers arranged as a covalent organic framework, wherein at a macroscopic level the covalent organic framework is a film.

**[00272]** The deposition of the reaction mixture as a wet layer may be achieved by any suitable conventional technique and applied by any of a number of application methods. Typical application methods include, for example, hand coating, spray coating, web coating, dip coating and the like. The SOF forming reaction mixture may use a wide range of molecular building block loadings. In embodiments, the loading is between about 2 percent by weight and 50 percent by weight based on the total weight of the reaction mixture. The term "loading" refers, for example, to the molecular building block components of the charge transport SOF reaction mixture. These loadings are useful in dip coating, roll, spray coating, and the like. Generally, a more concentrated coating dispersion may be used for roll coating. Drying of the deposited coating may be affected by any suitable conventional technique such as oven drying, infra-red radiation drying, air drying and the like. Generally, the thickness of the charge transport SOF layer is between about 5 micrometers to about

100 micrometers, such as about 10 micrometers to about 70 micrometers or 10 micrometers to about 40 micrometers. In general, the ratio of the thickness of the charge transport layer to the charge generating layer may be maintained from about 2:1 to 200:1 and in some instances as great as 400:1.

**[00273]**      Single Layer P/R – Organic Polymer

**[00274]**      The materials and procedures described herein may be used to fabricate a single imaging layer type photoreceptor containing a binder, a charge generating material, and a charge transport material. For example, the solids content in the dispersion for the single imaging layer may range from about 2% to about 30% by weight, based on the weight of the dispersion.

**[00275]**      Where the imaging layer is a single layer combining the functions of the charge generating layer and the charge transport layer, illustrative amounts of the components contained therein are as follows: charge generating material (about 5% to about 40% by weight), charge transport material (about 20% to about 60% by weight), and binder (the balance of the imaging layer).

**[00276]**      Single Layer P/R – SOF

**[00277]**      The materials and procedures described herein may be used to fabricate a single imaging layer type photoreceptor containing a charge generating material and a charge transport SOF. For example, the solids content in the dispersion for the single imaging layer may range from about 2% to about 30% by weight, based on the weight of the dispersion.

**[00278]**      Where the imaging layer is a single layer combining the functions of the charge generating layer and the charge transport layer, illustrative amounts of the components contained therein are as follows: charge generating material (about 2 % to about 40 % by weight), with an inclined added functionality of charge transport molecular building block (about 20 % to about 75 % by weight).

**[00279]**      The Overcoating Layer

**[00280]**      Embodiments in accordance with the present disclosure can, optionally, further include an overcoating layer or layers 8 as an outermost layer or

outer layer of the imaging member, which, if employed, are positioned over the charge generation layer or over the charge transport layer and may be the imaging surface. This layer may comprise SOFs that are electrically insulating or slightly semi-conductive.

**[00281]** Such a protective overcoating layer includes a SOF forming reaction mixture containing a plurality of molecular building blocks that optionally contain charge transport segments.

**[00282]** Additives may be present in the overcoating layer in the range of about 0.5 to about 40 weight percent of the overcoating layer. In embodiments, additives include organic and inorganic particles which can further improve the wear resistance and/or provide charge relaxation property. In embodiments, organic particles include Teflon powder, carbon black, and graphite particles. In embodiments, inorganic particles include insulating and semiconducting metal oxide particles such as silica, zinc oxide, tin oxide and the like. Another semiconducting additive is the oxidized oligomer salts as described in U.S. Patent No. 5,853,906. In embodiments, oligomer salts are oxidized N, N, N', N'-tetra-p-tolyl-4,4'-biphenyldiamine salt.

**[00283]** The SOF overcoating layer may be prepared by

- (a) preparing a liquid-containing reaction mixture comprising a plurality of molecular building blocks with an inclined charge transport properties each comprising a segment and a number of functional groups;
- (b) depositing the reaction mixture as a wet film; and
- (c) promoting a change of the wet film including the molecular building blocks to a dry film comprising the SOF comprising a plurality of the segments and a plurality of linkers arranged as a covalent organic framework, wherein at a macroscopic level the covalent organic framework is a film.

**[00284]** The deposition of the reaction mixture as a wet layer may be achieved by any suitable conventional technique and applied by any of a number of application methods. Typical application methods include, for example, hand coating, spray

coating, web coating, dip coating and the like. Promoting the change of the wet film to the dry SOF may be affected by any suitable conventional techniques, such as oven drying, infrared radiation drying, air drying, and the like.

**[00285]** Overcoating layers from about 2 micrometers to about 15 micrometers, such as from about 2 micrometers to about 7 micrometers are effective in preventing charge transport molecule leaching, crystallization, and charge transport layer cracking in addition to providing scratch and wear resistance.

**[00286]** The Ground Strip

**[00287]** The ground strip 9 may comprise a film-forming binder and electrically conductive particles. Cellulose may be used to disperse the conductive particles. Any suitable electrically conductive particles may be used in the electrically conductive ground strip layer 8. The ground strip 8 may, for example, comprise materials that include those enumerated in U.S. Patent No. 4,664,995. Typical electrically conductive particles include, for example, carbon black, graphite, copper, silver, gold, nickel, tantalum, chromium, zirconium, vanadium, niobium, indium tin oxide, and the like.

**[00288]** The electrically conductive particles may have any suitable shape. Typical shapes include irregular, granular, spherical, elliptical, cubic, flake, filament, and the like. In embodiments, the electrically conductive particles should have a particle size less than the thickness of the electrically conductive ground strip layer to avoid an electrically conductive ground strip layer having an excessively irregular outer surface. An average particle size of less than about 10 micrometers generally avoids excessive protrusion of the electrically conductive particles at the outer surface of the dried ground strip layer and ensures relatively uniform dispersion of the particles through the matrix of the dried ground strip layer. Concentration of the conductive particles to be used in the ground strip depends on factors such as the conductivity of the specific conductive materials utilized.

**[00289]** In embodiments, the ground strip layer may have a thickness of from about 7 micrometers to about 42 micrometers, such as from about 14 micrometers to about 27 micrometers.

**[00290]** In an alternative embodiment, a SOF may be incorporated into a system for imparting an image onto a substrate or a system for the printing of viscous liquid inks. Such a system may comprise a photoreceptor optionally comprising a SOF (for example, the imaging surface of the photoreceptor may comprise the SOF), which for the purposes of describing an exemplary system may be a photobelt, although the form of the photoreceptor may also take on other forms, as described above, as a substitute for a photobelt. An electrically insulative spacer layer may be formed over one surface of photobelt, then patterned to form an array of lands, which define physically isolated cells. If present, such a patterned spacer layer may be referred to as being “pixilated.” The material comprising an electrically insulative spacer layer may have multiple properties, including: physically and chemically robust in the presence of an ink and metering system, and laterally electrically isolating, such material may be a SOF. The lateral electrical isolation should maintain the charge for a time longer than the time required to complete the image development.

**[00291]** One candidate for photobelt is either a SOF, or a laser patterned photopolymer-based gravure. Such a patterned photopolymer-based gravure may use a thin diamond-like coating on the hardened polymer, facilitating very high resolution (greater than 12,000 dots per inch) image development.

**[00292]** A ink reservoir and metering system may provide a controlled amount of ink for each cell. A mechanism, such as a screened corona charging unit (“scorotron”), is provided for blanket charging of the ink within the cells. An optical addressing system such as a laser raster output scanner (ROS) may be present for optically addressing each cell in a cell-by-cell and row-by-row, raster fashion. A biased conductive impression roller may be used to apply pressure to a substrate such as a moving image receiving web. While discharged ink may remain *in situ* until a next bulk charging/selective discharging/developing cycle, an optional cleaning

station may be provided to remove ink remaining in any cells after the image transfer to image receiving web.

**[00293]** Additional elements which may form part of a complete system include a source of an imaging substrate, such as sheet paper, a developer portion at which the ink is transferred from an image receiving web to a substrate, thereby developing the image thereon, a fixer portion for fusing, evaporating, melting or otherwise fixing the ink to substrate, and an outfeed portion for receiving the substrate with the desired image printed and fixed thereon. It will be appreciated that each of these elements are optional and that few or lesser elements may be included in apparatus taking advantage of the present disclosure. Furthermore, while the above description mentions an apparatus that may form an image on a paper substrate, the present disclosure contemplates forming images on many other forms of substrates, and indeed one significant advantage of the present disclosure is the ability for form an image on a wider variety of substrates than present systems currently permit.

**[00294]** According to the method disclosed herein, ink from a reservoir is loaded into the cells of the pixilated photoreceptor. A metering system may remove excess ink such that the level of ink in each cell is relatively uniform, and optionally below the top surface of lands. The metering system may incorporate blades or rollers as disclosed in U.S. Application Serial Nos. 12/566,568 and 12/566,518 to Chow et. al. A blanket charge may be applied to the ink in all cells, such as when passing by a scorotron. In such an embodiment, the charge may be positive, but polarities can be reversed.

**[00295]** Individual cells may be exposed to light based on an image to be printed, developing the image onto the pixilated photoreceptor. In embodiments, a charge on an ink within a cell may dissipate when a local region of the photobelt is exposed to light. In embodiments, the light may penetrate the gravure cell and may be incident on a photoreceptive surface of a photobelt. The exposed region of the photobelt may be conductive and may discharge ink cells in contact with the exposed region thereof. Optionally, to increase the discharge speed, a conducting pad may connect each ink cell to the edge of the photoreceptor under the gravure cell walls. In

embodiments, the ink conductivity may be high enough so that this electrostatic discharge is relatively rapid. In embodiments, the ink may remain charged if not exposed to light by optical addressing system. In embodiments, ink in the cells to be subsequently printed may remain charged, while the ink in the non-image cells does not retain its charge. In embodiments, a desired image may be developed onto the pixilated photoreceptor, although in alternative embodiments a reverse image may be developed on photoreceptor.

**[00296]** In embodiments, a moving image receiving web may be in physical contact with the top of the lands, so that it is in close proximity to and not physically touching the ink in the cells. Impression roller may perform two functions at this point. First, it may apply a pressure to image receiving web so that the later is brought against lands. Second, impression roller may be biased so that there is an electrostatic charge-based attraction drawing charged ink towards its surface. This attraction may cause the ink to exit its cell and become applied to the image receiving web disposed between the ink and the charged impression roller. Generally, an uncharged ink may not be influenced by electrostatic forces to move towards impression roller, and therefore remains within its cell, and thus may result in a gap in the ink appearing on the image receiving web.

**[00297]** The individual spots of ink applied to the surface of image receiving web may be constrained in size in one or more of a variety of ways. First, there may be a fixed volume of ink within the cell. This may limit any dispersion on the surface of image receiving web. Second, the use of relatively high viscosity ink may influence the size of the ink spot. A high viscosity ink may further limit spreading after application on the image receiving web. Third, the image receiving web may be formed of a non-wetting material, such as an SOF designed to have such properties, thereby further still limiting the dispersion of ink on the surface of image receiving web. Finally, the image receiving web may be in physical contact with the upper surfaces of lands. The sidewalls thereof may define not only cell, but also a lateral form at the surface of image receiving web, which physically may further constrain the dispersion of ink on the surface of image receiving web.

**[00298]** In embodiments, an image developed onto image receiving web may then be applied to a substrate, such as sheet paper or other form of substrate. Additional steps (1) to deliver the substrate for development, (2) fix the image onto the substrate, and (3) handle the final printed substrate, may also optionally be handled at this point.

**[00299]** In embodiments, a SOF may be incorporated into a device employing a pixilated photoconductor as part of the printing system and method. In such an embodiment, the part count is reduced, as is the need for specialized components, apart from the pixilated photoconductor, which may comprise a SOF, as compared to known systems and methods. Cleaning requirements may also be reduced compared to many various prior approaches to electrostatic proximity printing. Furthermore, higher resolution is possible, expensive toner inks may not be required, and belt architectures may be used. Belt architectures are convenient because they can be used to provide long development nips, which is desirable for fast printing or more viscous inks.

**[00300]** In embodiments, shorting electrodes may be provided under the ink and within the cells to increase discharge speed. For example, a marking process employing such an arrangement comprises a carrier (such as a belt portion of the photoreceptor) on which is formed a conductor layer, a charge generation layer, and a transport layer, each of which may comprise a SOF. Shorting electrodes may be formed over the transport layer. An electrically insulative spacer layer may be formed over shorting electrodes and any exposed regions of transport layer. Spacer layer may be patterned to form an array of lands, which define physically isolated cells. In embodiments, at least a portion of shorting electrodes are exposed within cells.

**[00301]** In embodiments, an ink, which may be a conductive ink, is applied within the isolated cells. The structure may then be charged (if a conductive ink is present, the ink may be charged as well). At this point, the conductivity of the charge generation layer may be altered by exposure to light such that individual cells may selectively be discharged. The discharging according to this embodiment may occur by creation of a conduction path between the ink and a conductor via shorting electrodes. The role of shorting electrodes is, for example, to facilitate and expedite

charge conduction the between charged ink and conductor (which may for example be grounded). In embodiments, ink in a cell may thereby be selectively discharged.

**[00302]** In embodiments, a biased substrate may be applied over the structure and ink, and the attraction between any charged ink present and biased substrate causes the charged ink to become attached to substrate. The substrate is then removed, and the developed image affixed to substrate, as previously described.

**[00303]** In an additional embodiment, a SOF may be incorporated into a system (i.e., a SOF may be incorporated into one or more of the components listed below) that is part of an electrographic printing system and may include an ink loading unit or mechanism, a blanket roller, a cleaning blade, a blanket roller cleaner, a speed controller, an image forming unit, and an electric field generator. Such a system may include more or less than the above components. Some of the above components may be optional.

**[00304]** In embodiments, the ink loading unit or mechanism and the blanket roller may form a metering unit in the electrographic printing system. The ink loading mechanism may be a conventional ink loading mechanism. It may include an anilox roller, a doctor blade and a containment blade. The combined components of the doctor blade, the ink supply, and the containment blade may be referred to as a chamber blade system.

**[00305]** In embodiments, a SOF may be incorporated into an anilox roller. Such an anilox roller may have a structure corresponding to a conventional anilox roller, which has a gravure with a plurality of valleys or grooves such as valley and lands. The valleys and the lands form the cells. The valley is used to contain ink obtained from an ink supply. The filling of the cells with the ink may be done with conventional techniques such as a chamber blade system, or a pickup roller. A conventional stiff containment blade may be used to leave the cells full or nearly full (e.g., 90% of the volume provided by the valley). The doctor blade may be used to clean the lands or to wipe off any ink residue as in the conventional system. The anilox roller may rotate or move circularly in a first direction (e.g., counterclockwise).

**[00306]** The blanket roller, which may comprise an SOF, is rotationally engaged with the anilox roller to withdraw, extract, or pull the ink out of the cells causing the valleys to be partially filled. The ink in the fully or nearly full cells adheres to the surface of the blanket roller. As the blanket roller rotates, the adhered ink may be pulled out reducing the ink amount in the full or nearly full cells. The ink volume or the depth in the valleys may be reduced approximately by half of the original fill level. The ink withdrawn, extracted or pulled by the blanket roller may be collected into a container by a blanket roller blade. The collected ink in the container may be recycled to be re-used as the ink for the ink supply. The blanket roller may need to be cleaned so that a fresh surface may be used to meter and pull out ink. A blanket roller cleaner may be used to clean the ink off the blanket roller and recycle the ink into the ink supply.

**[00307]** The cleaning blade cleans tops of the lands of the cells to remove any ink residue remaining on tops of the lands. The cleaning blade may be positioned subsequent to the action of the blanket roller in either doctor or wiping mode. After the cleaning, the cells may become cleaned as a cleaned half full cell. The cleaning done by the cleaning blade may use a standard blading mode.

**[00308]** The image-forming unit may be coupled to the ink loading mechanism to form an image using the ink from the cleaned cells. The image forming unit may include a SOF containing photoreceptor drum or belt having a photoreceptor rotationally engaged with the anilox roller, a charge image generator, which may comprise a SOF, coupled to the photoreceptor drum or belt to image-wise charge the photoreceptor, and a substrate in contact or nearly in contact (in proximity) with the photoreceptor drum or belt to receive the image as the photoreceptor drum or belt rotates. The charge image generator may be made by any of known methods to generate a charge image, including a blanket charging with scorotron followed by an image-wise discharging scanning laser or light emitting diode bar array, or a direct write system such as an addressable array of small charge emitters (e.g., iconography).

**[00309]** The amount of ink to be pulled out from the full or nearly full cells may be controlled, tuned, or varied to provide a desired performance. There may be a number of techniques to do this.

**[00310]** In embodiments, the SOFs may have different toughness. The difference in toughness may be brought about by the choice of segments and/or linkers as well as by introduction of capping units, and varying capping group concentration in a SOF. In embodiments, the toughness of the SOF can be enhanced or the toughness of the SOF can be attenuated.

**[00311]** In embodiments, toughness may be assessed by measuring the stress-strain curve for SOFs. This test is conducted by mounting a dog-bone shaped piece of SOF of known dimensions between two clamps; one stationary, and one moving. The moving clamp applies a force at a known rate (N/min) causing a stress (Force/area) on the film. This stress causes the film to elongate and a graph comparing stress vs. strain is created. The Young's Modulus (slope of the linear section) as well as rupture point (stress and strain at breakage) and toughness (integral of the curve) can be determined. These data provide insight into the mechanical properties of the film. For the purposes of embodiments the differences in mechanical properties (toughness) between SOFs are denoted by their respective rupture points.

**[00312]** In embodiments, the rupture points of SOF films, such as capped SOFs (with respect to the corresponding non-capped SOF compositions), may be attenuated by about 1% to about 85%, such as from about 5% to about 25%.

**[00313]** In embodiments, the rupture points of SOF films, such as capped SOFs (with respect to the corresponding non-capped SOF compositions) may be enhanced by about 1% to about 400%, about 20% to about 200%, or from about 50% to about 100%.

**[00314]** In embodiments, the "consistency" of a printing ink may be increased to influence on the productivity and quality of a print job. For example, the consistency may be selected for various individual properties and may be adjusted to match specific printing presses, substrates, printing subjects, speed, and so forth, as optimally as possible. As used herein, the term "dynamic viscosity" ( $\eta$ ) refers to the

inner resistance to the flow of the ink. The more viscous an ink, the less easily it flows and the more difficult it is for it to spread into a film. The units of measure for this are Pa·s (Pascal second), or cP (centi Poise) = 1 mPa·s (millipascal second).

**[00315]** Exemplary marking materials may include, toner, ink, adhesive(s), surface finish treatment(s), protective coating(s), and electrically conductive material(s). For example, suitable ink marking materials include highly viscous, pasty inks such as those used in offset printing (dynamic viscosity  $\eta = 40\text{-}100\text{ Pa}\cdot\text{s}$ ) and in letterpress printing (dynamic viscosity  $\eta = 50\text{-}150\text{ Pa}\cdot\text{s}$ ); gravure liquid inks (dynamic viscosity  $\eta = 0.05\text{-}0.01\text{ Pa}\cdot\text{s}$ ); ink jet inks, which have a low dynamic viscosity ( $\eta = 1$  to  $30\text{ mPa}\cdot\text{s}$ ), as well as inks with viscosities between these values. For example, in embodiments, the marking material is a liquid ink with a viscosity above about 100 cp, such as a liquid ink with a viscosity from about 100 cp to about 200,000 cp, or a liquid ink with a viscosity above about 1000 cp, such as from about 1000 cp to 150,000 cp.

**[00316] Examples**

**[00317]** A number of examples of the process used to make SOFs are set forth herein and are illustrative of the different compositions, conditions, techniques that may be utilized. Identified within each example are the nominal actions associated with this activity. The sequence and number of actions along with operational parameters, such as temperature, time, coating method, and the like, are not limited by the following examples. All proportions are by weight unless otherwise indicated. The term "rt" refers, for example, to temperatures ranging from about 20 °C to about 25 °C. Mechanical measurements were measured on a TA Instruments DMA Q800 dynamic mechanical analyzer using methods standard in the art. Differential scanning calorimetry was measured on a TA Instruments DSC 2910 differential scanning calorimeter using methods standard in the art. Thermal gravimetric analysis was measured on a TA Instruments TGA 2950 thermal gravimetric analyzer using methods standard in the art. FT-IR spectra was measured on a Nicolet Magna 550 spectrometer using methods standard in the art. Thickness measurements <1 micron were measured on a Dektak 6m Surface Profiler. Surface energies were measured on a Fibro DAT 1100 (Sweden) contact angle instrument using methods standard in the

art. Unless otherwise noted, the SOFs produced in the following examples were either defect-free SOFs or substantially defect-free SOFs.

**[00318]** The SOFs coated onto Mylar were delaminated by immersion in a room temperature water bath. After soaking for 10 minutes the SOF film generally detached from Mylar substrate. This process is most efficient with a SOF coated onto substrates known to have high surface energy (polar), such as glass, mica, salt, and the like.

**[00319]** Given the examples below it will be apparent, that the compositions prepared by the methods of the present disclosure may be practiced with many types of components and may have many different uses in accordance with the disclosure above and as pointed out hereinafter.

**[00320] Embodiment of a Patterned SOF Composition**

**[00321]** An embodiment of the disclosure is to attain a SOF wherein the microscopic arrangement of segments is patterned. The term "patterning" refers, for example, to the sequence in which segments are linked together. A patterned SOF would therefore embody a composition wherein, for example, segment A is only connected to segment B, and conversely, segment B is only connected to segment A. Further, a system wherein only one segment exists, say segment A, is employed is will be patterned because A is intended to only react with A. In principle a patterned SOF may be achieved using any number of segment types. The patterning of segments may be controlled by using molecular building blocks whose functional group reactivity is intended to compliment a partner molecular building block and wherein the likelihood of a molecular building block to react with itself is minimized. The aforementioned strategy to segment patterning is non-limiting. Instances where a specific strategy to control patterning has not been deliberately implemented are also embodied herein.

**[00322]** A patterned film may be detected using spectroscopic techniques that are capable of assessing the successful formation of linking groups in a SOF. Such spectroscopies include, for example, Fourier-transfer infrared spectroscopy, Raman spectroscopy, and solid-state nuclear magnetic resonance spectroscopy. Upon

acquiring a data by a spectroscopic technique from a sample, the absence of signals from functional groups on building blocks and the emergence of signals from linking groups indicate the reaction between building blocks and the concomitant patterning and formation of an SOF.

**[00323]** Different degrees of patterning are also embodied. Full patterning of a SOF will be detected by the complete absence of spectroscopic signals from building block functional groups. Also embodied are SOFs having lowered degrees of patterning wherein domains of patterning exist within the SOF. SOFs with domains of patterning, when measured spectroscopically, will produce signals from building block functional groups which remain unmodified at the periphery of a patterned domain.

**[00324]** It is appreciated that a very low degree of patterning is associated with inefficient reaction between building blocks and the inability to form a film. Therefore, successful implementation of the process of the present disclosure requires appreciable patterning between building blocks within the SOF. The degree of necessary patterning to form a SOF is variable and can depend on the chosen building blocks and desired linking groups. The minimum degree of patterning required is that required to form a film using the process described herein, and may be quantified as formation of about 20 % or more of the intended linking groups, such as about 40 % or more of the intended linking groups or about 50 % or more of the intended linking groups; the nominal degree of patterning embodied by the present disclosure is formation of about 60 % of the intended linking group, such as formation of about 100 % of the intended linking groups. Formation of linking groups may be detected spectroscopically as described earlier in the embodiments.

**[00325]** PRODUCTION OF A SOF

**[00326]** The following experiments demonstrate the development of a SOF. The activity described below is non-limiting as it will be apparent that many types of approaches may be used to generate patterning in a SOF.

**[00327]** EXAMPLE 1 describes the synthesis of a Type 2 SOF wherein components are combined such that etherification linking chemistry is promoted

between two building blocks. The presence of an acid catalyst and a heating action yield a SOF with the method described in EXAMPLE 1.

**[00328]**      EXAMPLE 1: Type 2 SOF

**[00329]**      *(Action A) Preparation of the liquid containing reaction mixture.* The following were combined: the building block benzene-1,4-dimethanol [segment = p-xylyl; Fg = hydroxyl (-OH); (0.47 g, 3.4 mmol)] and a second building block N<sub>4</sub>,N<sub>4</sub>,N<sub>4</sub>',N<sub>4</sub>'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N<sub>4</sub>,N<sub>4</sub>,N<sub>4</sub>',N<sub>4</sub>'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.12 g, 1.7 mmol)], and 17.9 g of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.31 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture.

**[00330]**      *(Action B) Deposition of reaction mixture as a wet film.* The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 8 mil gap.

**[00331]**      *(Action C) Promotion of the change of the wet film to a dry SOF.* The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 3-6 microns, which may be delaminated from the substrate as a single free-standing SOF. The color of the SOF was green. The Fourier-transform infrared spectrum of a portion of this SOF is provided in FIG. 4.

**[00332]**      To demonstrate that the SOF prepared in EXAMPLE 1 comprises segments from the employed molecular building blocks that are patterned within the SOF, three control experiments were conducted. Namely, three liquid reaction mixtures were prepared using the same procedure as set forth in Action A in EXAMPLE 1; however, each of these three formulations were modified as follows:

- (Control reaction mixture 1; Example 2) the building block benzene-1,4-dimethanol was not included.
- (Control reaction mixture 2; Example 3) the building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine was not included.
- (Control reaction mixture 3; Example 4) the catalyst p-toluenesulfonic acid was not included

**[00333]** The full descriptions of the SOF forming process for the above described control experiments are detailed in EXAMPLES 2 – 4 below.

**[00334]** EXAMPLE 2: (Control experiment wherein the building block benzene-1,4-dimethanol was not included)

**[00335]** *(Action A) Preparation of the liquid containing reaction mixture.* The following were combined: the building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.12 g, 1.7 mmol)], and 17.9 g of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.31 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture.

**[00336]** *(Action B) Deposition of reaction mixture as a wet film.* The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 8 mil gap.

**[00337]** *(Action C) Attempted promotion of the change of the wet film to a dry SOF.* The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions did not provide a film. Instead, a precipitated powder of the building block was deposited onto the substrate.

[00338] EXAMPLE 3: (Control experiment wherein the building block N<sub>4</sub>,N<sub>4</sub>,N<sub>4</sub>',N<sub>4</sub>'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine was not included)

[00339] *(Action A) Preparation of the liquid containing reaction mixture.* The following were combined: the building block benzene-1,4-dimethanol [segment = p-xylyl; Fg = hydroxyl (-OH); (0.47 g, 3.4 mmol)] and 17.9 g of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.31 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture.

[00340] *(Action B) Deposition of reaction mixture as a wet film.* The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 8 mil gap.

[00341] *(Action C) Attempted promotion of the change of the wet film to a dry SOF.* The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions did not provide a film. Instead, a precipitated powder of the building block was deposited onto the substrate.

[00342] EXAMPLE 4: (Control experiment wherein the acid catalyst p-toluenesulfonic acid was not included)

[00343] *(Action A) Preparation of the liquid containing reaction mixture.* The following were combined: the building block benzene-1,4-dimethanol [segment = p-xylyl; Fg = hydroxyl (-OH); (0.47 g, 3.4 mmol)] and a second building block N<sub>4</sub>,N<sub>4</sub>,N<sub>4</sub>',N<sub>4</sub>'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N<sub>4</sub>,N<sub>4</sub>,N<sub>4</sub>',N<sub>4</sub>'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.12 g, 1.7 mmol)], and 17.9 g of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room

temperature, the solution was filtered through a 0.45 micron PTFE membrane to yield the liquid containing reaction mixture.

**[00344]**        *(Action B) Deposition of reaction mixture as a wet film.* The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR™ substrate using a constant velocity draw down coater outfitted with a bird bar having an 8 mil gap.

**[00345]**        *(Action C) Attempted promotion of the change of the wet film to a dry SOF.* The metalized MYLAR™ substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions did not provide a film. Instead, a precipitated powder of the building blocks was deposited onto the substrate.

**[00346]**        As described in EXAMPLES 2 – 4, each of the three control reaction mixtures were subjected to Action B and Action C as outlined in EXAMPLE 1. However, in all cases a SOF did not form; the building blocks simply precipitated on the substrate. It is concluded from these results that building blocks cannot react with themselves under the stated processing conditions nor can the building blocks react in the absence of a promoter (p-toluenesulfonic acid). Therefore, the activity described in EXAMPLE 1 is one wherein building blocks (benzene-1,4-dimethanol and N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine) can only react with each other when promoted to do so. A patterned SOF results when the segments p-xylyl and N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine connect only with each other. The Fourier-transform infrared spectrum, compared to that of the products of the control experiments (FIG. 5) of the SOF shows absence of functional groups (notably the absence of the hydroxyl band from the benzene-1,4-dimethanol) from the starting materials and further supports that the connectivity between segments has proceed as described above. Also, the complete absence of the hydroxyl band in the spectrum for the SOF indicates that the patterning is to a very high degree.

**[00347]**        Described below are further Examples of defect-free SOFs and/or substantially defect-free SOFs prepared in accordance with the present disclosure. In

the following examples (Action A) is the *preparation of the liquid containing reaction mixture*; (Action B) is the *deposition of reaction mixture as a wet film*; and (Action C) is the *promotion of the change of the wet film to a dry SOF*.

**[00348]        EXAMPLE 5: Type 2 SOF**

**[00349]**        (Action A) The following were combined: the building block benzene-1,3,5-trimethanol [segment = benzene-1,3,5-trimethyl; Fg = hydroxyl (-OH); (0.2 g, 1.2 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.59 g, 0.8 mmol)], and 8.95 g of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.16 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 20 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 2-4 microns that could be delaminated from the substrate as a single free-standing SOF. The color of the SOF was green.

**[00350]        EXAMPLE 6: Type 2 SOF**

**[00351]**        (Action A) The following were combined: the building block 1,6-n-hexanediol [segment = n-hexyl; Fg = hydroxyl (-OH); (0.21 g, 1.8 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.58 g, 0.87 mmol)], and 8.95 g of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as

0.16 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 20 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 4-5 microns that could be delaminated from the substrate as a single free standing SOF. The color of the SOF was green. The Fourier-transform infrared spectrum of a portion of this SOF is provided in FIG. 6.

**[00352]**      EXAMPLE 7: Type 2 SOF

**[00353]**      (Action A) The following were combined: the building block benzene-1,4-dimethanol [segment = p-xylyl; Fg = hydroxyl (-OH); (0.64 g, 4.6 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.54 g, 2.3 mmol)], and 7.51 g of 1,4-dioxane. The mixture was shaken and heated to 60 °C until a homogenous solution resulted, which was then filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.28 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 4 min. These actions provided a SOF having a thickness ranging from about 8-12 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was green.

**[00354]**      EXAMPLE 8: Type 2 SOF

**[00355]**      (Action A) The following were combined: the building block 1,6-n-hexanediol [segment = n-hexyl; Fg = hydroxyl (-OH); (0.57 g, 4.8 mmol)] and a

second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.61 g, 2.42 mmol)], and 7.51 g of 1,4-dioxane. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to rt, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.22 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 12-20 microns that could be delaminated from the substrate as a single free-standing film. The color of the SOF was green.

**[00356]**        EXAMPLE 9: Type 2 SOF

**[00357]**        (Action A) The following were combined: the building block 4,4'-(cyclohexane-1,1-diyl)diphenol [segment = 4,4'-(cyclohexane-1,1-diyl)diphenyl; Fg = hydroxyl (-OH); (0.97 g, 6 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.21 g, 1.8 mmol)], and 7.51 g of 1,4-dioxane. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to rt, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.22 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 12-20 microns that could be delaminated from the substrate as a single free-standing film. The color

of the SOF was green. The Fourier-transform infrared spectrum of SOF is provided in FIG. 7.

**[00358]        EXAMPLE 10: Type 2 SOF**

**[00359]**        (Action A) The following were combined: the building block benzene-1,4-dimethanol [segment = p-xylyl; Fg = hydroxyl (-OH); (0.52 g, 3.8 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.26 g, 1.9 mmol)], and 6.3 g of 1,4-dioxane and 1.57 g of n-butyl acetate. The mixture was shaken and heated to 60 °C until a homogenous solution resulted, which was then filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.28 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 4 min. These actions provided a SOF having a thickness of 7-10 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was green.

**[00360]        EXAMPLE 11: Type 2 SOF**

**[00361]**        (Action A) Same as EXAMPLE 7. (Action B) The reaction mixture was applied to a photoconductive layer, containing a pigment and polymeric binder, supported on metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 20 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00362]        EXAMPLE 12: Type 2 SOF**

**[00363]**        (Action A) The following were combined: the building block benzene-1,4-dimethanol [segment = p-xylyl; Fg = hydroxyl (-OH); (0.52 g, 3.8 mmol)] and a

second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.26 g, 1.9 mmol)], and 6.3 g of 1,4-dioxane and 1.57 g of methyl isobutyl ketone. The mixture was shaken and heated to 60 °C until a homogenous solution resulted, which was then filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.28 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 4 min. These actions provided a SOF having a thickness ranging from about 7-10 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was green.

**[00364]**      EXAMPLE 13: Type 2 SOF

**[00365]**      (Action A) The following were combined: the building block 1,6-n-hexanediol [segment = n-hexyl; Fg = hydroxyl (-OH); (0.47 g, 4.0 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.31 g, 2.0 mmol)], 6.3 g of 1,4-dioxane, and 1.57 g of n-butyl acetate. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.22 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 8-12 microns

that could be delaminated from the substrate as a single free-standing film. The color of the SOF was green.

**[00366]        EXAMPLE 14: Type 2 SOF**

**[00367]**        (Action A) Same as EXAMPLE 10. (Action B) The reaction mixture was applied to a photoconductive layer, containing a pigment and polymeric binder, supported on metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 20 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00368]        EXAMPLE 15: Type 2 SOF**

**[00369]**        (Action A) The following were combined: the building block 1,6-n-hexanediol [segment = n-hexyl; Fg = hydroxyl (-OH); (0.47 g, 4.0 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (1.31 g, 2.0 mmol)], 6.3 g of 1,4-dioxane, and 1.57 g of methyl isobutyl ketone. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.22 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 8-12 microns that could be delaminated from the substrate as a single free-standing film. The color of the SOF was green.

**[00370]        EXAMPLE 16: Type 2 SOF**

**[00371]** (Action A) The following were combined: the building block 4,4'-(cyclohexane-1,1-diyl)diphenol [segment = 4,4'-(cyclohexane-1,1-diyl)diphenyl; Fg = hydroxyl (-OH); (0.8 g)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.8 g, 1.5 mmol)], 1,4-dioxane, and 1.57 g of n-butyl acetate. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to rt, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.22 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided SOF having a thickness of about 12 microns that could be delaminated from the substrate as a single free-standing film. The color of the SOF was green.

**[00372]** EXAMPLE 17: Type 2 SOF

**[00373]** (Action A) Same as EXAMPLE 13. (Action B) The reaction mixture was applied to a photoconductive layer, containing a pigment and polymeric binder, supported on metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 20 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00374]** EXAMPLE 18: Type 2 SOF

**[00375]** (Action A) The following were combined: the building block 4,4'-(cyclohexane-1,1-diyl)diphenol [segment = 4,4'-(cyclohexane-1,1-diyl)diphenyl; Fg = hydroxyl (-OH); (0.8 g, 3.0 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-

tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.8 g, 1.5 mmol)], 1,4-dioxane, and 1.57 g of methyl isobutyl ketone. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.22 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided SOF having a thickness of about 12 microns that could be delaminated from the substrate as a single free-standing film. The color of the SOF was green.

**[00376]        EXAMPLE 19: Type 2 SOF**

**[00377]        (Action A)** Same as EXAMPLE 7. **(Action B)** The reaction mixture was applied to a photoconductive layer, containing a pigment and polymeric binder, supported on metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. **(Action C)** The supported wet layer was allowed to dry at ambient temperature in an actively vented fume hood for 5 min and was then transferred to an actively vented oven preheated to 120 °C and left to heat for 15 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00378]        EXAMPLE 20: Type 2 SOF**

**[00379]        (Action A)** Same as EXAMPLE 10. **(Action B)** The reaction mixture was applied to a photoconductive layer, containing a pigment and polymeric binder, supported on metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. **(Action C)** The supported wet layer was allowed to dry at ambient temperature in an actively vented fume hood for 5 min and was then transferred to an actively vented oven preheated to 120 °C and

left to heat for 15 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00380]**        **EXAMPLE 21: Type 2 SOF**

**[00381]**        (Action A) Same as EXAMPLE 13. (Action B) The reaction mixture was applied to a photoconductive layer, containing a pigment and polymeric binder, supported on metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was allowed to dry at ambient temperature in an actively vented fume hood for 5 min and was then transferred to an actively vented oven preheated to 120 °C and left to heat for 15 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns and could not be delaminated.

**[00382]**        **EXAMPLE 22: Type 2 SOF**

**[00383]**        (Action A) Same as EXAMPLE 7. (Action B) The reaction mixture was applied to a layered photosensitive member comprising a generator layer and a transport layer containing a diamine type molecule dispersed in a polymeric binder using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was allowed to dry at ambient temperature in an actively vented fume hood for 5 min and was then transferred to an actively vented oven preheated to 120 °C and left to heat for 15 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00384]**        **EXAMPLE 23: Type 2 SOF**

**[00385]**        (Action A) Same as EXAMPLE 10. (Action B) The reaction mixture was applied to layered photosensitive member comprising a generator layer and a transport layer containing a diamine type molecule dispersed in a polymeric binder using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was allowed to dry at ambient temperature in an actively vented fume hood for 5 min and was then transferred to an actively vented oven preheated to 120 °C and left to heat for 15 min. These actions provided a

uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00386]        EXAMPLE 24: Type 2 SOF**

**[00387]**        (Action A) Same as EXAMPLE 13. (Action B) The reaction mixture was applied to layered photosensitive member comprising a generator layer and a transport layer containing a diamine type molecule dispersed in a polymeric binder using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The supported wet layer was allowed to dry at ambient temperature in an actively vented fume hood for 5 min and was then transferred to an actively vented oven preheated to 120 °C and left to heat for 15 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness ranging from about 9-10 microns.

**[00388]        EXAMPLE 25: Type 1 SOF**

**[00389]**        (Action A) The following were combined: the building block (4,4',4'',4'''-(biphenyl-4,4'-diylbis(azanetriyl))tetrakis(benzene-4,1-diyl))tetramethanol [segment = (4,4',4'',4'''-(biphenyl-4,4'-diylbis(azanetriyl))tetrakis(benzene-4,1-diyl); Fg = alcohol (-OH); (1.48 g, 2.4 mmol)], and 8.3 g of 1,4-dioxane. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.15 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 25 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided SOF having a thickness ranging from about 8-24 microns. The color of the SOF was green.

**[00390]        EXAMPLE 26: Type 1 SOF**

**[00391]** (Action A) The following were combined: the building 4,4',4''-nitrilotris(benzene-4,1-diyl)trimethanol [segment = (4,4',4''-nitrilotris(benzene-4,1-diyl)trimethyl); Fg = alcohol (-OH); (1.48 g, 4.4 mmol)], and 8.3 g of 1,4-dioxane. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.15 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR™ substrate using a constant velocity draw down coater outfitted with a bird bar having a 15 mil gap. (Action C) The metalized MYLAR™ substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided SOF having a thickness ranging from about 6-15 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was green. The Fourier-transform infrared spectrum of this film is provided in FIG. 8. Two-dimensional X-ray scattering data is provided in FIG. 14. As seen in FIG. 14, no signal above the background is present, indicating the absence of molecular order having any detectable periodicity.

**[00392]** EXAMPLE 27: Type 2 SOF

**[00393]** (Action A) The following were combined: the building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.26 g, 0.40 mmol)] and a second building block 3,3'-(4,4'-(biphenyl-4-ylazanediyl)bis(4,1-phenylene))dipropan-1-ol [segment = 3,3'-(4,4'-(biphenyl-4-ylazanediyl)bis(4,1-phenylene))dipropyl; Fg = hydroxy (-OH); (0.34 g, 0.78 mmol)], and 1.29 mL of 1-methoxy-2-propanol. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.2 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr)

MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 8 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 150 °C and left to heat for 40 min. These actions provided SOF having a thickness ranging from about 15-20 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was green.

**[00394]**        EXAMPLE 28: Type 2 SOF

**[00395]**        (Action A) Same as EXAMPLE 24. (Action B) The reaction mixture was applied to layered photosensitive member comprising a generator layer and a transport layer containing a diamine type molecule dispersed in a polymeric binder using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The supported wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness of about 5 microns.

**[00396]**        EXAMPLE 29: Type 2 SOF

**[00397]**        (Action A) Same as EXAMPLE 24. (Action B) The reaction mixture was applied to layered photosensitive member comprising a generator layer and a transport layer containing a diamine type molecule dispersed in a polymeric binder affixed to a spin coating device rotating at 750 rpm. The liquid reaction mixture was dropped at the centre rotating substrate to deposit the wet layer. (Action C) The supported wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a uniformly coated multilayer device wherein the SOF had a thickness of about 0.2 microns.

**[00398]**        EXAMPLE 30: Type 2 SOF

**[00399]**        (Action A) The following were combined: the building block terephthalaldehyde [segment = benzene; Fg = aldehyde (-CHO); (0.18 g, 1.3 mmol)] and a second building block tris(4-aminophenyl)amine [segment = triphenylamine; Fg = amine (-NH<sub>2</sub>); (0.26 g, 0.89 mmol)], and 2.5 g of tetrahydrofuran. The mixture was shaken until a homogenous solution resulted. Upon cooling to room temperature, the

solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.045 g of a 10 wt % solution of p-toluenesulfonic acid in 1-tetrahydrofuran to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 5 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 40 min. These actions provided a SOF having a thickness of about 6 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was red-orange. The Fourier-transform infrared spectrum of this film is provided in FIG 9.

**[00400]        EXAMPLE 31: Type 1 SOF**

**[00401]**        (Action A) The following were combined: the building block 4,4',4''-nitrilotribenzaldehyde [segment = triphenylamine; Fg = aldehyde (-CHO); (0.16 g, 0.4 mmol)] and a second building block tris(4-aminophenyl)amine [segment = triphenylamine; Fg = amine (-NH<sub>2</sub>); (0.14 g, 0.4 mmol)], and 1.9 g of tetrahydrofuran. The mixture was stirred until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having an 5 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 40 min. These actions provided a SOF having a thickness of about 6 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was red. The Fourier-transform infrared spectrum of this film is provided in FIG 10.

**[00402]        EXAMPLE 32: Type 2 SOF**

**[00403]**        (Action A) The following were combined: the building block glyoxal [segment = single covalent bond; Fg = aldehyde (-CHO); (0.31 g, 5.8 mmol – added as 40 wt % solution in water i.e. 0.77 g aqueous glyoxal)] and a second building block

tris(4-aminophenyl)amine [segment = triphenylamine; Fg = amine (-NH<sub>2</sub>); (1.14 g, (3.9 mmol)], and 8.27 g of tetrahydrofuran. The mixture was shaken until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 10 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging from about 6-12 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was red.

**[00404]        EXAMPLE 33: Type 2 SOF**

**[00405]**        (Action A) The following were combined: the building block terephthalaldehyde [segment = benzene; Fg = aldehyde (-CHO); (0.18 g, 1.3 mmol)] and a second building block tris(4-aminophenyl)amine [segment = triphenylamine; Fg = amine (-NH<sub>2</sub>); (0.26 g, 0.89 mmol)], 2.5 g of tetrahydrofuran, and 0.4 g water. The mixture was shaken until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 40 min. These actions provided a SOF having a thickness ranging 6 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was red-orange.

**[00406]        EXAMPLE 34: Type 1 SOF**

**[00407]**        (Action A) The following were combined: the building block 4,4',4''-nitrilotribenzaldehyde [segment = triphenylamine; Fg = aldehyde (-CHO); (0.16 g, 0.4 mmol)] and a second building block tris(4-aminophenyl)amine [segment = triphenylamine; Fg = amine (-NH<sub>2</sub>); (0.14 g, 0.4 mmol)], 1.9 g of tetrahydrofuran, and

0.4 g water. The mixture was stirred until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR™ substrate using a constant velocity draw down coater outfitted with a bird bar having an 5 mil gap. (Action C) The metalized MYLAR™ substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 120 °C and left to heat for 40 min. These actions provided a SOF having a thickness of about 6 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was red-orange.

**[00408]        EXAMPLE 35: Type 2 SOF**

**[00409]**        (Action A) Same as EXAMPLE 28. (Action B) The reaction mixture was dropped from a glass pipette onto a glass slide. (Action C) The glass slide was heated to 80 °C on a heating stage yielding a deep red SOF having a thickness of about 200 microns which could be delaminated from the glass slide.

**[00410]        EXAMPLE 36: Type 1 SOF**

**[00411]**        (Action A) The following were combined: the building block tris-[(4-hydroxymethyl)-phenyl]-amine [segment = tri-(*p*-tolyl)-amine; Fg = hydroxy (-OH); 5.12 g]; the additives Cymel303 (55 mg) and Silclean 3700 (210 mg), and the catalyst Nacure XP-357 (267 mg) and 1-methoxy-2-propanol (13.27 g). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 55 °C for 65 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 240 mm/min. (Action C) The photoreceptor drum supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a SOF having a thickness of about 6.9 microns. FIG. 11 is a photo-induced discharge curve (PIDC) illustrating the photoconductivity of this SOF overcoat layer (voltage at 75 ms (expose-to-measure)).

**[00412]        EXAMPLE 37: Type 1 SOF with additives**

**[00413]** (Action A) The following were combined: the building block tris-[(4-hydroxymethyl)-phenyl]-amine [segment = tri-(*p*-tolyl)-amine; Fg = hydroxy (-OH); 4.65 g]; the additives Cymel303 (49 mg) and Silclean 3700 (205 mg), and the catalyst Nacure XP-357 (254 mg) and 1-methoxy-2-propanol (12.25 g). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 55 °C for 65 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. A polyethylene wax dispersion (average particle size = 5.5 microns, 40% solids in *i*-propyl alcohol, 613 mg) was added to the reaction mixture which was sonicated for 10 min and mixed on the rotator for 30 min. (Action B) The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 240 mm/min. (Action C) The photoreceptor drum supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a film having a thickness of 6.9 microns with even incorporation of the wax particles in the SOF. FIG. 12 is a photo-induced discharge curve (PIDC) illustrating the photoconductivity of this SOF overcoat layer (voltage at 75 ms (expose-to-measure)).

**[00414]** EXAMPLE 38: Type 2 SOF

**[00415]** (Action A) The following were combined: the building block *N,N,N',N'*-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = *N,N,N',N'*-tetra-(*p*-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); 3.36 g] and the building block *N,N'*-diphenyl-*N,N'*-bis-(3-hydroxyphenyl)-biphenyl-4,4'-diamine [segment = *N,N,N',N'*-tetraphenyl-biphenyl-4,4'-diamine; Fg – hydroxyl (-OH); 5.56 g]; the additives Cymel303 (480 mg) and Silclean 3700 (383 mg), and the catalyst Nacure XP-357 (480 mg) and 1-methoxy-2-propanol (33.24 g). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 55 °C for 65 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 485 mm/min. (Action C) The photoreceptor drum supporting the wet layer was rapidly

transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a film having a thickness ranging from 6.0 to 6.2 microns. FIG. 13 is a photo-induced discharge curve (PIDC) illustrating the photoconductivity of this SOF overcoat layer (voltage at 75 ms (expose-to-measure)).

**[00416]        EXAMPLE 39: Type 2 SOF**

**[00417]**        (Action A) The following can be combined: the building block dipropylcarbonate [segment = carbonyl [-C(=O)-]; Fg = propoxy (CH<sub>3</sub>CH<sub>2</sub>CH<sub>2</sub>O-); 4.38 g, 30 mmol] and the building block 1,3,5-trihydroxycyclohexane [segment = cyclohexane; Fg – hydroxyl (-OH); 3.24 g, 20 mmol] and catalyst sodium methoxide (38 mg) and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and heated for 40 min.

**[00418]        EXAMPLE 40: Type 2 SOF**

**[00419]**        (Action A) The following can be combined: the building block dipropylcarbonate [segment = carbonyl [-C(=O)-]; Fg = propoxy (CH<sub>3</sub>CH<sub>2</sub>CH<sub>2</sub>O-); 4.38 g, 30 mmol] and the building block 1,3,5-trihydroxycyclohexane [segment = cyclohexane; Fg – hydroxyl (-OH); 3.24 g, 20 mmol]; phosphoric acid (2 M aq, 100 mg); and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00420]        EXAMPLE 41: Type 2 SOF**

**[00421]**        (Action A) The following can be combined: the building block 1,1'-carbonyldiimidazole [segment = carbonyl [-C(=O)-]; Fg = imidazole; 4.86 g, 30 mmol] and the building block 1,3,5-trihydroxycyclohexane [segment = cyclohexane;

Fg – hydroxyl (-OH); 3.24 g, 20 mmol] and catalyst sodium methoxide (38 mg) and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00422]** EXAMPLE 42: Type 2 SOF

**[00423]** (Action A) The following can be combined: the building block carbonyldiimidazole [segment = carbonyl [-C(=O)-]; Fg = imidazole; 4.86 g, 30 mmol] and the building block 1,3,5-trihydroxycyclohexane [segment = cyclohexane; Fg – hydroxyl (-OH); 3.24 g, 20 mmol]; phosphoric acid (2 M aq, 100 mg); and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00424]** EXAMPLE 43: Type 2 SOF

**[00425]** (Action A) The following can be combined: the building block trimesic acid [segment = 1,3,5-benzenetricarboxylate; Fg = H; 4.20 g, 20 mmol] and the building block 1,6-hexanediol [segment = hexane; Fg – hydroxyl (-OH); 3.55 g, 30 mmol]; phosphoric acid (2 M aq, 100 mg); and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00426]** EXAMPLE 44: Type 2 SOF

**[00427]** (Action A) The following can be combined: the building block trimesic acid [segment = 1,3,5-benzenetricarboxylate; Fg = H; 4.20 g, 20 mmol] and the building block 1,6-hexanediol [segment = hexane; Fg – hydroxyl (-OH); 3.55 g, 30 mmol]; N,N-dimethyl-4-aminopyridine (50 mg); and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00428]** EXAMPLE 45: Type 2 SOF

**[00429]** (Action A) The following can be combined: the building block trimesic acid [segment = 1,3,5-benzenetricarboxylate; Fg = H; 4.20 g, 20 mmol] and the building block hexamethylenediamine [segment = hexane; Fg – amine (-NH<sub>2</sub>); 3.49 g, 30 mmol]; phosphoric acid (2 M aq, 100 mg); and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00430]** EXAMPLE 46: Type 2 SOF

**[00431]** (Action A) The following can be combined: the building block trimesic acid [segment = 1,3,5-benzenetricarboxylate; Fg = H; 4.20 g, 20 mmol] and the building block hexamethylenediamine [segment = hexane; Fg – amine (-NH<sub>2</sub>); 3.49 g, 30 mmol]; N,N-dimethyl-4-aminopyridine (50 mg); and N-methyl-2-pyrrolidinone (25.5 g). The mixture is mixed on a rolling wave rotator for 10 min and filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture is applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The

substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 200 °C and left to heat for 40 min.

**[00432]**      EXAMPLE 47: Type 2 SOF

**[00433]**      (Action A) Preparation of liquid containing reaction mixture. The following can be combined: the building block 1,4-diisocyanatobenzene [segment = phenyl; Fg = isocyanate (-N=C=O); (0.5 g, 3.1 mmol)] and a second building block 4,4',4''-nitriлотris(benzene-4,1-diyl)trimethanol [segment = (4,4',4''-nitriлотris(benzene-4,1-diyl)trimethyl); (0.69, 2.1 mmol)] 10.1 g of dimethylformamide, and 1.0 g of triethylamine. The mixture is stirred until a homogenous solution is obtained. Upon cooling to room temperature, the solution is filtered through a 0.45 micron PTFE membrane. (Action B) The reaction mixture is to be applied to the reflective side of a metalized (TiZr) MYLAR™ substrate using a constant velocity draw down coater outfitted with a bird bar having a 8 mil gap. (Action C) The metalized MYLAR™ substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 120 min.

**[00434]**      EXAMPLE 48: Type 2 SOF

**[00435]**      (Action A) Preparation of liquid containing reaction mixture. The following can be combined: the building block 1,4-diisocyanatohexane [segment = hexyl; Fg = isocyanate (-N=C=O); (0.38 g, 3.6 mmol)] and a second building block triethanolamine [segment = triethylamine; (0.81, 5.6 mmol)] 10.1 g of dimethylformamide, and 1.0 g of triethylamine. The mixture is stirred until a homogenous solution is obtained. Upon cooling to room temperature, the solution is filtered through a 0.45 micron PTFE membrane. (Action B) The reaction mixture is to be applied to the reflective side of a metalized (TiZr) MYLAR™ substrate using a constant velocity draw down coater outfitted with a bird bar having a 8 mil gap. (Action C) The metalized MYLAR™ substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 120 min.

**[00436]**      EXAMPLE 49: Type 2 SOF

**[00437]** (Action A) The following were combined: the building block N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = N,N,N',N'-tetra-(p-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); 4.24 g] and the building block N,N'-diphenyl-N,N'-bis-(3-hydroxyphenyl)-terphenyl-4,4'-diamine [segment = N,N,N',N'-tetraphenyl-terphenyl-4,4'-diamine; Fg – hydroxyl (-OH); 5.62 g]; the additives Cymel303 (530 mg) and Silclean 3700 (420 mg), and the catalyst Nacure XP-357 (530 mg) and 1-methoxy-2-propanol (41.62 g). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 55 °C for 65 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 485 mm/min. (Action C) The photoreceptor drum supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a SOF having a thickness of 6.2 microns.

**[00438]** EXAMPLE 49: Type 2 SOF Attempt

**[00439]** (Action A) Attempted preparation of the liquid containing reaction mixture. The following were combined: the building block tris-[(4-hydroxymethyl)-phenyl]-amine [segment = tri-(p-tolyl)-amine; Fg = hydroxy (-OH); 5.12 g]; the additives Cymel303 (55 mg), Silclean 3700 (210 mg), and 1-methoxy-2-propanol (13.27 g). The mixture was heated to 55 °C for 65 min in an attempt to fully dissolve the molecular building block. However it did not fully dissolve. A catalyst Nacure XP-357 (267 mg) was added and the heterogeneous mixture was further mixed on a rolling wave rotator for 10 min. In this Example, the catalyst was added after the heating step. The solution was not filtered prior to coating due to the amount of undissolved molecular building block. (Action B) Deposition of reaction mixture as a wet film. The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 240 mm/min. (Action C) Promotion of the change of the wet film to a dry film. The photoreceptor drum supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions did not provide a

uniform film. There were some regions where a non-uniform film formed that contained particles and other regions where no film was formed at all.

**[00440] EXAMPLE 50: Type 2 SOF**

**[00441]** (Action A) The following were combined: the building block tris-[(4-hydroxymethyl)-phenyl]-amine [segment = tri-(p-tolyl)-amine; Fg = hydroxy (-OH); 5.12 g]; the additives Cymel303 (55 mg) and Silclean 3700 (210 mg), and the catalyst Nacure XP-357 (267 mg) and 1-methoxy-2-propanol (13.27 g). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 55 °C for 65 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. It was noted that the viscosity of the reaction mixture increased after the heating step (although the viscosity of the solution before and after heating was not measured). (Action B) The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 240 mm/min. (Action C) The photoreceptor drum supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a SOF having a thickness of 6.9 microns.

**[00442] EXAMPLE 51: Type 2 SOF**

**[00443]** (Action A) The following were combined: the building block N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = N,N,N',N'-tetra-(p-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); 1.84 g] and the building block 3,3'-(4,4'-(biphenyl-4-ylazanediyl)bis(4,1-phenylene))dipropan-1-ol [segment = 3,3'-(4,4'-(biphenyl-4-ylazanediyl)bis(4,1-phenylene))dipropyl; Fg = hydroxy (-OH); (2.41 g] and a catalyst p-toluenesulphonic acid (10 wt% solution in dowlanol, 460 mg) and 1-methoxy-2-propanol (16.9 g – containing 50 ppm DC510). The mixture was mixed on a rolling wave rotator for 5 min and then heated at 70 °C for 30 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a production-coated web photoreceptor with a Hirano web coater. Syringe pump speed: 4.5

mL/min. (Action C) The photoreceptor supporting the wet layer was fed at a rate of 1.5 m/min into an actively vented oven preheated to 130 °C for 2 min. These actions provided a SOF overcoat layer having a thickness of 2.1 microns on a photoreceptor.

**[00444] EXAMPLE 52: Type 2 SOF**

**[00445]** (Action A) The following were combined: the building block N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = N,N,N',N'-tetra-(p-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); 5.0 g] and the building block benzenedimethanol [segment = p-xylyl; Fg – hydroxyl (-OH); 2.32 g] and a catalyst p-toluenesulphonic acid (10 wt% solution in dowanol, 720 mg) and 1-methoxy-2-propanol (22.5 g – containing 50 ppm DC510). The mixture was mixed on a rolling wave rotator for 5 min and then heated at 40 °C for 5 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a production-coated, production web photoreceptor a Hirano web coater. Syringe pump speed: 5 mL/min. (Action C) The photoreceptor supporting the wet layer was fed at a rate of 1.5 m/min into an actively vented oven preheated to 130 °C for 2 min. These actions provided a SOF overcoat layer having a thickness of 2.2 microns on a photoreceptor.

**[00446] EXAMPLE 53: Type 2 SOF**

**[00447]** (Action A) The following were combined: the building block N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = N,N,N',N'-tetra-(p-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); 5.0 g] and the building block benzenedimethanol [segment = p-xylyl; Fg – hydroxyl (-OH); 2.32 g] and a catalyst p-toluenesulphonic acid (10 wt% solution in dowanol, 720 mg) and 1-methoxy-2-propanol (22.5 g – containing 50 ppm DC510). The mixture was mixed on a rolling wave rotator for 5 min and then heated at 40 °C for 5 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a production-coated, production web photoreceptor with a Hirano web coater. Syringe pump speed: 10 mL/min. (Action

C) The photoreceptor supporting the wet layer was fed at a rate of 1.5 m/min into an actively vented oven preheated to 130 °C for 2 min. These actions provided a SOF overcoat layer having a thickness of 4.3 microns on a photoreceptor.

**[00448]** Five photoreceptor samples, two with SOF overcoat layers, one with an HP indigo photoreceptor, one with a Tigirs photoreceptor with PACSO, and a Kocera  $\alpha$ -Si photoreceptor were spotted and rubbed with flexo yellow ink, extender, and reducer. The SOF overcoated photoreceptor sample did not have any observable damage after being in contact with the ink and extender for over 72 hours. The HP indigo photoreceptor, Tigirs photoreceptor with PACSO, and Kocera  $\alpha$ -Si photoreceptor were all significantly damaged and exhibited irreversible physical damage, discoloration and wear on the spotted portions of each respective photoreceptor.

**[00449]** An image formed from half UV flexo ink and half extender having a viscosity of 1000 cp and a printing speed of 0.4 m/sec was developed onto the SOF overcoated photoreceptor. This viscosity is orders of magnitude higher than what an inkjet can print. 20 pixel dots (a 600 dpi ROS was used to image the photoreceptor) were created. The SOF overcoated photoreceptor showed no signs of discernable wear after 50 tests and even hundreds of tests in some instances. Where the HP indigo photoreceptor, Tigirs photoreceptor with PACSO, and Kocera  $\alpha$ -Si photoreceptor displaced significant wear after only 10 to 20 print tests. The SOF overcoated photoreceptor was cleaned numerous times with a cleaning solution (isopropyl alcohol) and no physical damage was observed. These results are important for ruling out photoreceptor damage as a possible cause for background printing.

**[00450]** EXAMPLE 54:

**[00451]** (Action A) The following were combined: the building 4,4',4''-nitrilotris(benzene-4,1-diyl)trimethanol [segment = (4,4',4''-nitrilotris(benzene-4,1-diyl)trimethyl); Fg = alcohol (-OH); (1.48 g, 4.4 mmol)], 0.5 g water and 7.8 g of 1,4-dioxane. The mixture was shaken and heated to 60 °C until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45

micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.15 g of a 10 wt % solution of p-toluenesulfonic acid in 1,4-dioxane to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the reflective side of a metalized (TiZr) MYLAR<sup>TM</sup> substrate using a constant velocity draw down coater outfitted with a bird bar having a 15 mil gap. (Action C) The metalized MYLAR<sup>TM</sup> substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 130 °C and left to heat for 40 min. These actions provided SOF having a thickness ranging from about 4-10 microns that could be delaminated from substrate as a single free-standing film. The color of the SOF was green. Two-dimensional X-ray scattering data is provided in FIG. 14. As seen in FIG. 14,  $2\theta$  is about 17.8 and d is about 4.97 angstroms, indicating that the SOF possesses molecular order having a periodicity of about 0.5 nm.

**[00452]        EXAMPLE 55: Type 2 SOF**

**[00453]**        (Action A) The following can be combined: the building block 4-hydroxybenzyl alcohol [segment = toluene; Fg = hydroxyl (-OH); (0.0272 g, 0.22 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.0728 g, 0.11 mmol)], and 0.88 g of 1-methoxy-2-propanol and 0.01 g of a 10 wt % solution of silclean in 1-methoxy-2-propanol. The mixture is shaken and heated to 55 °C until a homogenous solution is obtained. Upon cooling to rt, the solution is filtered through a 0.45 micron PTFE membrane. To the filtered solution is added an acid catalyst delivered as 0.01 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the aluminum substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The aluminum substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min.

**[00454]        EXAMPLE 56: Type 2 SOF**

**[00455]** (Action A) The following can be combined: the building block 4-(hydroxymethyl)benzoic acid [segment = 4-methylbenzaldehyde; Fg = hydroxyl (-OH); (0.0314 g, 0.206 mmol)] and a second building block N4,N4,N4',N4'-tetrakis(4-(methoxymethyl)phenyl)biphenyl-4,4'-diamine [segment = N4,N4,N4',N4'-tetra-p-tolylbiphenyl-4,4'-diamine; Fg = methoxy ether (-OCH<sub>3</sub>); (0.0686 g, 0.103 mmol)], and 0.88 g of 1-methoxy-2-propanol and 0.01 g of a 10 wt % solution of silclean in 1-methoxy-2-propanol. The mixture is shaken and heated to 55 °C until a homogenous solution is obtained. Upon cooling to rt, the solution is filtered through a 0.45 micron PTFE membrane. To the filtered solution is added an acid catalyst delivered as 0.01 g of a 10 wt % solution of p-toluenesulfonic acid in 1-methoxy-2-propanol to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied to the aluminum substrate using a constant velocity draw down coater outfitted with a bird bar having a 5 mil gap. (Action C) The aluminum substrate supporting the wet layer is rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min.

**[00456]** EXAMPLE 57: Type 2 SOF

**[00457]** (Action A) The following were combined: the building block 1,4-diaminobenzene [segment = benzene; Fg = amine (-NH<sub>2</sub>); (0.14 g, 1.3 mmol)] and a second building block 1,3,5-triformylbenzene [segment = benzene; Fg = aldehyde (-CHO); (0.144 g, 0.89 mmol)], and 2.8 g of NMP. The mixture was shaken until a homogenous solution resulted. Upon cooling to room temperature, the solution was filtered through a 0.45 micron PTFE membrane. To the filtered solution was added an acid catalyst delivered as 0.02 g of a 2.5 wt % solution of p-toluenesulfonic acid in NMP to yield the liquid containing reaction mixture. (Action B) The reaction mixture was applied quartz plate affixed to the rotating unit of a variable velocity spin coater rotating at 1000 RPM for 30 seconds. (Action C) The quartz plate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 180 °C and left to heat for 120 min. These actions provide a yellow film having a thickness of 400 nm that can be delaminated from substrate upon immersion in water.

**[00458]** EXAMPLE 58: Composite SOFs

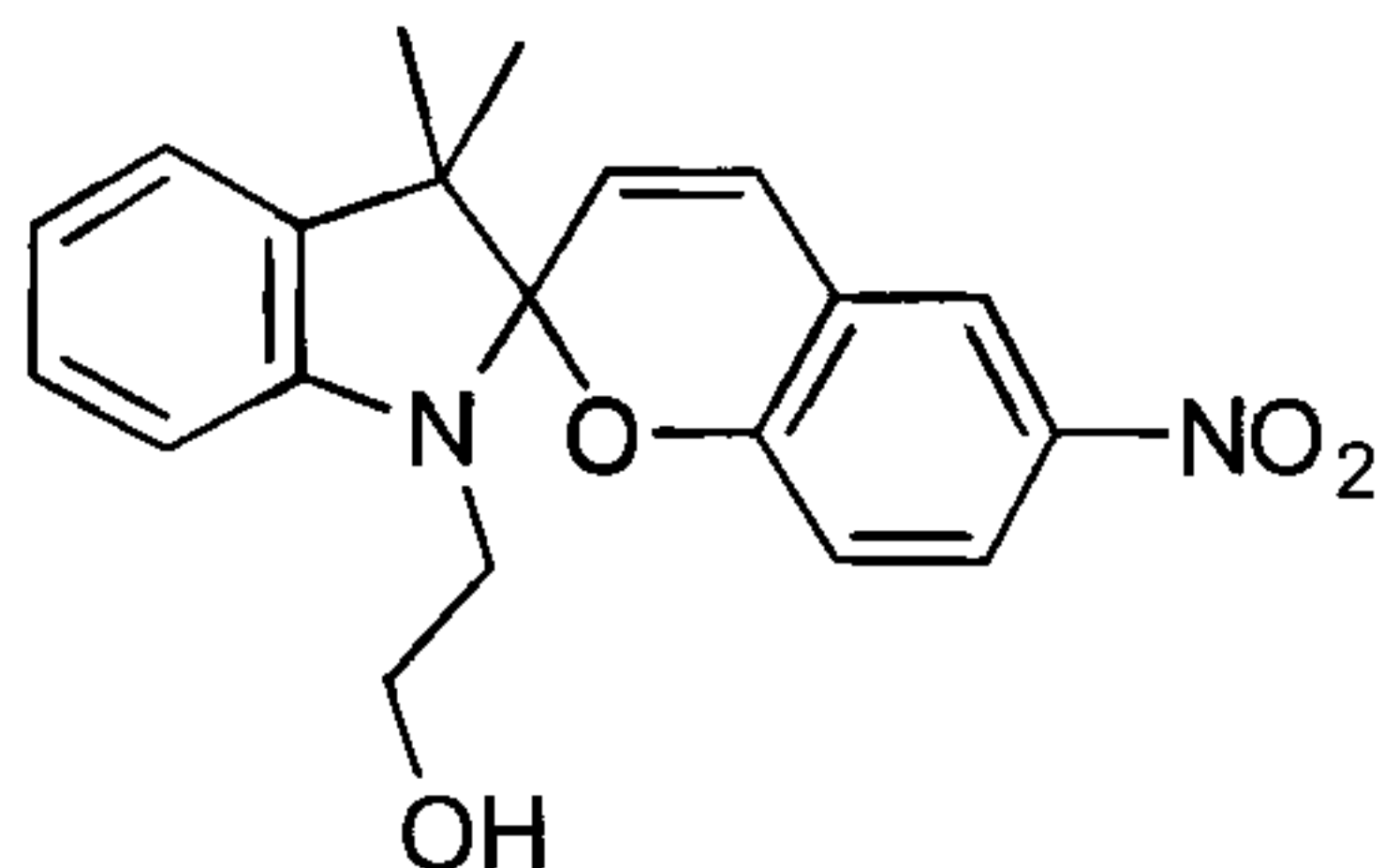
**[00459]** Composite SOFs were prepared involving the process and building blocks described in Example 1. In these cases the solvent used was dioxane. All SOFs were prepared on metalized mylar substrates, by depositing a wet layer with a 20 mil bird bar and promoting a change of the the wet layer at 130 °C for 40 min. at total 30 % solids loading in the reaction mixture with 10 % of the solid loading being from the secondary component. Secondary components were introduced by including them in the reaction mixture before promoting the change of the wet layer to form the SOF. Six different composite SOFs were produced, each containing a different secondary component: composite SOF 1 including a hole transport molecule (N4,N4'-diphenyl-N4,N4'-di-m-tolyl-[1,1'-biphenyl]-4,4'-diamine), composite SOF 2 including a polymer (polystyrene), composite SOF 3 including nanoparticles (C60 Buckminster fullerene), composite SOF 4 including small organic molecules (biphenyl), composite SOF 5 including metal particles (copper micropowder), and composite SOF 6 including electron acceptors (quinone). Some secondary components were soluble in the reaction mixture; some were dispersed (not soluble) in the reaction mixture. The six composite SOFs produced were substantially pinhole free SOFs that included the composite materials incorporated into the SOF. In some cases (e.g. copper micropowder composite SOF) the dispersion of the secondary component (dopant) was visually evident. The thicknesses of these SOFs ranged from 15-25 microns.

**[00460]** Example 59: Photochromic SOFs

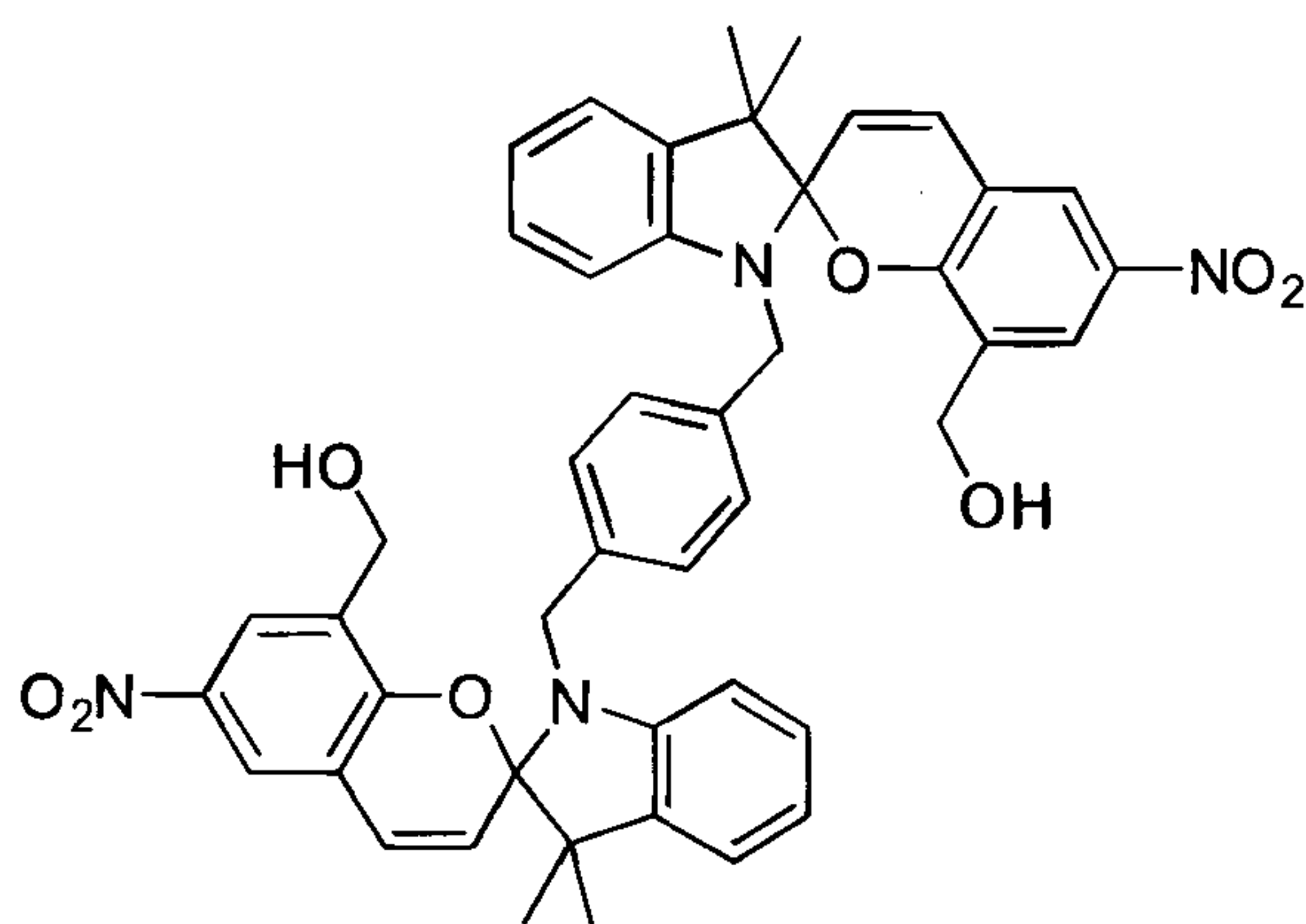
**[00461]** (Action A) Preparation of the liquid containing reaction mixture: The following were combined: the SOF building block tris-(4-hydroxymethyl)triphenylamine [segment = triphenylamine; Fg = hydroxy (-OH); 0.200 g]; the photochromic molecules 1-5 (see below) (0.02 g), and the catalyst p-toluene sulfonic acid (0.01 g); and, 1-methoxy-2-propanol (0.760 g). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 55 °C for 5 min until a homogenous solution resulted. The solution was filtered through a 1 micron PTFE membrane. (Action B) Deposition of reaction mixture as a wet film: The reaction mixture was applied to a 3 mil Mylar substrate using a constant velocity drawdown coater outfitted with a 5 mil gap bird bar. (Action C) Promotion of the change of the

wet film to a dry SOF: The Mylar sheet supporting the wet layer was rapidly transferred to an actively vented oven preheated to 120°C and left to heat for 5 min. These actions provided a film having a thickness of 3-5 microns. The following photochromic molecules were incorporated in SOFs:

**[00462]** (1) Spiropyran 1-OH (functional SOF capping building block)

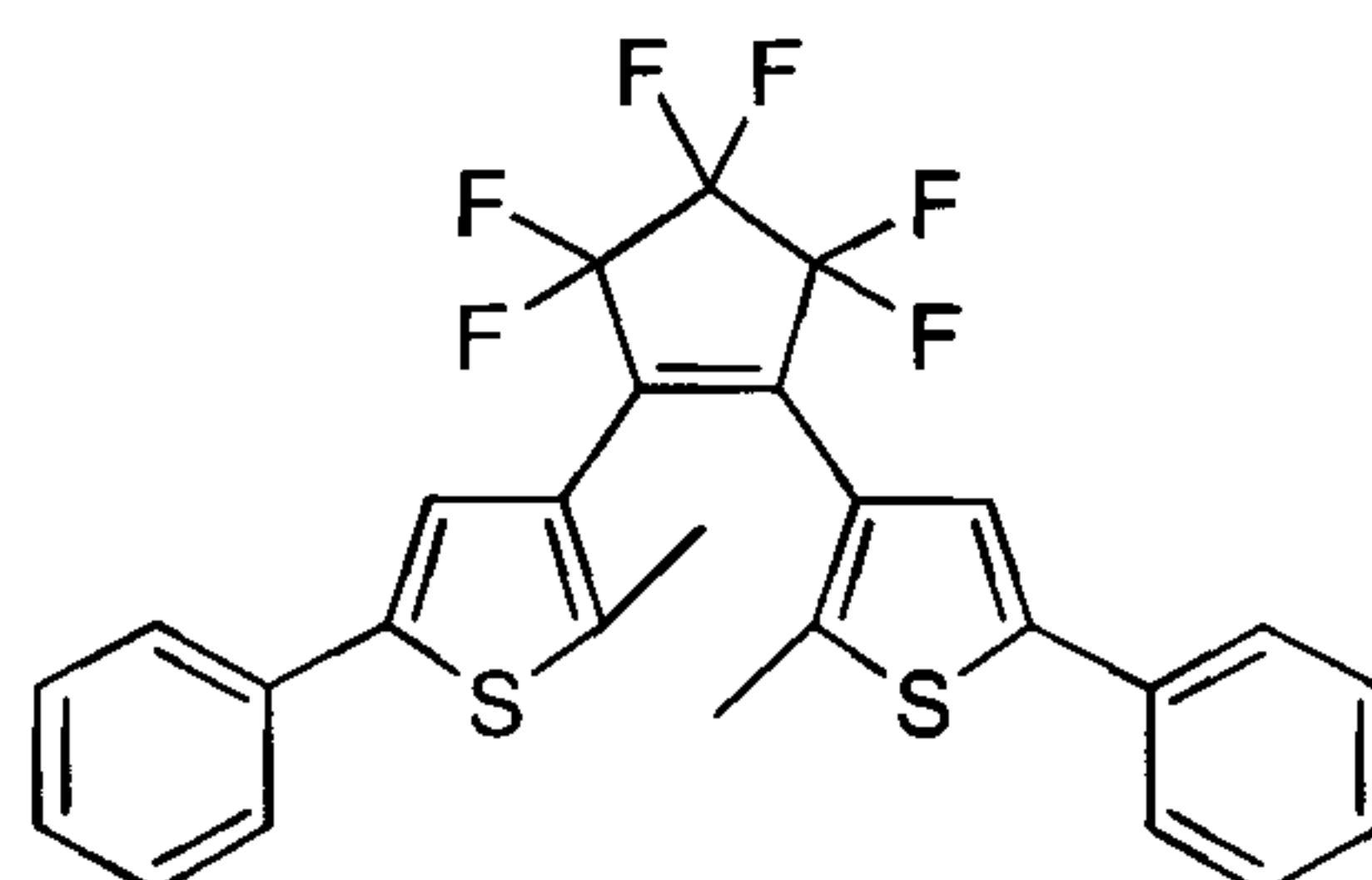


**[00463]** (2) Bisspiropyran 2-OH (functional SOF building block)



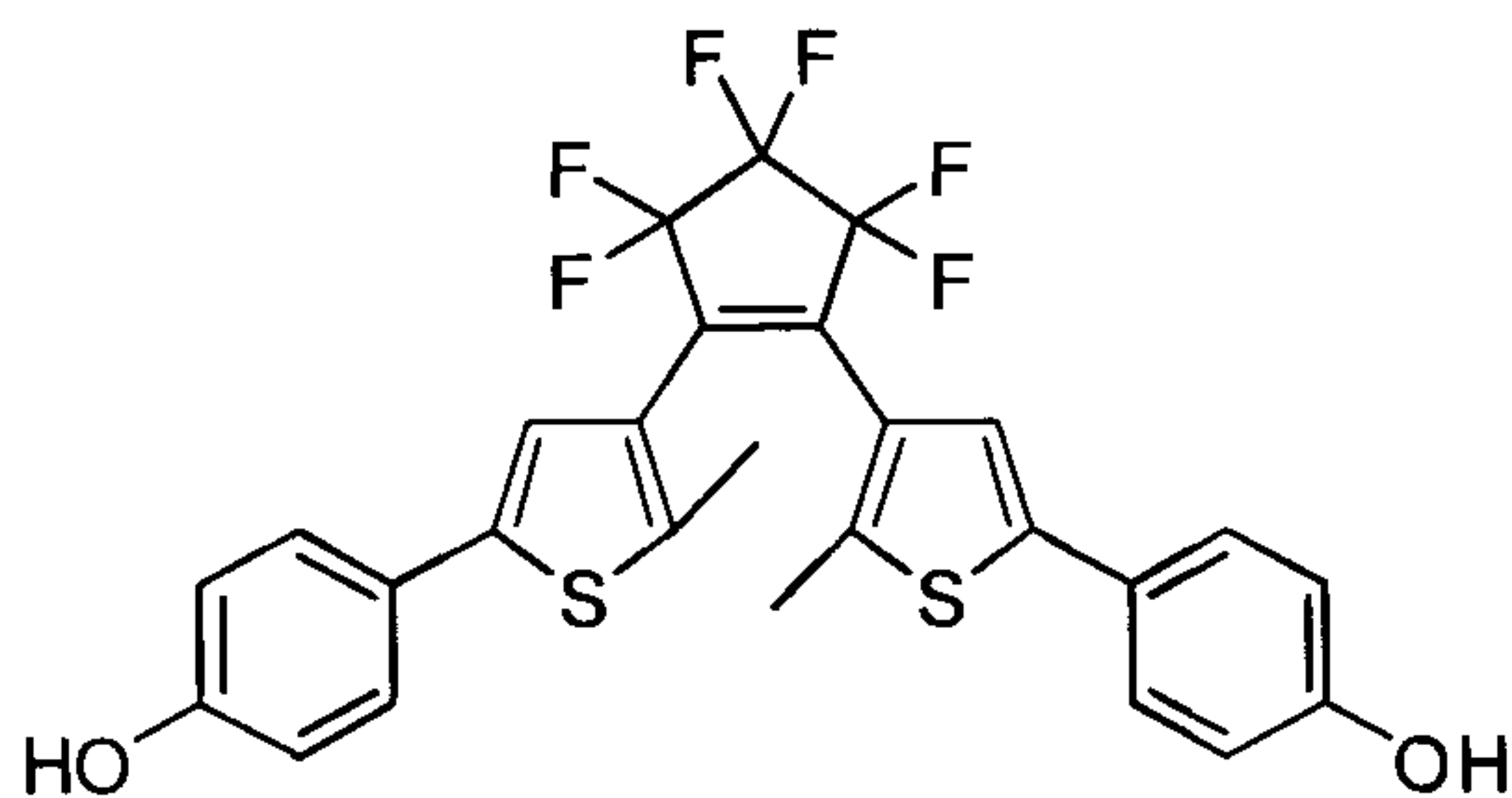
**[00464]** (3) Spirooxazine (composite SOF)

**[00465]** (4) DTE (composite SOF)



**[00466]**

**[00467]** (5) DTE 2-OH (functional SOF building block)



**[00468]** All formulations formed substantially pinhole free films, however photochromic molecules (4) and (5) performed the best, as seen in Table 2 (below).

**Table 2: Writing/erasing test observations**

| Photochromic Molecule                        | Color as synthesized | Color After Write at 365 nm for 6 s. | Erase? |
|----------------------------------------------|----------------------|--------------------------------------|--------|
| SOF only                                     | Light yellow         | n/a                                  | n/a    |
| (4) DTE (composite SOF)                      | Light yellow         | Dark purple                          | YES    |
| (5) DTE 2-OH (functional SOF building block) | Light green          | Dark purple                          | YES    |

**[00469]** UV-Visible spectra of photochromic SOF with molecules (4) and (5) clearly demonstrate the coloration (presence of broad absorbance centered ~600 nm after UVA write) and erasable capability (loss of ~600 nm absorbance following visible light erase) of the photochromic SOF films. The photochromic responses were comparable to polymer matrix systems in terms of writing/erasing speed and contrast of image. This indicates the SOF film does not affect the performance of these DTE type photochromic materials.

**[00470]** To test chemical/environmental/mechanical stability, the photochromic SOFs were placed in acetone for 15 minutes. Experimental observations are detailed in the table below (Table 3). The photochromic SOF with molecule (5) fully preserves film integrity and photochromic behavior. The photochromic SOF with molecule (4) leaches out the photochromic component and as a result loses photochromic activity.

**Table 3: Acetone test observations**

| <b>Sample</b>                                                | <b>Optical<br/>Density Before<br/>Acetone Stress<br/>Test</b> | <b>Optical<br/>Density After<br/>Acetone Stress<br/>Test</b> | <b>Performance After Acetone Stress<br/>Test</b>                                                                                                                                                                      |
|--------------------------------------------------------------|---------------------------------------------------------------|--------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>(4) DTE</b><br>(composite<br>SOF)                         | 0.69                                                          | 0.14                                                         | <ul style="list-style-type: none"> <li>▪ SOF largely maintains integrity (some swelling and softening was observed)</li> <li>▪ Photochromic molecule leaches into acetone</li> </ul> <p>SOF is no longer writable</p> |
| <b>(5) DTE 2-OH</b><br>(functional<br>SOF building<br>block) | 0.83                                                          | 0.91                                                         | <ul style="list-style-type: none"> <li>▪ SOF maintains integrity</li> <li>▪ No observed leaching of photochromic molecule</li> </ul> <p>SOF has excellent writing properties</p>                                      |

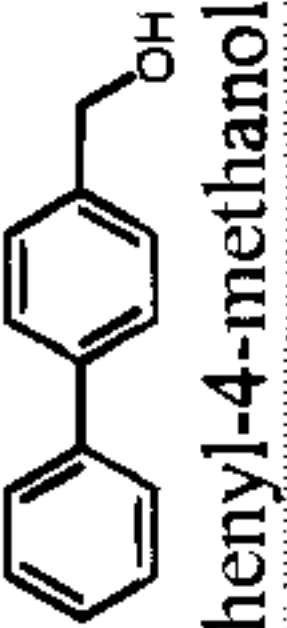
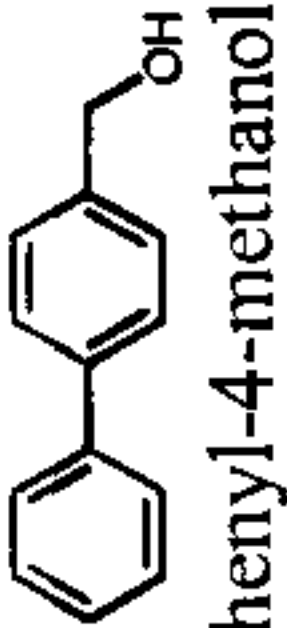
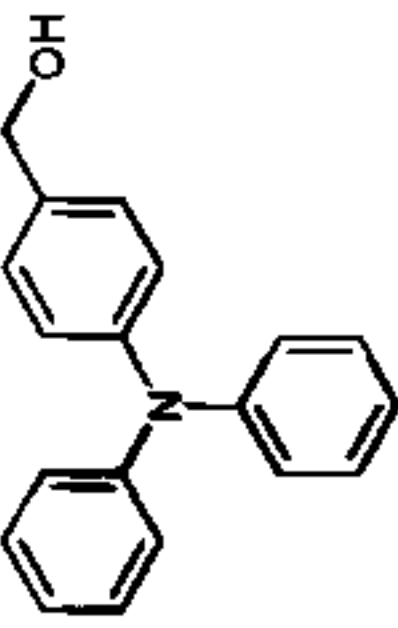
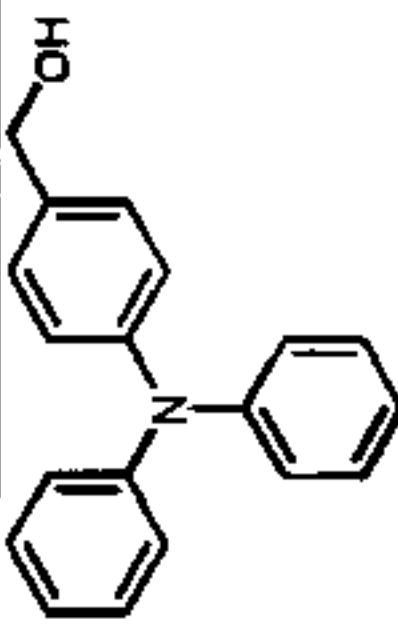
**[00471]** The photochromic SOF with molecule (5) was placed in acetone and sonicated for 5 minutes. This is an extreme test that polymer-based photochromic systems would not survive. After removal from solvent, the photochromic SOF with molecule (5) essentially maintains the SOF integrity and writes at about the same level when exposed to UV LED device, i.e. photochromic activity is preserved. The photochromic SOF derived from the photochromic molecule (5), which chemically bonds to the SOF structure, does not leach from the SOF and can withstand harsh chemical (acetone solvent) and mechanical (ultrasonication) stresses.

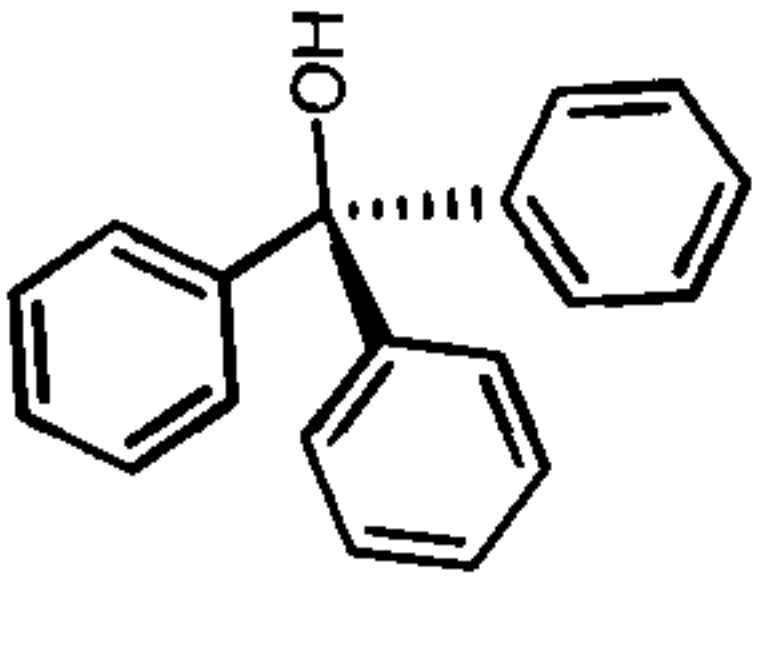
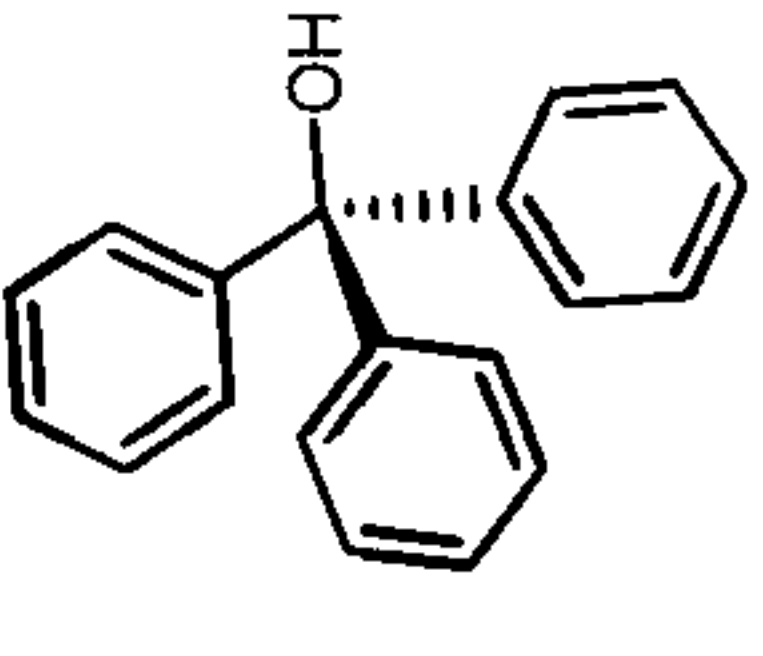
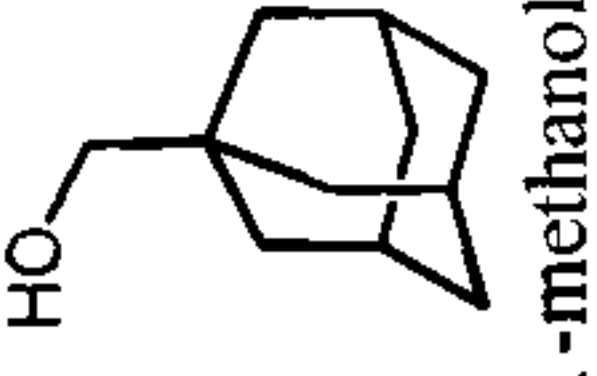
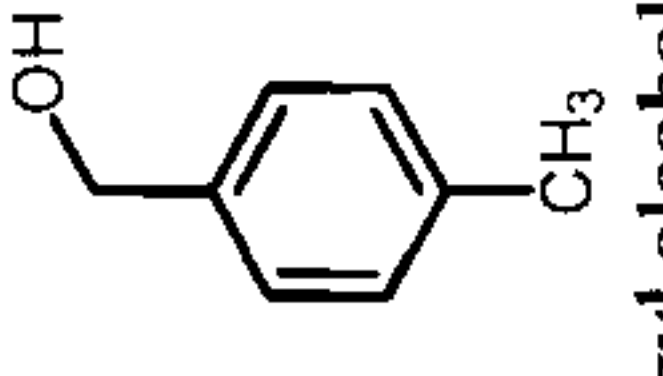
**[00472]** EXAMPLE 60:

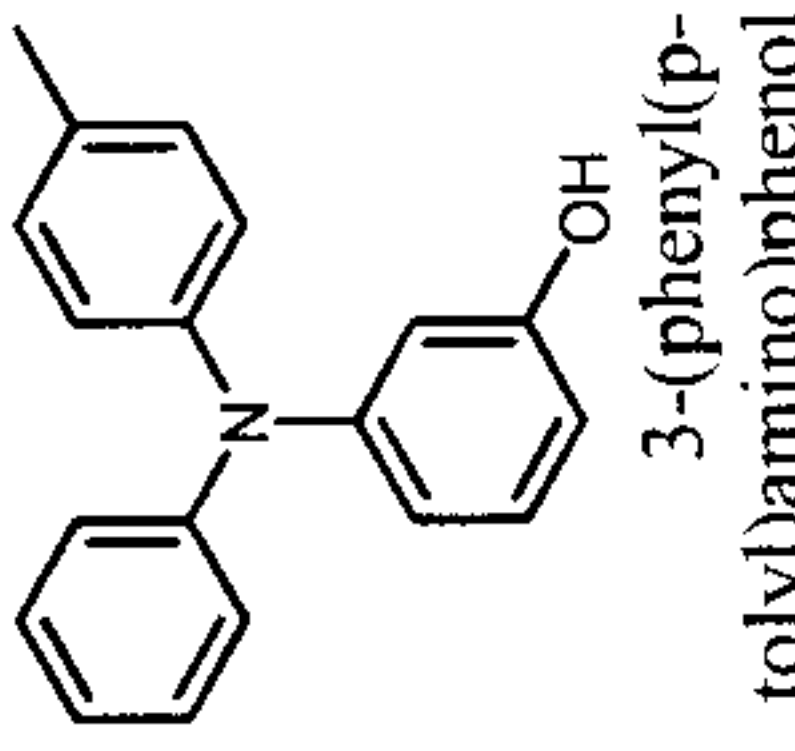
**[00473]** (Action A) The following were combined: the building block N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = N,N,N',N'-tetra-(p-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); in the amounts listed in Table 4] and the capping unit as designated in Table 4; the additive Silclean 3700, and the catalyst Nacure XP-357 and dowanol. The mixture was mixed on a

rolling wave rotator for 10 min and then heated at 65 °C for 60 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to an aluminum substrate. (Action C) The aluminum substrate supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a film having a thickness ranging from 4 to 10 microns.

Table 4: Capped SOF formulations

| Test # | Building Block 1                                                   | Capping Unit                                                                                                               | Additive       | Solvent | Catalyst         | Gap   | Notes                                           |
|--------|--------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------|----------------|---------|------------------|-------|-------------------------------------------------|
| 1      | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine | <br>Biphenyl-4-methanol                 | Sileclean 3700 | dowanol | 2 % Nacure XP357 | 10mil | 1.5 Molar Ratio of Capping Unit: Building Block |
|        |                                                                    |                                                                                                                            |                | 1.5600  |                  |       |                                                 |
| 2      | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine | <br>Biphenyl-4-methanol                 | Sileclean 3700 | dowanol | 2 % Nacure XP357 | 10mil | 0.5 Molar Ratio of Capping Unit: Building Block |
|        |                                                                    |                                                                                                                            |                | 1.5600  |                  |       |                                                 |
| 3      | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine | <br>(4-(diphenylamino)phenyl)methanol | Sileclean 3700 | dowanol | 2 % Nacure XP357 | 10mil | 1.5 Molar Ratio of Capping Unit: Building Block |
|        |                                                                    |                                                                                                                            |                | 1.5600  |                  |       |                                                 |
| 4      | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine | <br>(4-(diphenylamino)phenyl)methanol | Sileclean 3700 | dowanol | 2 % Nacure XP357 | 10mil | 0.5 Molar Ratio of Capping Unit: Building Block |
|        |                                                                    |                                                                                                                            |                | 1.5600  |                  |       |                                                 |

|   |                                                                              |                                                                                                                           |                         |                   |                          |       |                                                                |
|---|------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------|-------------------------|-------------------|--------------------------|-------|----------------------------------------------------------------|
| 5 | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine<br>0.3295 | <br>triphenylmethanol<br>0.0705        | Silclean 3700<br>0.0200 | dowanol<br>1.5600 | 2 % Nacure XP357<br>0.02 | 10mil | 1.5 Molar<br>Ratio of<br>Capping<br>Unit:<br>Building<br>Block |
| 6 | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine<br>0.2437 | <br>triphenylmethanol<br>0.1563        | Silclean 3700<br>0.0200 | dowanol<br>1.5600 | 2 % Nacure XP357<br>0.02 | 10mil | 0.5 Molar<br>Ratio of<br>Capping<br>Unit:<br>Building<br>Block |
| 7 | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine<br>0.3519 | <br>adamantane-1-methanol<br>0.0481  | Silclean 3700<br>0.0200 | dowanol<br>1.5600 | 2 % Nacure XP357<br>0.02 | 10mil | 0.5 Molar<br>Ratio of<br>Capping<br>Unit:<br>Building<br>Block |
| 8 | N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine<br>0.3635 | <br>4-methylbenzyl alcohol<br>0.0365 | Silclean 3700<br>0.0200 | dowanol<br>1.5600 | 2 % Nacure XP357<br>0.02 | 10mil | 0.5 Molar<br>Ratio of<br>Capping<br>Unit:<br>Building<br>Block |

|   |                                                                                                 |                                                                                                                                                           |               |         |                  |       |                                                 |
|---|-------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|---------|------------------|-------|-------------------------------------------------|
| 9 | <div>N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine</div> <div>0.3262</div> | <div><div>3-(phenyl(p-tolyl)amino)phenol</div></div> <div>0.0738</div> | Silclean 3700 | dowanol | 2 % Nacure XP357 | 10mil | 0.5 Molar Ratio of Capping Unit: Building Block |
|   |                                                                                                 |                                                                                                                                                           | 0.0200        | 1.5600  | 0.02             |       |                                                 |

**[00474]** All of the above formulations produced pinhole-free SOFs from visual inspection. FT-IR spectroscopy of the SOF demonstrated that the linking between THM-TBD building blocks and capping units was successful and efficient since –OH bands detected in the films were strongly attenuated or completely absent.

**[00475]** The thermal stability of the capped SOFs is comparable to that of the THM-TBD SOF without capping units. No decomposition observed until 400 °C, which is indicative of a highly-linked material.

**[00476]** Mechanical properties of films were strongly affected by the introduction of capping groups. The mechanical properties of capped SOF films were assessed by collecting stress-strain data for the free standing films. In general, SOF films containing capping units had greater toughness and a less-linear stress-strain curve compared to the pure SOF film constructed only from THM-TBD. The mechanical data clearly indicates that the change at the microscopic level attained through introduction of capping units into SOFs has a direct effect on the macroscopic properties of the film.

**[00477]** EXAMPLE 61:

**[00478]** (Action A) The following were combined: the building block N,N,N',N'-tetrakis-[(4-hydroxymethyl)phenyl]-biphenyl-4,4'-diamine [segment = N,N,N',N'-tetra-(p-tolyl)biphenyl-4,4'-diamine; Fg = hydroxy (-OH); in the amounts listed in Tables 5-8] and the capping unit, the additive Silclean 3700, the catalyst Nacure XP-357 and Dowanol (as designated in Table 3-6). The mixture was mixed on a rolling wave rotator for 10 min and then heated at 65 °C for 60 min until a homogenous solution resulted. The mixture was placed on the rotator and cooled to room temperature. The solution was filtered through a 1 micron PTFE membrane. (Action B) The reaction mixture was applied to a commercially available, 30 mm drum photoreceptor using a cup coater (Tsukiage coating) at a pull-rate of 485 mm/min. (Action C) The photoreceptor drum supporting the wet layer was rapidly transferred to an actively vented oven preheated to 140 °C and left to heat for 40 min. These actions provided a film having a thickness ranging from 6 to 7 microns.

Table 5: Test 11—low B4M loading (12 wt %, 4.5 mmol)

| Type                | Building Block | Cap Unit | Curing    | Catalyst      | Additive      | Solvent    | % Solid Content |
|---------------------|----------------|----------|-----------|---------------|---------------|------------|-----------------|
| Compound            | THM-TBD        | B4M      | Cymel 303 | Nacure XP-357 | Silclean 3700 | Dowanol PM | 28.0%           |
| % Active            | 1.00           | 1.00     | 1.00      | 0.20          | 0.25          | 0.00       | Total Mass      |
| Total weight (gr.)  | 3.6856         | 0.5461   | 0.2275    | 0.2264        | 0.1815        | 11.4000    | 16.2671         |
| Active weight (gr.) | 3.69           | 0.55     | 0.23      | 0.05          | 0.05          | 0.00       | Scaling Factor  |
| Percent weight (%)  | 81.00%         | 12.00%   | 5.00%     | 1.00%         | 1.00%         | 0.00%      | 1.50            |
| Scaled weight (gr.) | 5.5284         | 0.8192   | 0.3413    | 0.3396        | 0.2723        | 17.1000    | 24.4007         |
| Actual weight (gr.) | 5.5290         | 0.8189   | 0.3434    | 0.3408        | 0.2744        | 17.1096    | 24.4161         |

Table 6: Test 12—high B4M loading (30 wt %, 11 mmol)

| Type                | Building Block | Cap Unit | Curing    | Catalyst      | Additive      | Solvent    | % Solid Content |
|---------------------|----------------|----------|-----------|---------------|---------------|------------|-----------------|
| Compound            | THM-TBD        | B4M      | Cymel 303 | Nacure XP-357 | Silclean 3700 | Dowanol PM | 28.0%           |
| % Active            | 1.00           | 1.00     | 1.00      | 0.20          | 0.25          | 0.00       | Total Mass      |
| Total weight (gr.)  | 2.8668         | 1.3652   | 0.2275    | 0.2264        | 0.1815        | 11.4000    | 16.2674         |
| Active weight (gr.) | 2.87           | 1.37     | 0.23      | 0.05          | 0.05          | 0.00       | Scaling Factor  |
| Percent weight (%)  | 63.00%         | 30.00%   | 5.00%     | 1.00%         | 1.00%         | 0.00%      | 1.50            |
| Scaled weight (gr.) | 4.3002         | 2.0478   | 0.3413    | 0.3396        | 0.2723        | 17.1000    | 24.4011         |
| Actual weight (gr.) | 4.3001         | 2.0485   | 0.3444    | 0.3330        | 0.2712        | 17.1078    | 24.4050         |

Table 7: Test 13—low MHM-TPA loading (17 wt %, 4.5 mmol)

| Type                | Building Block | Cap Unit | Curing    | Catalyst      | Additive      | Solvent    | % Solid Content |
|---------------------|----------------|----------|-----------|---------------|---------------|------------|-----------------|
| Compound            | THM-TBD        | MHM-TPA  | Cymel 303 | Nacure XP-357 | Silclean 3700 | Dowanol PM | 28.0%           |
| % Active            | 1.00           | 1.00     | 1.00      | 0.20          | 0.25          | 0.00       | Total Mass      |
| Total weight (gr.)  | 3.4581         | 0.7736   | 0.2275    | 0.2264        | 0.1815        | 11.4000    | 16.2671         |
| Active weight (gr.) | 3.46           | 0.77     | 0.23      | 0.05          | 0.05          | 0.00       | Scaling Factor  |
| Percent weight (%)  | 76.00%         | 17.00%   | 5.00%     | 1.00%         | 1.00%         | 0.00%      | 1.50            |
| Scaled weight (gr.) | 5.1872         | 1.1604   | 0.3413    | 0.3396        | 0.2723        | 17.1000    | 24.4007         |
| Actual weight (gr.) | 5.1869         | 1.1603   | 0.3407    | 0.3390        | 0.2710        | 17.0993    | 24.3972         |

Table 8: Test 14—high MHM-TPA loading (37 wt %, 11 mmol)

| Type                | Building Block | Cap Unit | Curing    | Catalyst      | Additive      | Solvent    | % Solid Content |
|---------------------|----------------|----------|-----------|---------------|---------------|------------|-----------------|
| Compound            | THM-TBD        | MHM-TPA  | Cymel 303 | Nacure XP-357 | Silclean 3700 | Dowanol PM | 28.0%           |
| % Active            | 1.00           | 1.00     | 1.00      | 0.20          | 0.25          | 0.00       | Total Mass      |
| Total weight (gr.)  | 2.5483         | 1.6837   | 0.2275    | 0.2264        | 0.1815        | 11.4000    | 16.2674         |
| Active weight (gr.) | 2.55           | 1.68     | 0.23      | 0.05          | 0.05          | 0.00       | Scaling Factor  |
| Percent weight (%)  | 56.00%         | 37.00%   | 5.00%     | 1.00%         | 1.00%         | 0.00%      | 1.50            |
| Scaled weight (gr.) | 3.8225         | 2.5256   | 0.3413    | 0.3396        | 0.2723        | 17.1000    | 24.4011         |
| Actual weight (gr.) | 3.8227         | 2.5270   | 0.3413    | 0.3405        | 0.2716        | 17.1024    | 24.4055         |

**[00479]** All of the above formulations produced pinhole-free SOFs from visual inspection. FT-IR spectroscopy of the SOF demonstrated that the linking between THM-TBD building blocks and capping units was successful and efficient since –OH bands detected in the films were strongly attenuated or completely absent. FIG. 15 is a photo-induced discharge curve (PIDC) illustrating the photoconductivity of a capped SOF overcoat layer (voltage at 75 ms (expose-to-measure)). The electrical properties of the devices are excellent (low  $V_r$  and no cycle up). See PIDCs and cycling data in Figures 15 and 16, respectively.

**[00480]** BCR wear data for capped SOF OCLs shows (for both types of capping units) higher wear rates with respect to capping unit loading. The wear magnitude and difference between high and low loadings is small, indicating that considerable latitude exists to increase wear rates by further increasing capping unit loading, which would also lower the amount (and cost) of required HTM.

**[00481]** Print tests present no print quality issues and are essentially identical to non-overcoated P/R devices.

**[00482]** It will be appreciated that several of the above-disclosed and other features and functions, or alternatives thereof, may be desirably combined into many other different systems or applications. The scope of the claims should not be limited by the preferred embodiments set forth in the examples, but should be given the broadest interpretation consistent with the specification as a whole. Unless specifically recited in a claim, steps or components of claims should not be implied or imported from the specification or any other claims as to any particular order, number, position, size, shape, angle, color, or material.

WHAT IS CLAIMED IS:

1. An imaging member for ink-based digital printing comprising:  
a substrate;  
a charge generating layer;  
a charge transport layer; and  
an optional overcoat layer;

wherein an outermost layer of the imaging member is an imaging surface that comprises a structured organic film (SOF) comprising a plurality of segments including at least a first segment type and a plurality of linkers including at least a first linker type arranged as a covalent organic framework (COF), wherein the first segment type and/or the first linker type comprises at least one atom that is not carbon.

2. The imaging member of claim 1, wherein the charge transport layer is the outermost layer, and the charge transport layer is from about 10 to about 40 microns thick.

3. The imaging member of claim 1, wherein the charge generating layer and the charge transport layer are combined into a single layer with a thickness from about 10 to about 40 microns.

4. The imaging member of claim 3, wherein the single layer is the outermost layer.

5. The imaging member of claim 1, wherein the charge generating layer absorbs electromagnetic radiation between from about 400 nm to about 800 nm.

6. The imaging member of claim 1, wherein the SOF is a composite SOF.

7. The imaging member of claim 1, wherein the SOF has an added functionality of electroactivity.

8. The imaging member of claim 7, wherein the added functionality of electroactivity is hole transport or electron transport.

9. The imaging member of claim 1, wherein the framework of the SOF comprises a capping unit.

10. The imaging member of claim 1, comprising an overcoat layer, wherein the outermost layer is the overcoat layer, and the overcoat layer is from about 1 to about 10 microns thick.

11. The imaging member of claim 1, wherein the imaging surface that comprises the SOF is not physically damaged after about 24 hours of continuous exposure to an ink.

12. The imaging member of claim 11, wherein the ink is selected from the group consisting of: liquid toner, dye-based ink, pigment-based ink, adhesive, surface finish treatment, protective coating, and electrically conductive material.

13. An imaging apparatus for ink-based digital printing, comprising:  
 an imaging member, wherein an outermost layer of the imaging member comprises a structured organic film (SOF) comprising a plurality of segments including at least a first segment type and a plurality of linkers including at least a first linker type arranged as a covalent organic framework (COF), wherein the first segment type and/or the first linker type comprises at least one atom that is not carbon;  
 a charging unit to impart an electrostatic charge on the imaging member;  
 an exposure unit to create an electrostatic latent image on the imaging member;  
 an ink delivery unit to create an ink image on the imaging member;  
 a transfer unit to transfer the ink image from the imaging member; and  
 an optional cleaning unit.

14. The imaging apparatus of claim 13, wherein the ink delivery unit comprising an anilox roller to fill ink from an ink supply into cells in the anilox roller;  
 a soft blade positioned slightly below surface of the lands to partially remove ink from the cells; and  
 an optional a hard blade positioned at the surface of the lands to clean residue of ink on the surface of the lands as the anilox roller rotates.

15. The imaging apparatus of claim 14, wherein the ink is a liquid with a viscosity above 100 cp.

16. The imaging apparatus of claim 14, wherein the ink is selected from the group consisting of: liquid toner, dye-based ink, pigment-based ink, adhesive, surface finish treatment, protective coating, and electrically conductive material.

17. The imaging apparatus of claim 14, wherein the imaging surface that comprises the SOF is not physically damaged after about 24 hours of continuous exposure to the ink.

18. The imaging apparatus of claim 13, wherein the SOF is a composite SOF.

19. The imaging apparatus of claim 13, wherein the SOF has an added functionality of electroactivity.

20. The imaging apparatus of claim 13, wherein the framework of the SOF comprises a capping unit.

21. The imaging member of claim 1, wherein the at least one atom of an element that is not carbon is selected from the group consisting of hydrogen, oxygen, nitrogen, silicon, phosphorous, selenium, fluorine, boron, and sulfur.

22. The imaging apparatus of claim 13, wherein the at least one atom of an element that is not carbon is selected from the group consisting of hydrogen, oxygen, nitrogen, silicon, phosphorous, selenium, fluorine, boron, and sulfur.

23. An imaging member for ink-based digital printing comprising:
- a substrate;
  - a charge generating layer;
  - a charge transport layer; and
  - an optional overcoat layer;

wherein an outermost layer of the imaging member is an imaging surface that comprises a structured organic film (SOF) comprising a plurality of segments including at least a first segment type and a plurality of linkers including at least a first linker type arranged as a covalent organic framework (COF), wherein the SOF is a substantially defect-free film, and the first segment type and/or the first linker type comprises a hydrogen.

24. The imaging member of claim 23, wherein the plurality of segments and/or the plurality of the linkers comprises at least one atom selected from the group

consisting of oxygen, nitrogen, silicon, phosphorous, selenium, fluorine, boron, and sulfur.

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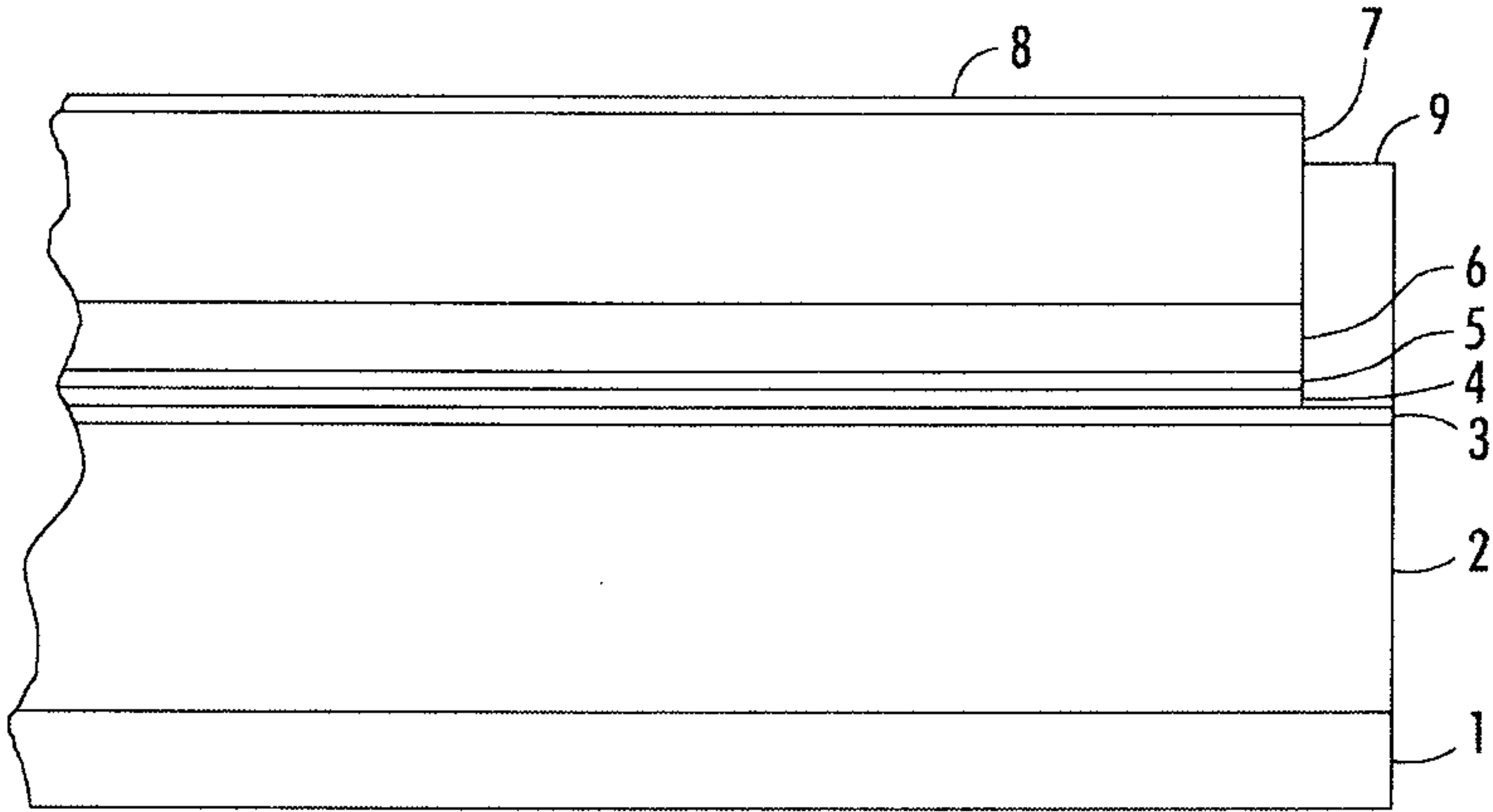


**FIG. 1**

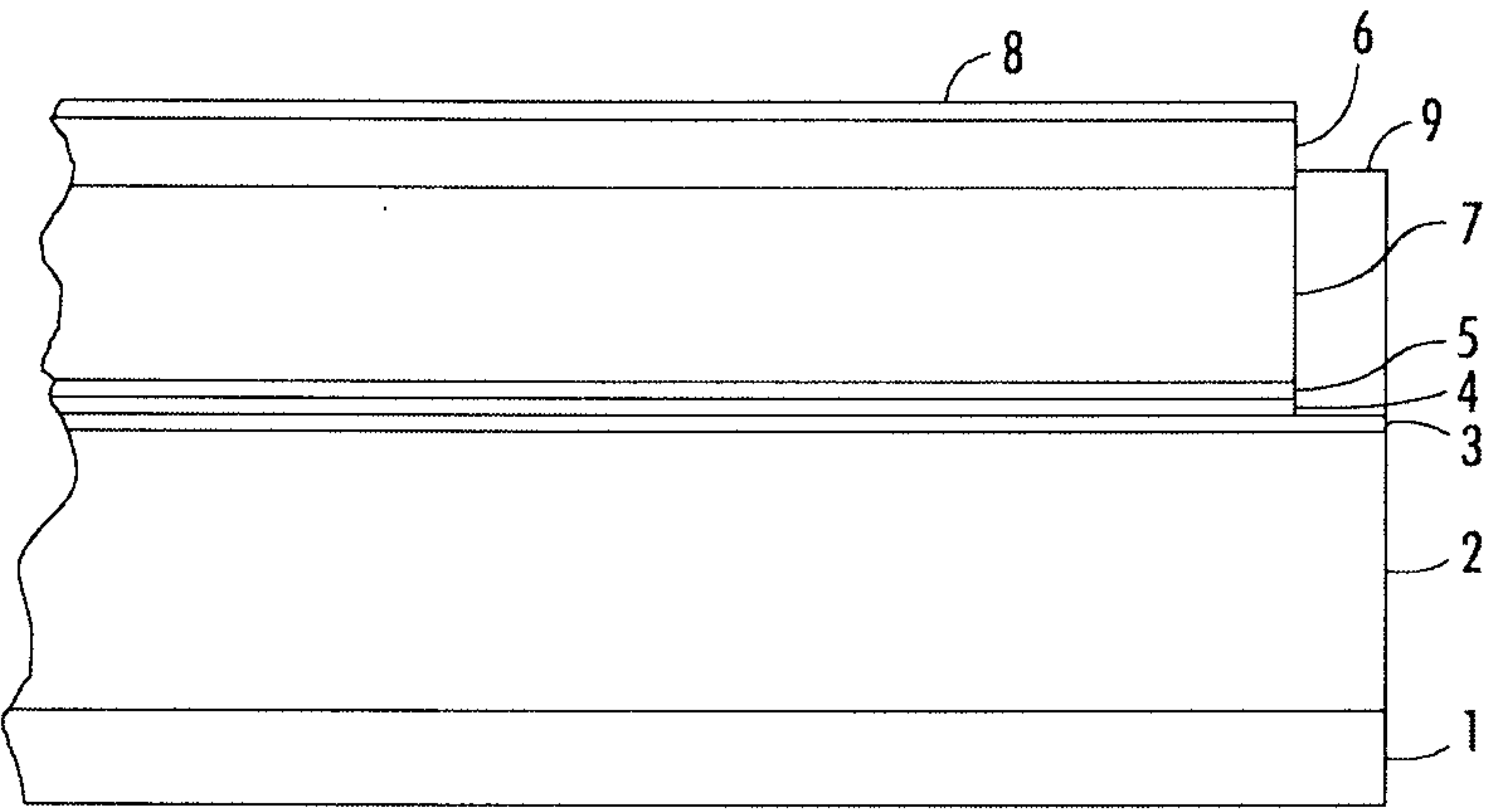


**FIG. 2**

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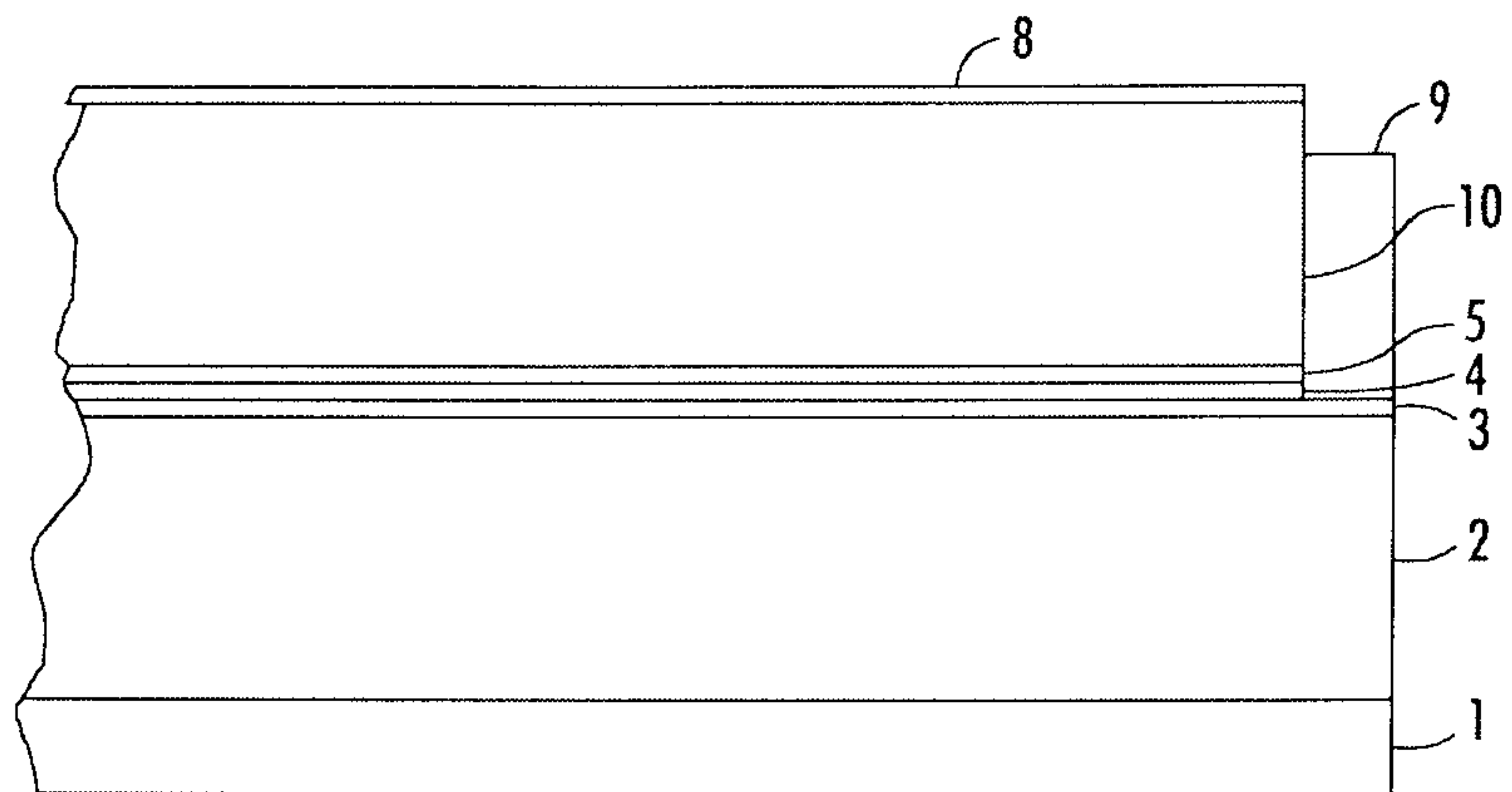
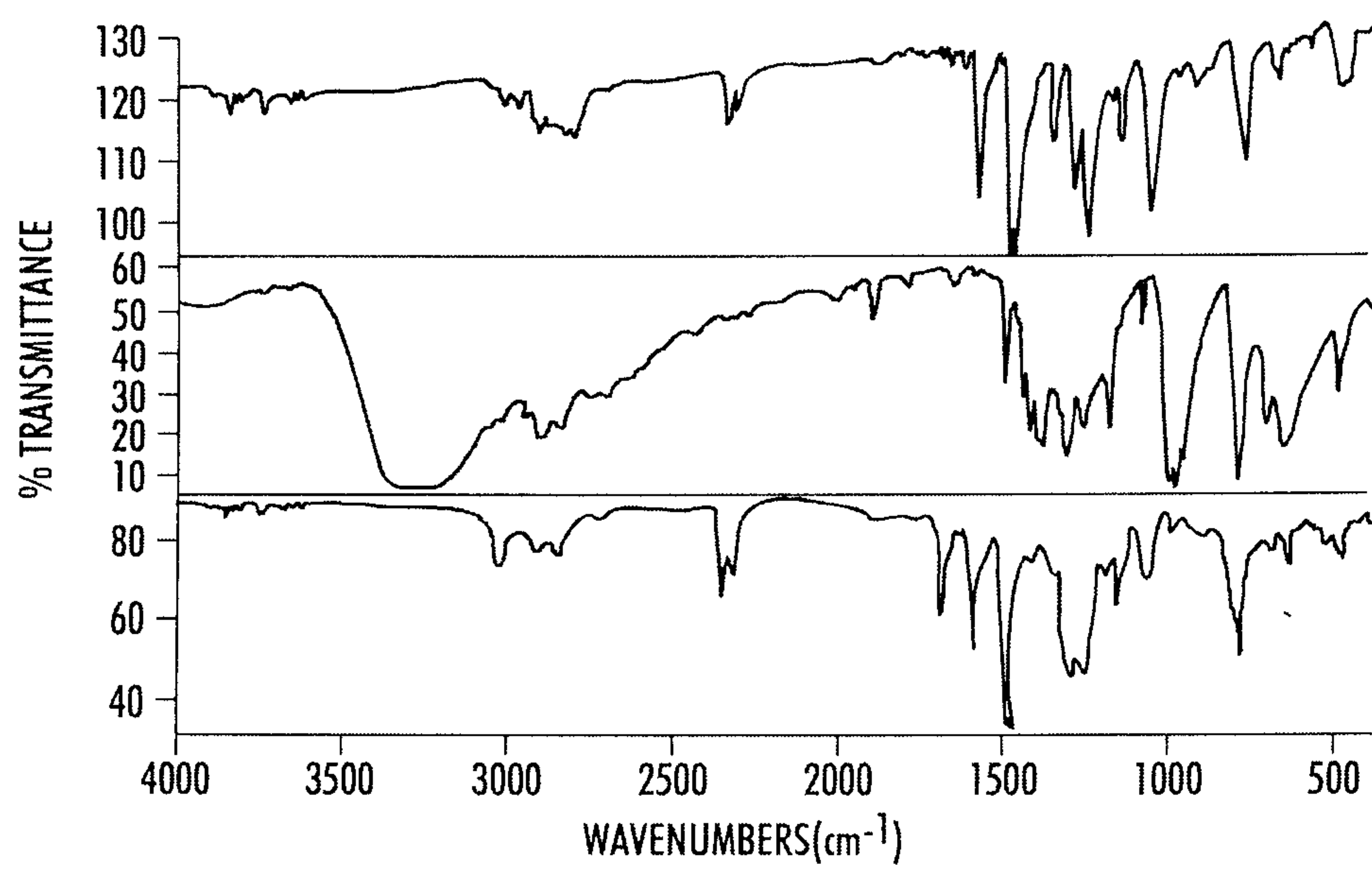
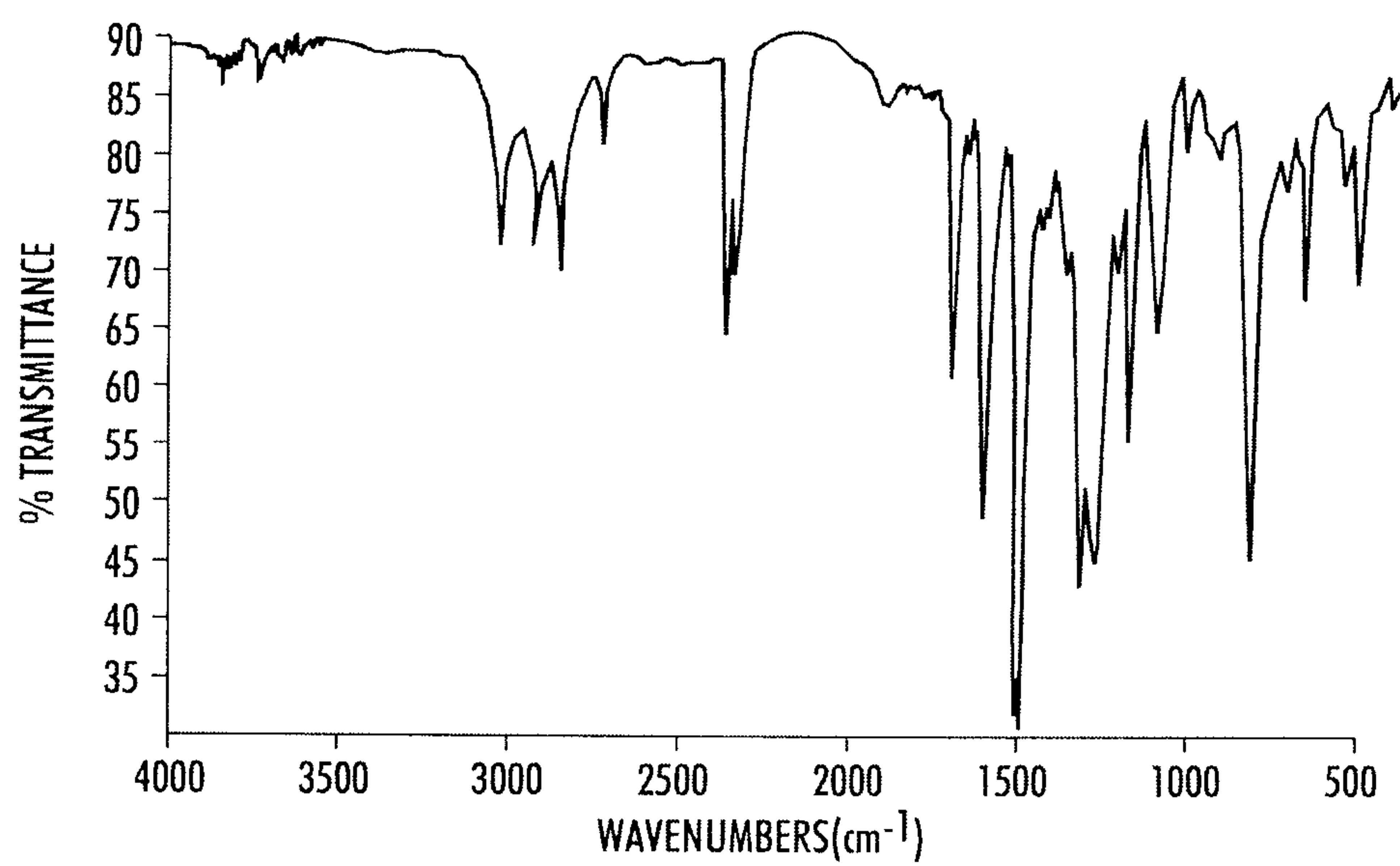
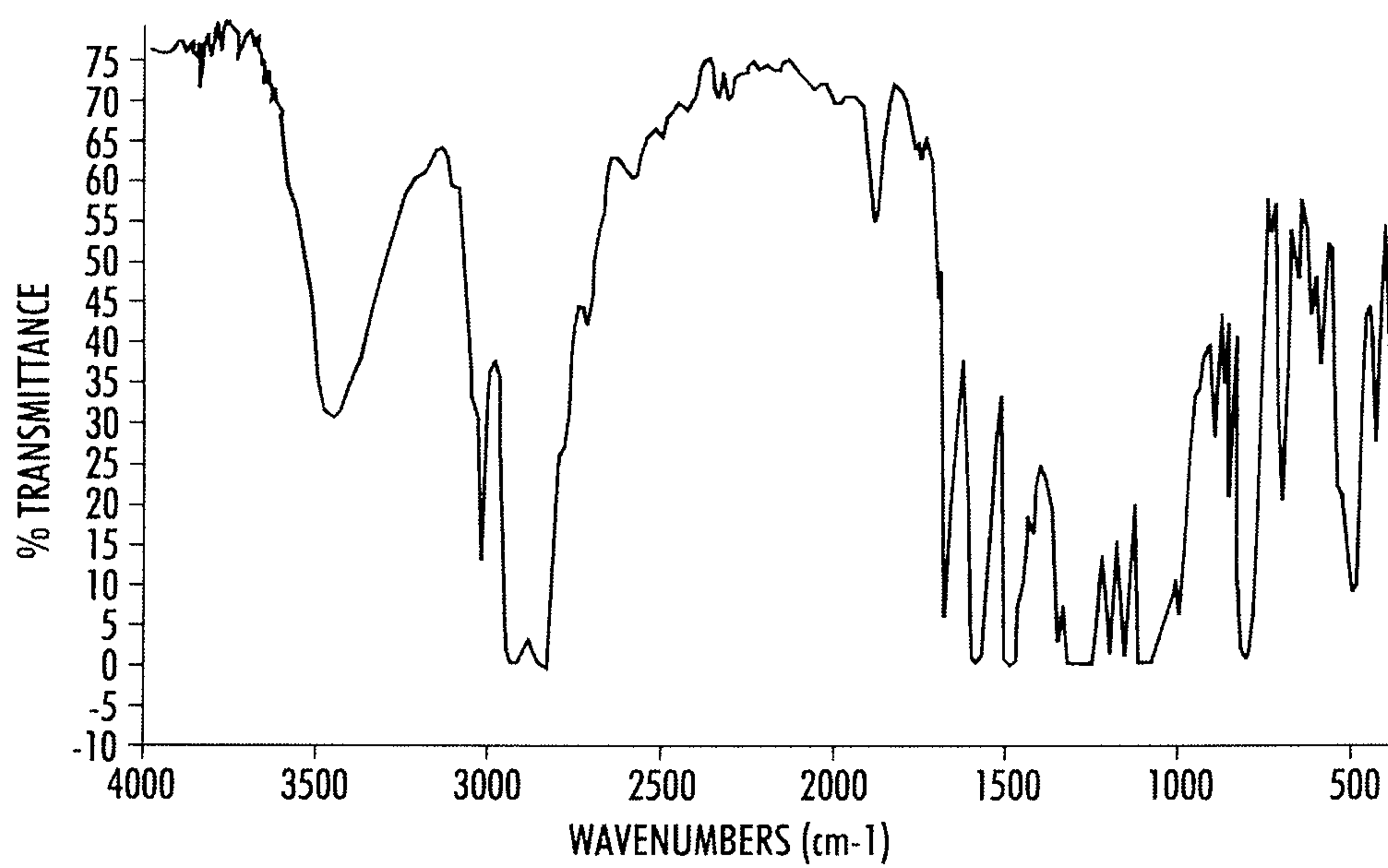
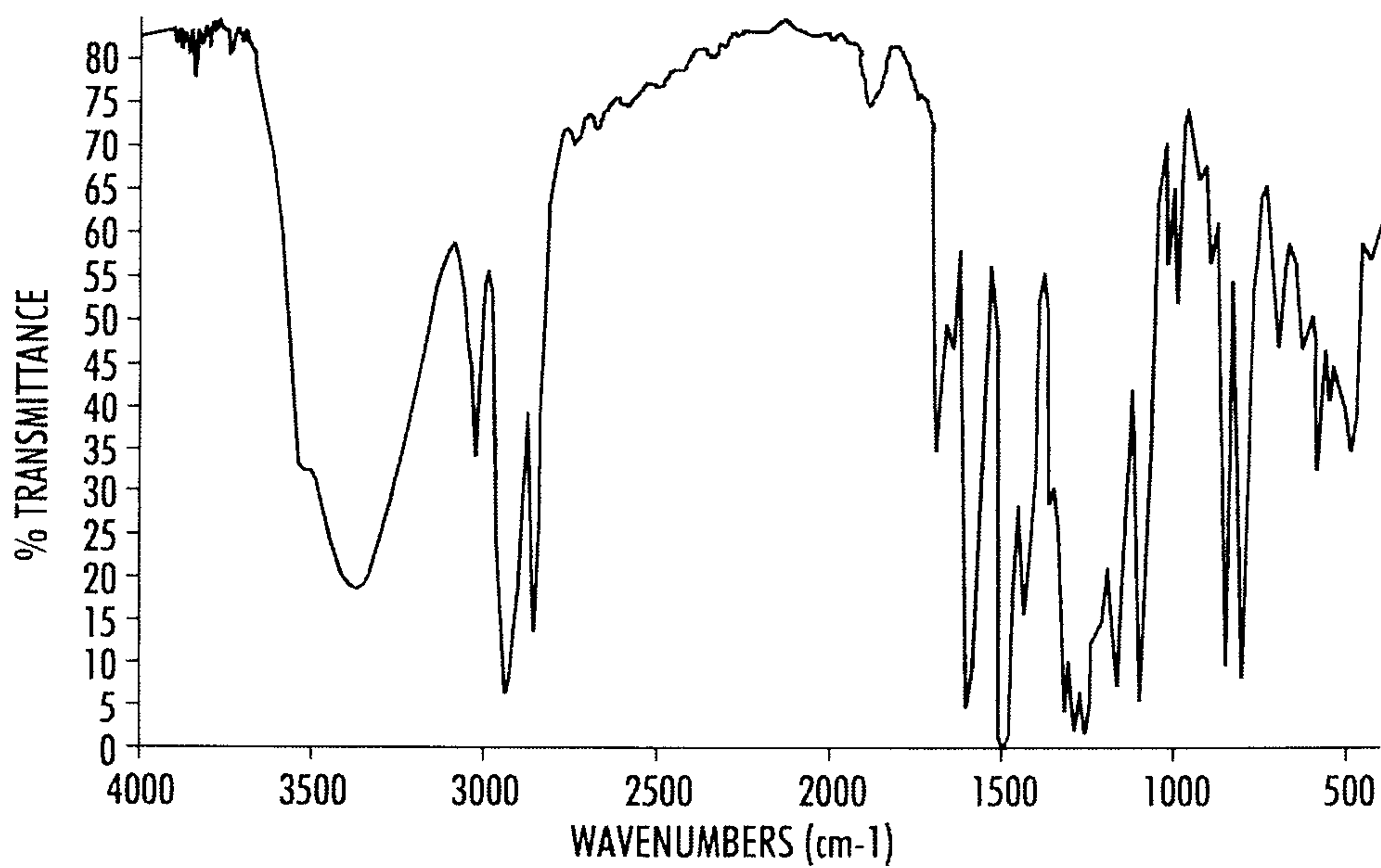


**FIG. 3**

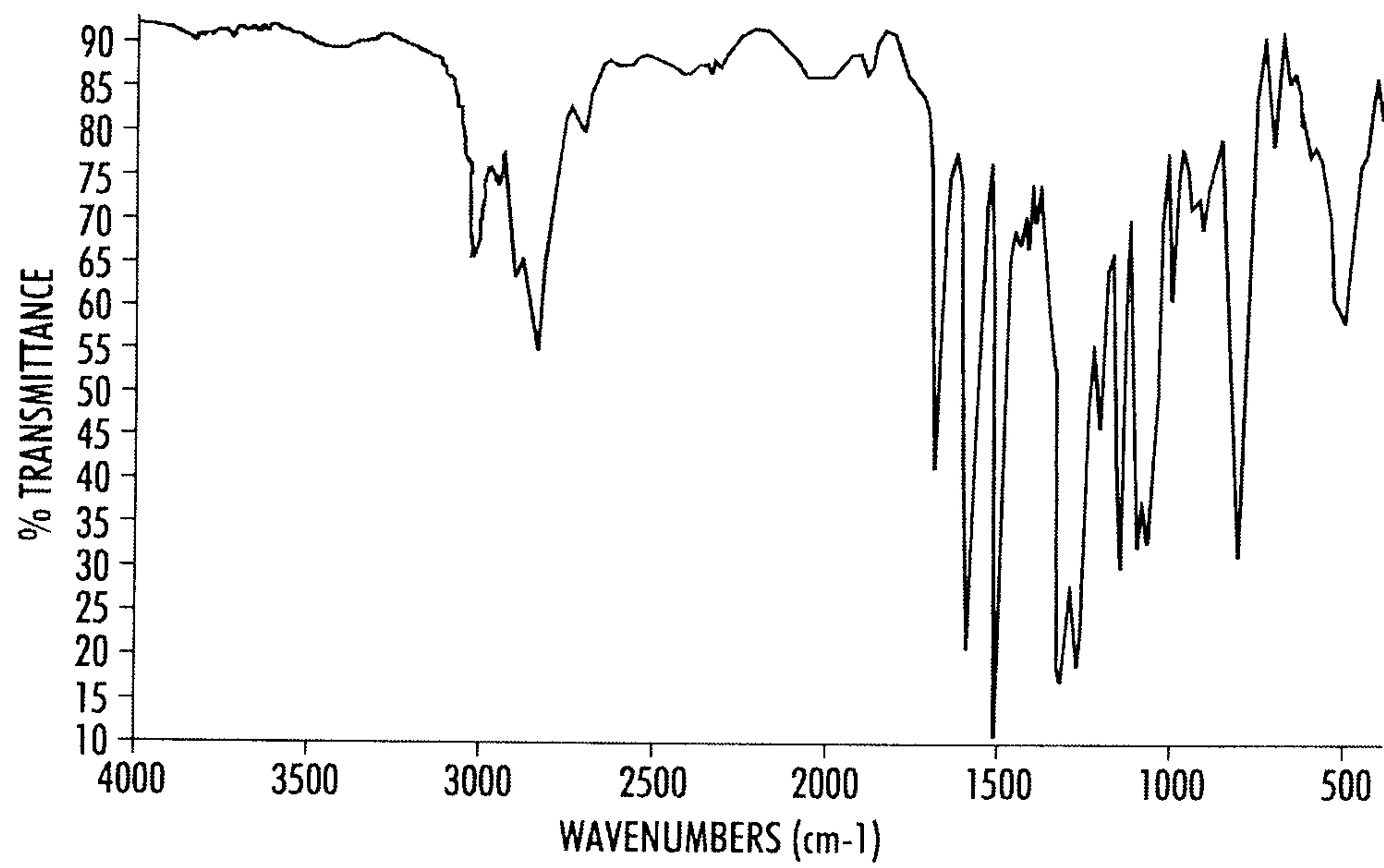
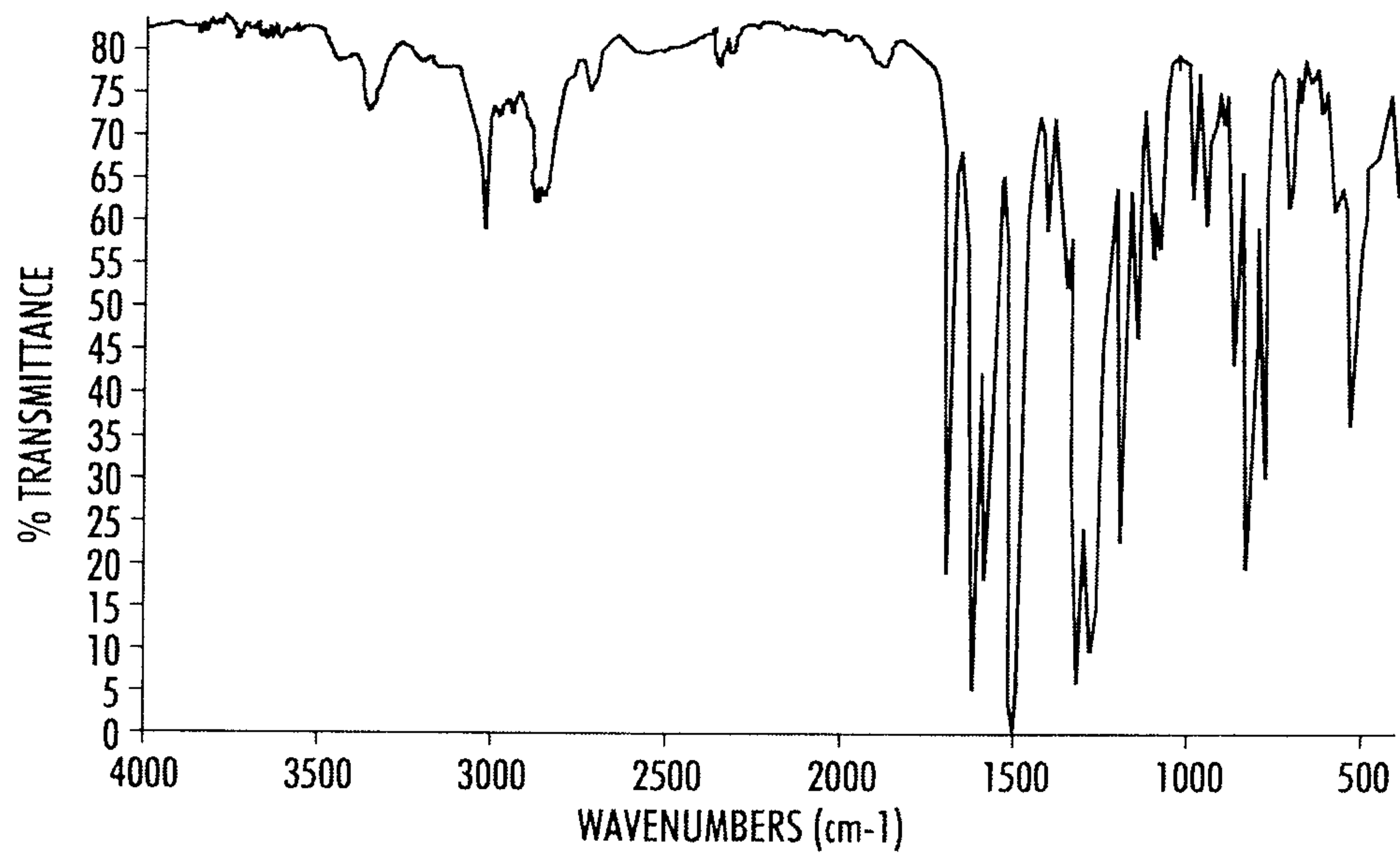
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**FIG. 4****FIG. 5**

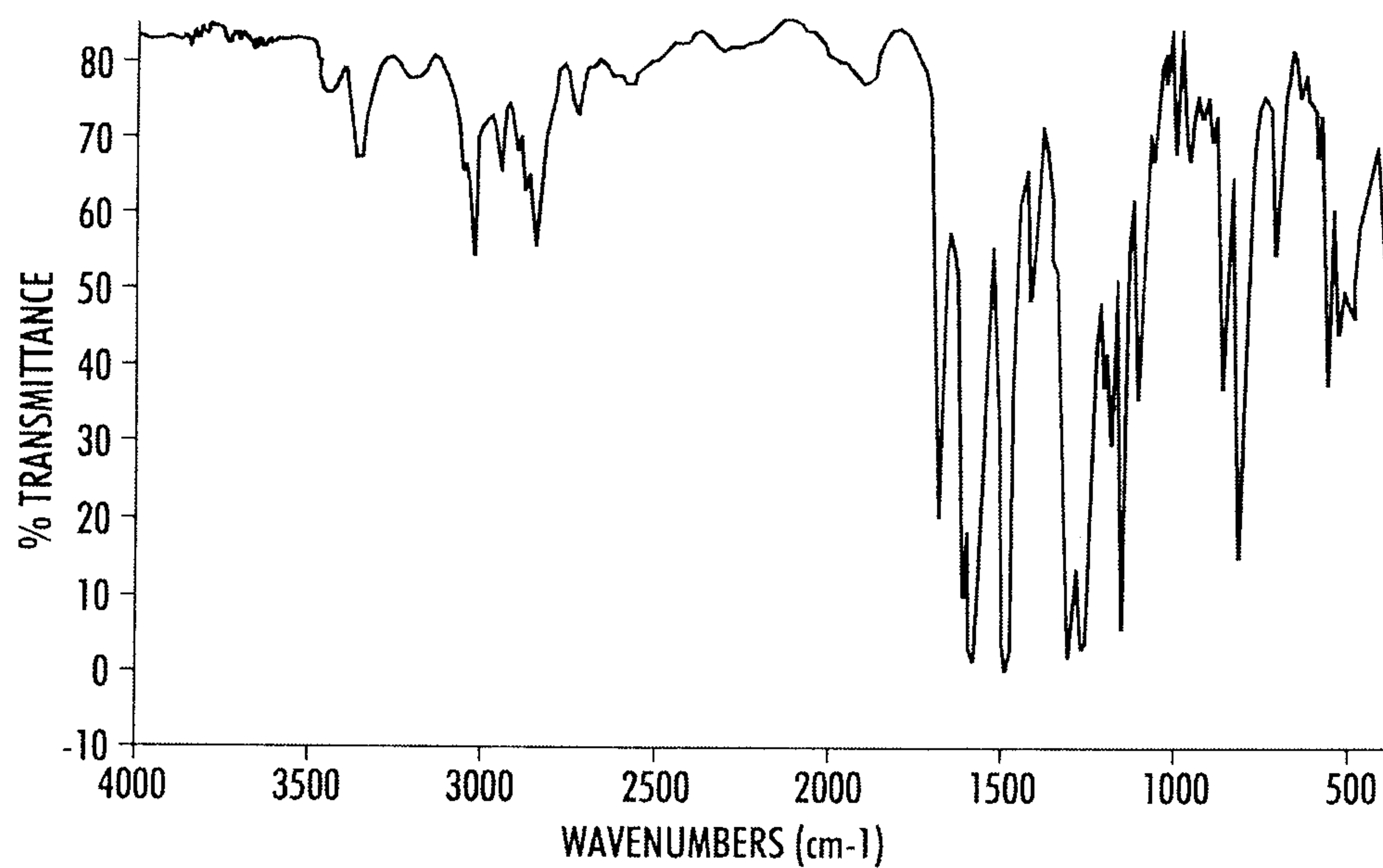
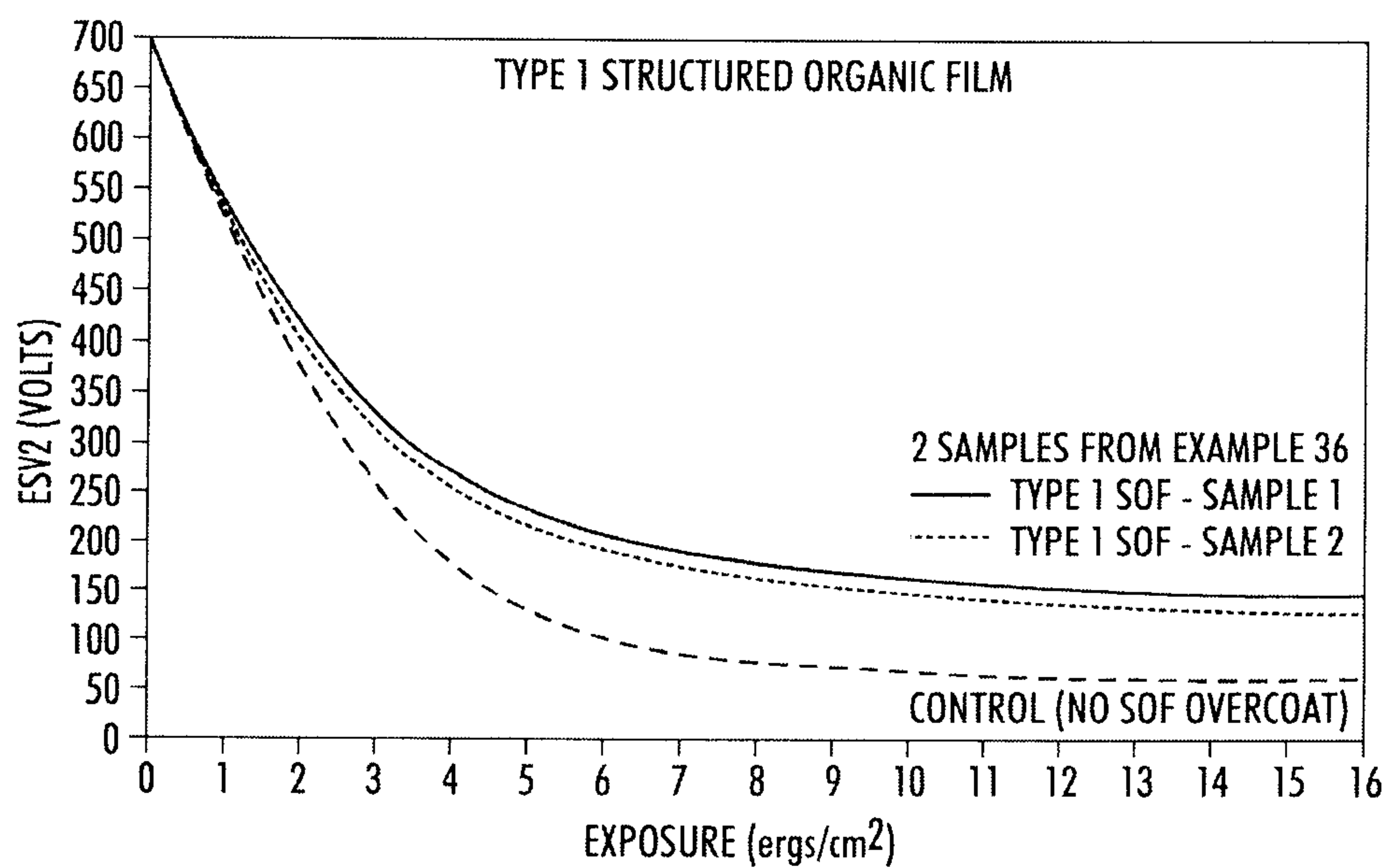
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**FIG. 6****FIG. 7**

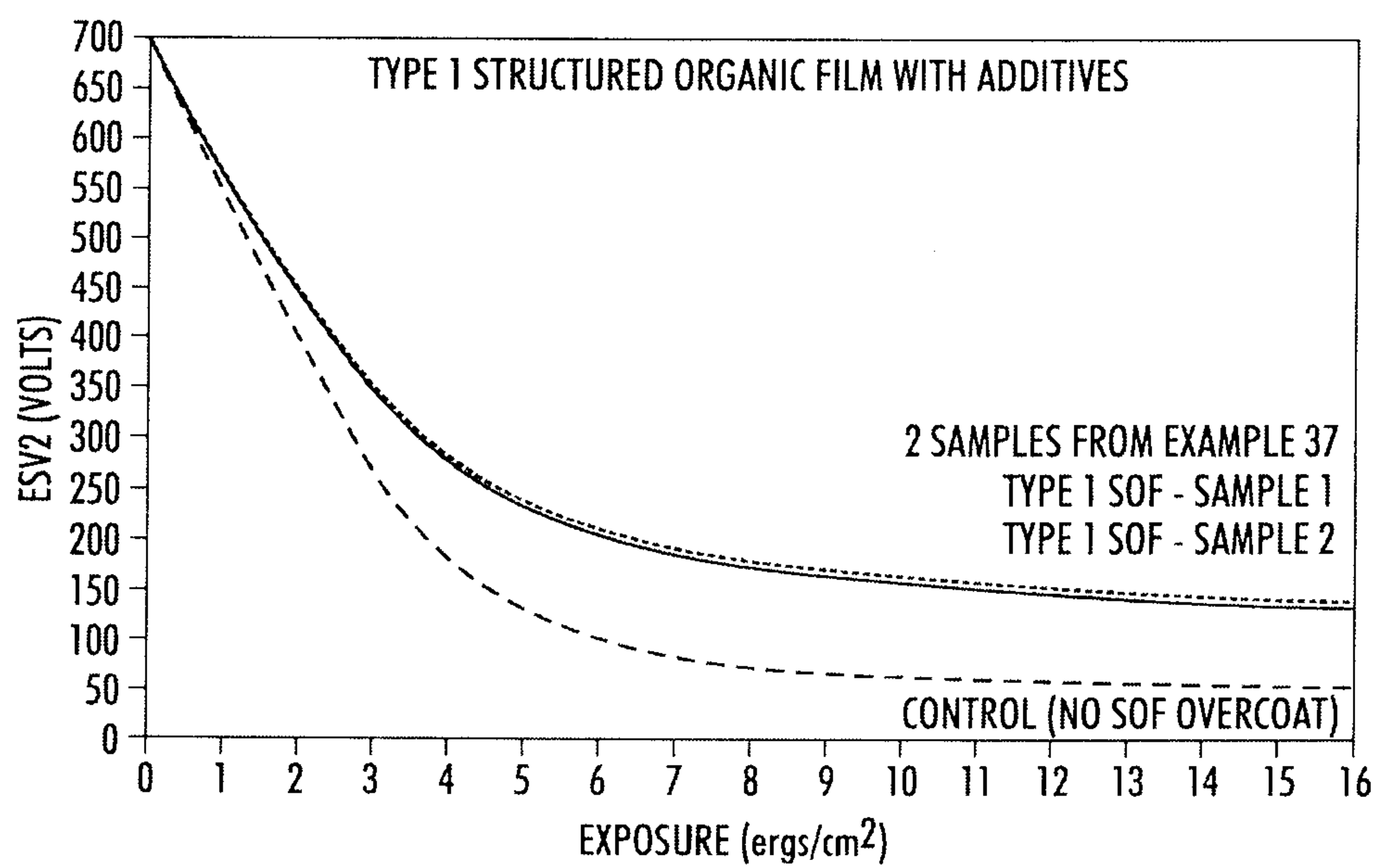
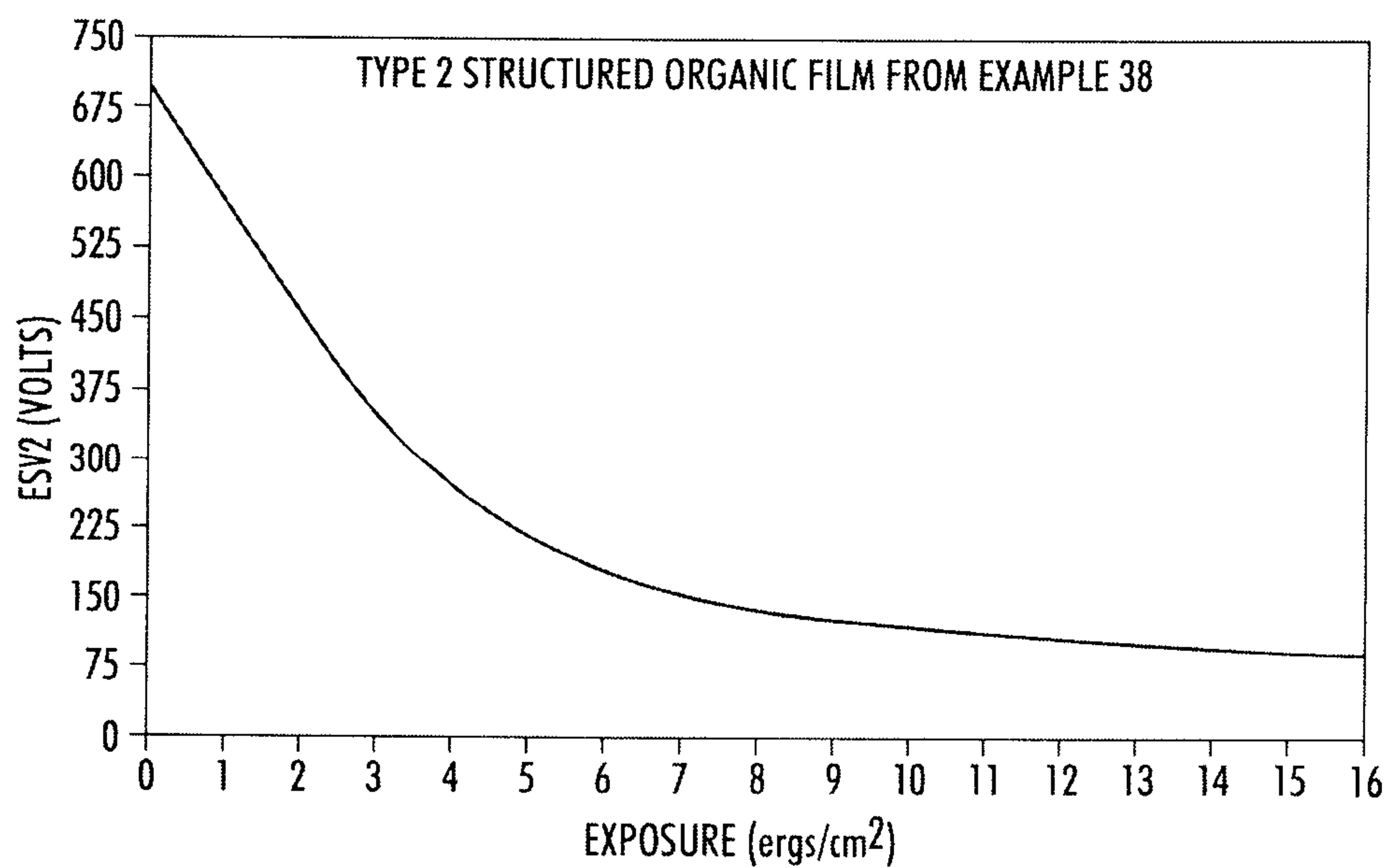
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**FIG. 8****FIG. 9**

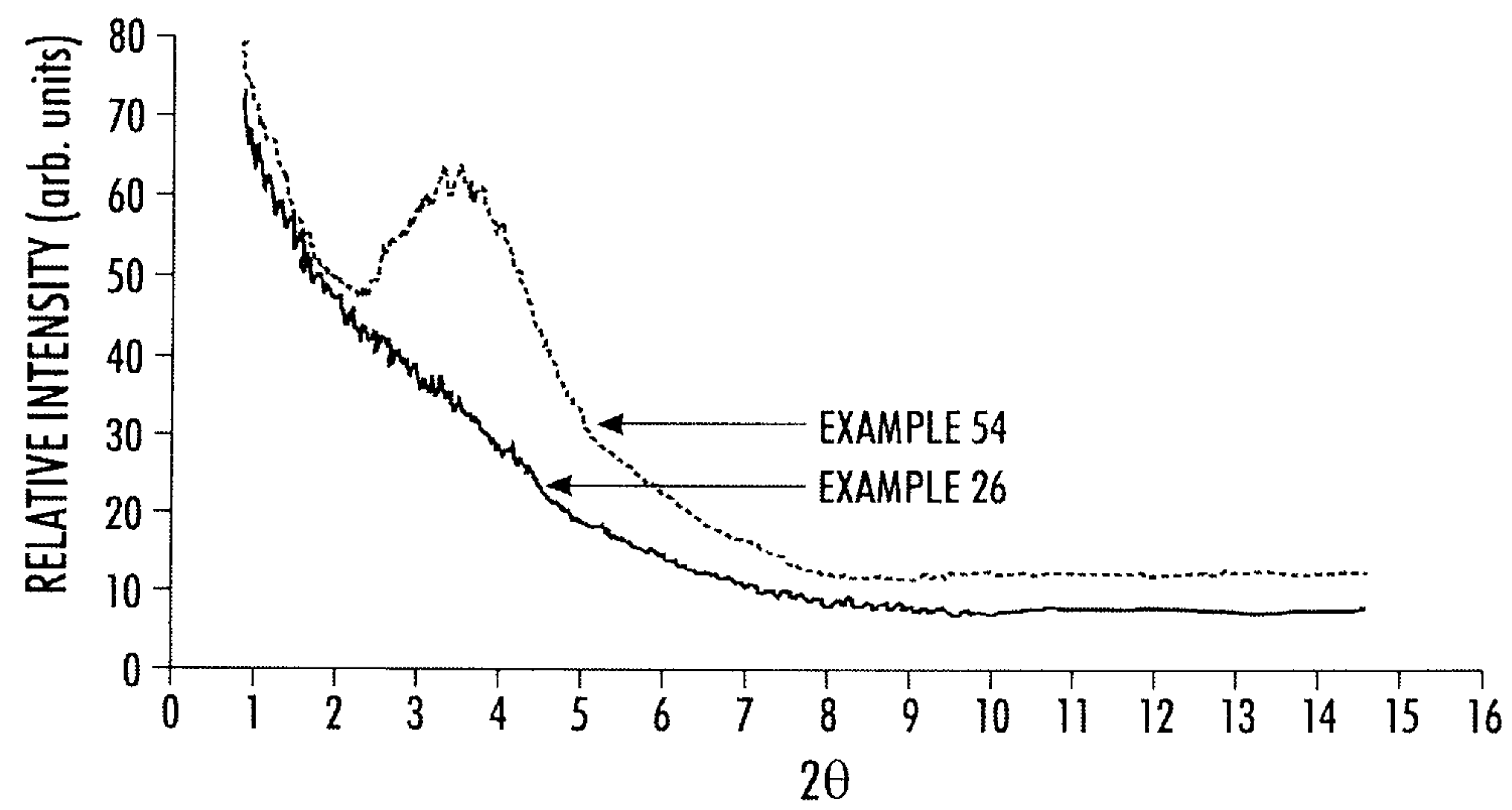
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**FIG. 10****FIG. 11**

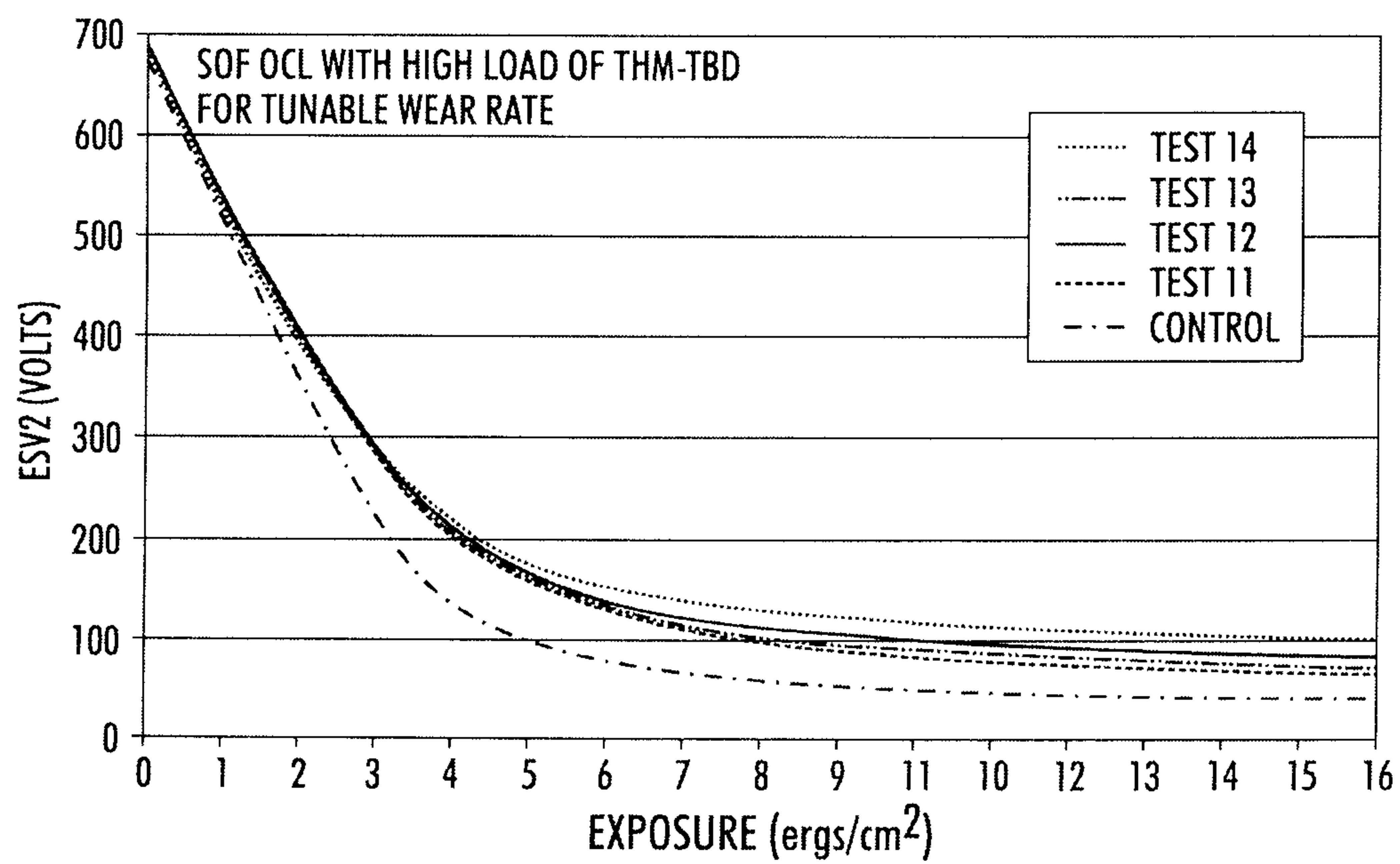
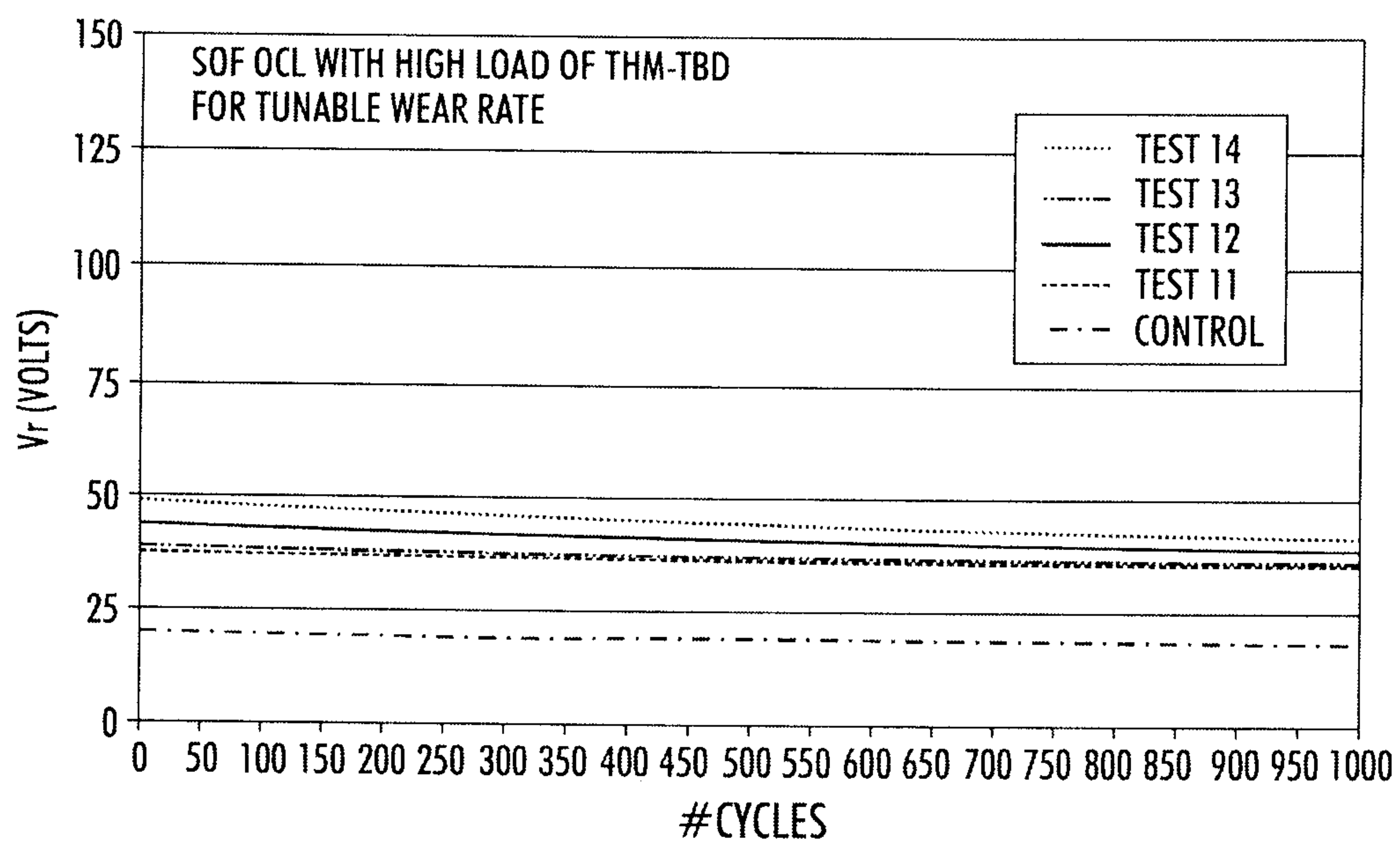
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**FIG. 12****FIG. 13**

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**FIG. 14**

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**FIG. 15****FIG. 16**

