



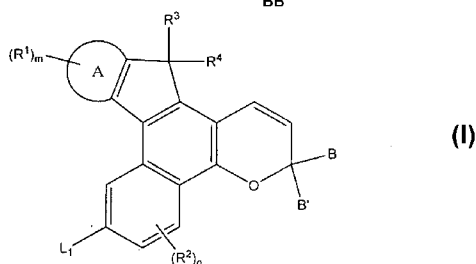
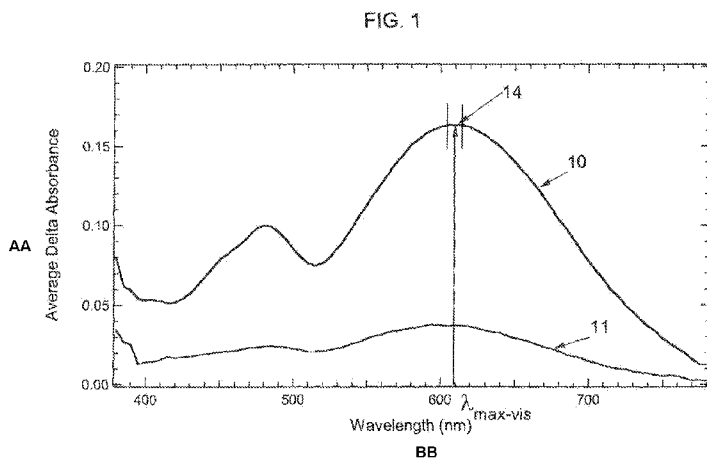
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[Continued on next page]

(54) Title: PHOTOCROMIC COMPOUNDS AND COMPOSITIONS



(57) Abstract: The present invention relates to compounds represented by the following Formula (I). Ring-A of the Formula (I) can be, for example an aryl group, and L<sub>1</sub> is a chiral or achiral lengthening group. The compound represented by Formula (I) can be a photochromic compound. The present invention also relates to photochromic compositions and photochromic articles that include one or more photochromic compounds, such as represented by Formula (I).





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## PHOTOCHROMIC COMPOUNDS AND COMPOSITIONS

### CROSS REFERENCE TO RELATED APPLICATIONS

[001] This application is a continuation-in-part of U.S. Patent Application Serial Number 12/329,092 filed on December 5, 2008, which is a continuation-in-part of U.S. Patent Application Serial Number 10/846,629, filed May 17, 2004 (now U.S. Patent 7,342,112), and which in turn claims the benefit of U.S. Provisional Application Serial Number 60/484,100, filed July 1, 2003, all of which documents are hereby incorporated herein by reference in their entireties.

### FIELD OF THE INVENTION

[002] The present invention relates to photochromic compounds, and compositions and articles that include the photochromic compounds of the present invention.

### BACKGROUND OF THE INVENTION

[003] Conventional photochromic compounds have at least two states, a first state having a first absorption spectrum and a second state having a second absorption spectrum that differs from the first absorption spectrum, and are capable of switching between the two states in response to at least actinic radiation. Further, conventional photochromic compounds can be thermally reversible. That is, conventional photochromic compounds are capable of switching between a first state and a second state in response to at least actinic radiation and reverting back to the first state in response to thermal energy. As used herein "actinic radiation" means electromagnetic radiation, such as but not limited to ultraviolet and visible radiation that is capable of causing a response. More specifically, conventional photochromic compounds can undergo a transformation in response to actinic radiation from one isomer to another, with each isomer having a characteristic absorption spectrum, and can further revert back to the first isomer in response to thermal energy (i.e., be thermally reversible). For example, conventional thermally reversible photochromic compounds are generally capable of switching from a first state, for example a "clear state," to a second state, for example a "colored state," in response to actinic radiation and reverting back to the "clear" state in response to thermal energy.

[004] Dichroic compounds are compounds that are capable of absorbing one of two orthogonal plane polarized components of transmitted radiation more strongly than the other. Thus, dichroic compounds are capable of linearly polarizing transmitted radiation. As used

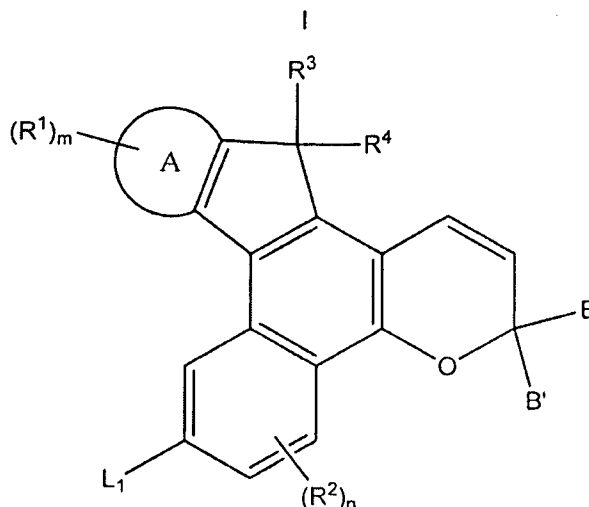
herein, "linearly polarize" means to confine the vibrations of the electric vector of light waves to one direction or plane. However, although dichroic materials are capable of preferentially absorbing one of two orthogonal plane polarized components of transmitted radiation, if the molecules of the dichroic compound are not suitably positioned or arranged, no net linear polarization of transmitted radiation will be achieved. That is, due to the random positioning of the molecules of the dichroic compound, selective absorption by the individual molecules will cancel each other such that no net or overall linear polarizing effect is achieved. Thus, it is generally necessary to suitably position or arrange the molecules of the dichroic compound within another material in order to form a conventional linear polarizing element, such as a linearly polarizing filter or lens for sunglasses.

**[005]** In contrast to the dichroic compounds, it is generally not necessary to position or arrange the molecules of conventional photochromic compounds to form a conventional photochromic element. Thus, for example, conventional photochromic elements, such as lenses for photochromic eyewear, can be formed, for example, by spin coating a solution containing a conventional photochromic compound and a "host" material onto the surface of the lens, and suitably curing the resultant coating or layer without arranging the photochromic compound in any particular orientation. Further, even if the molecules of the conventional photochromic compound were suitably positioned or arranged as discussed above with respect to the dichroic compounds, because conventional photochromic compounds do not strongly demonstrate dichroism, elements made therefrom are generally not strongly linearly polarizing.

**[006]** It would be advantageous to provide photochromic compounds, such as but not limited to thermally reversible photochromic compounds, that can exhibit useful photochromic and/or dichroic properties in at least one state, and that can be used in a variety of applications to impart photochromic and/or dichroic properties.

#### **SUMMARY OF THE INVENTION**

**[007]** In accordance with the present invention there is provided a compound represented by the following Formula I,



**[008]** Ring-A of Formula-I, and other related formulas disclosed further herein, is selected from, aside from the  $(R^1)_m$ - group, unsubstituted aryl, substituted aryl, unsubstituted fused ring aryl, substituted fused ring aryl, unsubstituted heteroaryl, and substituted heteroaryl. With some embodiments, Ring-A is selected from aryl, fused ring aryl, and heteroaryl.

**[009]** With further reference of Formula-I, and other related formulas disclosed further herein,  $m$  is selected from 0 to a total number of positions to which  $R^1$  can be bonded to Ring-A, such as 0 to 4 when Ring-A is a 6-membered aromatic ring. In addition,  $R^1$ , for each  $m$ , is independently selected from,  $L_2$  as described further herein, and a chiral or achiral group selected from formyl, alkylcarbonyl, alkoxycarbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxycarbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkyloxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino.

**[010]** With further reference to Formula-I, and other related formulas disclosed further herein,  $n$  is selected from 0 to 3. In addition,  $R^2$ , for each  $n$ , is independently a chiral or achiral group selected from, formyl, alkylcarbonyl, alkoxycarbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxycarbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkyloxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted

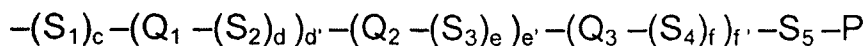
aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino.

**[011]** The R<sup>3</sup> and R<sup>4</sup> groups of the compound represented by Formula-I and other related formulas disclosed further herein, are each independently selected from, hydrogen, hydroxyl, and a chiral or achiral group selected from optionally substituted heteroalkyl, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, optionally substituted heterocycloalkyl, halogen, optionally substituted amino, carboxy, alkylcarbonyl, alkoxy carbonyl, optionally substituted alkoxy, and aminocarbonyl. Alternatively, one of R<sup>3</sup> and R<sup>4</sup> is a bond, one of R<sup>3</sup> and R<sup>4</sup> is oxygen, and R<sup>3</sup> and R<sup>4</sup> together form oxo (=O). Further alternatively, R<sup>3</sup> and R<sup>4</sup> together with any intervening atoms form a group selected from optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl.

**[012]** The B and B' groups of the compound represented by Formula-I and other related formulas disclosed further herein, are each independently selected from hydrogen, L<sub>3</sub> as described further herein, halogen, and a chiral or achiral group selected from metallocenyl, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, optionally substituted heteroalkyl, optionally substituted alkoxy, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted heterocycloalkyl, and optionally substituted cycloalkyl. Alternatively, B and B' taken together with any intervening atoms can form a group selected from optionally substituted cycloalkyl and optionally substituted heterocycloalkyl.

**[013]** The L<sub>1</sub>, L<sub>2</sub> and L<sub>3</sub> groups of the compound represented by Formula-I and other related formulas disclosed further herein, are each independently selected from a chiral or achiral lengthening group represented by the following Formula II,

II



**[014]** The Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> groups of Formula II are each independently for each occurrence a divalent group chosen from, an unsubstituted or a substituted aromatic group, an unsubstituted or a substituted alicyclic group, and an unsubstituted or a substituted heterocyclic group. Each substituent of the Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> groups can be independently chosen from, a group represented by P, liquid crystal mesogens, halogen, poly(C<sub>1</sub>-C<sub>18</sub> alkoxy), C<sub>1</sub>-C<sub>18</sub> alkoxy carbonyl, C<sub>1</sub>-C<sub>18</sub> alkyl carbonyl, C<sub>1</sub>-C<sub>18</sub> alkoxy carbonyloxy, aryloxy carbonyloxy, perfluoro(C<sub>1</sub>-C<sub>18</sub>)alkoxy,

perfluoro(C<sub>1</sub>-C<sub>18</sub>)alkoxycarbonyl, perfluoro(C<sub>1</sub>-C<sub>18</sub>)alkylcarbonyl, perfluoro(C<sub>1</sub>-C<sub>18</sub>)alkylamino, di-(perfluoro(C<sub>1</sub>-C<sub>18</sub>)alkyl)amino, perfluoro(C<sub>1</sub>-C<sub>18</sub>)alkylthio, C<sub>1</sub>-C<sub>18</sub> alkylthio, C<sub>1</sub>-C<sub>18</sub> acetyl, C<sub>3</sub>-C<sub>10</sub> cycloalkyl, C<sub>3</sub>-C<sub>10</sub> cycloalkoxy, a straight-chain or branched C<sub>1</sub>-C<sub>18</sub> alkyl group that is mono-substituted with cyano, halo, or C<sub>1</sub>-C<sub>18</sub> alkoxy, or poly-substituted with halo, and a group comprising one of the following formulae: -M(T)<sub>(t-1)</sub> and -M(OT)<sub>(t-1)</sub>, wherein M is chosen from aluminum, antimony, tantalum, titanium, zirconium and silicon, T is chosen from organofunctional radicals, organofunctional hydrocarbon radicals, aliphatic hydrocarbon radicals and aromatic hydrocarbon radicals, and t is the valence of M.

**[015]** The subscripts c, d, e, and f of Formula-II are each independently an integer selected from 0 to 20, inclusive of the recited values. The S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> groups of Formula-II are each independently for each occurrence a spacer unit chosen from the following categories (1), (2) and (3). The spacer units of category (1) include, -(CH<sub>2</sub>)<sub>g</sub>-, -(CF<sub>2</sub>)<sub>h</sub>-, -Si(Z)<sub>2</sub>(CH<sub>2</sub>)<sub>g</sub>-, -(Si(CH<sub>3</sub>)<sub>2</sub>O)<sub>h</sub>-, wherein Z is independently chosen for each occurrence from hydrogen, C<sub>1</sub>-C<sub>18</sub> alkyl, C<sub>3</sub>-C<sub>10</sub> cycloalkyl and aryl; g is independently chosen for each occurrence from 1 to 20; h is a whole number from 1 to 16 inclusive. The spacer units of category (2) include, -N(Z)-, -C(Z)=C(Z)-, -C(Z)=N-, -C(Z')-C(Z')- or a single bond, wherein Z is independently chosen for each occurrence from hydrogen, C<sub>1</sub>-C<sub>18</sub> alkyl, C<sub>3</sub>-C<sub>10</sub> cycloalkyl and aryl, and Z' is independently chosen for each occurrence from C<sub>1</sub>-C<sub>18</sub> alkyl, C<sub>3</sub>-C<sub>10</sub> cycloalkyl and aryl. The spacer units of category (3) include, -O-, -C(O)-, -C≡C-, -N=N-, -S-, -S(O)-, -S(O)(O)-, -(O)S(O)-, -(O)S(O)O-, -O(O)S(O)O-, or straight-chain or branched C<sub>1</sub>-C<sub>24</sub> alkylene residue, said C<sub>1</sub>-C<sub>24</sub> alkylene residue being unsubstituted, mono-substituted by cyano or halo, or poly-substituted by halo. With regard to the spacer units from which S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> can be chosen, there is the proviso that when two spacer units comprising heteroatoms are linked together the spacer units are linked so that heteroatoms are not directly linked to each other. With regard to the spacer units from which S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> can be chosen, there is the further proviso that when S<sub>1</sub> is linked to a compound of the present invention, such as Formula I, and S<sub>5</sub> is linked to P, S<sub>1</sub> and S<sub>5</sub> are in each case so linked such that two heteroatoms are not directly linked to each other.

**[016]** With further reference to Formula-II, P is chosen from: hydroxy, amino, C<sub>2</sub>-C<sub>18</sub> alkenyl, C<sub>2</sub>-C<sub>18</sub> alkynyl, azido, silyl, siloxy, silylhydride, (tetrahydro-2H-pyran-2-yl)oxy, thio, isocyanato, thioisocyanato, acryloyloxy, methacryloyloxy, 2-(acryloyloxy)ethylcarbonyl, 2-(methacryloyloxy)ethylcarbonyl, aziridinyl, allyloxycarbonyloxy, epoxy, carboxylic acid, carboxylic ester, acryloylamino, methacryloylamino, aminocarbonyl, C<sub>1</sub>-C<sub>18</sub> alkyl aminocarbonyl, aminocarbonyl(C<sub>1</sub>-C<sub>18</sub>)alkyl, C<sub>1</sub>-C<sub>18</sub> alkyloxycarbonyloxy, halocarbonyl, hydrogen, aryl,

hydroxy(C<sub>1</sub>-C<sub>18</sub>)alkyl, C<sub>1</sub>-C<sub>18</sub> alkyl, C<sub>1</sub>-C<sub>18</sub> alkoxy, amino(C<sub>1</sub>-C<sub>18</sub>)alkyl, C<sub>1</sub>-C<sub>18</sub> alkylamino, di-(C<sub>1</sub>-C<sub>18</sub>)alkylamino, C<sub>1</sub>-C<sub>18</sub> alkyl(C<sub>1</sub>-C<sub>18</sub>)alkoxy, C<sub>1</sub>-C<sub>18</sub> alkoxy(C<sub>1</sub>-C<sub>18</sub>)alkoxy, nitro, poly(C<sub>1</sub>-C<sub>18</sub>)alkyl ether, (C<sub>1</sub>-C<sub>18</sub>)alkyl(C<sub>1</sub>-C<sub>18</sub>)alkoxy(C<sub>1</sub>-C<sub>18</sub>)alkyl, polyethyleneoxy, polypropyleneoxy, ethylenyl, acryloyl, acryloyloxy(C<sub>1</sub>-C<sub>18</sub>)alkyl, methacryloyl, methacryloyloxy(C<sub>1</sub>-C<sub>18</sub>)alkyl, 2-chloroacryloyl, 2-phenylacryloyl, acryloyloxyphenyl, 2-chloroacryloylamino, 2-phenylacryloylaminocarbonyl, oxetanyl, glycidyl, cyano, isocyanato(C<sub>1</sub>-C<sub>18</sub>)alkyl, itaconic acid ester, vinyl ether, vinyl ester, a styrene derivative, main-chain and side-chain liquid crystal polymers, siloxane derivatives, ethyleneimine derivatives, maleic acid derivatives, fumaric acid derivatives, unsubstituted cinnamic acid derivatives, cinnamic acid derivatives that are substituted with at least one of methyl, methoxy, cyano and halogen, or substituted or unsubstituted chiral or non-chiral monovalent or divalent groups chosen from steroid radicals, terpenoid radicals, alkaloid radicals and mixtures thereof, wherein the substituents are independently chosen from C<sub>1</sub>-C<sub>18</sub> alkyl, C<sub>1</sub>-C<sub>18</sub> alkoxy, amino, C<sub>3</sub>-C<sub>10</sub> cycloalkyl, C<sub>1</sub>-C<sub>18</sub> alkyl(C<sub>1</sub>-C<sub>18</sub>)alkoxy, fluoro(C<sub>1</sub>-C<sub>18</sub>)alkyl, cyano, cyano(C<sub>1</sub>-C<sub>18</sub>)alkyl, cyano(C<sub>1</sub>-C<sub>18</sub>)alkoxy or mixtures thereof, or P is a structure having from 2 to 4 reactive groups, or P is an unsubstituted or substituted ring opening metathesis polymerization precursor, or P is a substituted or unsubstituted photochromic compound.

**[017]** The subscripts d', e' and f' of Formula-II can each independently chosen from 0, 1, 2, 3, and 4, provided that the sum of d' + e' + f' is at least 2.

**[018]** In accordance with the present invention there is further provided photochromic compositions and articles that include one or more of the compounds of the present invention.

#### BRIEF DESCRIPTION OF THE DRAWING

**[019]** FIG.1 is a graphical representation of two average difference absorption spectrum obtained for a photochromic compound according to various non-limiting embodiments disclosed herein using the CELL METHOD.

#### DETAILED DESCRIPTION OF THE INVENTION

**[020]** As used herein, including the specification and claims, the following words, phrases and symbols are generally intended to have the meanings as set forth below, except to the extent that the context in which they are used indicates otherwise. The following abbreviations and terms have the indicated meanings throughout.



**[021]** A dash (“-”) that is not between two letters or symbols is used to indicate a point of attachment for a substituent. For example,  $-\text{CONH}_2$  is attached through the carbon atom.

**[022]** The term “alkyl” by itself or as part of another substituent refers to a saturated or unsaturated, branched, or straight-chain monovalent hydrocarbon radical derived by the removal of one hydrogen atom from a single carbon atom of a parent alkane, alkene, or alkyne. Examples of alkyl groups include, but are not limited to, methyl; ethyls such as ethanyl, ethenyl, and ethynyl; propyls such as propan-1-yl, propan-2-yl, prop-1-en-1-yl, prop-1-en-2-yl, prop-2-en-1-yl (allyl), prop-1-yn-1-yl, prop-2-yn-1-yl, *etc.*; butyls such as butan-1-yl, butan-2-yl, 2-methyl-propan-1-yl, 2-methyl-propan-2-yl, but-1-en-1-yl, but-1-en-2-yl, 2-methyl-prop-1-en-1-yl, but-2-en-1-yl, but-2-en-2-yl, buta-1,3-dien-1-yl, buta-1,3-dien-2-yl, but-1-yn-1-yl, but-1-yn-3-yl, but-3-yn-1-yl, *etc.*; and the like.

**[023]** The term “alkyl” is specifically intended to include groups having any degree or level of saturation, *i.e.*, groups having exclusively single carbon-carbon bonds, groups having one or more double carbon-carbon bonds, groups having one or more triple carbon-carbon bonds, and groups having mixtures of single, double, and triple carbon-carbon bonds. Where a specific level of saturation is intended, the terms “alkanyl,” “alkenyl,” and “alkynyl” are used. In certain embodiments, an alkyl group includes from 1 to 20 carbon atoms, in certain embodiments, from 1 to 10 carbon atoms, in certain embodiments, from 1 to 8 or 1 to 6 carbon atoms, and in certain embodiments from 1 to 3 carbon atoms.

**[024]** The term “acyl” by itself or as part of another substituent refers to a radical  $-\text{C}(\text{O})\text{R}^{30}$ , where  $\text{R}^{30}$  is hydrogen, alkyl, heteroalkyl, cycloalkyl, heterocycloalkyl, cycloalkylalkyl, heterocycloalkylalkyl, aryl, heteroaryl, arylalkyl, or heteroarylalkyl, which can be substituted, as defined herein. Examples of acyl groups include, but are not limited to, formyl, acetyl, cyclohexylcarbonyl, cyclohexylmethylcarbonyl, benzoyl, benzylcarbonyl, and the like.

**[025]** The term “alkoxy” by itself or as part of another substituent refers to a radical  $-\text{OR}^{31}$  where  $\text{R}^{31}$  is alkyl, cycloalkyl, cycloalkylalkyl, aryl, or arylalkyl, which can be substituted, as defined herein. In some embodiments, alkoxy groups have from 1 to 18 carbon atoms. Examples of alkoxy groups include, but are not limited to, methoxy, ethoxy, propoxy, butoxy, cyclohexyloxy, and the like.

**[026]** The term “alkoxycarbonyl” by itself or as part of another substituent refers to a radical  $-\text{C}(\text{O})\text{OR}^{31}$  where  $\text{R}^{31}$  is alkyl, cycloalkyl, cycloalkylalkyl, aryl, or arylalkyl, which can be substituted, as defined herein.

**[027]** The term "amino" refers to the radical  $-NH_2$ .

**[028]** The term "aminocarbonyl" by itself or as part of another substituent refers to radical of the formula  $-NC(O)R^{60}$  where each  $R^{60}$  is selected from hydrogen, alkyl, substituted alkyl, alkoxy, substituted alkoxy, cycloalkyl, substituted cycloalkyl, heterocycloalkyl, substituted heterocycloalkyl, aryl, substituted aryl, heteroaryl, substituted heteroaryl, arylalkyl, substituted arylalkyl, heteroarylalkyl, and substituted heteroarylalkyl.

**[029]** The term "aryl" by itself or as part of another substituent refers to a monovalent aromatic hydrocarbon radical derived by the removal of one hydrogen atom from a single carbon atom of a parent aromatic ring system. Aryl encompasses 5- and 6-membered carbocyclic aromatic rings, for example, benzene; bicyclic ring systems wherein at least one ring is carbocyclic and aromatic, for example, naphthalene, indane, and tetralin; and tricyclic ring systems wherein at least one ring is carbocyclic and aromatic, for example, fluorene. Aryl encompasses multiple ring systems having at least one carbocyclic aromatic ring fused to at least one carbocyclic aromatic ring, cycloalkyl ring, or heterocycloalkyl ring. For example, aryl includes 5- and 6-membered carbocyclic aromatic rings fused to a 5- to 7-membered heterocycloalkyl ring containing one or more heteroatoms chosen from N, O, and S. For such fused, bicyclic ring systems wherein only one of the rings is a carbocyclic aromatic ring, the point of attachment can be at the carbocyclic aromatic ring or the heterocycloalkyl ring. Examples of aryl groups include, but are not limited to, groups derived from aceanthrylene, acenaphthylene, acephenanthrylene, anthracene, azulene, benzene, chrysene, coronene, fluoranthene, fluorene, hexacene, hexaphene, hexalene, as-indacene, s-indacene, indane, indene, naphthalene, octacene, octaphene, octalene, ovalene, penta-2,4-diene, pentacene, pentalene, pentaphene, perylene, phenalene, phenanthrene, picene, pleiadene, pyrene, pyranthrene, rubicene, triphenylene, trinaphthalene, and the like. In certain embodiments, an aryl group can include from 5 to 20 carbon atoms, and in certain embodiments, from 5 to 12 carbon atoms. Aryl, however, does not encompass or overlap in any way with heteroaryl, separately defined herein. Hence, a multiple ring system in which one or more carbocyclic aromatic rings is fused to a heterocycloalkyl aromatic ring, is heteroaryl, not aryl, as defined herein.

**[030]** The term "arylalkyl" by itself or as part of another substituent refers to an acyclic alkyl radical in which one of the hydrogen atoms bonded to a carbon atom, typically a terminal or  $sp^3$  carbon atom, is replaced with an aryl group. Examples of arylalkyl groups include, but are not limited to, benzyl, 2-phenylethan-1-yl, 2-phenylethen-1-yl, naphthylmethyl, 2-naphthylethan-1-yl, 2-naphthylethen-1-yl, naphthobenzyl, 2-naphthophenylethan-1-yl, and the like. Where specific

alkyl moieties are intended, the nomenclature arylalkanyl, arylalkenyl, or arylalkynyl is used. With some embodiments, an arylalkyl group is C<sub>7-30</sub> (C<sub>7</sub>-C<sub>30</sub>) arylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the arylalkyl group is C<sub>1-10</sub> and the aryl moiety is C<sub>6-20</sub>, and in certain embodiments, an arylalkyl group is C<sub>7-20</sub> arylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the arylalkyl group is C<sub>1-8</sub> and the aryl moiety is C<sub>6-12</sub>.

**[031]** The term "carboxamidyl" by itself or as part of another substituent refers to a radical of the formula -C(O)NR<sup>60</sup>R<sup>61</sup> where each R<sup>60</sup> and R<sup>61</sup> are independently hydrogen, alkyl, substituted alkyl, alkoxy, substituted alkoxy, cycloalkyl, substituted cycloalkyl, heterocycloalkyl, substituted heterocycloalkyl, aryl, substituted aryl, heteroaryl, substituted heteroaryl, arylalkyl, substituted arylalkyl, heteroarylalkyl, or substituted heteroarylalkyl, or R<sup>60</sup> and R<sup>61</sup> together with the nitrogen atom to which they are bonded form a heterocycloalkyl, substituted heterocycloalkyl, heteroaryl, or substituted heteroaryl ring.

**[032]** The term "compounds" refers to compounds encompassed by structural Formulas I and IA herein and includes any specific compounds within these formulae whose structure is disclosed herein. Compounds can be identified either by their chemical structure and/or chemical name. When the chemical structure and chemical name conflict, the chemical structure is determinative of the identity of the compound. The compounds described herein can contain one or more chiral centers and/or double bonds and therefore can exist as stereoisomers such as double-bond isomers (*i.e.*, geometric isomers), enantiomers, or diastereomers. Accordingly, any chemical structures within the scope of the specification depicted, in whole or in part, with a relative configuration encompass all possible enantiomers and stereoisomers of the illustrated compounds including the stereoisomerically pure form (*e.g.*, geometrically pure, enantiomerically pure, or diastereomerically pure) and enantiomeric and stereoisomeric mixtures. Enantiomeric and stereoisomeric mixtures can be resolved into their component enantiomers or stereoisomers using separation techniques or chiral synthesis techniques well known to the skilled artisan.

**[033]** The term "precursor" and related terms, such as "precursors" with regard to the various groups, for example, R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, B and B', of the compounds and intermediates described herein, for example, the compounds represented by Formulas I, Ia, and Ib, means a group that can be converted in one or more steps to the final or desired group. For purposes of non-limiting illustration: a precursor of a hydroxyl group (-OH) includes, but is not limited to, a carboxylic acid ester group (-OC(O)R where R is hydrogen or an optionally substituted hydrocarbyl); and a precursor of a carboxylic acid ester group (-OC(O)R) includes, but is not

limited to, a hydroxyl group (-OH), which can be reacted, for example, with a carboxylic acid halide, such as acetic acid chloride (or acetyl chloride).

**[034]** For the purposes of the present disclosure, the term "chiral compounds" are compounds having at least one center of chirality (i.e., at least one asymmetric atom, in particular at least one asymmetric C atom), having an axis of chirality, a plane of chirality or a screw structure. The term "achiral compounds" refers to compounds which are not chiral.

**[035]** Compounds represented by Formula I, and related formulas as disclosed further herein, such as Formulas Ia and Ib, include, but are not limited to, optical isomers of compounds thereof, racemates thereof, and other mixtures thereof. In such embodiments, the single enantiomers or diastereomers, *i.e.*, optically active forms, can be obtained by asymmetric synthesis or by resolution of the racemates. Resolution of the racemates can be accomplished, for example, by conventional methods such as crystallization in the presence of a resolving agent, or chromatography, using, for example a chiral high-pressure liquid chromatography (HPLC) column. Unless otherwise stated, however, it should be assumed that compounds represented by Formula I and related formulas cover all asymmetric variants of the compounds described herein, including isomers, racemates, enantiomers, diastereomers, and other mixtures thereof. In addition, compounds represented by Formula I and related formulas include Z- and E-forms (*e.g.*, cis- and trans-forms) of compounds with double bonds. In embodiments in which compounds represented by Formula I and related formulas exist in various tautomeric forms, compounds provided by the present disclosure include all tautomeric forms of the compound.

**[036]** The compound represented by represented by Formula I, and related formulas as disclosed further herein, such as Formulas Ia and Ib, can also exist in several tautomeric forms including the enol form, the keto form, and mixtures thereof. Accordingly, the chemical structures depicted herein encompass all possible tautomeric forms of the illustrated compounds. Compounds can exist in unsolvated forms as well as solvated forms, including hydrated forms and as N-oxides. In general, compounds can be hydrated, solvated, or N-oxides. Certain compounds can exist in single or multiple crystalline or amorphous forms. In general, all physical forms are equivalent for the uses contemplated herein and are intended to be within the scope provided by the present disclosure. Further, when partial structures of the compounds are illustrated, an asterisk (\*) indicates the point of attachment of the partial structure to the rest of the molecule.

**[037]** The term "cycloalkyl" by itself or as part of another substituent refers to a saturated or unsaturated cyclic alkyl radical. Where a specific level of saturation is intended, the nomenclature "cycloalkanyl" or "cycloalkenyl" is used. Examples of cycloalkyl groups include, but are not limited to, groups derived from cyclopropane, cyclobutane, cyclopentane, cyclohexane, and the like. In certain embodiments, a cycloalkyl group is C<sub>3-15</sub> (C<sub>3</sub>-C<sub>15</sub>) cycloalkyl, and in certain embodiments, C<sub>3-12</sub> cycloalkyl or C<sub>5-12</sub> cycloalkyl.

**[038]** The term "cycloalkylalkyl" by itself or as part of another substituent refers to an acyclic alkyl radical in which one of the hydrogen atoms bonded to a carbon atom, typically a terminal or sp<sup>3</sup> carbon atom, is replaced with a cycloalkyl group. Where specific alkyl moieties are intended, the nomenclature cycloalkylalkanyl, cycloalkylalkenyl, or cycloalkylalkynyl is used. In certain embodiments, a cycloalkylalkyl group is C<sub>7-30</sub> (C<sub>7</sub>-C<sub>30</sub>) cycloalkylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the cycloalkylalkyl group is C<sub>1-10</sub> and the cycloalkyl moiety is C<sub>6-20</sub>, and in certain embodiments, a cycloalkylalkyl group is C<sub>7-20</sub> cycloalkylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the cycloalkylalkyl group is C<sub>1-8</sub> and the cycloalkyl moiety is C<sub>4-20</sub> or C<sub>6-12</sub>.

**[039]** The term "halogen" refers to a fluoro, chloro, bromo, or iodo group.

**[040]** The term "heteroalkyl" by itself or as part of another substituent refer to an alkyl group in which one or more of the carbon atoms (and any associated hydrogen atoms) are independently replaced with the same or different heteroatomic groups. In some embodiments, heteroalkyl groups have from 1 to 8 carbon atoms. Examples of heteroatomic groups include, but are not limited to, -O-, -S-, -S-S-, -NR<sup>38</sup>-, =N-N=, -N=N-, -N=N-NR<sup>39</sup>R<sup>40</sup>-, -PR<sup>41</sup>-, -P(O)<sub>2</sub>-, -POR<sup>42</sup>-, -O-P(O)<sub>2</sub>-, -SO-, -SO<sub>2</sub>-, -SnR<sup>43</sup>R<sup>44</sup>- and the like, where R<sup>38</sup>, R<sup>39</sup>, R<sup>40</sup>, R<sup>41</sup>, R<sup>42</sup>, R<sup>43</sup>, and R<sup>44</sup> are independently hydrogen, alkyl, substituted alkyl, aryl, substituted aryl, arylalkyl, substituted arylalkyl, cycloalkyl, substituted cycloalkyl, heterocycloalkyl, substituted heterocycloalkyl, heteroalkyl, substituted heteroalkyl, heteroaryl, substituted heteroaryl, heteroarylalkyl, or substituted heteroarylalkyl. Where a specific level of saturation is intended, the nomenclature "heteroalkanyl," "heteroalkenyl," or "heteroalkynyl" is used. With some embodiments, R<sup>38</sup>, R<sup>39</sup>, R<sup>40</sup>, R<sup>41</sup>, R<sup>42</sup>, R<sup>43</sup>, and R<sup>44</sup> are independently chosen from hydrogen and C<sub>1-3</sub> alkyl.

**[041]** The term "heteroaryl" by itself or as part of another substituent refers to a monovalent heteroaromatic radical derived by the removal of one hydrogen atom from a single atom of a parent heteroaromatic ring system. The term "heteroaryl" encompasses multiple ring systems having at least one aromatic ring fused to at least one other ring, which can be aromatic or non-

aromatic in which at least one ring atom is a heteroatom. The term "heteroaryl" encompasses 5- to 12-membered aromatic, such as 5- to 7-membered, monocyclic rings containing one or more, for example, from 1 to 4, or in certain embodiments, from 1 to 3, heteroatoms chosen from N, O, and S, with the remaining ring atoms being carbon; and bicyclic heterocycloalkyl rings containing one or more, for example, from 1 to 4, or in certain embodiments, from 1 to 3, heteroatoms chosen from N, O, and S, with the remaining ring atoms being carbon and wherein at least one heteroatom is present in an aromatic ring. For example, heteroaryl includes a 5- to 7-membered heterocycloalkyl, aromatic ring fused to a 5- to 7-membered cycloalkyl ring. For such fused, bicyclic heteroaryl ring systems wherein only one of the rings contains one or more heteroatoms, the point of attachment can be at the heteroaromatic ring or the cycloalkyl ring. In certain embodiments, when the total number of N, S, and O atoms in the heteroaryl group exceeds one, the heteroatoms are not adjacent to one another. In certain embodiments, the total number of N, S, and O atoms in the heteroaryl group is not more than two. In certain embodiments, the total number of N, S, and O atoms in the aromatic heterocycle is not more than one. The term heteroaryl does not encompass or overlap with aryl as defined herein.

**[042]** Examples of heteroaryl groups include, but are not limited to, groups derived from acridine, arsinole, carbazole,  $\beta$ -carboline, chromane, chromene, cinnoline, furan, imidazole, indazole, indole, indoline, indolizine, isobenzofuran, isochromene, isoindole, isoindoline, isoquinoline, isothiazole, isoxazole, naphthyridine, oxadiazole, oxazole, perimidine, phenanthridine, phenanthroline, phenazine, phthalazine, pteridine, purine, pyran, pyrazine, pyrazole, pyridazine, pyridine, pyrimidine, pyrrole, pyrrolizine, quinazoline, quinoline, quinolizine, quinoxaline, tetrazole, thiadiazole, thiazole, thiophene, triazole, xanthene, and the like. In certain embodiments, a heteroaryl group is from 5- to 20-membered heteroaryl, and in certain embodiments from 5- to 12-membered heteroaryl or from 5- to 10-membered heteroaryl. In certain embodiments heteroaryl groups are those derived from thiophene, pyrrole, benzothiophene, benzofuran, indole, pyridine, quinoline, imidazole, oxazole, and pyrazine.

**[043]** The term "heteroarylalkyl" by itself or as part of another substituent refers to an acyclic alkyl radical in which one of the hydrogen atoms bonded to a carbon atom, typically a terminal or  $sp^3$  carbon atom, is replaced with a heteroaryl group. Where specific alkyl moieties are intended, the nomenclature heteroarylalkanyl, heteroarylalkenyl, or heteroarylalkynyl is used. With some embodiments, a heteroarylalkyl group is a 6- to 30-membered heteroarylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the heteroarylalkyl is 1- to 10-membered and the heteroaryl moiety is a 5- to 20-membered heteroaryl, and with some embodiments, 6- to 20-

membered heteroarylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the heteroarylalkyl is 1- to 8-membered and the heteroaryl moiety is a 5- to 12-membered heteroaryl.

**[044]** The term "heterocycloalkyl" by itself or as part of another substituent refers to a partially saturated or unsaturated cyclic alkyl radical in which one or more carbon atoms (and any associated hydrogen atoms) are independently replaced with the same or different heteroatom. Examples of heteroatoms to replace the carbon atom(s) include, but are not limited to, N, P, O, S, Si, etc. Where a specific level of saturation is intended, the nomenclature "heterocycloalkanyl" or "heterocycloalkenyl" is used. Examples of heterocycloalkyl groups include, but are not limited to, groups derived from epoxides, azirines, thiiranes, imidazolidine, morpholine, piperazine, piperidine, pyrazolidine, pyrrolidine, quinuclidine, and the like.

**[045]** The term "heterocycloalkylalkyl" by itself or as part of another substituent refers to an acyclic alkyl radical in which one of the hydrogen atoms bonded to a carbon atom, typically a terminal or  $sp^3$  carbon atom, is replaced with a heterocycloalkyl group. Where specific alkyl moieties are intended, the nomenclature heterocycloalkylalkanyl, heterocycloalkylalkenyl, or heterocycloalkylalkynyl is used. In certain embodiments, a heterocycloalkylalkyl group is a 6- to 30-membered heterocycloalkylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the heterocycloalkylalkyl is 1- to 10-membered and the heterocycloalkyl moiety is a 5- to 20-membered heterocycloalkyl, and in certain embodiments, 6- to 20-membered heterocycloalkylalkyl, e.g., the alkanyl, alkenyl, or alkynyl moiety of the heterocycloalkylalkyl is 1- to 8-membered and the heterocycloalkyl moiety is a 5- to 12-membered heterocycloalkyl.

**[046]** The term "leaving group" refers to an atom or a group capable of being displaced by a nucleophile and includes halogen, such as chloro, bromo, fluoro, and iodo, alkoxycarbonyl (e.g., acetoxy), aryloxy, mesyloxy, tosyloxy, trifluoromethanesulfonyloxy, aryloxy (e.g., 2,4-dinitrophenoxy), methoxy, N,O-dimethylhydroxylamino, and the like.

**[047]** "The term "parent aromatic ring system" refers to an unsaturated cyclic or polycyclic ring system having a conjugated  $\pi$  (pi) electron system. Included within the definition of "parent aromatic ring system" are fused ring systems in which one or more of the rings are aromatic and one or more of the rings are saturated or unsaturated, such as, for example, fluorene, indane, indene, phenalene, etc. Examples of parent aromatic ring systems include, but are not limited to, aceanthrylene, acenaphthylene, acephenanthrylene, anthracene, azulene, benzene, chrysene, coronene, fluoranthene, fluorene, hexacene, hexaphene, hexalene, as-indacene, s-indacene, indane, indene, naphthalene, octacene, octaphene, octalene, ovalene,

penta-2,4-diene, pentacene, pentalene, pentaphene, perylene, phenalene, phenanthrene, picene, pleiadene, pyrene, pyranthrene, rubicene, triphenylene, trinaphthalene, and the like.

**[048]** The term "parent heteroaromatic ring system" refers to a parent aromatic ring system in which one or more carbon atoms (and any associated hydrogen atoms) are independently replaced with the same or different heteroatom. Examples of heteroatoms to replace the carbon atoms include, but are not limited to, N, P, O, S, Si, *etc.* Specifically included within the definition of "parent heteroaromatic ring systems" are fused ring systems in which one or more of the rings are aromatic and one or more of the rings are saturated or unsaturated, such as, for example, arsindole, benzodioxan, benzofuran, chromane, chromene, indole, indoline, xanthene, *etc.* Examples of parent heteroaromatic ring systems include, but are not limited to, arsindole, carbazole,  $\beta$ -carboline, chromane, chromene, cinnoline, furan, imidazole, indazole, indole, indoline, indolizine, isobenzofuran, isochromene, isoindole, isoindoline, isoquinoline, isothiazole, isoxazole, naphthyridine, oxadiazole, oxazole, perimidine, phenanthridine, phenanthroline, phenazine, phthalazine, pteridine, purine, pyran, pyrazine, pyrazole, pyridazine, pyridine, pyrimidine, pyrrole, pyrrolizine, quinazoline, quinoline, quinolizine, quinoxaline, tetrazole, thiadiazole, thiazole, thiophene, triazole, xanthene, and the like.

**[049]** The term "perhaloalkyl" is a subset of substituted alkyl wherein each available hydrogen atom is replaced with the same or different halogen atom. Examples of perhaloalkyl includes, but is not limited to,  $-\text{CF}_3$ ,  $-\text{CF}_2\text{CF}_3$ , and  $-\text{C}(\text{CF}_3)_3$ .

**[050]** The term "perhaloalkoxy" is a subset of substituted alkoxy wherein each hydrogen atom of  $\text{R}^{31}$  is replaced with the same or different halogen atom. Examples of perhaloalkoxy includes, but is not limited to,  $-\text{OCF}_3$ ,  $-\text{OCF}_2\text{CF}_3$ , and  $-\text{OC}(\text{CF}_3)_3$ .

**[051]** The term "protecting group" refers to a grouping of atoms, which when attached to a reactive group in a molecule masks, reduces, or prevents that reactivity. Examples of protecting groups can be found in Wuts and Greene, "Protective Groups in Organic Synthesis," John Wiley & Sons, 4th ed. 2006; Harrison *et al.*, "Compendium of Organic Synthetic Methods," Vols. 1-11, John Wiley & Sons 1971-2003; Larock "Comprehensive Organic Transformations," John Wiley & Sons, 2nd ed. 2000; and Paquette, "Encyclopedia of Reagents for Organic Synthesis," John Wiley & Sons, 11th ed. 2003. Examples of amino protecting groups include, but are not limited to, formyl, acetyl, trifluoroacetyl, benzyl, benzyloxycarbonyl (CBZ), *tert*-butoxycarbonyl (Boc), trimethylsilyl (TMS), 2-trimethylsilyl-ethanesulfonyl (SES), trityl and substituted trityl groups, allyloxycarbonyl, 9-fluorenylmethyloxycarbonyl (Fmoc), nitro-veratryloxycarbonyl (NVOC), and the like. Examples of hydroxy protecting groups include, but are not limited to, those in which



the hydroxy group is either acylated or alkylated such as benzyl, and trityl ethers as well as alkyl ethers, tetrahydropyranyl ethers, trialkylsilyl ethers, and allyl ethers.

**[052]** The term "Silyl" by itself or as part of another substituent refers to a radical of the formula  $-\text{SiR}^{30}\text{R}^{31}\text{R}^{31}$  where each of  $\text{R}^{30}$ ,  $\text{R}^{31}$ , and  $\text{R}^{31}$  is independently selected from alkyl, alkoxy, and phenyl, which can each be substituted, as defined herein.

**[053]** The term "siloxy" by itself or as part of another substituent refers to a radical of the formula  $-\text{OSiR}^{30}\text{R}^{31}\text{R}^{31}$  where each of  $\text{R}^{30}$ ,  $\text{R}^{31}$ , and  $\text{R}^{31}$  is independently selected from alkyl, alkoxy, and phenyl, which can each be substituted, as defined herein.

**[054]** The term "substituted" refers to a group in which one or more hydrogen atoms are independently replaced with the same or different substituent(s), which are in each case other than hydrogen. Examples of substituents include, but are not limited to,  $-\text{R}^{64}$ ,  $-\text{R}^{60}$ ,  $-\text{O}^-$ ,  $(-\text{OH})$ ,  $=\text{O}$ ,  $-\text{OR}^{60}$ ,  $-\text{SR}^{60}$ ,  $-\text{S}^-$ ,  $=\text{S}$ ,  $-\text{NR}^{60}\text{R}^{61}$ ,  $=\text{NR}^{60}$ ,  $-\text{CX}_3$ ,  $-\text{CN}$ ,  $-\text{CF}_3$ ,  $-\text{OCN}$ ,  $-\text{SCN}$ ,  $-\text{NO}$ ,  $-\text{NO}_2$ ,  $=\text{N}_2$ ,  $-\text{N}_3$ ,  $-\text{S}(\text{O})_2\text{O}^-$ ,  $-\text{S}(\text{O})_2\text{OH}$ ,  $-\text{S}(\text{O})_2\text{R}^{60}$ ,  $-\text{OS}(\text{O})_2\text{O}^-$ ,  $-\text{OS}(\text{O})_2\text{R}^{60}$ ,  $-\text{P}(\text{O})(\text{O}^-)_2$ ,  $-\text{P}(\text{O})(\text{OR}^{60})(\text{O}^-)$ ,  $-\text{OP}(\text{O})(\text{OR}^{60})(\text{OR}^{61})$ ,  $-\text{C}(\text{O})\text{R}^{60}$ ,  $-\text{C}(\text{S})\text{R}^{60}$ ,  $-\text{C}(\text{O})\text{OR}^{60}$ ,  $-\text{C}(\text{O})\text{NR}^{60}\text{R}^{61}$ ,  $-\text{C}(\text{O})\text{O}^-$ ,  $-\text{C}(\text{S})\text{OR}^{60}$ ,  $-\text{NR}^{62}\text{C}(\text{O})\text{NR}^{60}\text{R}^{61}$ ,  $-\text{NR}^{62}\text{C}(\text{S})\text{NR}^{60}\text{R}^{61}$ ,  $-\text{NR}^{62}\text{C}(\text{NR}^{63})\text{NR}^{60}\text{R}^{61}$ ,  $-\text{C}(\text{NR}^{62})\text{NR}^{60}\text{R}^{61}$ ,  $-\text{S}(\text{O})_2$ ,  $\text{NR}^{60}\text{R}^{61}$ ,  $-\text{NR}^{63}\text{S}(\text{O})_2\text{R}^{60}$ ,  $-\text{NR}^{63}\text{C}(\text{O})\text{R}^{60}$ , and  $-\text{S}(\text{O})\text{R}^{60}$  where each  $-\text{R}^{64}$  is independently a halogen; each  $\text{R}^{60}$  and  $\text{R}^{61}$  are independently hydrogen, alkyl, substituted alkyl, alkoxy, substituted alkoxy, cycloalkyl, substituted cycloalkyl, heterocycloalkyl, substituted heterocycloalkyl, aryl, substituted aryl, heteroaryl, substituted heteroaryl, arylalkyl, substituted arylalkyl, heteroarylalkyl, or substituted heteroarylalkyl, or  $\text{R}^{60}$  and  $\text{R}^{61}$  together with the nitrogen atom to which they are bonded form a heterocycloalkyl, substituted heterocycloalkyl, heteroaryl, or substituted heteroaryl ring, and  $\text{R}^{62}$  and  $\text{R}^{63}$  are independently hydrogen, alkyl, substituted alkyl, aryl, substituted aryl, arylalkyl, substituted arylalkyl, cycloalkyl, substituted cycloalkyl, heterocycloalkyl, substituted heterocycloalkyl, heteroaryl, substituted heteroaryl, heteroarylalkyl, or substituted heteroarylalkyl, or  $\text{R}^{62}$  and  $\text{R}^{63}$  together with the atom to which they are bonded form one or more heterocycloalkyl, substituted heterocycloalkyl, heteroaryl, or substituted heteroaryl rings. With some embodiments, a tertiary amine or aromatic nitrogen can be substituted with one or more oxygen atoms to form the corresponding nitrogen oxide.

**[055]** The term "sulfonate" by itself or as part of another substituent refers to a sulfur radical of the formula  $-\text{S}(\text{O})_2\text{O}^-$ .

**[056]** The term "sulfonyl" by itself or as part of another substituent refers to a sulfur radical of the formula  $-\text{S}(\text{O})_2\text{R}^{60}$  where  $\text{R}^{60}$  can be selected from hydrogen, alkyl, substituted alkyl, alkoxy,

substituted alkoxy, cycloalkyl, substituted cycloalkyl, heterocycloalkyl, substituted heterocycloalkyl, aryl, substituted aryl, heteroaryl, substituted heteroaryl, arylalkyl, substituted arylalkyl, heteroarylalkyl, and substituted heteroarylalkyl.

**[057]** With some embodiments, substituted aryl and substituted heteroaryl include one or more of the following substitute groups (or substituents): F, Cl, Br, C<sub>1-3</sub> alkyl, substituted alkyl, C<sub>1-3</sub> alkoxy, -S(O)<sub>2</sub>NR<sup>50</sup>R<sup>51</sup>, -NR<sup>50</sup>R<sup>51</sup>, -CF<sub>3</sub>, -OCF<sub>3</sub>, -CN, -NR<sup>50</sup>S(O)<sub>2</sub>R<sup>51</sup>, -NR<sup>50</sup>C(O)R<sup>51</sup>, C<sub>5-10</sub> aryl, substituted C<sub>5-10</sub> aryl, C<sub>5-10</sub> heteroaryl, substituted C<sub>5-10</sub> heteroaryl, -C(O)OR<sup>50</sup>, -NO<sub>2</sub>, -C(O)R<sup>50</sup>, -C(O)NR<sup>50</sup>R<sup>51</sup>, -OCHF<sub>2</sub>, C<sub>1-3</sub> acyl, -SR<sup>50</sup>, -S(O)<sub>2</sub>OH, -S(O)<sub>2</sub>R<sup>50</sup>, -S(O)R<sup>50</sup>, -C(S)R<sup>50</sup>, -C(O)O, -C(S)OR<sup>50</sup>, -NR<sup>50</sup>C(O)NR<sup>51</sup>R<sup>52</sup>, -NR<sup>50</sup>C(S)NR<sup>51</sup>R<sup>52</sup>, and -C(NR<sup>50</sup>)NR<sup>51</sup>R<sup>52</sup>, C<sub>3-8</sub> cycloalkyl, and substituted C<sub>3-8</sub> cycloalkyl, wherein R<sup>50</sup>, R<sup>51</sup>, and R<sup>52</sup> are each independently selected from hydrogen and C<sub>1-4</sub> alkyl.

**[058]** As used herein and in the claims, recitations of "linear or branched" or "linear, branched or cyclic" groups, such as linear or branched alkyl, or linear, branched or cyclic alkyl, are herein understood to include: a methylene group or a methyl group; groups that are linear, such as linear C<sub>2</sub>-C<sub>25</sub> alkyl groups; groups that are appropriately branched, such as branched C<sub>3</sub>-C<sub>25</sub> alkyl groups; and groups that are appropriately cyclic, such as C<sub>3</sub>-C<sub>25</sub> cycloalkyl (or cyclic C<sub>3</sub>-C<sub>25</sub> alkyl) groups.

**[059]** As used herein and in the claims, unless otherwise indicated, left-to-right representations of linking groups, such as divalent linking groups, are inclusive of other appropriate orientations, such as, right-to-left orientations. For purposes of non-limiting illustration, the left-to-right representation of the divalent linking group -C(O)O-, is inclusive of the right-to-left representation thereof, -O(O)C-.

**[060]** As used herein and the appended claims, the articles "a," "an," and "the" include plural referents unless expressly and unequivocally limited to one referent.

**[061]** Unless otherwise indicated, all numbers expressing quantities of ingredients, reaction conditions, and other properties or parameters used in the specification are to be understood as being modified in all instances by the term "about." Accordingly, unless otherwise indicated, it should be understood that the numerical parameters set forth in the following specification and attached claims are approximations. At the very least, and not as an attempt to limit the application of the doctrine of equivalents to the scope of the claims, numerical parameters should be read in light of the number of reported significant digits and the application of ordinary rounding techniques.

**[062]** All numerical ranges herein include all numerical values numerical values within the recited range of numerical values. Further, while the numerical ranges and parameters setting forth the broad scope of the disclosure are approximations as discussed above, the numerical values set forth in the Examples section are reported as precisely as possible. It should be understood, however, that such numerical values inherently contain certain errors resulting from the measurement equipment and/or measurement technique. For purposes of non-limiting illustration, a stated range or ratio of "1 to 10" should be considered to include any and all subranges between (and inclusive of) the minimum value of 1 and the maximum value of 10; that is, all subranges or subratios beginning with a minimum value of 1 or more and ending with a maximum value of 10 or less, such as but not limited to, 1 to 6.1, 3.5 to 7.8, and 5.5 to 10.

**[063]** As used herein the term "liquid crystal cell" refers to a structure containing a liquid crystal material that is capable of being ordered. Active liquid crystal cells are cells wherein the liquid crystal material is capable of being switched between ordered and disordered states or between two ordered states by the application of an external force, such as electric or magnetic fields. Passive liquid crystal cells are cells wherein the liquid crystal material maintains an ordered state. One non-limiting example of an active liquid crystal cell element or device is a liquid crystal display.

**[064]** The phrase "an at least partial coating" means an amount of coating covering from a portion to the complete surface of the substrate. The phrase "an at least partially cured coating" refers to a coating in which the curable or crosslinkable components are at least partially cured, crosslinked and/or reacted. In alternate non-limiting embodiments, the degree of reacted components, can vary widely, e.g., from 5% to 100% of all the possible curable, crosslinkable and/or reactable components.

**[065]** The phrase "an at least partially abrasion resistant coating or film" refers to a coating or film that demonstrates a Bayer Abrasion Resistance Index of from at least 1.3 to 10.0 in ASTM F-735 Standard Test Method for Abrasion Resistance of Transparent Plastics and Coatings Using the Oscillating Sand Method. The phrase "an at least partially antireflective coating" is a coating that at least partially improves the antireflective nature of the surface to which it is applied by increasing the percent transmittance as compared to an uncoated surface. The improvement in percent transmittance can range from 1 to 9 percent above the untreated surface. Put another way, the percent transmittance of the treated surface can range from a percentage greater than the untreated surface up to 99.9.

**[066]** Various non-limiting embodiments of the disclosure will now be described. One non-limiting embodiment provides a thermally reversible, photochromic compound comprising a Lengthening group  $L_1$ , and optionally  $L_2$  and/or  $L_3$ , also described hereinafter. Another non-limiting embodiment provides a photochromic compound adapted to have at least a first state and a second state, wherein the thermally reversible, photochromic compound has an average absorption ratio greater than 1.5 in at least one state as determined according to the CELL METHOD, which is described in detail below. Further, according to various non-limiting embodiments, the thermally reversible, photochromic compound has an average absorption ratio greater than 1.5 in an activated state as determined according to the CELL METHOD. As used herein with respect to photochromic compounds, the term "activated state" refers to the photochromic compound when exposed to sufficient actinic radiation to cause the at least a portion of the photochromic compound to switch states.

**[067]** In general, the CELL METHOD of measuring average absorption ratio of a photochromic compound involves obtaining an absorption spectrum for the photochromic compound, in an activated or unactivated state, in each of two orthogonal polarization directions while the photochromic compound is at least partially aligned in an aligned liquid crystal medium that is contained within a cell assembly. More specifically, the cell assembly includes two opposing glass substrates that are spaced apart by 20 microns  $\pm$  1 micron. The substrates are sealed along two opposite edges to form the cell. The inner surface of each of the glass substrates is coated with a polyimide coating, the surface of which has been at least partially ordered by rubbing. Alignment of the photochromic compound is achieved by introducing the photochromic compound and a liquid crystal medium into the cell assembly and allowing the liquid crystal medium to align with the rubbed polyimide surface. Because the photochromic compound is contained within the liquid crystal medium, alignment of the liquid crystal medium causes the photochromic compound to be aligned. It will be appreciated by those skilled in the art that the choice of the liquid crystal medium and the temperature used during testing can affect the measured absorption ratio. Accordingly, as set forth in more detail in the Examples, for purposes of the CELL METHOD, absorption ratio measurements are taken at room temperature ( $73^\circ\text{F} \pm 0.5^\circ\text{F}$  or better) and the liquid crystal medium is Licristal<sup>®</sup> E7 (which is reported to be a mixture of cyanobiphenyl and cyanoterphenyl liquid crystal compounds).

**[068]** Once the liquid crystal medium and the photochromic compound are aligned, the cell assembly is placed on an optical bench (which is described in more detail in the Examples). To obtain the average absorption ratio in the activated state, activation of the photochromic

compound is achieved by exposing the photochromic compound to UV radiation for a time sufficient to reach a saturated or near saturated state (that is, a state wherein the absorption properties of the photochromic compound do not substantially change over the interval of time during which the measurements are made). Absorption measurements are taken over a period of time (typically 10 to 300 seconds) at 3 second intervals for light that is linearly polarized in a plane perpendicular to the optical bench (referred to as the 0° polarization plane or direction) and light that is linearly polarized in a plane that is parallel to the optical bench (referred to as the 90° polarization plane or direction) in the following sequence: 0°, 90°, 90°, 0° etc. The absorbance of the linearly polarized light by the cell is measured at each time interval for all of the wavelengths tested and the unactivated absorbance (i.e., the absorbance of the cell with the liquid crystal material and the unactivated photochromic compound) over the same range of wavelengths is subtracted to obtain absorption spectra for the photochromic compound in each of the 0° and 90° polarization planes to obtain an average difference absorption spectrum in each polarization plane for the photochromic compound in the saturated or near-saturated state.

**[069]** For example, with reference to FIG. 1, there is shown the average difference absorption spectrum (generally indicated **10**) in one polarization plane that was obtained for a photochromic compound according to one non-limiting embodiment disclosed herein. The average absorption spectrum (generally indicated **11**) is the average difference absorption spectrum obtained for the same photochromic compound in the orthogonal polarization plane. Based on the average difference absorption spectra obtained for the photochromic compound, the average absorption ratio for the photochromic compound is obtained as follows. The absorption ratio of the photochromic compound at each wavelength in a predetermined range of wavelengths corresponding to  $\lambda_{\text{max-vis}} \pm 5$  nanometers (generally indicated as **14** in Fig. 1), wherein  $\lambda_{\text{max-vis}}$  is the wavelength at which the photochromic compound had the highest average absorbance in any plane, is calculated according to the following equation:

$$AR_{\lambda_i} = Ab_{\lambda_i}^1 / Ab_{\lambda_i}^2 \quad \text{Eq. 1}$$

wherein,  $AR_{\lambda_i}$  is the absorption ratio at wavelength  $\lambda_i$ ,  $Ab_{\lambda_i}^1$  is the average absorption at wavelength  $\lambda_i$  in the polarization direction (i.e., 0° or 90°) having the higher absorbance, and  $Ab_{\lambda_i}^2$  is the average absorption at wavelength  $\lambda_i$  in the remaining polarization direction. As previously discussed, the "absorption ratio" refers to the ratio of the absorbance of radiation linearly polarized in a first plane to the absorbance of the same wavelength radiation linearly polarized in a plane orthogonal to the first plane, wherein the first plane is taken as the plane with the highest absorbance.

**[070]** The average absorption ratio ("AR") for the photochromic compound is then calculated by averaging the individual absorption ratios obtained for the wavelengths within the predetermined range of wavelengths (i.e.,  $\lambda_{\text{max-vis}}$  +/- 5 nanometers) according to the following equation:

$$AR = (\sum AR_{\lambda_i}) / n_i \quad \text{Eq. 2}$$

wherein, AR is average absorption ratio for the photochromic compound,  $AR_{\lambda_i}$  are the individual absorption ratios (as determined above in Eq. 1) for each wavelength within the predetermined range of wavelengths (i.e.,  $\lambda_{\text{max-vis}}$  +/- 5 nanometers), and  $n_i$  is the number of individual absorption ratios averaged.

**[071]** As previously discussed, conventional thermally reversible photochromic compounds are adapted to switch from a first state to a second state in response to actinic radiation, and to revert back to the first state in response to thermal energy. More specifically, conventional thermally reversible, photochromic compounds are capable of transforming from one isomeric form (for example and without limitation, a closed form) to another isomeric form (for example and without limitation, an open form) in response to actinic radiation, and reverting back to the closed form when exposed to thermal energy. However, as previously discussed, generally conventional thermally reversible photochromic compounds do not strongly demonstrate dichroism.

**[072]** As discussed above, non-limiting embodiments disclosed herein provide a thermally reversible photochromic compound having an average absorption ratio greater than 1.5 in at least one state as determined according to CELL METHOD and/or a thermally reversible photochromic compound that can be used as an intermediate in the preparation of a photochromic compound having an absorption ratio greater than 1.5. Thus, the thermally reversible photochromic compound according to this non-limiting embodiment can display useful photochromic properties and/or useful photochromic and dichroic properties. That is, the thermally reversible, photochromic compound can be a thermally reversible, photochromic and/or photochromic-dichroic compound. As used herein with respect to the photochromic compounds described herein, the term "photochromic-dichroic" means displaying both photochromic and dichroic properties under certain conditions, which properties are at least detectable by instrumentation.

**[073]** In accordance with other non-limiting embodiments, the thermally reversible photochromic compounds can be thermally reversible photochromic-dichroic compounds having an average absorption ratio ranging from 4 to 20, from 3 to 30, or from 2.0 to 50 in at least one

state as determined according to CELL METHOD. It will be appreciated by those skilled in the art that the higher the average absorption ratio of the photochromic compound the more linearly polarizing the photochromic compound will be. Therefore, according to various non-limiting embodiments, the thermally reversible photochromic compounds can have any average absorption ratio required to achieve a desired level of linear polarization.

**[074]** With some embodiments of the present invention, Ring-A is selected from unsubstituted aryl and substituted aryl. With further embodiments, Ring-A is selected from, aside from the  $(R^1)_m$ - group, unsubstituted aryl and substituted aryl. In accordance with some embodiments, Ring-A is selected from aryl, such as a 6-membered aromatic ring (e.g., a benzene ring). Typically, Ring-A, aside from the  $(R^1)_m$ - group, is selected from unsubstituted aryl, unsubstituted fused ring aryl, and unsubstituted heteroaryl (or aryl, fused ring aryl, and heteroaryl). Examples of aryl groups from which Ring-A can be selected include, but are not limited to, phenyl and biphenyl. Examples of fused ring aryl groups from which Ring-A can be selected include, but are not limited to, polycyclic aromatic hydrocarbons, such as naphthyl and anthracenyl. Examples of heteroaryl groups from which Ring-A can be selected include, but are not limited to, furanyl, pyranyl and pyridinyl.

**[075]** According to some embodiments,  $R^1$ , for each  $m$ , is independently selected from,  $L_2$ , formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl and optionally substituted amino. In addition,  $R^2$ , for each  $n$ , is independently selected from, formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl and optionally substituted amino.

**[076]** The  $R^3$  and  $R^4$  groups of the compound represented by Formula I, can in some embodiments, each be independently selected from hydrogen, hydroxy, and chiral and achiral groups selected from optionally substituted heteroalkyl, optionally substituted alkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, halogen, optionally substituted amino, carboxy, alkylcarbonyl, alkoxy carbonyl, optionally substituted alkoxy, and aminocarbonyl. Alternatively, one of  $R^3$  and  $R^4$  is a bond, one of  $R^3$  and  $R^4$  is oxygen, and  $R^3$  and  $R^4$  together form oxo (=O). Further alternatively,  $R^3$  and  $R^4$  together with

any intervening atoms form a group selected from optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl.

**[077]** The B and B' groups can each independently be selected, with some further embodiments, from L<sub>3</sub>, hydrogen, halogen, chiral or achiral groups selected from optionally substituted alkyl, optionally substituted alkenyl, optionally substituted heteroalkyl, optionally substituted alkoxy, optionally substituted aryl, optionally substituted heteroaryl, and optionally substituted cycloalkyl, or B and B' taken together with any intervening atoms form a group selected from optionally substituted cycloalkyl and optionally substituted heterocycloalkyl.

**[078]** The L<sub>1</sub>, L<sub>2</sub> and L<sub>3</sub> groups of the compounds according to the present invention, can, in some embodiments, be each independently selected from the chiral or achiral lengthening group represented by Formula II, in which Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> are each independently for each occurrence a divalent group selected from optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl. Each substituent of these groups from which Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> can be independently selected from, can be selected from P, liquid crystal mesogens, halogen, poly(C<sub>1</sub>-C<sub>12</sub> alkoxy), C<sub>1</sub>-C<sub>12</sub> alkoxy carbonyl, C<sub>1</sub>-C<sub>12</sub> alkyl carbonyl, perfluoro(C<sub>1</sub>-C<sub>12</sub>)alkoxy, perfluoro(C<sub>1</sub>-C<sub>12</sub>)alkoxy carbonyl, perfluoro(C<sub>1</sub>-C<sub>12</sub>)alkyl carbonyl, C<sub>1</sub>-C<sub>18</sub> acetyl, C<sub>3</sub>-C<sub>7</sub> cycloalkyl, C<sub>3</sub>-C<sub>7</sub> cycloalkoxy, straight-chain C<sub>1</sub>-C<sub>12</sub> alkyl, and branched C<sub>1</sub>-C<sub>12</sub> alkyl. The straight-chain C<sub>1</sub>-C<sub>12</sub> alkyl and branched C<sub>1</sub>-C<sub>12</sub> alkyl can be mono-substituted with a group selected from, halogen, and C<sub>1</sub>-C<sub>12</sub> alkoxy. Alternatively, The straight-chain C<sub>1</sub>-C<sub>12</sub> alkyl and branched C<sub>1</sub>-C<sub>12</sub> alkyl are poly-substituted with at least two groups independently selected from halogen.

**[079]** The c, d, e, and f subscripts of Formula II can each independently, and more particularly, be selected from an integer chosen from 1 to 10. The S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> groups of Formula II can each be independently, and more particularly, for each occurrence a spacer unit chosen from the following categories (1), (2) and (3). The spacer units of category (1) include, substituted or unsubstituted alkylene, substituted or unsubstituted haloalkylene, -Si(CH<sub>2</sub>)<sub>g</sub>-, and -(Si[(CH<sub>3</sub>)<sub>2</sub>O]<sub>h</sub>)-, wherein g for each occurrence is independently chosen from an integer from 1 to 10; h for each occurrence is independently chosen from an integer from 1 to 8; and said substitutes for the alkylene and haloalkylene are independently selected from C<sub>1</sub>-C<sub>12</sub> alkyl, C<sub>3</sub>-C<sub>7</sub> cycloalkyl and phenyl. The spacer units of category (2) include, -N(Z)-, -C(Z)=C(Z)-, and a single bond, wherein Z for each occurrence is independently selected from hydrogen, C<sub>1</sub>-C<sub>12</sub> alkyl, C<sub>3</sub>-C<sub>7</sub> cycloalkyl and phenyl. The spacer units of category (3) include, -O-, -C(=O)-, -C≡C-, -N=N-, -S-, and -S(=O)-. With regard to the spacer units from which S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> can



be more particularly chosen, there is the proviso that when two spacer units comprising heteroatoms are linked together the spacer units are linked so that heteroatoms of the first spacer unit are not directly linked to the heteroatoms of the second spacer unit. With regard to the spacer units from which  $S_1$ ,  $S_2$ ,  $S_3$ ,  $S_4$ , and  $S_5$  can be more particularly chosen, there is the further proviso that when  $S_1$  is linked to Formula I and  $S_5$  is linked to P,  $S_1$  and  $S_5$  are each linked so that two heteroatoms are not directly linked to each other

**[080]** The group P of Formula II can with some embodiments be more particularly selected for each occurrence from hydroxy, amino,  $C_2$ - $C_{12}$  alkenyl,  $C_2$ - $C_{12}$  alkenyl, silyl, siloxy, (tetrahydro-2H-pyran-2-yl)oxy, isocyanato, acryloyloxy, methacryloyloxy, epoxy, carboxylic acid, carboxylic ester,  $C_1$ - $C_{12}$  alkyloxycarbonyloxy, halocarbonyl, hydrogen, aryl, hydroxy( $C_1$ - $C_{12}$ )alkyl,  $C_1$ - $C_{12}$  alkyl,  $C_1$ - $C_{12}$  alkoxy, ethylene, acryloyl, acryloyloxy( $C_1$ - $C_{12}$ )alkyl, methacryloyl, methacryloyloxy( $C_1$ - $C_{12}$ )alkyl, oxetanyl, glycidyl, vinyl ether, siloxane derivatives, unsubstituted cinnamic acid derivatives, cinnamic acid derivatives that are substituted with at least one of methyl, methoxy, cyano and halogen, and substituted or unsubstituted chiral or non-chiral monovalent or divalent groups chosen from steroid radicals, wherein each substituent is independently chosen from  $C_1$ - $C_{12}$  alkyl,  $C_1$ - $C_{12}$  alkoxy, amino,  $C_3$ - $C_7$  cycloalkyl,  $C_1$ - $C_{12}$  alkyl( $C_1$ - $C_{12}$ )alkoxy, or P is a structure having from 2 to 4 reactive groups.

**[081]** With still further embodiments of the invention,  $R^1$ , for each m, can independently and more particularly be selected from,  $L_2$ , alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heterocycloalkyl and optionally substituted amino. In addition,  $R^2$ , for each n, can be independently and more particularly selected from, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heterocycloalkyl and optionally substituted amino.

**[082]** With such still further embodiments of the invention,  $R^3$  and  $R^4$  can each independently and more particularly be selected from, hydrogen, hydroxy, and chiral groups selected from optionally substituted heteroalkyl, optionally substituted alkyl, optionally substituted aryl, optionally substituted cycloalkyl, halogen, carboxy, alkylcarbonyl, alkoxy carbonyl, optionally substituted alkoxy, and aminocarbonyl. Alternatively, one of  $R^3$  and  $R^4$  is a bond, one of  $R^3$  and  $R^4$  is oxygen, and  $R^3$  and  $R^4$  together form oxo (=O). Further alternatively,  $R^3$  and  $R^4$  together with any intervening atoms form optionally substituted cycloalkyl.

**[083]** The B and B' groups of the compounds of the present invention can each independently and further particularly be selected from L<sub>3</sub>, hydrogen, chiral groups selected from optionally substituted alkyl, optionally substituted alkenyl, optionally substituted aryl, optionally substituted heteroaryl, and optionally substituted cycloalkyl, or wherein B and B' are taken together with any intervening atoms to form a group selected from optionally substituted cycloalkyl.

**[084]** The L<sub>1</sub>, L<sub>2</sub> and L<sub>3</sub> groups of the compounds according to the present invention, can, in some further embodiments, each be independently selected from the chiral or achiral lengthening group represented by Formula II, in which Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> are each independently and more particularly for each occurrence a divalent group selected from optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl. Each substituent of the Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> groups can be independently selected from, P, C<sub>1</sub>-C<sub>6</sub> alkoxy, perfluoro(C<sub>1</sub>-C<sub>6</sub>)alkoxy, C<sub>3</sub>-C<sub>7</sub> cycloalkyl, C<sub>3</sub>-C<sub>7</sub> cycloalkoxy, straight-chain C<sub>1</sub>-C<sub>6</sub> alkyl, and branched C<sub>1</sub>-C<sub>6</sub> alkyl. The straight-chain C<sub>1</sub>-C<sub>6</sub> alkyl and branched C<sub>1</sub>-C<sub>6</sub> alkyl are mono-substituted with a group selected from halogen and C<sub>1</sub>-C<sub>12</sub> alkoxy. Alternatively, the straight-chain C<sub>1</sub>-C<sub>6</sub> alkyl and branched C<sub>1</sub>-C<sub>6</sub> alkyl are poly-substituted with at least two groups independently selected from halogen.

**[085]** The c, d, e, and f subscripts of Formula II can each independently be selected from an integer chosen from 1 to 10. The S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> groups of Formula II can each be independently, and further particularly, for each occurrence, a spacer unit chosen from the following categories (1), (2) and (3). The spacer units of category (1) include, substituted or unsubstituted alkylene. The spacer units of category (2) include, -N(Z)-, -C(Z)=C(Z)-, and a single bond, wherein Z for each occurrence is independently selected from hydrogen and C<sub>1</sub>-C<sub>6</sub> alkyl. The spacer units of category (3) include, -O-, -C(=O)-, -C≡C-, and -N=N-, -S-. With regard to the spacer units from which S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> can be more particularly chosen, there is the proviso that when two spacer units comprising heteroatoms are linked together the spacer units are linked so that heteroatoms of the first spacer unit are not directly linked to the heteroatoms of the second spacer unit. With regard to the spacer units from which S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> can be more particularly chosen, there is the further proviso that when S<sub>1</sub> is linked to Formula I and S<sub>5</sub> is linked to P, S<sub>1</sub> and S<sub>5</sub> are each linked so that two heteroatoms are not directly linked to each other.

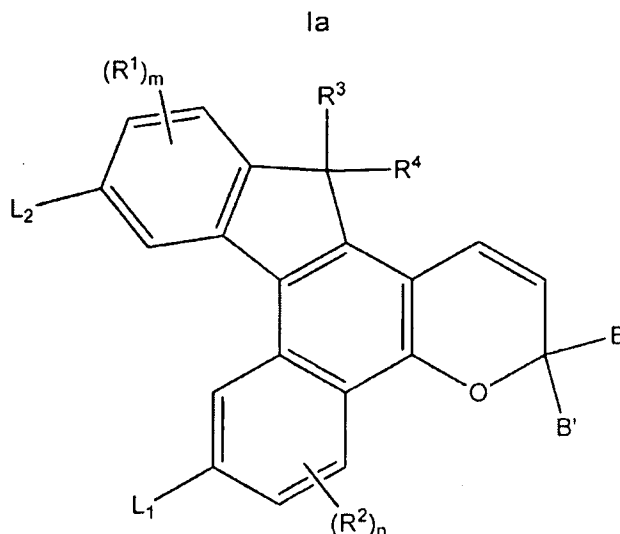
**[086]** The group P of Formula II can with some embodiments be further particularly selected for each occurrence from hydroxy, amino, C<sub>2</sub>-C<sub>6</sub> alkenyl, C<sub>2</sub>-C<sub>6</sub> alkenyl, siloxy, (tetrahydro-2H-pyran-2-yl)oxy, isocyanato, acryloyloxy, methacryloyloxy, epoxy, carboxylic acid, carboxylic

ester, C<sub>1</sub>-C<sub>6</sub> alkyloxycarbonyloxy, hydrogen, aryl, hydroxy(C<sub>1</sub>-C<sub>6</sub>)alkyl, C<sub>1</sub>-C<sub>6</sub> alkyl, ethylene, acryloyl, acryloyloxy(C<sub>1</sub>-C<sub>12</sub>)alkyl, oxetanyl, glycidyl, vinyl ether, siloxane derivatives, and substituted or unsubstituted chiral or non-chiral monovalent or divalent groups chosen from steroid radicals. Each substituent, of the groups from which P can be selected, are independently chosen from C<sub>1</sub>-C<sub>6</sub> alkyl, C<sub>1</sub>-C<sub>6</sub> alkoxy, amino, C<sub>3</sub>-C<sub>7</sub> cycloalkyl.

**[087]** With some embodiments of the present invention, R<sup>1</sup> is not selected from L<sub>2</sub>, and each of B and B' are not selected from L<sub>3</sub>. As such, with some embodiments, the only lengthening group on the compound of the present invention is L<sub>1</sub>.

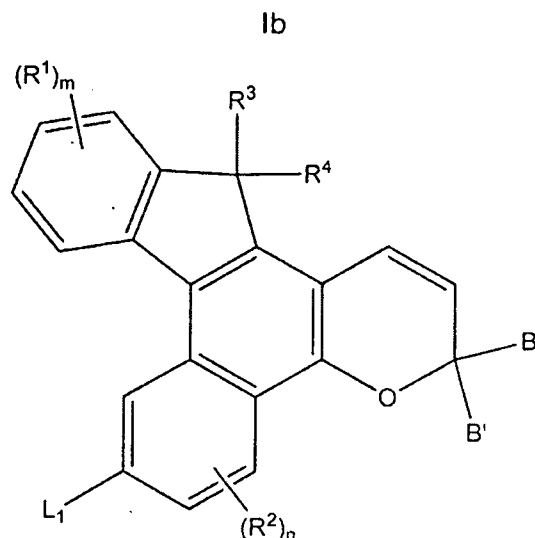
**[088]** The R<sup>1</sup> group of the compounds of the present invention, for example as represented by Formula I, can be for each m, independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and CF<sub>3</sub>. In addition, R<sup>2</sup>, for each n, is independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and CF<sub>3</sub>. The R<sup>3</sup> and R<sup>4</sup> groups can each independently be selected from, methyl, ethyl, propyl and butyl. The B and B' groups can each independently be selected from phenyl substituted with one or more groups independently selected from aryl, heteroaryl, heterocycloalkyl, alkyl, alkenyl, alkynyl, alkoxy, halogen, amino, alkylcarbonyl, carboxy, and alkoxy carbonyl. The L<sub>1</sub>, L<sub>2</sub> and L<sub>3</sub> groups can more particularly be selected from the chiral or achiral lengthening group represented by Formula II, in which: (i) Q<sub>1</sub> is unsubstituted aryl, Q<sub>2</sub> for each occurrence are each independently chosen from optionally substituted aryl, and Q<sub>3</sub> is optionally substituted cycloalkyl; (ii) e for each occurrence is 1, f is 1, S<sub>3</sub> for each occurrence is a single bond, S<sub>4</sub> is a single bond, and S<sub>5</sub> is -(CH<sub>2</sub>)<sub>g</sub>-, wherein g is from 1 to 20; (iii) P is hydrogen; and (iv) e' is 1 or 2, and f' is 1.

**[089]** The compounds of the present invention can, in some embodiments, be represented by the following Formula Ia,



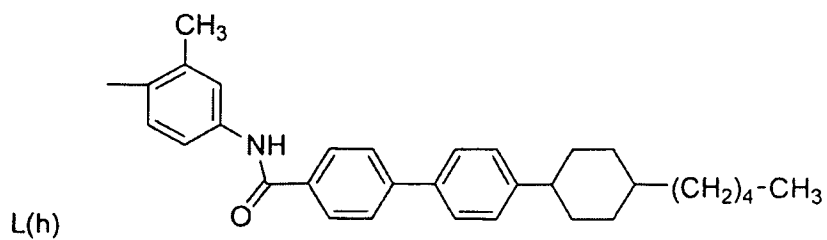
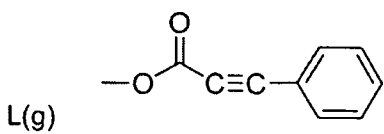
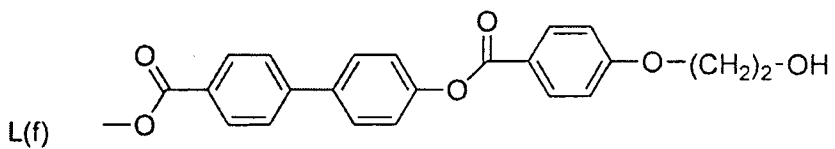
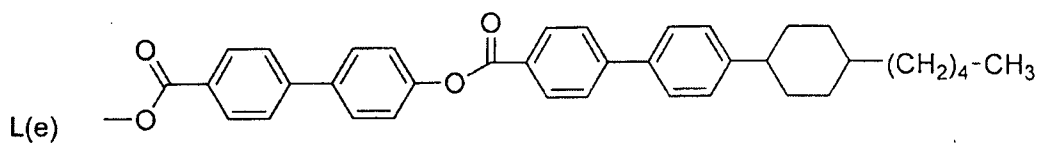
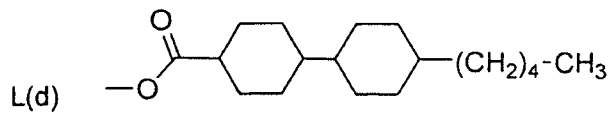
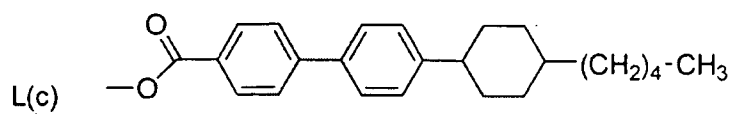
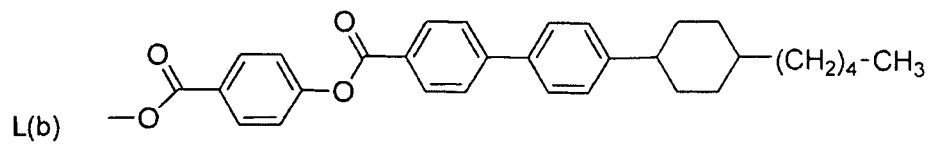
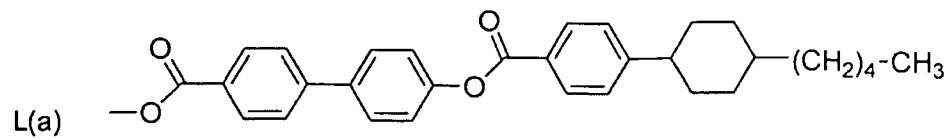
**[090]** The groups and subscripts of the compound represented by Formula Ia are each independently as described previously herein with regard to Formula I. The subscript  $m$  of Formula Ia more particularly is from 0 to 3 (e.g., 0, 1, 2 or 3). With some embodiments,  $R^1$  of Formula Ia, is not selected from  $L_2$ . For example, each  $R^1$  of the compound represented by Formula Ia, can be independently for each  $m$ , from formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxy carbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkoxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino.

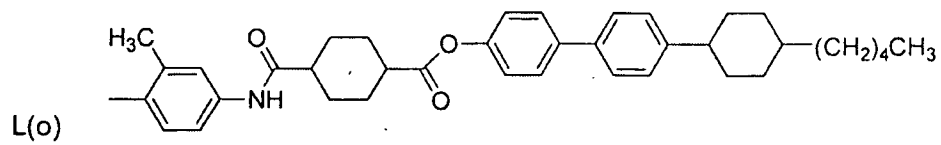
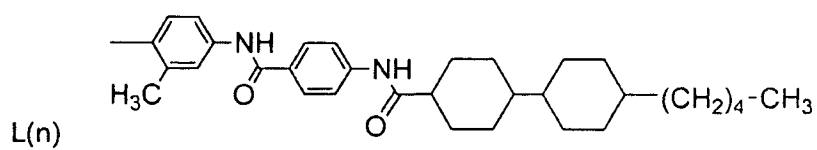
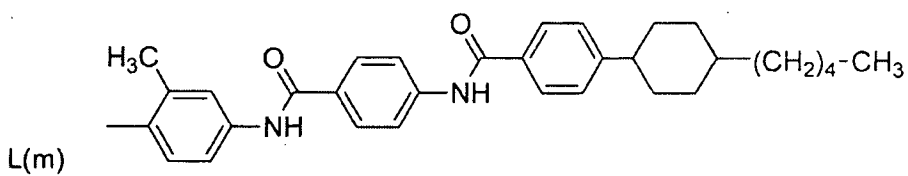
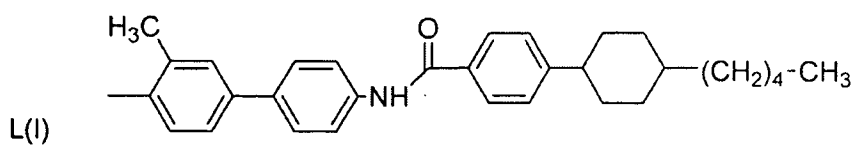
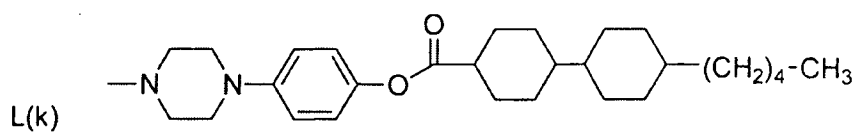
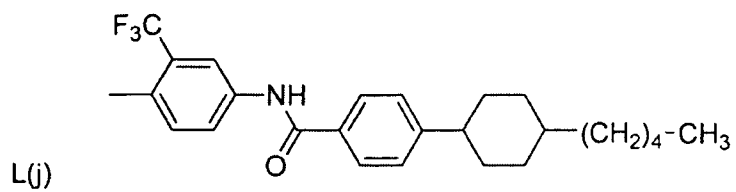
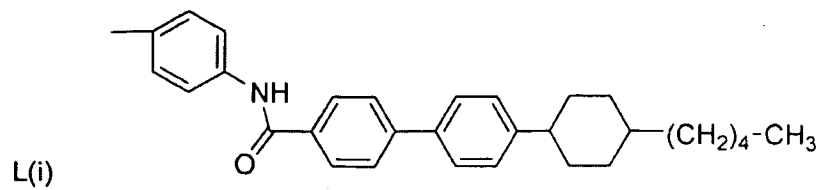
**[091]** The compounds of the present invention can, with some further embodiments, be represented by the following Formula Ib,

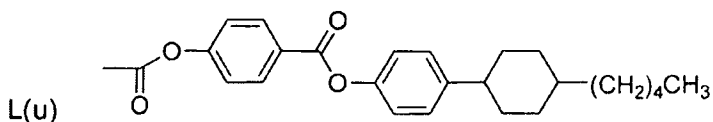
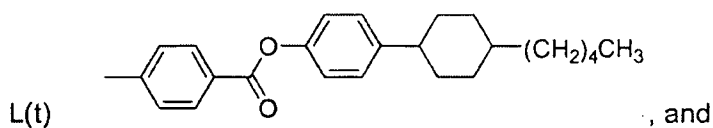
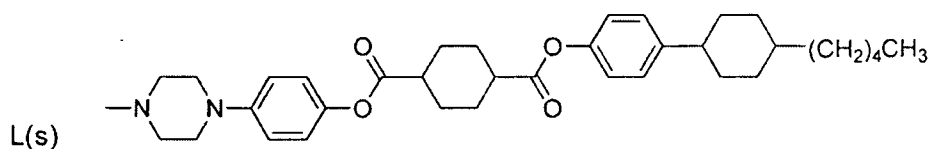
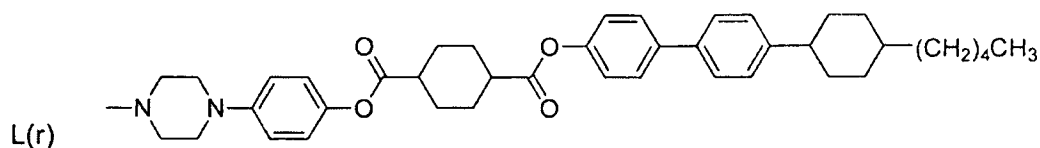
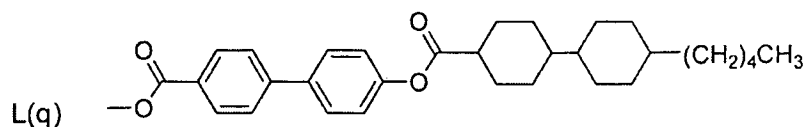
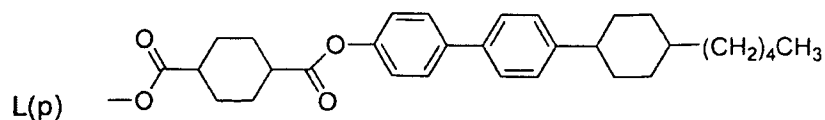


**[092]** The groups and subscripts of the compound represented by Formula Ib are each independently as described previously herein with regard to Formula I. The subscript  $m$  of Formula Ib more particularly is from 0 to 3 (e.g., 0, 1, 2 or 3). With some embodiments,  $R^1$  of Formula Ib, is not selected from  $L_2$ , and each of  $B$  and  $B'$  are not selected from  $L_3$ , in which case  $L_1$  is the only lengthening group present on the compound of the present invention represented by Formula Ib. For example,  $R^1$  of Formula Ib can be selected, independently for each  $m$ , from formyl, alkylcarbonyl, alkoxycarbonyl, aminocarbonyl, arylcarbonyl, aryloxycarbonyl, aminocarbonyloxy, alkoxycarbonylamino, aryloxycarbonylamino, boronic acid, boronic acid esters, cycloalkoxycarbonylamino, heterocycloalkyloxycarbonylamino, heteroaryloxycarbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino. In addition,  $B$  and  $B'$  of Formula Ib can each independently selected from hydrogen, halogen, and chiral or achiral groups selected from metallocenyl, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, optionally substituted heteroalkyl, optionally substituted alkoxy, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted heterocycloalkyl, and optionally substituted cycloalkyl, or wherein  $B$  and  $B'$  are taken together with any intervening atoms to form a group selected from optionally substituted cycloalkyl and optionally substituted heterocycloalkyl.

**[093]** With some embodiments,  $L_1$ ,  $L_2$  and  $L_3$  can each be independently selected from lengthening groups represented by the following Formulas L(a) through L(u).



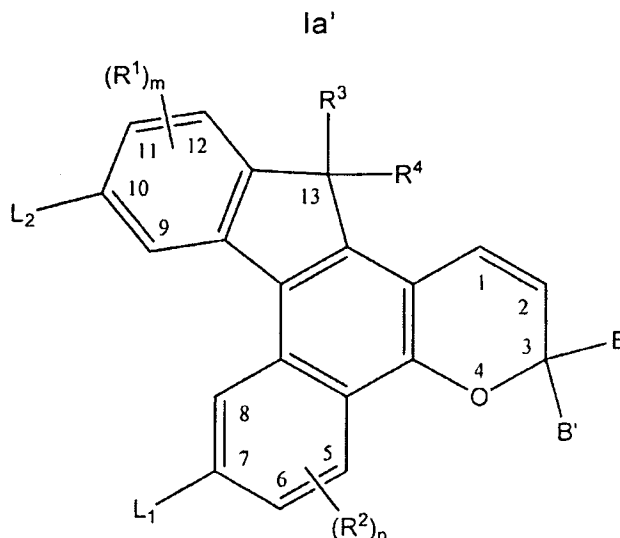




[094] In accordance with further embodiments of the present invention,  $L_1$  of the compound represented by Formula Ib can be selected from lengthening groups represented by Formulas L(a) through L(u). In accordance with embodiments in which  $L_1$  of Formula Ib is selected from lengthening groups represented by Formulas L(a) through L(u):  $R^1$ , for each  $m$ , can be independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and  $CF_3$ ;  $R^2$ , for each  $n$ , can be independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and  $CF_3$ ; the  $R^3$  and  $R^4$  groups can each be independently selected from, methyl, ethyl, propyl and butyl; and the  $A$  and  $B$  and  $B'$  groups can each be independently selected from phenyl substituted with one or more groups independently selected from aryl, heteroaryl, heterocycloalkyl, alkyl, alkenyl, alkynyl, alkoxy, halogen, amino, alkylcarbonyl, carboxy, and alkoxy carbonyl.



**[095]** The compounds of the present invention in which Ring-A is a benzene ring, such as represented by Formulas Ia and Ib, can be further described with regard to the various positions, or ring positions, of the compound to which groups can be bonded, such as  $R^1$ ,  $R^2$ ,  $L_1$ ,  $L_2$ ,  $R^3$ ,  $R^4$ , B and B'. For purposes of non-limiting demonstration, the ring positions of the compound represented by Formula Ia can be numbered as illustrated in the following Formula Ia'.



**[096]** The groups of Formula Ia' are each independently as described previously herein. With reference to Figure Ia',  $L_1$  is bonded to position-7,  $L_2$  is bonded to position 10,  $R^3$  and  $R^4$  are each bonding to position 13, and B and B' are each bonded to position 3 of the compound. With further reference to Figure 1a',  $R^1$  can be bonded to positions 9, 11 and/or 12, when m is greater than zero, and  $R^2$  can be bonded to positions 5, 6 and/or 8, when n is greater than zero. With reference to Figure 1b, in which the same ring numbering positions of Figure 1a' are equivalently applicable,  $R^1$  can be bonded to positions 9, 10, 11 and/or 12 when m is greater than zero.

**[097]** The compounds of the present invention can be used alone, as mixtures, or in combination with other compounds, compositions, and/or materials.

**[098]** The compounds of the present invention can be prepared in accordance with art-recognized methods. For purposes of non-limiting illustration, the compounds of the present invention can be prepared in accordance with the procedures described with reference to the schemes, examples and cited references described in further detail below.

[099] In the schemes and examples described further herein, the following abbreviations have the following meanings. If an abbreviation is not defined, it has its generally accepted and art-recognized meaning.

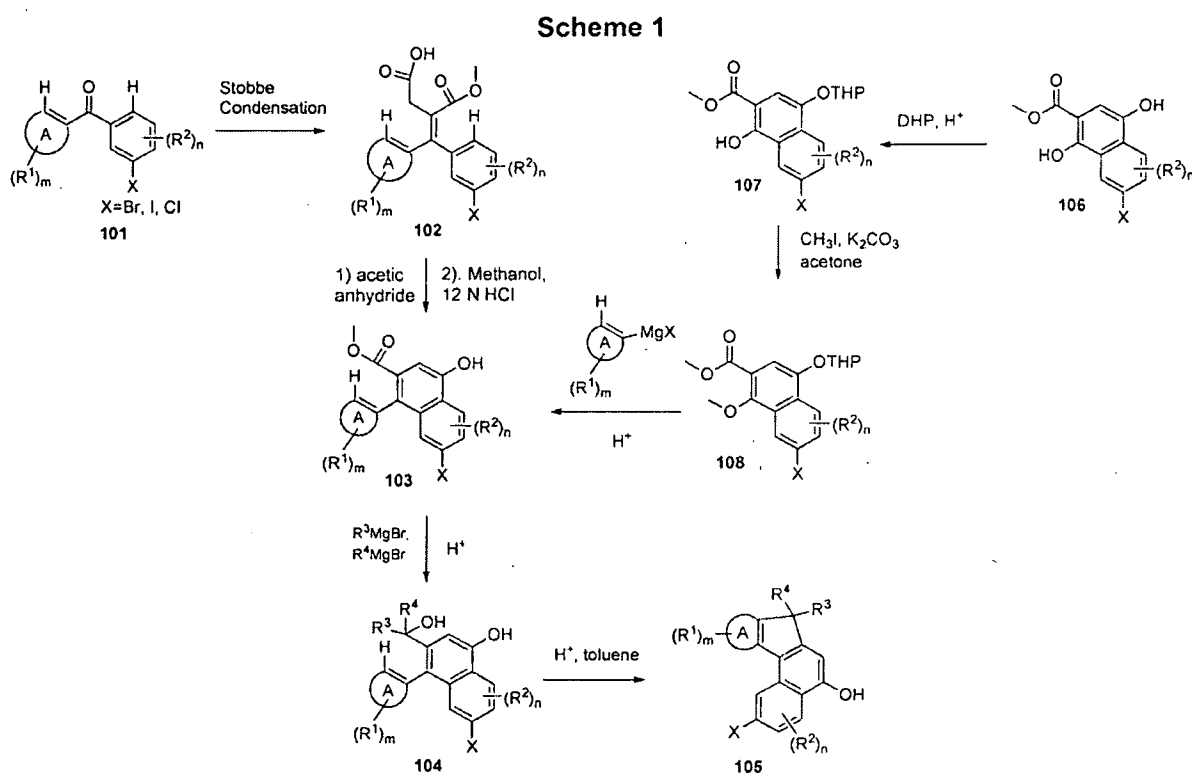
BINAP	=	2,2'-bis(diphenylphosphino)-1,1'-binaphthyl
Bi(OTf) <sub>3</sub>	=	bismuth triflate
CuI	=	copper iodide
DHP	=	3,4-dihydro-2H-pyran
DCC	=	dicyclohexylcarbodiimide
DCM	=	dichloromethane
DBSA	=	dodecylbenzenesulfonic acid
DIBAL	=	diisobutylaluminium hydride
DMAP	=	4-dimethylaminopyridine
DME	=	dimethyl ether
DMF	=	N,N-dimethylformamide
DMSO	=	dimethylsulfoxide
Dppf	=	1,1'-bis(diphenylphosphino)ferrocene
EtMgBr	=	ethyl magnesium bromide
Et <sub>2</sub> O	=	diethylether
g	=	gram
h	=	hour
HPLC	=	high-performance liquid chromatography
(iPr) <sub>2</sub> NH	=	diisopropyl amine
HOAc	=	acetic acid
LDA	=	lithium diisopropylamide
KMnO <sub>4</sub>	=	potassium permanganate
M	=	molar (molarity)
mCPBA	=	meta-Chloroperoxybenzoic acid
MeLi	=	methyl lithium
mg	=	milligram
min	=	minutes
mL	=	milliliter
mmol	=	millimoles
mM	=	millimolar
NatOBu	=	sodium <i>tert</i> -butoxide

N	=	normal (normality)
ng	=	nanogram
nm	=	nanometer
nM	=	nanomolar
NMP	=	<i>N</i> -methyl pyrrolidone
NMR	=	nuclear magnetic resonance
Pd(OAc) <sub>2</sub>	=	palladium acetate
Pd <sub>2</sub> (dba) <sub>3</sub>	=	tris(dibenzylideneacetone)dipalladium(0)
PPh <sub>3</sub>	=	triphenyl phosphine
PPTS	=	pyridine <i>p</i> -toluenesulfonate
pTSA	=	<i>p</i> -toluenesulfonic acid
PdCl <sub>2</sub> (PPh <sub>3</sub> ) <sub>2</sub>	=	bis(triphenylphosphine)palladium(II) chloride
PBS	=	phosphate buffered saline
TBAF	=	Tetra- <i>n</i> -butylammonium fluoride
THF	=	tetrahydrofuran
TLC	=	thin layer chromatography
t-BuOH	=	t-butanol
(Tf) <sub>2</sub> O	=	trifluoromethanesulfonic acid anhydride
μL	=	microliter
μM	=	micromolar
Zn(OAc) <sub>2</sub>	=	zinc acetate
Zn(CN) <sub>2</sub>	=	Zinc cyanide

**[0100]** As discussed in the schemes outlined further below, compound **105** represents an intermediate that can serve as the basis for preparing embodiments of photochromic dichroic dyes described herein. For example, it can be prepared as shown in Scheme 1, 2, 3, 4 and 5. Once prepared, the hydroxy functionality of compound **105** can be used for pyran formation as described with reference to Scheme 6. The halogen of **105** can be either converted into a lengthening group via Suzuki Reaction or converted into another functional group **Q** as illustrated with reference to Scheme 6. Chemistries that can be used for functional group conversion are demonstrated with reference to Schemes 7, 8 and 9. The functional group **Q** can either be a lengthening group or converted to lengthening group.

**[0101]** With the schemes described herein, X can be selected from halogen, e.g., F, Br, Cl and I. Each m and n is an integer chosen from 0 to the total number of available positions. From Scheme 1 to Scheme 9, R<sup>1</sup> and R<sup>2</sup> for each occurrence, can each be independently selected

from hydrogen, halogen and optionally substituted chiral or achiral groups selected from alkyl, perfluoroalkyl, alkenyl, alkynyl, cycloalkyl, aryl, heteroaryl, alkoxy, perfluoroalkoxy, heteroalkyl, heterocycloalkyl, alkylthiol, arylthiol, amino aminocarbonyl, aryloxycarbonyl, alkyloxycarbonyl, aminocarbonyloxy, alkoxy-carbonylamino, aryloxycarbonylamino, cycloalkoxycarbonylamino, heterocycloalkyloxycarbonylamino and heteroaryloxycarbonylamino.



**[0102]** Scheme 1 demonstrates a method by which compound **105** can be prepared. The  $\text{R}^3$  and  $\text{R}^4$  groups of Scheme 1 can be selected from optionally substituted chiral or achiral groups such as heteroalkyl, alkyl, perfluoroalkyl, alkenyl, alkynyl, aryl, heteroaryl, cycloalkyl, and heterocycloalkyl.

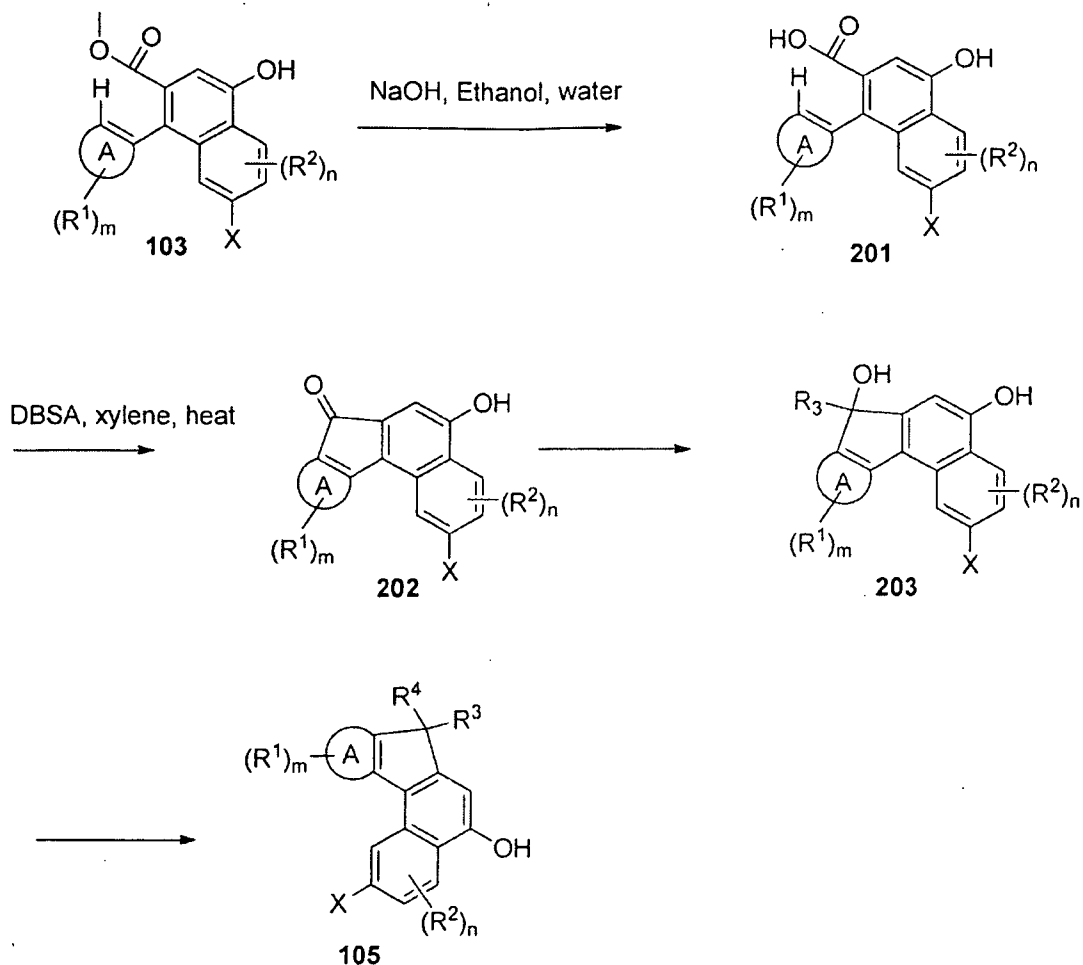
**[0103]** The aryl ketone **101** can either be purchased or prepared by Friedel-Crafts methods or Grignard or Cuperate methods known in the art. For example, see the publication Friedel-Crafts and Related Reactions, George A. Olah, Interscience Publishers, 1964, Vol. 3, Chapter XXXI (Aromatic Ketone Synthesis); "Regioselective Friedel-Crafts Acylation of 1,2,3,4-Tetrahydroquinoline and Related Nitrogen Heterocycles: Effect on NH Protective Groups and Ring Size" by Ishihara, Yugi et al, J. Chem. Soc., Perkin Trans. 1, pages 3401 to 3406, 1992;

"Addition of Grignard Reagents to Aryl Acid Chlorides: An efficient synthesis of aryl ketones" by Wang, Xiao-jun et al, Organic Letters, Vol. 7, No. 25, 5593-5595, 2005, and references cited therein, which disclosures related to the aforementioned synthetic methods are incorporated herein by reference in their entireties. A Stobbe reaction of aryl ketone **101** with dimethyl succinate in the presence of potassium t-butoxide provides the condensed product of compound **102**, which undergoes a ring closure reaction in acetic anhydride followed by methanolysis to form the product of compound **103**.

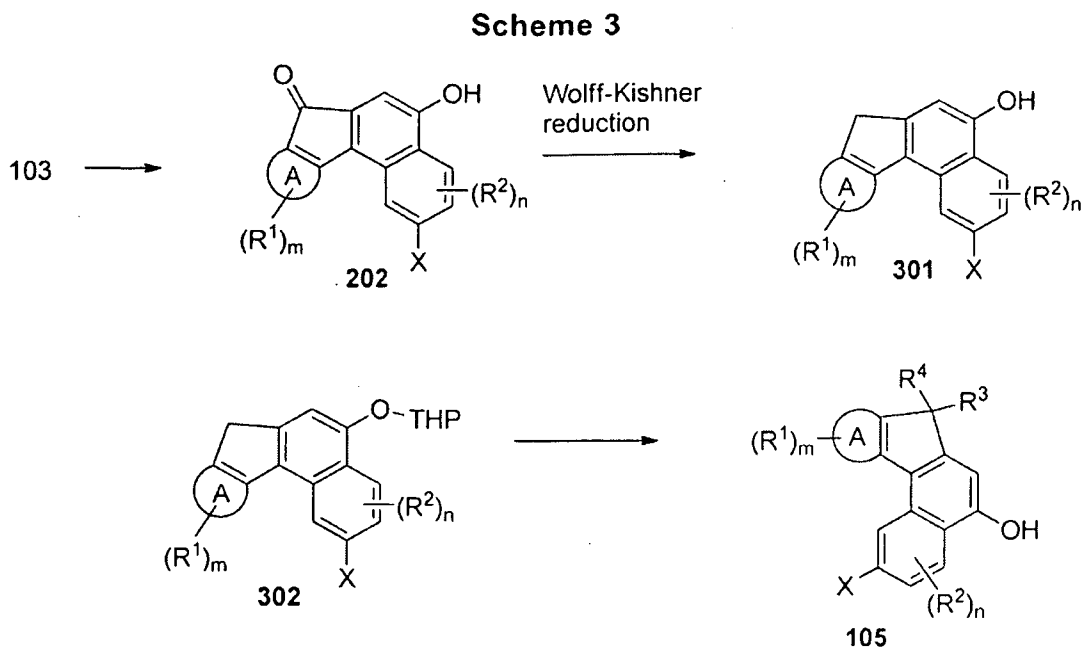
**[0104]** Compound **103** can also be prepared from an ester-mediated nucleophilic aromatic substitution reaction starting from compound **106** by methods known to those skilled in the art, for example, as further described in Synthesis, January 1995, pages 41-43; The Journal of Chemistry Society Perkin Transaction 1, 1995, pages 235-241 and U.S. Patent No. 7,557,208 B2, which disclosures related to such synthetic methods are incorporated herein by reference in their entireties.

**[0105]** Once prepared, compound **103** can be further converted to indeno-fused product of compound **105** with various substitutions on the bridge carbon via various multistep reactions that can be found in U.S. Pat. Nos. 5,645,767; 5,869,658; 5,698,141; 5,723,072; 5,961,892; 6,113,814; 5,955,520; 6,555,028; 6,296,785; 6,555,028; 6,683,709; 6,660,727; 6,736,998; 7,008,568; 7,166,357; 7,262,295; 7,320,826 and 7,557,208, which disclosures related to the substituents on the bridge carbon are incorporated herein by reference in their entireties. What is shown in Scheme 1 illustrates that compound **103** reacts with Grignard reagent followed by a ring closure reaction to provide compound **105**.

Scheme 2



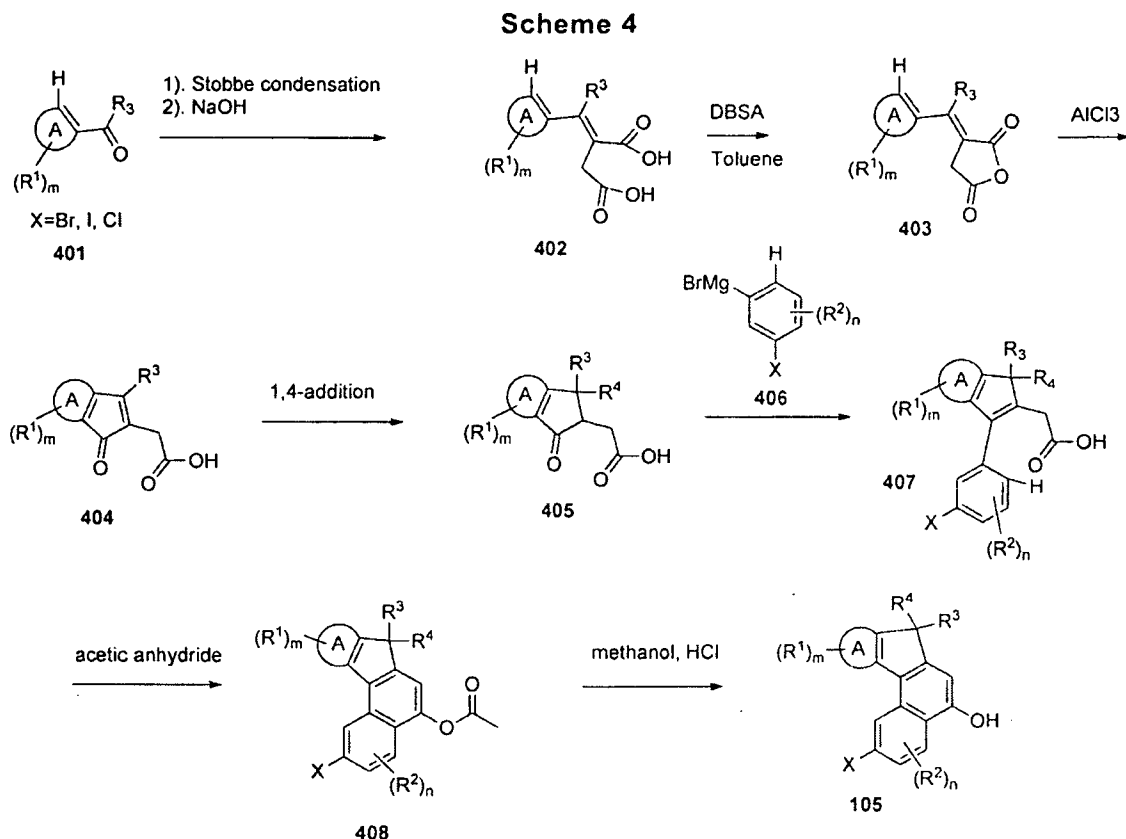
**[0106]** Scheme 2 illustrates a second way of converting compound **103** to compound **105**. After hydrolysis of compound **103** followed by a ring closure reaction, compound **202** was obtained. The carbonyl of compound **202** can react with a nucleophile, like Grignard reagent, Organo lithium reagent, or perfluoroalkyl trimethylsilane to form compound **203**. The  $R^3$  group can be selected from optionally substituted chiral or achiral groups such as heteroalkyl, alkyl, perfluoroalkyl, alkenyl, alkynyl, aryl, heteroaryl, cycloalkyl and heterocycloalkyl. The hydroxyl group of compound **203** can be easily converted into  $R^4$ , which can be selected from halogen and optionally substituted chiral or achiral groups such as alkoxy, silanoxy, heteroaryloxy and aryloxy.



**[0107]** Scheme 3 illustrates a third way of converting compound **103** to compound **105**.

Compound **202** from Scheme 2 can be reduced to **301** using a Wolff-Kishner reduction or its modified version. Examples can be found in "Practical procedures for the preparation of N-tert-butyltrimethylsilylhydrozones and their use in modified Wolff-Kishner reductions and in the synthesis of vinyl halides and gem-dihalides" by Furrow, M.E., et al, J Am Chem Soc: 126(17): 5436-45, May 5 2004, and references therein, which disclosures related to the Wolff-Kishner reduction are incorporated herein by reference. After hydroxy protection, compound **302** has a very nucleophilic gem-carbon once deprotonated by base like LDA or methyl Grignard reagent. By those skilled in the art, the deprotonated compound **302** can be converted to  $R^3$  and  $R^4$  by reacting it with electrophiles such as alkyl halides, carbon dioxide, acid chlorides, nitriles and chloroformate derivatives. As a result, compound **105** can be prepared with  $R_1$  and  $R_2$  selected from hydrogen, optionally substituted chiral or achiral groups selected from heteroalkyl, alkyl, cycloalkyl, carboxy, alkylcarbonyl, alkoxy carbonyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, or  $R^3$  and  $R^4$  can be taken together with any intervening atoms to form a group selected from oxo, optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl.

**[0108]** Schemes 4 and 5 represent summaries of two novel methods of preparing compound **105**, which are not believed to have been previously described.

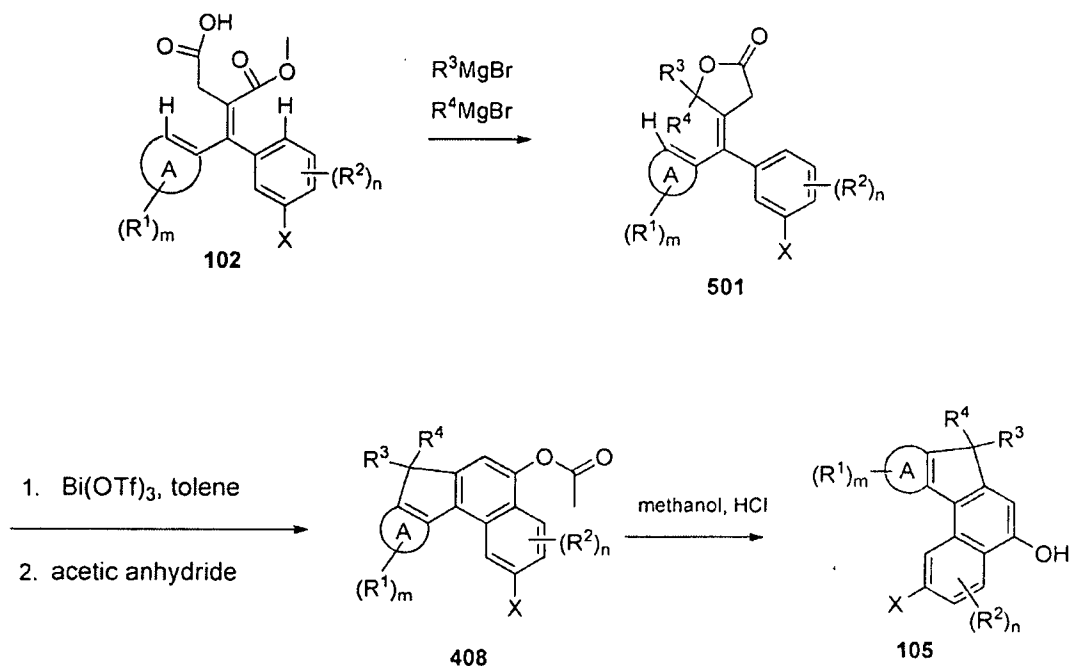


**[0109]** Scheme 4 starts from aryl ketone 401. R<sup>3</sup> can be selected from hydrogen, optionally substituted chiral or achiral groups such as heteroalkyl, alkyl, perfluoroalkyl, alkenyl, alkynyl, aryl, heteroaryl, cycloalkyl and heterocycloalkyl.

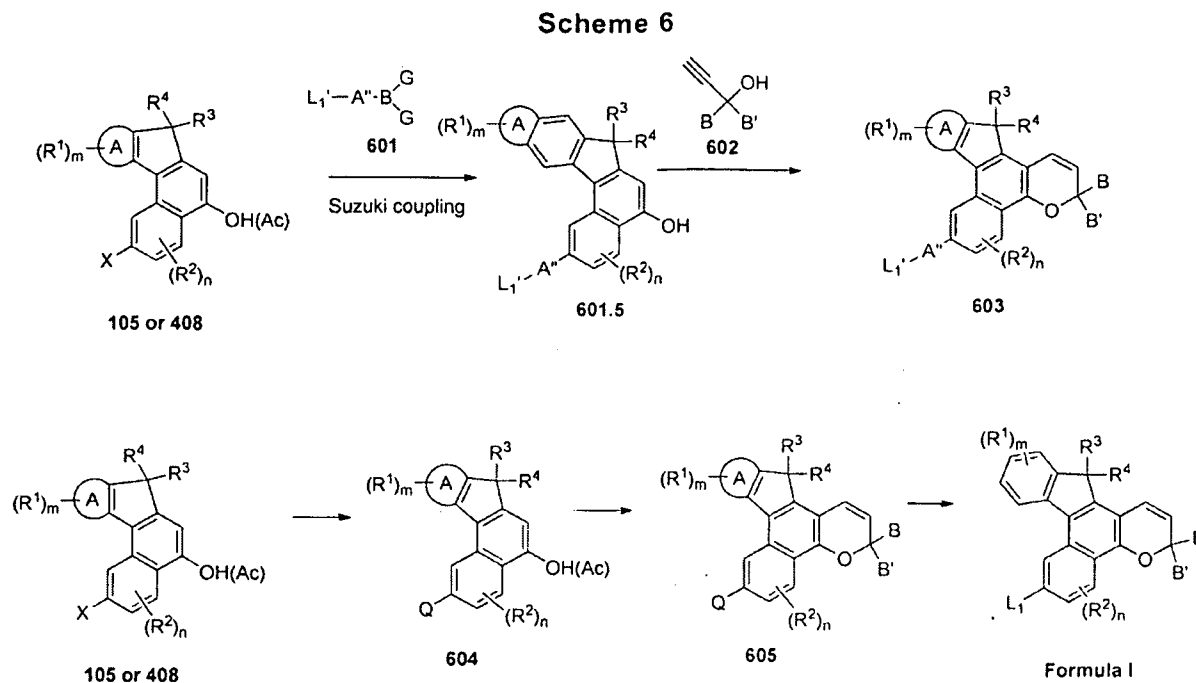
**[0110]** After a Stobbe reaction with dimethyl succinate, compound 402 is converted to an anhydride 403. This anhydride can be transformed into an indenone acid 404 with the use of aluminum chloride. A 1,4-addition reaction can be done with the use of nucleophiles like organometallic reagent, amine, alcohol and thiol. The reaction provides indano acid 405. R<sup>4</sup> can be selected from hydrogen, optionally substituted chiral or achiral groups such as heteroalkyl, alkyl, alkenyl, alkynyl, aryl, heteroaryl, cycloalkyl, heterocycloalkyl, amino, alkoxy, and thiol. Compound 405 can react with a Grignard reagent 406 to form compound 407 after acidic workup. Compound 407 undergoes a ring closure reaction in acetic anhydride followed by methanolysis to form product 408, which can be either used directly in Scheme 6 or converted to compound 105 by hydrolysis.



## Scheme 5



**[0111]** Scheme 5 starts from Stobbe product 102, which reacts with a Grignard reagent to provide compound 501.  $R^3$  and  $R^4$  can be selected from optionally substituted chiral or achiral groups such as heteroalkyl, alkyl, perfluoroalkyl, alkenyl, alkynyl, aryl, heteroaryl, cycloalkyl and heterocycloalkyl. After treating with bismuth triflate in toluene and then acetic anhydride, two ring closure reactions occur in the same pot sequentially. The efficient reaction results in compound 408, which can be converted into compound 105.



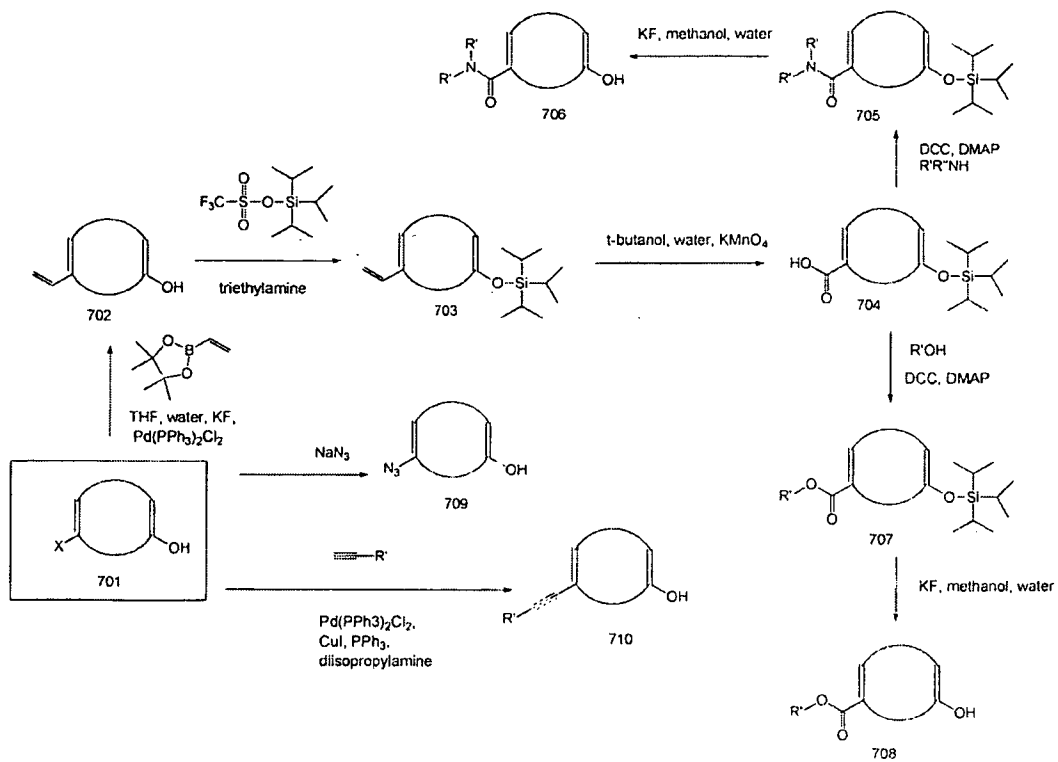
**[0112]** Scheme 6 illustrates methods of converting compounds 105 and 408 into photochromic dichroic dyes. When Suzuki reaction is applied, the lengthening group is added with the use of a boronic derivative 601, the synthesis of which can be found from "Palladium(0)-Catalyzed Cross-Coupling Reaction of Alkoxydiboron with Haloarenes: A Direct Procedure for Arylboronic Esters, *J. Org. Chem.* 60, page 7508-7519, 1995" by Miyaura, Norio et al and references therein, which disclosures related to such synthetic methods are incorporated herein by reference. The pyran ring of compound 603 is formed with the coupling with a propargyl alcohol 602. Compound 603 can also be obtained when the sequence of the two reactions are changed. As described herein, G can be -OH or -O-Alkyl; A'' may be selected from aryl, alkenyl, alkynyl and heteroaryl; A' and L' together form the L<sub>1</sub>, L<sub>2</sub> or L<sub>3</sub> group; and B and B' can each be independently selected from L<sub>3</sub>, hydrogen, halogen, and optionally substituted chiral or achiral groups such as metallocenyl, alkyl or perfluoroalkyl, alkenyl, alkynyl, heteroalkyl, alkoxy, perfluoroalkoxy, aryl, heteroaryl, heterocycloalkyl, and cycloalkyl, or wherein B and B' are taken together with any intervening atoms to form a group such as optionally substituted cycloalkyl and optionally substituted heterocycloalkyl.

**[0113]** Also shown in Scheme 6 as alternative ways of incorporating lengthening groups, halogen X can be converted to other functional group Q with the formation of compound 604. Compound 604 can react with a propargyl alcohol to form pyran dye 605, which can be a

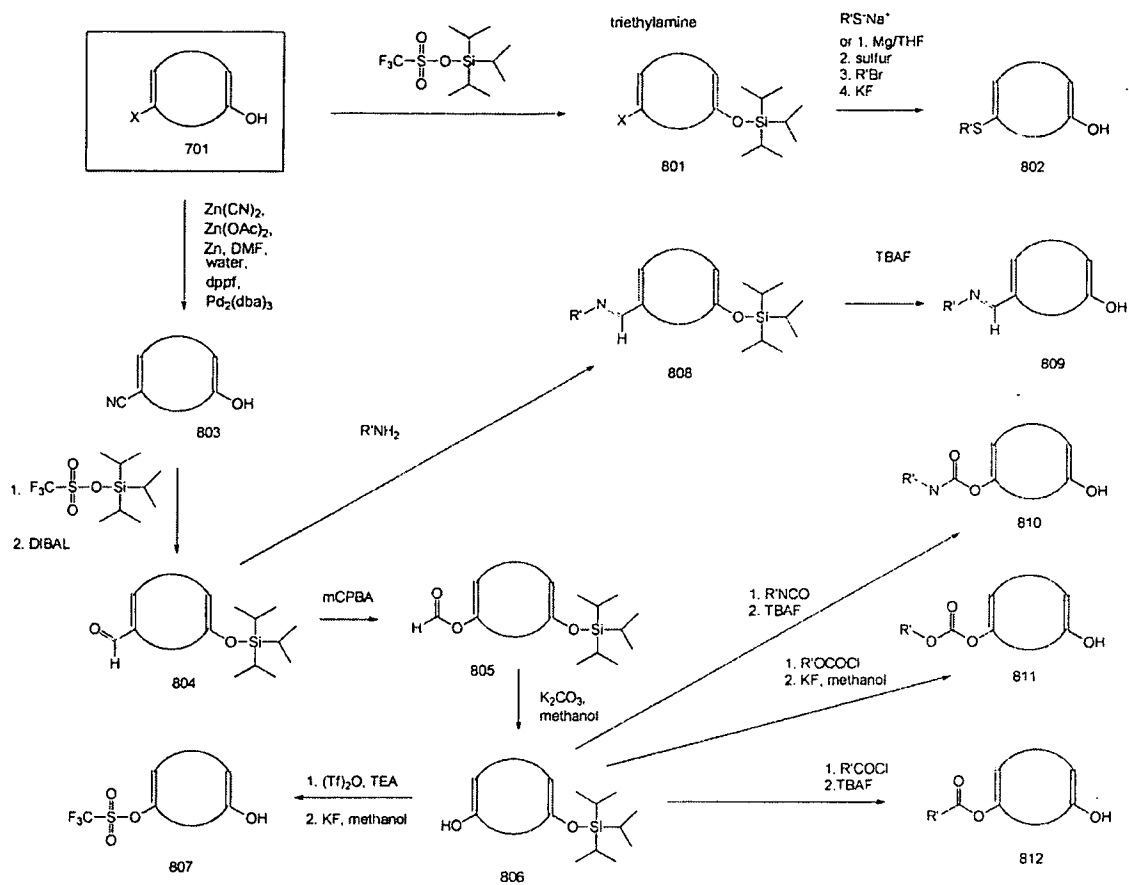
photochromic dichroic dye itself or can be converted to photochromic dichroic dye **Formula I**. These new functional groups Q can include:  $-N_3$ ,  $-CN$ ,  $-COOR'$ ,  $-CCR'$ ,  $-CHCHR'$ ,  $-OCOR'$ ,  $-OCOOR'$ ,  $-SR'$ ,  $-OSO_2R'$ ,  $-OR'$ ,  $-OTf$ ,  $-CHO$ ,  $-OCHO$ ,  $-OCONR'$ ,  $-NR'R'$ ,  $-NR'CONR'R'$ ,  $-NR'COR'$ ,  $-NR'COOR'$ ,  $-CHNR'$ , and  $-CONR'R'$ , wherein R' can be independently chosen from hydrogen,  $L_1$ , an unsubstituted or substituted alkyl group having from 1 to 18 carbon atoms, an unsubstituted or substituted aryl group, an unsubstituted or substituted alkene or alkyne group having from 2 to 18 carbon atoms,  $-CF_3$  and a perfluorinated alkyl group having from 2 to 18 carbon atoms or two R' can come together with  $-N$  and form a heterocycloalkyl such as piperazinyl.

**[0114]** Schemes 7, 8 and 9 illustrate details of converting halogen to other functional groups that can be either further converted to lengthening groups or are lengthening groups themselves. The chemistries are conducted at hydroxy stage starting from compound 105, which is simplified as compound 701 in Schemes 7 and 8. Each of the hydroxy products of compounds 702, 706, 708, 709, 710, 802, 803, 807, 809, 810, 811, 812, 901, 903, 904 and 906 can be converted to pyran photochromic compounds using the propargyl alcohol chemistry shown in Scheme 6.

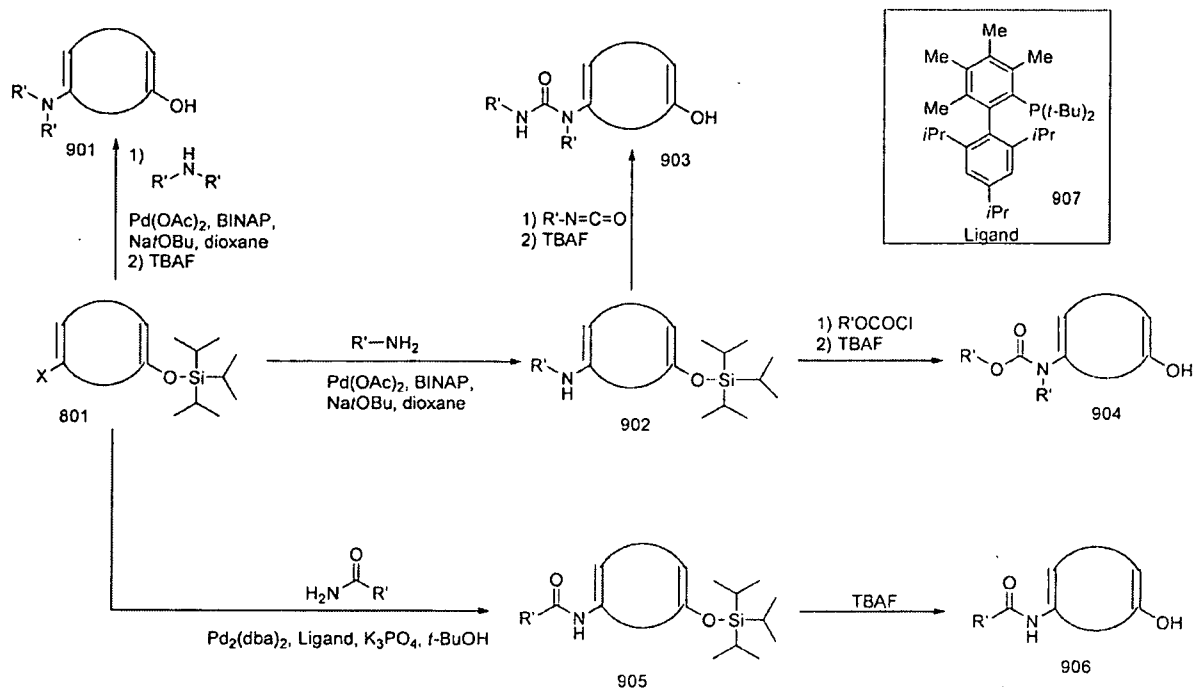
Scheme 7



Scheme 8

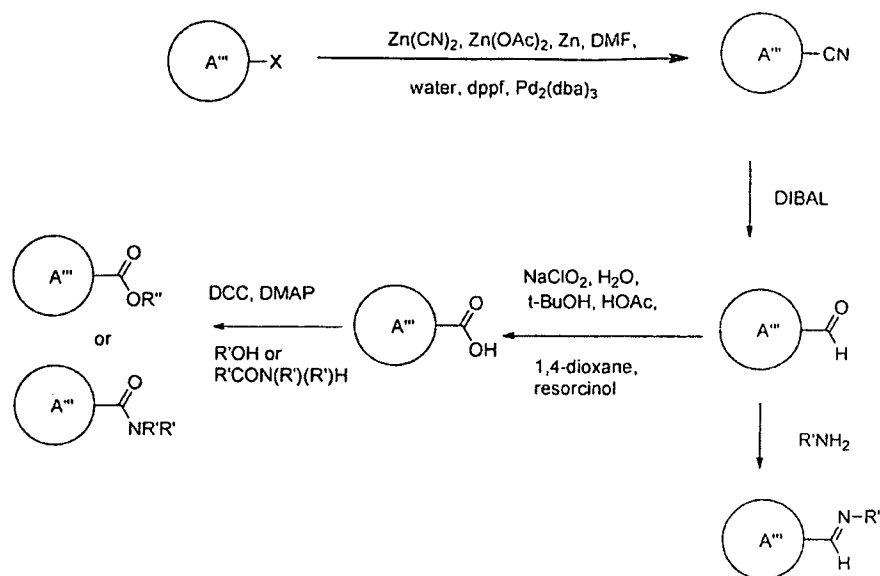


Scheme 9



[0115] Scheme 10 shows chemistries that can be conducted on the photochromic dichroic dye. A''' is a simplified version of Formula I with one of R<sup>1</sup> or R<sup>2</sup> selected from halogen X. X is located at one of the positions where R<sup>1</sup> and R<sup>2</sup> would be located. This Scheme compliments what can be done from Schemes 1 to 9 for R<sup>1</sup> and R<sup>2</sup> and install groups like cyano, aldehyde, carboxylic acid, and optionally substituted chiral or achiral groups selected from imine, alkoxycarbonyl, aminocarbonyl and aryloxycarbonyl as R<sup>1</sup> and R<sup>2</sup>. The cyanation and oxidation methods have been described in U.S. Patent Pub. No. 2009/0309076A1, wherein these cyanation and oxidation methods are incorporated herein by reference.

Scheme 10



**[0116]** The compounds of the present invention can be used as thermally reversible photochromic compounds and/or compositions according to various non-limiting embodiments disclosed herein. Such compounds can be used in a variety of applications to provide photochromic and/or photochromic-dichroic properties.

**[0117]** The photochromic compositions of the present invention can include at least one of the compounds described herein, and optionally at least one other photochromic compound. The photochromic composition can be chosen from a variety of materials. Examples of such materials include, but are not limited to: (a) a single photochromic compound; (b) a mixture of photochromic compounds; (c) a material comprising at least one photochromic compound such as a polymeric resin or an organic monomer solution; (d) a material such as a monomer or polymer to which at least one photochromic compound is chemically bonded; (e) material (c) or (d) further comprising a coating to substantially prevent contact of the at least one photochromic compound with external materials; (f) a photochromic polymer; or (g) mixtures thereof.

**[0118]** The present invention further provides a photochromic article that includes an organic material and a photochromic compound/composition of the present invention that is connected to at least a portion of the organic host material. As used herein the term "connected to" means in direct contact with an object or indirect contact with an object through one or more other structures or materials, at least one of which is in direct contact with the object. Further, the photochromic compound can be connected to at least a portion of the host by incorporation into the host material or by application onto the host material, for example, as part of a coating or

layer. In addition to the photochromic compound, the photochromic composition can further include at least one additive chosen from, for example, dyes, alignment promoters, antioxidants, kinetic enhancing additives, photoinitiators, thermal initiators, polymerization inhibitors, solvents, light stabilizers, e.g., ultraviolet light absorbers and hindered amines stabilizers, heat stabilizers, mold release agents, rheology control agents, leveling agents, free radical scavengers, gelators and adhesion promoters.

**[0119]** Examples of dyes that can be present in the at least partial coating according to various embodiments disclosed herein include organic dyes that are capable of imparting a desired color or other optical property to the at least partial coating.

**[0120]** As used herein, the term "alignment promoter" means an additive that can facilitate at least one of the rate and uniformity of the alignment of a material to which it is added. Examples of alignment promoters that can be present in the at least partial coatings according to various embodiments disclosed herein include those described in U.S. Patent 6,338,808 and U.S. Patent Publication No. 2002/0039627.

**[0121]** Antioxidants, e.g., polyphenolic antioxidants, are organic compounds used to retard oxidation. Examples of antioxidants are described in U.S. Pat. Nos. 4,720,356, 5,391,327 and 5,770,115, the disclosures of which are incorporated herein by reference.

**[0122]** Examples of kinetic enhancing additives that can be present in the at least partial coating according to various embodiments disclosed herein include epoxy-containing compounds, organic polyols, and/or plasticizers. More specific examples of such kinetic enhancing additives are disclosed in U.S. Patent 6,433,043 and U.S. Patent Publication No. 2003/0045612.

**[0123]** Examples of photoinitiators that can be present in the at least partial coating according to various embodiments disclosed herein include cleavage-type photoinitiators and abstraction-type photoinitiators. Examples of cleavage-type photoinitiators include acetophenones,  $\alpha$ -aminoalkylphenones, benzoin ethers, benzoyl oximes, acylphosphine oxides and bisacylphosphine oxides or mixtures of such initiators. A commercial example of such a photoinitiator is DAROCURE<sup>®</sup> 4265, which is available from Ciba Chemicals, Inc. Examples of abstraction-type photoinitiators include benzophenone, Michler's ketone, thioxanthone, anthraquinone, camphorquinone, fluorone, ketocoumarin or mixtures of such initiators.



**[0124]** Another Example of a photoinitiator that can be present in according to various embodiments disclosed herein is a visible light photoinitiator. Examples of suitable visible light photoinitiators are set forth at column 12, line 11 to column 13, line 21 of U.S. Patent 6,602,603.

**[0125]** Examples of thermal initiators include organic peroxy compounds and azobis(organonitrile) compounds. Specific examples of organic peroxy compounds that are useful as thermal initiators include peroxy monocarbonate esters, such as tertiarybutylperoxy isopropyl carbonate; peroxydicarbonate esters, such as di(2-ethylhexyl) peroxydicarbonate, di(secondary butyl) peroxydicarbonate and diisopropylperoxydicarbonate; diacyperoxides, such as 2,4-dichlorobenzoyl peroxide, isobutyryl peroxide, decanoyl peroxide, lauroyl peroxide, propionyl peroxide, acetyl peroxide, benzoyl peroxide and p-chlorobenzoyl peroxide; peroxyesters such as t-butylperoxy pivalate, t-butylperoxy octylate and t-butylperoxyisobutyrate; methylethylketone peroxide, and acetylcyclohexane sulfonyl peroxide. In one embodiment the thermal initiators used are those that do not discolor the resulting polymerizate. Examples of azobis(organonitrile) compounds that can be used as thermal initiators include azobis(isobutyronitrile), azobis(2,4-dimethylvaleronitrile) or a mixture thereof.

**[0126]** Examples of polymerization inhibitors include: nitrobenzene, 1,3,5-trinitrobenzene, p-benzoquinone, chloranil, DPPH, FeCl<sub>3</sub>, CuCl<sub>2</sub>, oxygen, sulfur, aniline, phenol, p-dihydroxybenzene, 1,2,3-trihydroxybenzene, and 2,4,6-trimethylphenol.

**[0127]** Examples of solvents that can be present in the LC compositions according to various embodiments disclosed herein include those that will dissolve solid components of the LC compositions, that are compatible with the LC compositions and the elements and substrates, and/or can ensure uniform coverage of a surface(s) to which the LC composition is applied. Potential solvents include the following: propylene glycol monomethyl ether acetate and their derivatives (sold as DOWANOL® industrial solvents), acetone, amyl propionate, anisole, benzene, butyl acetate, cyclohexane, dialkyl ethers of ethylene glycol, e.g., diethylene glycol dimethyl ether and their derivatives (sold as CELLOSOLVE® industrial solvents), diethylene glycol dibenzoate, dimethyl sulfoxide, dimethyl formamide, dimethoxybenzene, ethyl acetate, isopropyl alcohol, methyl cyclohexanone, cyclopentanone, methyl ethyl ketone, methyl isobutyl ketone, methyl propionate, propylene carbonate, tetrahydrofuran, toluene, xylene, 2-methoxyethyl ether, 3-propylene glycol methyl ether, and mixtures thereof.

**[0128]** Examples of thermal stabilizers may include a basic nitrogen-containing compound for example, biurea, allantoin or a metal salt thereof, a carboxylic acid hydrazide, e.g., an aliphatic or aromatic carboxylic acid hydrazide, a metal salt of an organic carboxylic acid, an alkali or

alkaline earth metal compound, a hydrotalcite, a zeolite and an acidic compound (e.g., a boric acid compound, a nitrogen-containing cyclic compound having a hydroxyl group, a carboxyl group-containing compound, a (poly)phenol, butylated hydroxytoluene, and an aminocarboxylic acid) or mixtures thereof.

**[0129]** Examples of mold release agents include esters of long-chain aliphatic acids and alcohols such as pentaerythritol, guerbet alcohols, long-chain ketones, siloxanes, alpha.-olefin polymers, long-chain alkanes and hydrocarbons having 15 to 600 carbon atoms.

**[0130]** Rheology control agents are thickeners that are typically powders that may be inorganic, such as silica, organic such as microcrystalline cellulose or particulate polymeric materials. Gelators or gelling agents are often organic materials that can also affect the thixotropy of the material in which they are added. Examples of suitable gelators or gelling agents include natural gums, starches, pectins, agar-agar, and gelatins. Gelators or gelling agents may often be based on polysaccharides or proteins.

**[0131]** In certain embodiments, one or more surfactants may be used. Surfactants include materials otherwise known as wetting agents, anti-foaming agents, emulsifiers, dispersing agents, leveling agents etc. Surfactants can be anionic, cationic and nonionic, and many surfactants of each type are available commercially. Examples of nonionic surfactants that may be used include ethoxylated alkyl phenols, such as the IGEPAL® DM surfactants or octylphenoxy polyethoxy ethanol sold as TRITON® X-100, an acetylenic diol such as 2,4,7,9-tetramethyl-5-decyne-4,7-diol sold as SURFYNOL® 104, ethoxylated acetylenic diols, such as the SURFYNOL® 400 surfactant series, fluoro-surfactants, such as the FLUORAD® fluorochemical surfactant series, and capped nonionics such as the benzyl capped octyl phenol ethoxylates sold as TRITON® CF87, the propylene oxide capped alkyl ethoxylates, which are available as the PLURAFAC® RA series of surfactants, octylphenoxyhexadecylethoxy benzyl ether, polyether modified dimethylpolysiloxane copolymer in solvent sold as BYK®-306 additive by Byk Chemie and mixtures of such recited surfactants.

**[0132]** Free radical scavengers include synthetic pseudopeptides resistant to hydrolysis such as Carcinine hydrochloride; lipoamino acids such as L-lysine lauroylmethionine; plant extracts containing multi-enzymes; natural tocopherol and related compounds as well as compounds containing an active hydrogen such as -OH, -SH, or -NRH group. Further examples of free radical scavengers are chosen from the group of sterically hindered amines (HALS=hindered amine light stabilizer) which, unlike customary light protection agents, are not based on the absorption of the irradiated light or on the quenching of the absorbed light, but essentially on the

ability to scavenge or to replace free radicals and hydroperoxides formed during the photodegradation of polymeric materials and antioxidants.

**[0133]** Adhesion promoters include adhesion promoting organo-silane materials, such as aminoorganosilane materials, silane coupling agents, organic titanate coupling agents and organic zirconate coupling agents described in U.S. Patent Application Publication 2004/0207809 at paragraphs [0033] to [0042]. Further examples of adhesion promoters include zircon-aluminate adhesion promoting compounds that are commercially available from Rhone-Poulenc. Preparation of aluminum-zirconium complexes is described in the U.S. Patent Nos. 4,539,048 and 4,539,049. These patents describe zirco-aluminate complex reaction products corresponding to the empirical formula:  $(Al_2(OR_1O)_aAbBc)_X(OC(R_2)O)_Y(ZrAdBe)_Z$  wherein X, Y, and Z are at least 1, R<sub>2</sub> is an alkyl, alkenyl, aminoalkyl, carboxyalkyl, mercaptoalkyl, or epoxyalkyl group, having from 2 to 17 carbon atoms, and the ratio of X:Z is from about 2:1 to about 5:1. Additional zirco-aluminate complexes are described in U.S. Patent No. 4,650,526.

**[0134]** With some embodiments, there is provided a photochromic article that includes: a substrate; at least a partial coating of one alignment material; at least one additional at least partial coating of a liquid crystal material; and at least one photochromic compound according to the present invention.

**[0135]** Alignment materials can be used as a coating, layer, or film that has been oriented, for example by rubbing, grooving, or photo-alignment methods, and subsequently aligned such that the long axis of each of the liquid crystal molecules takes on an orientation that is generally parallel to the general direction of orientation of the surface. Examples of photo-orientable alignment materials include polymer-bonded photoactive cinnamic acid derivatives, coumarin derivatives, cis/trans isomerizable azo derivatives, and photochemically decomposable polyimide derivatives.

**[0136]** With some embodiments, the alignment material of the photochromic article includes a polymer network that can be obtained by exposure to at least one of, a magnetic field, an electric field, linearly polarized infrared radiation, linearly polarized ultraviolet radiation, linearly polarized visible radiation and a shear force. The liquid crystal material of the photochromic article can, with some embodiments, be a liquid crystal polymer.

**[0137]** Non-limiting examples of organic host materials that can be used in conjunction with various non-limiting embodiments of the present invention include liquid crystal materials and polymeric materials. Liquid crystal materials can be chosen from liquid crystal polymers, liquid

crystal pre-polymers and liquid crystal monomers. As used herein the term "pre-polymer" means partially polymerized materials. Liquid crystal polymers ("LCPs") are polymers capable of forming regions of highly ordered structure while in a liquid phase. As used herein, the term "liquid crystal monomer" means a monomeric compound that can display liquid crystal properties in the monomeric state and/or in the polymeric state. That is, the liquid crystal monomer can display liquid crystal properties by itself and/or after it has been incorporated into a polymer or copolymer to form a liquid crystal polymer (LCP). The LCPs can display at least one of a nematic phase, a smectic phase, a chiral nematic phase (i.e., a cholesteric phase), a discotic phase (including chiral discotic), a discontinuous cubic phase, a hexagonal phase, a bicontinuous cubic phase, a lamellar phase, a reverse hexagonal columnar phase, or an inverse cubic phase. In addition, in certain LCPs of the present disclosure, the LC monomers or residues thereof can transition from one phase to another, for example, in response to thermal energy or actinic radiation.

**[0138]** Examples of polymeric materials include, for example, homopolymers and copolymers, prepared from monomers and mixtures of monomers, such as those disclosed in U.S. Patent 5,962,617 and in U.S. Patent 5,658,501 from column 15, line 28 to column 16, line 17, wherein the disclosures of such polymeric materials in these U.S. patents are specifically incorporated herein by reference, an oligomeric material, a monomeric material or a mixture or combination thereof. Polymeric materials can be thermoplastic or thermoset polymeric materials, can be transparent or optically clear, and can have any refractive index required. Non-limiting examples of such disclosed monomers and polymers include: polyol(allyl carbonate) monomers, e.g., allyl diglycol carbonates such as diethylene glycol bis(allyl carbonate), which monomer is sold under the trademark CR-39 by PPG Industries, Inc.; polyurea-polyurethane (polyurea-urethane) polymers, which are prepared, for example, by the reaction of a polyurethane prepolymer and a diamine curing agent, a composition for one such polymer being sold under the trademark TRIVEX by PPG Industries, Inc.; polyol(meth)acryloyl terminated carbonate monomer; diethylene glycol dimethacrylate monomers; ethoxylated phenol methacrylate monomers; diisopropenyl benzene monomers; ethoxylated trimethylol propane triacrylate monomers; ethylene glycol bismethacrylate monomers; poly(ethylene glycol) bismethacrylate monomers; urethane acrylate monomers; poly(ethoxylated bisphenol A dimethacrylate); poly(vinyl acetate); poly(vinyl alcohol); poly(vinyl chloride); poly(vinylidene chloride); polyethylene; polypropylene; polyurethanes; polythiourethanes; thermoplastic polycarbonates, such as the carbonate-linked resin derived from bisphenol A and phosgene, one such material being sold under the trademark LEXAN; polyesters, such as the material sold under the

trademark MYLAR; poly(ethylene terephthalate); polyvinyl butyral; poly(methyl methacrylate), such as the material sold under the trademark PLEXIGLAS, and polymers prepared by reacting polyfunctional isocyanates with polythiols or polyepisulfide monomers, either homopolymerized or co-and/or terpolymerized with polythiols, polyisocyanates, polyisothiocyanates and optionally ethylenically unsaturated monomers or halogenated aromatic-containing vinyl monomers. Also contemplated are copolymers of such monomers and blends of the described polymers and copolymers with other polymers, for example, to form block copolymers or interpenetrating network products. Polymeric materials can also be self-assembled materials.

**[0139]** With some embodiments of the present invention, the polymer can be a block or non-block copolymer. With some further embodiments, the block copolymer can include hard blocks and soft blocks. In other embodiments, the polymer can be a non-block copolymer (i.e., a copolymer that does not have large blocks of specific monomer residues), such as a random copolymer, an alternating copolymer, periodic copolymers, statistical copolymers, and gradient copolymers. The present invention also encompasses copolymers of more than two different types of co-monomer residues.

**[0140]** In accordance with additional embodiments of the present invention, the organic host material is chosen from polyacrylates, polymethacrylates, poly(C<sub>1</sub>-C<sub>12</sub>) alkyl methacrylates, polyoxy(alkylene methacrylates), poly(alkoxylated phenol methacrylates), cellulose acetate, cellulose triacetate, cellulose acetate propionate, cellulose acetate butyrate, poly(vinyl acetate), poly(vinyl alcohol), poly(vinyl chloride), poly(vinylidene chloride), poly(vinylpyrrolidone), poly((meth)acrylamide), poly(dimethyl acrylamide), poly(hydroxyethyl methacrylate), poly((meth)acrylic acid), thermoplastic polycarbonates, polyesters, polyurethanes, polythiourethanes, poly(ethylene terephthalate), polystyrene, poly(alpha methylstyrene), copoly(styrene-methylmethacrylate), copoly(styrene-acrylonitrile), polyvinylbutyral and polymers of members of the group consisting of polyol(allyl carbonate)monomers, mono-functional acrylate monomers, mono-functional methacrylate monomers, polyfunctional acrylate monomers, polyfunctional methacrylate monomers, diethylene glycol dimethacrylate monomers, diisopropenyl benzene monomers, alkoxylated polyhydric alcohol monomers and diallylidene pentaerythritol monomers.

**[0141]** In accordance further embodiments of the present invention, the organic host material is a homopolymer or copolymer of monomer(s) chosen from acrylates, methacrylates, methyl methacrylate, ethylene glycol bis methacrylate, ethoxylated bisphenol A dimethacrylate, vinyl acetate, vinylbutyral, urethane, thiourethane, diethylene glycol bis(allyl carbonate), diethylene

glycol dimethacrylate, diisopropenyl benzene, and ethoxylated trimethylol propane triacrylate. The polymeric material most can include liquid crystal materials, self-assembling materials, polycarbonate, polyamide, polyimide, poly(meth)acrylate, polycyclic alkene, polyurethane, poly(urea)urethane, polythiourethane, polythio(urea)urethane, polyol(allyl carbonate), cellulose acetate, cellulose diacetate, cellulose triacetate, cellulose acetate propionate, cellulose acetate butyrate, polyalkene, polyalkylene-vinyl acetate, poly(vinylacetate), poly(vinyl alcohol), poly(vinyl chloride), poly(vinylformal), poly(vinylacetal), poly(vinylidene chloride), poly(ethylene terephthalate), polyester, polysulfone, polyolefin, copolymers thereof, and/or mixtures thereof.

**[0142]** Further, according to various non-limiting embodiments according to the present invention, the organic host material can form an optical element or portion thereof. Non-limiting examples of optical elements include ophthalmic elements, display elements, windows, and mirrors. As used herein the term "optical" means pertaining to or associated with light and/or vision. For example, although not limiting herein, according to various non-limiting embodiments, the optical element or device can be chosen from ophthalmic elements and devices, display elements and devices, windows, mirrors, packaging material such as shrinkwrap, and active and passive liquid crystal cell elements and devices.

**[0143]** As used herein the term "ophthalmic" means pertaining to or associated with the eye and vision. Non-limiting examples of ophthalmic elements include corrective and non-corrective lenses, including single vision or multi-vision lenses, which can be either segmented or non-segmented multi-vision lenses (such as, but not limited to, bifocal lenses, trifocal lenses and progressive lenses), as well as other elements used to correct, protect, or enhance (cosmetically or otherwise) vision, including without limitation, contact lenses, intra-ocular lenses, magnifying lenses, and protective lenses or visors. As used herein the term "display" means the visible or machine-readable representation of information in words, numbers, symbols, designs or drawings. Non-limiting examples of display elements and devices include screens, monitors, and security elements, including without limitation, security marks and authentication marks. As used herein the term "window" means an aperture adapted to permit the transmission of radiation therethrough. Non-limiting examples of windows include automotive and aircraft transparencies, filters, shutters, and optical switches. As used herein the term "mirror" means a surface that specularly reflects a large fraction of incident light.

**[0144]** For example, the organic host material can be an ophthalmic element, and more particularly, an ophthalmic lens.

**[0145]** Further, it is contemplated that the photochromic compounds of the present invention can be used alone or in conjunction with at least one other complementary organic photochromic compound having at least one activated absorption maxima within the range of 300 nm to 1000 nm, inclusive (or substances containing the same). For example, the photochromic compounds of the present invention can be combined with at least one other conventional organic photochromic compound such that the combination of photochromic compound, when activated, exhibits a desired hue. Non-limiting examples of suitable conventional organic photochromic compounds include the pyrans, oxazines, fulgides and fulgimides described hereinafter.

**[0146]** Non-limiting examples of thermally reversible complementary photochromic pyrans include benzopyrans, naphthopyrans, e.g., naphtho[1,2-b]pyrans, naphtho[2,1-b]pyrans, indeno-fused naphthopyrans, such as those disclosed in U.S. Patent 5,645,767, and heterocyclic-fused naphthopyrans, such as those disclosed in U.S. Patent Nos. 5,723,072, 5,698,141, 6,153,126, and 6,022,497, which are hereby incorporated by reference for the disclosure of such naphthopyrans ; spiro-9-fluoreno[1,2-b]pyrans; phenanthropyrans; quinopyrans; fluoroanthenopyrans; spiropyrans, e.g., spiro(benzindoline)naphthopyrans, spiro(indoline)benzopyrans, spiro(indoline)naphthopyrans, spiro(indoline)quinopyrans and spiro(indoline)pyrans. More specific examples of naphthopyrans and the complementary organic photochromic substances are described in U.S. Patent 5,658,501, the disclosures of which are hereby specifically incorporated by reference. Spiro(indoline)pyrans are also described in the text, Techniques in Chemistry, Volume III, "Photochromism", Chapter 3, Glenn H. Brown, Editor, John Wiley and Sons, Inc., New York, 1971, the disclosure of which is hereby incorporated by reference.

**[0147]** Non-limiting examples of thermally reversible complementary photochromic oxazines include benzoxazines, naphthoxazines, and spiro-oxazines, e.g., spiro(indoline)naphthoxazines, spiro(indoline)pyridobenzoxazines, spiro(benzindoline)pyridobenzoxazines, spiro(benzindoline)naphthoxazines, spiro(indoline)benzoxazines, spiro(indoline)fluoranthoxazine, and spiro(indoline)quinoxazine.

**[0148]** Additional non-limiting examples of thermally reversible complementary photochromic fulgides include: fulgimides, and the 3-furyl and 3-thienyl fulgides and fulgimides, which are disclosed in U.S. Patent 4,931,220 (wherein the disclosures of such fulgimides are hereby specifically incorporated by reference) and mixtures of any of the aforementioned photochromic materials/compounds.

**[0149]** For example, it is contemplated that the photochromic compounds disclosed herein can be used alone or in conjunction with another conventional organic photochromic compound (as discussed above), in amounts or ratios such that the organic host material into which the photochromic compounds are incorporated, or onto which the organic host materials are applied, can exhibit a desired color or colors, either in an activated or a "bleached" state. Thus the amount of the photochromic compounds used is not critical provided that a sufficient amount is present to produce a desired photochromic effect. As used herein, the term "photochromic amount" refers to the amount of the photochromic compound necessary to produce the desired photochromic effect.

**[0150]** The present invention also provides a photochromic article including a substrate, and an at least partial coating of a coating composition having a photochromic amount of a photochromic compound of the present disclosure connected to at least a portion of at least one surface thereof of the substrate. Further, although not limiting herein, at least a portion of the at least partial coating can be at least partially set. As used herein the term "set" means to fix in a desired orientation, and includes curing of the coating.

**[0151]** For example, according to the above-mentioned non-limiting embodiment, the coating composition can be chosen from, without limitation, polymeric coating compositions, paints, and inks. Further, in addition to the photochromic compounds disclosed herein, the coating compositions according to various non-limiting embodiments can further include at least one other conventional organic photochromic compounds having at least one activated absorption maxima within the range of 300 nm to 1000 nm, inclusive. The primer coating can, with some embodiments, include a polyurethane.

**[0152]** Non-limiting examples of suitable substrates to which the coating composition that includes a photochromic amount of the photochromic compounds can be applied include organic materials, inorganic materials, and combinations thereof. More particular examples of substrate materials include, but are not limited to, glass, masonry, textiles, ceramics, metals, wood, paper and polymeric organic materials. Non-limiting examples of suitable polymeric organic materials are set forth above.

**[0153]** Further provided in accordance with the present invention, are optical elements that include a substrate and an at least partial coating including at least one photochromic compound of the present disclosure connected to at least a portion of the substrate. Non-limiting examples of optical elements include, ophthalmic elements, display elements, windows, and mirrors. For example, the optical element can be an ophthalmic element, and the



substrate can be an ophthalmic substrate chosen from corrective and non-corrective lenses, partially formed lenses, and lens blanks.

**[0154]** Although not limiting herein, the optical elements can include any amount of the photochromic compound necessary to achieve the desired optical properties, such as but not limited to, photochromic properties and dichroic properties.

**[0155]** Other non-limiting examples of substrates that are suitable for use in conjunction with the foregoing non-limiting embodiment include untinted (non-tinted) substrates, tinted substrates, photochromic substrates, tinted-photochromic substrates, linearly polarizing substrates, circularly polarizing substrates, elliptically polarizing substrates, reflective substrates, and wave plates or retarder substrates, e.g., quarter-wave plate and half wave plate. As used herein with reference to substrates the term "untinted" means substrates that are essentially free of coloring agent additions (such as, but not limited to, conventional dyes) and have an absorption spectrum for visible radiation that does not vary significantly in response to actinic radiation. Further, with reference to substrates the term "tinted" means substrates that have a coloring agent addition (such as, but not limited to, conventional dyes) and an absorption spectrum for visible radiation that does not vary significantly in response to actinic radiation.

**[0156]** As used herein the term "linearly polarizing" with reference to substrates refers to substrates that are adapted to linearly polarize radiation (i.e., confine the vibrations of the electric vector of light waves to one direction). As used herein the term "circularly polarizing" with reference to substrates refers to substrates that are adapted to circularly polarize radiation. As used herein the term "elliptically polarizing" with reference to substrates refers to substrates that are adapted to elliptically polarize radiation. As used herein with the term "photochromic" with reference to substrates refers to substrates having an absorption spectrum for visible radiation that varies in response to at least actinic radiation and is thermally reversible. Further, as used herein with reference to substrates, the term "tinted-photochromic" means substrates containing a coloring agent addition as well as a photochromic compound, and having an absorption spectrum for visible radiation that varies in response to at least actinic radiation and is thermally reversible. Thus for example, the tinted-photochromic substrate can have a first color characteristic of the coloring agent and a second color characteristic of the combination of the coloring agent and the photochromic compound when exposed to actinic radiation.

**[0157]** The present invention also is directed to an optical element including a substrate and an at least partial coating including at least one photochromic compound of the present invention connected to at least a portion of the substrate. Further, the at least one thermally reversible

photochromic compound can be a photochromic-dichroic compound having an average absorption ratio greater than 1.5 in an activated state as determined according to CELL METHOD.

**[0158]** As discussed above, the optical elements according to the present invention can be display elements, such as, but not limited to screens, monitors, and security elements. For example, the optical element can be a display element comprising a first substrate having a first surface, a second substrate having a second surface, wherein the second surface of the second substrate is opposite and spaced apart from the first surface of the first substrate so as to define a gap; and a fluid material comprising at least one photochromic compound of the present disclosure positioned within the gap defined by the first surface of the first substrate and the second surface of the second substrate. Further, the at least one photochromic compound can be a photochromic-dichroic compound having an average absorption ratio greater than 1.5 in an activated state as determined according to CELL METHOD.

**[0159]** Further, according to this non-limiting embodiment, the first and second substrates can be independently chosen from untinted substrates, tinted substrates, photochromic substrates, tinted-photochromic substrates, linearly polarizing substrates, circularly polarizing substrates, elliptically polarizing substrates and reflective substrates and retarder substrates.

**[0160]** The present invention also provides a security element including a substrate and at least one photochromic compound of the present invention connected to at least a portion of the substrate. Non-limiting examples of security elements include security marks and authentication marks that are connected to at least a portion of a substrate, such as and without limitation: access cards and passes, e.g., tickets, badges, identification or membership cards, debit cards etc.; negotiable instruments and non-negotiable instruments e.g., drafts, checks, bonds, notes, certificates of deposit, stock certificates, etc.; government documents, e.g., currency, licenses, identification cards, benefit cards, visas, passports, official certificates, deeds etc.; consumer goods, e.g., software, compact discs ("CDs"), digital-video discs ("DVDs"), appliances, consumer electronics, sporting goods, cars, etc.; credit cards; and merchandise tags, labels and packaging.

**[0161]** Although not limiting herein, the security element can be connected to at least a portion of a substrate chosen from a transparent substrate and a reflective substrate. Alternatively, wherein a reflective substrate is required, if the substrate is not reflective or sufficiently reflective for the intended application, a reflective material can be first applied to at least a portion of the substrate before the security mark is applied thereto. For example, a reflective aluminum

coating can be applied to the at least a portion of the substrate prior to forming the security element thereon. Still further, security element can be connected to at least a portion of a substrate chosen from untinted substrates, tinted substrates, photochromic substrates, tinted-photochromic substrates, linearly polarizing, circularly polarizing substrates, and elliptically polarizing substrates.

**[0162]** Additionally, the at least one photochromic compound can be a thermally reversible photochromic-dichroic compound having an average absorption ratio greater than 1.5 in the activated state as determined according to CELL METHOD.

**[0163]** Furthermore, the aforementioned security element can further include one or more other coatings or sheets to form a multi-layer reflective security element with viewing angle dependent characteristics as described in U.S. Patent No. 6,641,874, which disclosure related to multi-reflective films is hereby specifically incorporated by reference herein.

**[0164]** The photochromic articles and optical elements described above can be formed in accordance with art-recognized methods and procedures. Although not limiting herein, it is contemplated that the photochromic compounds of the present invention can be connected to a substrate or host by incorporation into the host material or application onto the host or substrate, such as in the form of a coating.

**[0165]** For example, the photochromic-dichroic compound(s) can be incorporated into an organic host material by dissolving or dispersing the photochromic compound within the host material, e.g., casting it in place by adding the photochromic compound to the monomeric host material prior to polymerization, imbibition of the photochromic compound into the host material by immersion of the host material in a hot solution of the photochromic compound or by thermal transfer. As used herein the term "imbibition" includes permeation of the photochromic compound alone into the host material, solvent assisted transfer of the photochromic compound into a porous polymer, vapor phase transfer, and other such transfer methods. The photochromic material can be blended with at least a portion of the polymeric material, bonded to at least a portion of the polymeric material, and/or imbibed into at least a portion of the polymeric material, with some embodiments of the present invention.

**[0166]** Additionally, the photochromic compound of the present invention can be applied to the organic host material or other substrate as part of a coating composition (as discussed above) or a sheet comprising the photochromic compound. As used herein the term "coating" means a supported film derived from a flowable composition, which can or can not have a uniform

thickness. As used herein the term "sheet" means a pre-formed film having a generally uniform thickness and capable of self-support. In such cases ultraviolet light absorbers can be admixed with the photochromic materials before their addition to the coating or sheet or such absorbers can be superposed, e.g., superimposed, as a coating or film between the photochromic article and the incident light.

**[0167]** Non-limiting methods of applying coating compositions including the photochromic compounds of the present invention include those methods known in the art for applying coatings, such as, spin coating, spray coating, spray and spin coating, curtain coating, flow coating, dip coating, injection molding, casting, roll coating, wire coating, and overmolding. The coating including the photochromic compound can be applied to a mold and the substrate can be formed on top of the coating (i.e., overmolding). Additionally or alternatively, a coating composition without the photochromic compound can be first applied to the substrate or organic host material using any of the aforementioned techniques and thereafter imbibed with the photochromic compound as described above.

**[0168]** Non-limiting examples of coating compositions of film forming polymers that can include the photochromic materials of the present invention are as follows: photochromic/dichroic liquid crystal coatings, such as those described in U.S. Patent No. 7,256,921 at column 2, line 60 to column 94, line 23; photochromic polyurethane coatings, such as those described in U.S. Patent No. 6,187,444 at column 3, line 4 to column 12, line 15; photochromic aminoplast resin coatings, such as those described in U.S. Patent Nos. 6,432,544 at column 2, line 52 to column 14, line 5 and 6,506,488 at column 2, line 43 to column 12, line 23; photochromic polysiloxane coatings, such as those described in U.S. Patent No. 4,556,605 at column 2, line 15 to column 7, line 27; photochromic poly(meth)acrylate coatings, such as those described in U.S. Patent Nos. 6,602,603 at column 3, line 15 to column 7, line 50, 6,150,430 at column 8, lines 15-38, and 6,025,026 at column 8, line 66 to column 10, line 32; polyanhydride photochromic coatings, such as those described in U.S. Patent No. 6,436,525 at column 2, line 52 to column 11, line 60; photochromic polyacrylamide coatings such as those described in U.S. Patent No. 6,060,001 at column 2, line 6 to column 5, line 40; photochromic epoxy resin coatings, such as those described in U.S. Patent Nos. 6,268,055 at column 2, line 63 to column 15, line 12; and photochromic poly(urea-urethane) coatings, such as those described in U.S. Patent No. 6,531,076 at column 2, line 60 to column 10, line 49. The disclosures in the aforementioned U.S. Patents that relate to the film-forming polymers are hereby incorporated herein by reference.

**[0169]** Non-limiting methods of applying sheets including the photochromic compounds of the present invention to a substrate include, for example, at least one of: laminating, fusing, in-mold casting, and adhesively bonding the polymeric sheet to the at least a portion of the substrate. As used herein, the in-mold casting includes a variety of casting techniques, such as but not limited to: overmolding, wherein the sheet is placed in a mold and the substrate is formed (for example by casting) over at least a portion of the substrate; and injection molding, wherein the substrate is formed around the sheet. Further, it is contemplated that the photochromic compound can be applied to the sheet as a coating, incorporated into the sheet by imbibition or by other suitable methods, either prior to applying the sheet to the substrate or thereafter.

**[0170]** The polymeric sheet can include a polymeric composition of any of a wide variety of polymers, including both thermosetting polymers and thermoplastic polymers. As used herein, the term "polymer" is intended to include both polymers and oligomers, as well as both homopolymers and copolymers. Such polymers can include, for example, acrylic polymers, polyester polymers, polyurethane polymers, poly(urea)urethane polymers, polyamine polymers, polyepoxide polymers, polyamide polymers, polyether polymers, polysiloxane polymers, polysulfide polymers, copolymers thereof, and mixtures thereof. Generally these polymers can be any polymers of these types made by any method known to those skilled in the art.

**[0171]** The polymers used to form the polymeric sheet also can include functional groups including, but not limited to, carboxylic acid groups, amine groups, epoxide groups, hydroxyl groups, thiol groups, carbamate groups, amide groups, urea groups, isocyanate groups (including blocked isocyanate groups) mercaptan groups, groups having ethylenic unsaturation e.g., acrylate groups), vinyl groups, and combinations thereof. Appropriate mixtures of film-forming resins can also be used in the preparation of the coating compositions. If the polymer composition from which the polymeric sheet is formed includes functional group-containing polymers (such as any of the previously mentioned functional group-containing polymers), the polymer composition can further include a material having functional groups reactive with those of said polymer. Reaction can be facilitated, for example, by thermal, photoinitiated, oxidative, and/or radiative curing techniques. Also contemplated are mixtures of any of the foregoing polymers.

**[0172]** Further non-limiting examples of polymers suitable for use in forming the polymeric sheet of the present invention include the thermoplastic block copolymers of polyalkyl(meth)acrylate and polyamide described in Published U.S. Patent Application 2004/0068071 A1 at paragraphs [0020] – [0042], the specified portions of which is incorporated

by reference herein; and U.S. Patent No. 6,096,375 at column 18, line 8 to column 19, line 5, the specified portions of which are incorporated by reference herein.

**[0173]** In a particular embodiment of the present invention, the polymeric sheet includes an elastomeric polymer, for example thermoplastic elastomeric polymers. As used herein, by "elastomeric polymer" is meant a polymer that has a high degree of resiliency and elasticity such that it is capable of at least partially reversible deformation or elongation. In some instances, when stretched, the molecules of an elastomer are aligned and can take on aspects of a crystalline arrangement; and upon release, the elastomer can, to some extent, return to its natural disordered state. For purposes of the present invention, elastomeric polymers can include thermoplastic, thermoplastic elastomeric polymers, and thermosetting polymers provided such polymers fall within the description provided above for "elastomeric polymer."

**[0174]** The elastomeric polymer can include any of wide variety of art recognized elastomers including but not limited to copolymers of any of the previously mentioned polymers. In an embodiment of the present invention, the elastomeric polymer can include a block copolymer having ether and/or ester linkages in the polymer backbone. Examples of suitable block copolymers can include, but are not limited to, poly(amide-ether) block copolymers, poly(ester-ether) block copolymers, poly(ether-urethane) block copolymers, poly(ester-urethane) block copolymers, and/or poly(ether-urea) block copolymers. Suitable specific examples of such elastomeric polymers can include, but are not limited to, those commercially available under the tradenames DESMOPAN<sup>®</sup> and TEXIN<sup>®</sup> from Bayer Material Science; ARNITEL<sup>®</sup> from Royal DSM; and PEBAX<sup>®</sup> from Atofina Chemicals or Cordis Corporation.

**[0175]** Moreover, as discussed above, the photochromic compounds of the present invention can be incorporated (e.g., blended) or applied alone, or in combination with at least one other conventional organic photochromic compound, which can also be applied or incorporated into the host materials and substrates as described above. Additional coatings can be applied to the photochromic article including other photochromic coatings, anti-reflective coatings, linearly polarizing coatings, transitional coatings, primer coatings, adhesive coatings, mirrored coatings and protective coatings including antifogging coatings, oxygen barrier coatings and ultraviolet light absorbing coatings. With some embodiments, the transitional coating can include an acrylate and/or methacrylate polymer. With further embodiments, the protective coating can include at least one organosilane.

**[0176]** The present invention is more particularly described in the following examples, which are intended to be illustrative only, since numerous modifications and variations therein will be

apparent to those skilled in the art. Unless otherwise specified, all parts and all percentages are by weight.

### EXAMPLES

[0177] Part 1 describes the preparation of Examples 1-56. Part 2 describes the testing of the photochromic properties of the Examples. Part 3 describes the testing of the dichroic properties of the Examples. The term "reaction flask" is defined herein to include any suitable reaction flask such as a 3- or 4-neck flask of an appropriate size that was pre-treated such as by oven drying and was equipped with the necessary capabilities such as a reflux condenser, mechanical or magnetic stirrer, thermometer, solid addition funnel, dropping funnel or other equipment to conduct the described procedure as known to one skilled in the art.

[0178] In the examples below, the following abbreviations have the following meanings. If an abbreviation is not defined, it has its generally accepted meaning.

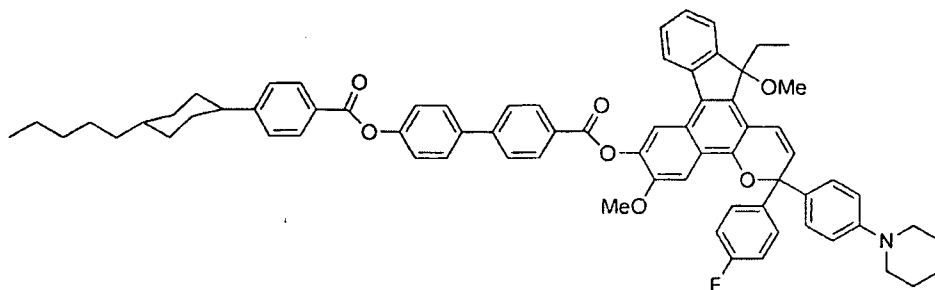
BINAP	=	2,2'-bis(diphenylphosphino)-1,1'-binaphthyl
Bi(OTf) <sub>3</sub>	=	bismuth triflate
CuI	=	copper iodide
DHP	=	3,4-dihydro-2H-pyran
DCC	=	dicyclohexylcarbodiimide
DCM	=	dichloromethane
DBSA	=	dodecylbenzenesulfonic acid
DIBAL	=	diisobutylaluminium hydride
DMAP	=	4-dimethylaminopyridine
DME	=	dimethyl ether
DMF	=	N,N-dimethylformamide
DMSO	=	dimethylsulfoxide
Dppf	=	1,1'-bis(diphenylphosphino)ferrocene
EtMgBr	=	ethyl magnesium bromide
Et <sub>2</sub> O	=	diethylether
g	=	gram
h	=	hour
HPLC	=	high-performance liquid chromatography
(iPr) <sub>2</sub> NH	=	diisopropyl amine
HOAc	=	acetic acid
LDA	=	lithium diisopropylamide

KMnO <sub>4</sub>	=	potassium permanganate
M	=	molar (molarity)
mCPBA	=	meta-Chloroperoxybenzoic acid
MeLi	=	methyl lithium
mg	=	milligram
min	=	minutes
mL	=	milliliter
mmol	=	millimoles
mM	=	millimolar
NatOBu	=	sodium <i>tert</i> -butoxide
N	=	normal (normality)
ng	=	nanogram
nm	=	nanometer
nM	=	nanomolar
NMP	=	<i>N</i> -methyl pyrrolidone
NMR	=	nuclear magnetic resonance
Pd(OAc) <sub>2</sub>	=	palladium acetate
Pd <sub>2</sub> (dba) <sub>3</sub>	=	tris(dibenzylideneacetone)dipalladium(0)
PPh <sub>3</sub>	=	triphenyl phosphine
PPTS	=	pyridine <i>p</i> -toluenesulfonate
pTSA	=	<i>p</i> -toluenesulfonic acid
PdCl <sub>2</sub> (PPh <sub>3</sub> ) <sub>2</sub>	=	bis(triphenylphosphine)palladium(II) chloride
PBS	=	phosphate buffered saline
TBAF	=	Tetra- <i>n</i> -butylammonium fluoride
THF	=	tetrahydrofuran
TLC	=	thin layer chromatography
t-BuOH	=	t-butanol
(Tf) <sub>2</sub> O	=	trifluoromethanesulfonic acid anhydride
μL	=	microliter
μM	=	micromolar
Zn(OAc) <sub>2</sub>	=	zinc acetate
Zn(CN) <sub>2</sub>	=	Zinc cyanide

## Part 1 – Preparation of Examples 1-56



## EXAMPLE 1



## Step 1

**[0179]** 7-Ethyl-2,3-dimethoxy-7H-benzo[c]fluorene-5,7-diol (20.0 g) and methanol (0.4 L) were added to a reaction flask. Trimethylorthoformate (32.6 mL) and pyridinium *p*-toluenesulfonate (3.0 g) were added and the mixture was heated to reflux for 3 h. The reaction mixture was cooled to room temperature and a precipitate formed. The precipitate was collected by vacuum filtration, washed with a minimum amount of cold methanol and dried under vacuum to provide product (20.0 g). NMR showed that the product had a structure consistent with 7-ethyl-2,3,7-trimethoxy-7H-benzo[c]fluorene-5-ol.

## Step 2

**[0180]** To a reaction flask was added methyl magnesium bromide (102.0 mL, 1.4M in 75:25 toluene:THF) under nitrogen. *cis*-2,6-Dimethylpiperidine (11.8 mL) was added drop-wise at room temperature with vigorous stirring. The reaction mixture was diluted with tetrahydrofuran (51.0 mL) to make the solvent ratio 1:1 with respect to toluene. The product (10.0 g) from Step 1 was added in several portions to the reaction mixture. The solution was heated to reflux for 5 h. The reaction mixture was cooled to room temperature and carefully poured into 10 weight percent HCl aqueous solution (200 mL) at 0 °C. The mixture was stirred for 15 minutes, diluted with ethyl acetate (100 mL) and partitioned. The organic layer was washed with saturated aqueous sodium bicarbonate (200 mL), dried with sodium sulfate and concentrated under vacuum to provide an oily residue. Dichloromethane (500 mL) was added to the residue and stirred to provide a precipitate. The precipitate was collected by vacuum filtration and dried (8.6 g). NMR showed that the product had a structure consistent with 7-ethyl-3,7-dimethoxy-7H-benzo[c]fluorene-2,5-diol. This procedure was repeated to produce enough product for the next step as well as other examples.

**Step 3**

**[0181]** To a reaction flask containing a chloroform solution (600 mL) of the product from Step 2, (77.7 g) and *p*-toluene sulfonic acid (8.8 g) was added 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol (35.7 g). The solution was heated to reflux for 4 h. An additional amount of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol (35.7 g) was added after 4 h and the mixture was heated to reflux for an additional 4 h. The reaction mixture was passed through a silica gel (Grade 60, 230-400 mesh) plug and eluted with CHCl<sub>3</sub>. Fractions containing the desired material were grouped and concentrated to provide an oily residue (101.3 g,) which was used directly in the next step. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-hydroxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

**Step 4**

**[0182]** To a reaction flask containing a stirred mixture of THF (500 mL), 4'-hydroxy-(1,1'-biphenyl)-4-carboxylic acid (50 g) and dihydropyran (21.6 g), was added *p*-toluenesulfonic acid (1 g). After stirring overnight, a precipitate formed and was collected by filtration, washed with diisopropyl ether (200 ml) and dried in vacuum. A white powder (59 g) was obtained as the product. NMR showed that the product had a structure consistent with 4'-((tetrahydro-2*H*-pyran-2-yl)oxy)-(1,1'-biphenyl)-4-carboxylic acid.

**Step 5**

**[0183]** To a reaction flask containing a dichloromethane solution (500 mL) of the product from Step 3(50.8 g), and the product from Step 4 (24.1 g) were added *N,N'*-dicyclohexylcarbodiimide (18.3 g) and DMAP (0.5 g) at room temperature. The resulting mixture was stirred for 8 h, diluted with dichloromethane (200 mL) and filtered. The filtrate was concentrated under vacuum to provide an oily residue which was used directly in the next step. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4'-((tetrahydro-2*H*-pyran-2-yl)oxy)-[1,1'-biphenyl]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

**Step 6**

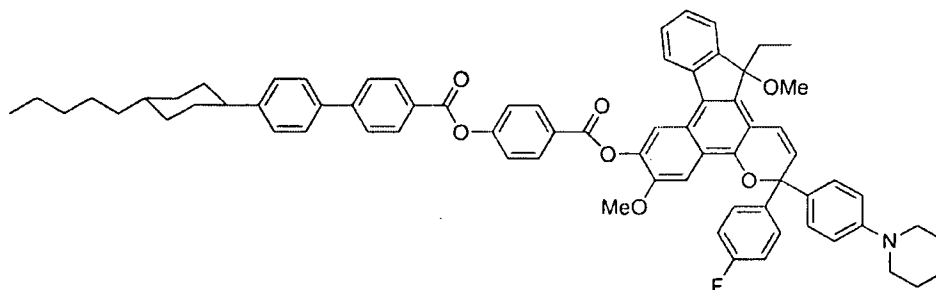
**[0184]** The product from Step 5 was added to a reaction flask and dissolved in a mixture of 1,2-dichloroethane (400 mL) and ethanol (200 mL). *p*-Toluene sulfonic acid (7.0 g) was added and the mixture was heated to reflux for 12 h. The solvent was removed under vacuum to provide an oily residue. The residue was purified by passing it through a plug of silica gel. Fractions

containing the desired material were grouped and concentrated. The material was used directly for the next step.

#### Step 7

**[0185]** To a reaction flask containing a dichloromethane solution (300 mL) of the product from Step 6 (21.7 g) and 4-(4-pentylcyclohexyl)benzoic acid (8.0 g) were added N,N'-dicyclohexylcarbodiimide (6.4 g) and DMAP (1.0 g) at room temperature. The resulting mixture was stirred for 12 h, diluted with dichloromethane (200 mL) and filtered. The filtrate was concentrated under vacuum to provide an oily residue. The residue was purified by passing it through a silica gel plug and eluting with a mixture of hexane and dichloromethane with a gradient ratio from 9/1 to 1/9. Fractions containing the desired material were grouped and concentrated to provide blue colored oil. The product was further purified by dissolution into dichloromethane followed by precipitation from methanol. A blue solid (22.7 g) was obtained. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4'-((4-(trans-4-pentylcyclohexyl)benzoyl)oxy)-[1,1'-biphenyl]-4-carboxyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### EXAMPLE 2



#### Step 1

**[0186]** A suspension of 1-bromo-4-(trans-4-pentylcyclohexyl)benzene (96 g), 4-(methoxycarbonyl)phenylboronic acid (56 g),  $K_2CO_3$  (17 g),  $Pd(PPh_3)_4$  (1.5 g), 1,4-dioxane (400 mL) and water (12 mL) was placed in a reaction flask and stirred at 105°C for 10 hours. The resulting mixture was poured into water (1 L) with stirring. The solution was filtered and a grey solid was recovered, washed with water, dissolved in  $CH_2Cl_2$  (400 mL), dried over  $MgSO_4$  and filtered through CELITE<sup>®</sup> filter aid. The filtrate was concentrated and poured into methanol (600 mL) under stirring. The precipitate was collected by filtration, washed with methanol and dried. A white solid was obtained (80.4 g) as the product. NMR showed that the product had a structure consistent with methyl 4'-(4-pentylcyclohexyl)biphenyl-4-carboxylate.

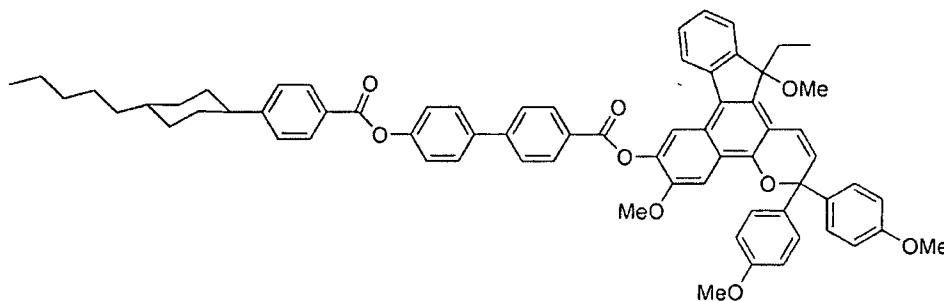
## Step 2

**[0187]** The product from Step 1 (20 g) was mixed with sodium hydroxide (6.57 g) and ethanol (500 mL) in a reaction flask. The mixture was heated to reflux for 4 hours, cooled to room temperature and acidified using conc. HCl. The precipitate that formed was collected by filtration, washed with water and dried. A white solid was obtained (18.2 g) as the product. NMR showed that the product had a structure consistent with 4'-(4-pentylcyclohexyl)biphenyl-4-carboxylic acid.

## Step 3

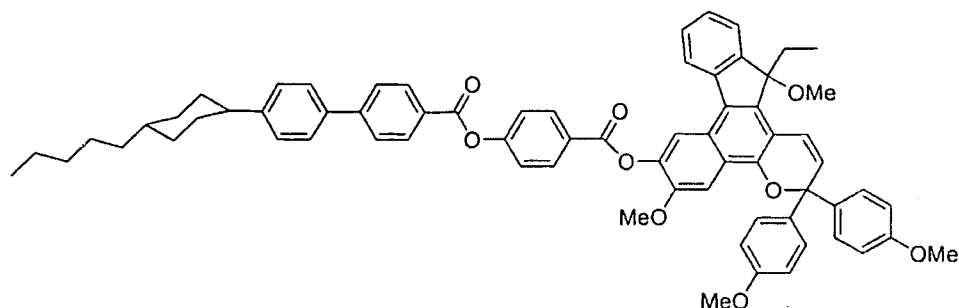
**[0188]** The procedures from Steps 1 to 7 of Example 1 were followed except that in Step 4, 4-hydroxybenzoic acid and methylene chloride were used in place of 4'-hydroxy-(1,1'-biphenyl)-4-carboxylic acid and THF and in Step 7, 4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid from Step 2 (above) was used in place of 4-(4-pentylcyclohexyl)benzoic acid. A blue solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4-(4'-(4-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyloxy)benzoyloxy))-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 3



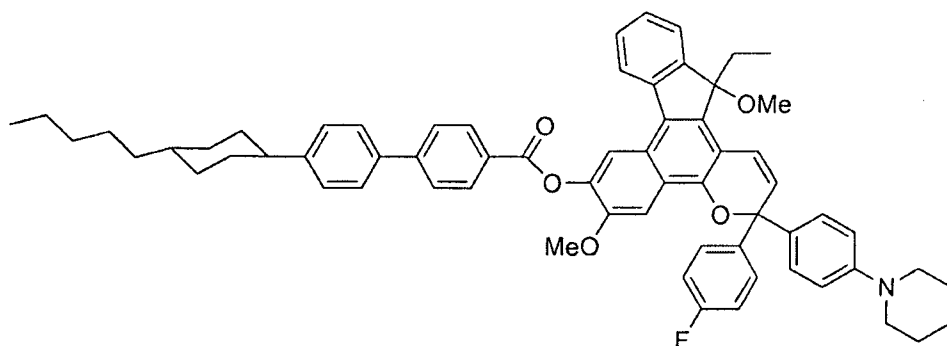
**[0189]** The procedures from Steps 1 to 7 of Example 1 were followed except that in Step 3, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-ylphenyl)-prop-2-yn-1-ol. A grey solid was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4'-((4-(trans-4-pentylcyclohexyl)benzoyl)oxy)-[1,1'-biphenyl]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 4



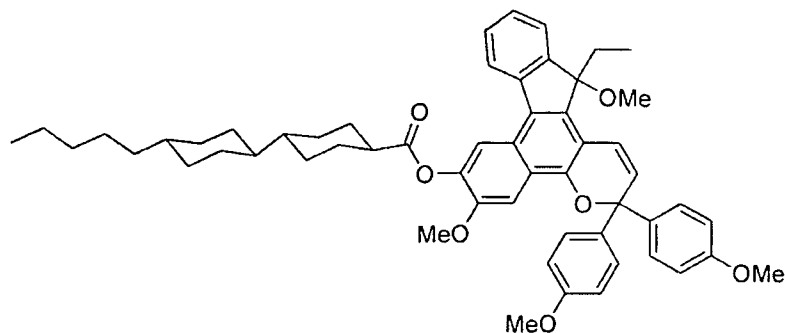
**[0190]** The procedures from Steps 1 to 3 of Example 2 were followed except that in Step 3, based on the procedures of Steps 1 to 7 of Example 1, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol that was used in Step 3 of Example 1. A grey solid was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4-(4'-(4-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyloxy)benzoyloxy))-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### EXAMPLE 5



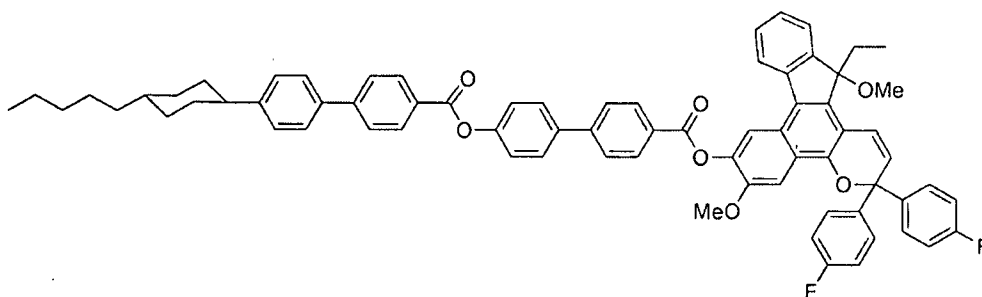
**[0191]** The procedures from Steps 1, 2, 3 and 5 of Example 1 were followed except that in Step 5, 4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid was used in place of 4'-((tetrahydro-2H-pyran-2-yl)oxy)-[1,1'-biphenyl]-4-carboxylic acid. A blue solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4-(4'-(4-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyloxy))-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### EXAMPLE 6



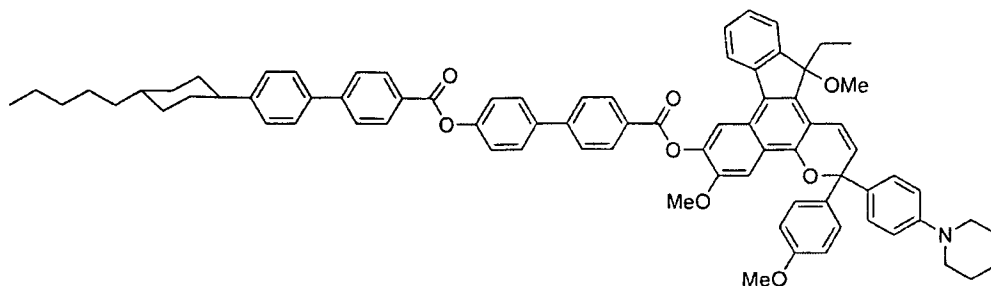
**[0192]** The procedures from Steps 1, 2, 3 and 5 of Example 1 were followed except that in Step 3, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol and in Step 5, (trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid was used in place of 4'-((tetrahydro-2H-pyran-2-yl)oxy)-[1,1'-biphenyl]-4-carboxylic acid. A grey solid was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### EXAMPLE 7



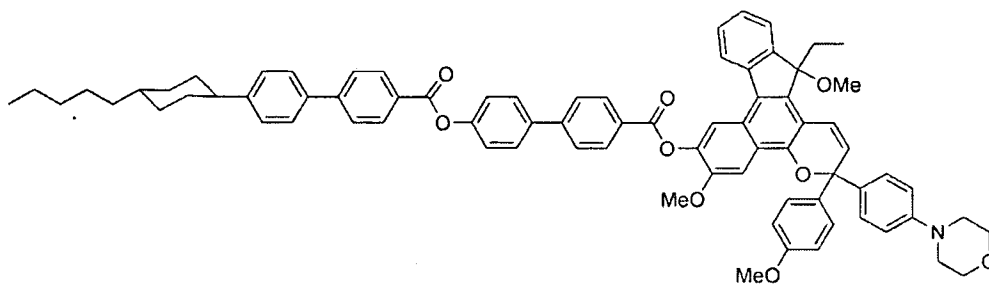
**[0193]** The procedures from Steps 1 to 7 of Example 1 were followed except that in Step 3, 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol and in Step 7, 4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid was used in place of 4-(4-pentylcyclohexyl)benzoic acid. A yellow solid was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-fluorophenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4'-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyloxy)-[1,1'-biphenyl]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 8



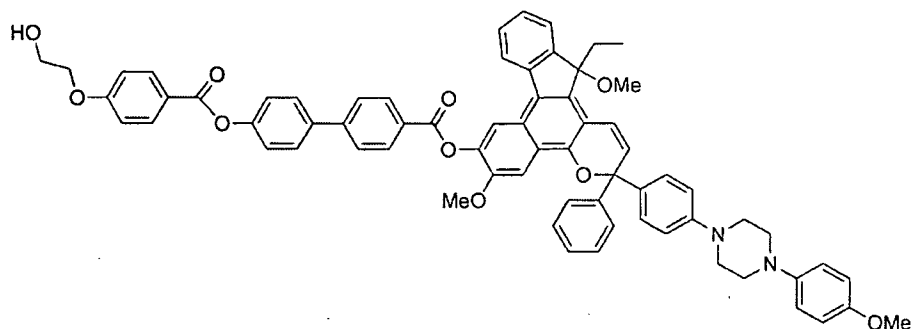
[0194] The procedures from Steps 1 to 7 of Example 1 were followed except that in Step 3, 1-(4-methoxyphenyl)-1-(4-piperidin-1-yl)phenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl)phenyl)prop-2-yn-1-ol and in Step 7, 4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid was used in place of 4-(4-pentylcyclohexyl)benzoic acid. A blue solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4'-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyloxy)-[1,1'-biphenyl]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 9



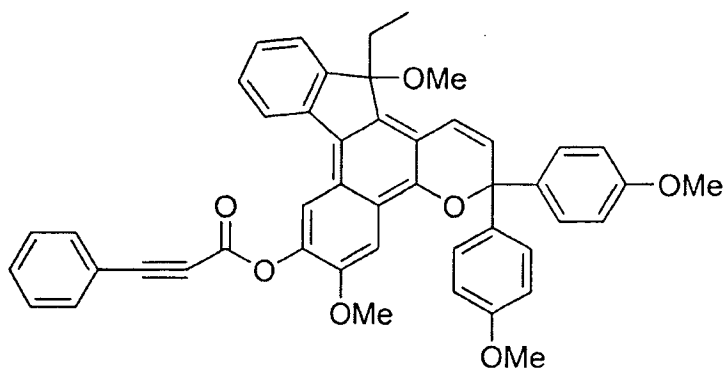
[0195] The procedures from Steps 1 to 7 of Example 1 were followed except that in Step 3, 1-(4-methoxyphenyl)-1-(4-morpholinophenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl)phenyl)prop-2-yn-1-ol and in Step 7, 4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid was used in place of 4-(4-pentylcyclohexyl)benzoic acid. A blue solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-(4-morpholinophenyl)-13-methoxy-13-ethyl-6-methoxy-7-(4'-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyloxy)-[1,1'-biphenyl]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 10



[0196] The procedures from Steps 1 to 7 of Example 1 were followed except that in Step 3, 1-(4-(4-(4-methoxyphenyl)piperazin-1-yl)phenyl)-1-phenylprop-2-yn-1-ol was used in place of 1-(4-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol and in Step 7, 4-(2-hydroxyethoxy)benzoic acid was used in place of 4-(4-pentylcyclohexyl)benzoic acid. A blue solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-(4-methoxyphenyl)piperazin-1-yl)-3-phenyl-13-methoxy-13-ethyl-6-methoxy-7-(4'-(4-(2-hydroxyethoxy)benzoyloxy)-[1,1'-biphenyl]-4-carbonyloxy)-[1,1'-biphenyl]-4-carbonyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 11

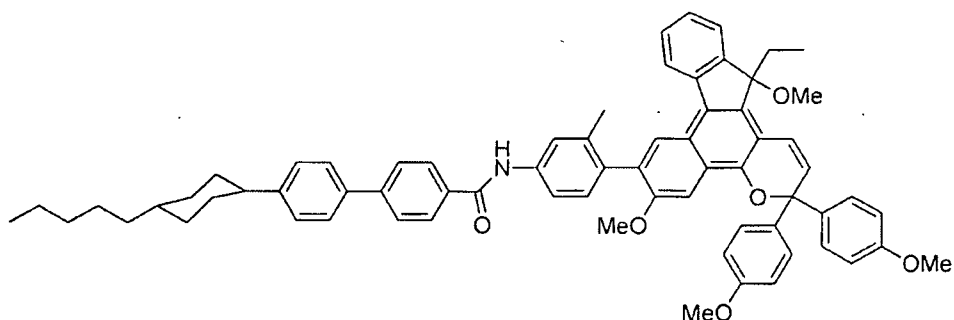


[0197] The procedures from Steps 1, 2, 3 and 5 of Example 1 were followed except that in Step 3, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of 1-(4-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol and in Step 5, 3-phenylpropionic acid was used in place of



4'-((tetrahydro-2*H*-pyran-2-yl)oxy)-[1,1'-biphenyl]-4-carboxylic acid. A grey solid was obtained as the product. The NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-(3-phenylpropionyloxy)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 12



## Step 1

**[0198]** The procedures from Steps 1 to 3 of Example 1 were followed except that in Step 3, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol. The NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-hydroxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran

## Step 2

**[0199]** To a reaction flask containing a dichloromethane solution (40 mL) of the product of Step 1 (6.1 g) was added triethylamine (3 mL). The resulting mixture was stirred for 5 min. Trifluoromethanesulfonic anhydride (2.1 mL) was added drop-wise to the solution and the mixture was stirred for 1 h at room temperature. Saturated aqueous sodium bicarbonate (200 ml) was added to the reaction mixture and stirred for 10 min. Dichloromethane (100 mL) was added, the solution was partitioned and the dichloromethane layer was collected. The organic extract was dried with sodium sulfate and concentrated under vacuum to provide an oily residue. The residue was purified by passing it through a plug of silica gel and eluting with a hexane: ethyl acetate mixture (9:1 based on volume). Fractions containing the desired material were grouped and concentrated to provide the product as colorless oil (7.1 g). NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-trifluoromethanesulfonyloxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 3

**[0200]** To a reaction flask containing Et<sub>3</sub>N (1.5 L) were added 4-bromo-3-methylaniline (144 g), 4,4,4',4',5,5,5',5'-octamethyl-2,2'-bi(1,3,2-dioxaborolane) (206 g) and CH<sub>3</sub>COOK (302.3 g). Nitrogen was passed through the reaction mixture for ~20 min and PdCl<sub>2</sub>(PPh<sub>3</sub>)<sub>2</sub> (27 g) was added. The resulting reaction mixture was heated to reflux with stirring. After ~4h reflux, water (1 L) was added. The organic layer was extracted using EtOAc (1 L). The recovered organic phase was evaporated to dryness. The remaining reaction mixture was added to a reaction flask containing 0.5 L of a mixture of hexanes:CH<sub>2</sub>Cl<sub>2</sub> (1:1 based on volume) and passed through the silica gel bed followed by a mixture of EtOAc:hexanes (1:3 based on volume) used as an eluting solvent. All organic fractions were collected together and the solvents were evaporated. The recovered product was isolated as very thick light yellow liquid (152 g). NMR showed that the product had a structure consistent with 3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline.

#### Step 4

**[0201]** Thionyl chloride [107 g (66 mL)] was added to a reaction flask containing the solid product from Step 2 of Example 2 (4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid (60 g). Toluene (0.75 L) was added and few drops of DMF was also added. The resulting mixture was heated at ~80 C for 3 and ½ h and cooled to room temperature. The solvent was evaporated using a rotovap fitted with a solid NaOH trap. The recovered solid was washed with cold hexanes, isolated and dried under vacuum to yield the product (55 g). NMR showed that the product had a structure consistent with 4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carbonyl chloride.

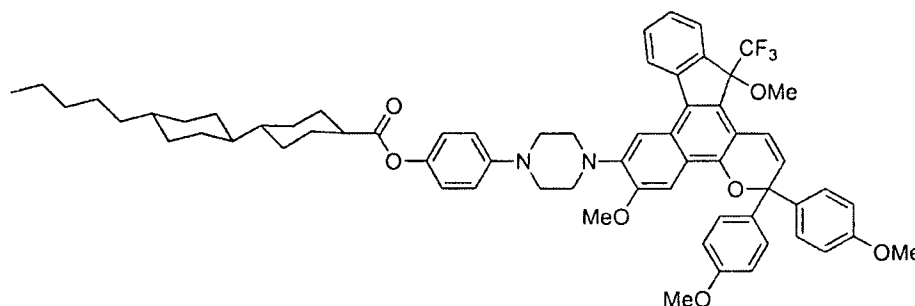
#### Step 5

**[0202]** To a reaction flask containing 0.25 L of CH<sub>2</sub>Cl<sub>2</sub> was added 3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline (25 g). The reaction mix was stirred under a N<sub>2</sub> atmosphere and Et<sub>3</sub>N [30.36 g (42 mL)] was added. The product of Step 4 (40 g) was added to a reaction flask containing CH<sub>2</sub>Cl<sub>2</sub> (0.5 L) and the resulting solution was added dropwise to the reaction mixture with stirring. After ~1 h stirring the solvent was evaporated and the recovered solid was washed with water and then acetone. The product was isolated and dried under vacuum (57 g). NMR showed that the product had a structure consistent with N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide.

#### Step 6

**[0203]** To a reaction flask containing tetrahydrofuran (100 mL) were added the product from Step 2 (7.1 g) and the product from Step 5 (8.3 g). An aqueous solution of potassium fluoride (6.0 g) in water (100 mL) was added to the reaction flask and the reaction mixture was degassed by bubbling with nitrogen for 15 min. Dichlorobis(triphenylphosphine)palladium(II) (0.7 g) was added and the resulting mixture was heated to reflux for 18 h, cooled to room temperature, diluted with ethyl acetate (100 mL) and filtered through a bed of CELITE® filter aid. The filtrate was partitioned and the organic layer was collected, dried with sodium sulfate and concentrated under vacuum to provide an oily residue. The residue was purified by passing it through a silica gel plug and eluting with hexane and ethyl acetate mixtures. Fractions containing the desired material were grouped and concentrated to provide a purple colored oil. The product was dissolved in dichloromethane followed by precipitation from methanol. A grey solid (6.2 g) was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 13



## Step 1

**[0204]** To a reaction flask were added 2,3-dimethoxy-7-oxo-7H-benzo[c]fluoren-5-yl acetate (20.7 g), trimethyl(trifluoromethyl)silane (42.2 mL), potassium fluoride (0.8 g) and anhydrous tetrahydrofuran (100 mL). Saturated potassium *tert*-butoxide in tetrahydrofuran was added (10 grams) in portions until the solution started to boil. The reaction mixture was stirred for 1 h, poured into a 10 weight percent solution of aqueous hydrochloric acid (500 mL) and stirred for 20 min. The aqueous solution was extracted with ethyl acetate (200 mL) three times. The extracts were combined, dried with sodium sulfate, filtered and concentrated to provide an oily residue. Dichloromethane (750 mL) was added to the residue to produce a precipitate. The precipitate was collected by vacuum filtration and dried. A yellow solid (13.0 g) was obtained as

the product. NMR showed that the product had a structure consistent with 2,3-dimethoxy-7-(trifluoromethyl)-7H-benzo[c]fluoren-5,7-diol.

#### Step 2

**[0205]** To a reaction flask containing a chloroform solution (300 mL) of the product from Step 1, (10.1 g) were added 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol (11.0 g), triisopropylorthoformate (12.0 mL) and pyridinium p-toluenesulfonate (0.7 g). The solution was heated to reflux for 4 h. The reaction mixture was concentrated under reduced pressure to provide an oily residue. The residue was dissolved in a minimum amount of dichloromethane and precipitated from hexanes. The precipitate was collected by vacuum filtration and dried. A red solid (13.4 g) was obtained as the product. NMR analysis of the red solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-6,7-dimethoxy-13-hydroxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### Step 3

**[0206]** To a reaction flask containing a tetrahydrofuran solution of the product from Step 2, (3.9 g) were added iodomethane (2.0 mL) and potassium tert-butoxide (2.1 g). The reaction mixture was heated to reflux for 2 h. The reaction mixture was poured into an aqueous solution of 10 weight percent hydrochloric acid (200 ml) and stirred for 10 min. The aqueous solution was partitioned three times with ethyl acetate using (100 ml) each time. The combined ethyl acetate extracts were dried with sodium sulfate and concentrated under vacuum to provide an oily residue. The residue was passed through a plug of silica gel and eluted with 4:1(v:v) hexane ethyl acetate mixture. Fractions containing the desired material were grouped and concentrated to provide a solid. A white colored solid (3.5 g) was obtained as the product. NMR analysis of the white solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-6,7,13-trimethoxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### Step 4

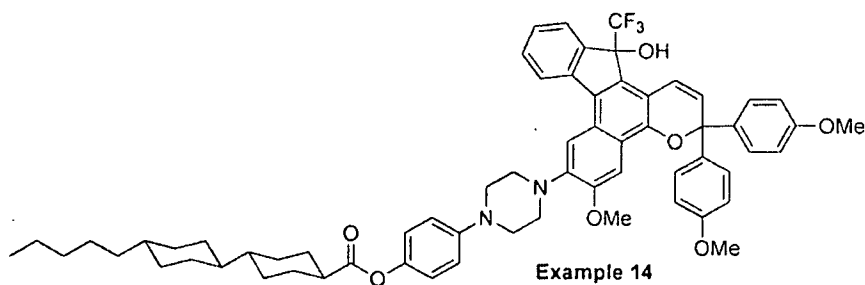
**[0207]** To a reaction flask containing a tetrahydrofuran solution of the product from Step 3, (0.7 g) was added 4-(piperazin-1-yl)phenol (0.6 g). The reaction mixture was cooled to 0 °C and a 2 molar solution of butyl lithium in hexanes (2.0 mL) was added drop-wise. The solution was stirred at 0°C for 10 min and warmed to room temperature. The reaction mixture was then poured into an aqueous solution of 10 weight percent hydrochloric acid and stirred for 10 min. The aqueous solution was partitioned three times with ethyl acetate using (100 mL) each time. The ethyl acetate extracts were combined, dried with sodium sulfate and concentrated under vacuum to provide an oily residue. The residue was passed through a plug of silica gel and

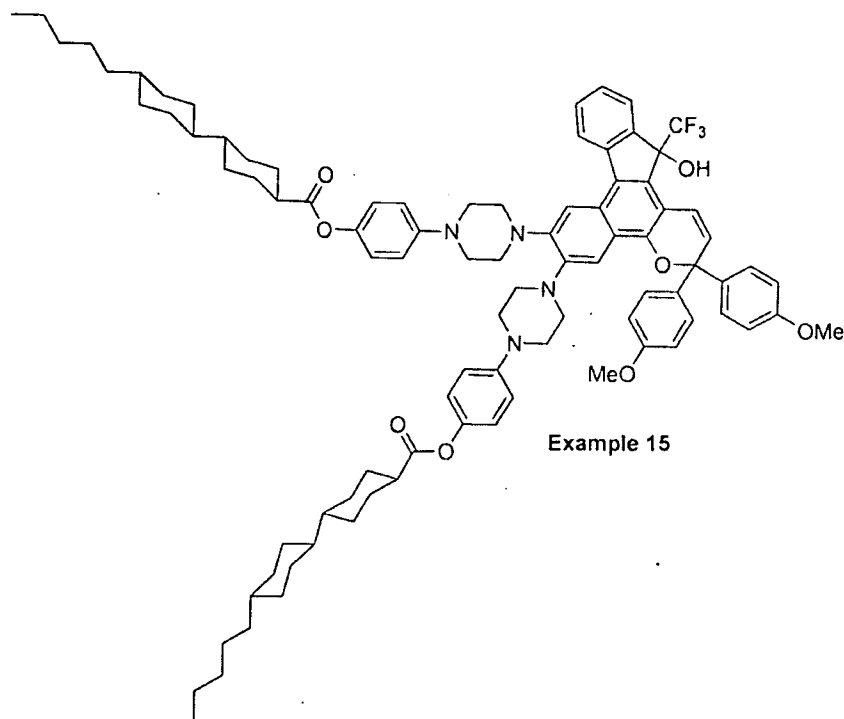
eluted with a mixture of 4:1(v:v)hexane ethyl acetate. Fractions containing the desired material were grouped and concentrated to provide an oil. A yellow colored oil (1.0 g) was obtained as the product. NMR analysis of the yellow oil indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-6,13-dimethoxy-7-(4-(4-hydroxyphenyl)piperazin-1yl)-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### Step 5

**[0208]** To a reaction flask containing a dichloromethane solution (20 mL) of the product from Step 4 (1.4 g) and (trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid (0.8 g) were added N,N'-dicyclohexylcarbodiimide (0.6 g) and DMAP (22.0 mg) at room temperature and stirred for 18 h. The resulting mixture was diluted with dichloromethane (200 mL) and filtered. The filtrate was concentrated under vacuum to provide an oily residue. The residue was passed through a silica gel plug and eluted with a mixture of 4:1 (v:v) hexane :ethyl acetate. Fractions containing the desired material were grouped and concentrated to provide a purple colored oil. The product was further purified by dissolution into dichloromethane followed by precipitation from methanol. A grey solid (0.9 g) was obtained as the product. NMR analysis of the grey solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-6,13-dimethoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)piperazin-1yl)-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

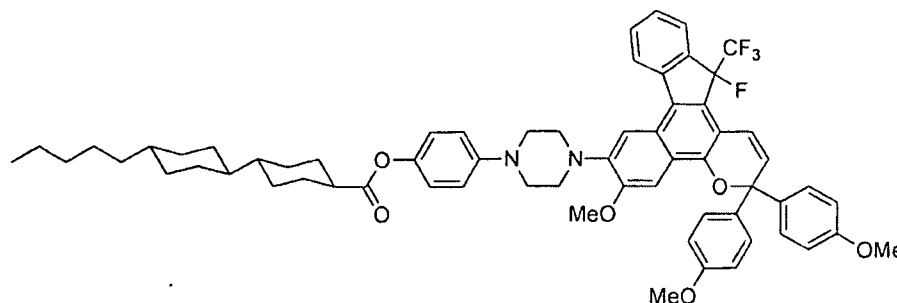
#### EXAMPLE 14 and EXAMPLE 15





[0209] The procedures of Steps 4 and 5 of Example 13 were followed except that in Step 4, the product of Step 2 was used in place of the product of Step 3 to produce two photochromics that were isolated by CombiFlash<sup>®</sup>. R<sub>f</sub> from Teledyne ISCO NMR showed that the less polar product had a structure consistent with Example 14, 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)piperazin-1yl)-13-hydroxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran. The other was also suggested by NMR as having a structure consistent with Example 15, 3,3-bis(4-methoxyphenyl)-6,7-di(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)piperazin-1yl)-13-hydroxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 16



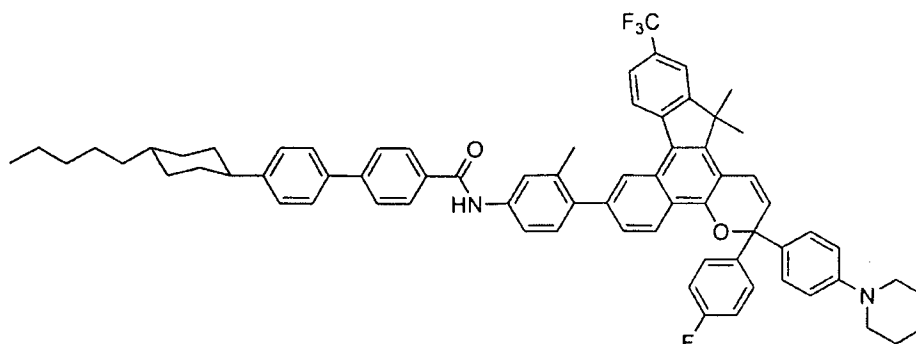
## Step 1

**[0210]** The product from Step 2 of Example 13, 3,3-bis(4-methoxyphenyl)-6,7-dimethoxy-13-hydroxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran (2.1 g) was dissolved in dichloromethane (20 mL) in a reaction flask and cooled to 0 °C. Dimethylaminosulfur trifluoride (0.6 mL) was added dropwise via a syringe. The reaction was warmed to room temperature and stirred for 1 h. The reaction mixture was quenched with saturated aqueous sodium bicarbonate (100 mL) and diluted with dichloromethane. The layers were separated and the aqueous layer was further extracted two times with dichloromethane using (25 mL) each time. The dichloromethane extracts were combined, dried with sodium sulfate, filtered and concentrated under vacuum to provide a residue. The residue was passed through a plug of silica gel (Grade 60, 230-400 mesh) and eluted with a mixture of 4:1(v:v) hexane :ethyl acetate. Fractions containing the desired material were grouped and concentrated to provide a yellow solid (0.8 g). NMR analysis of the yellow solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-6,7-dimethoxy-13-fluoro-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 2

**[0211]** The procedures of Steps 4 and 5 of Example 13 were followed except that in Step 4, the product of Step 1 (above) was used in place of the product of Step 3 of Example 13. A yellow solid was obtained as the product. NMR analysis of the yellow solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carbonyloxy)phenyl)piperazin-1-yl)-13-fluoro-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 17



## Step 1

**[0212]** Tribromobenzene (500.0 g) and tetrahydrofuran (2.0 L) were added to a reaction flask and the mixture was stirred. The solution was cooled to  $-10\text{ }^{\circ}\text{C}$  by immersing the flask into a salt-ice bath and *i*-propylmagnesium chloride in tetrahydrofuran (800.0 mL) was added dropwise (1 h) to keep the temperature of the solution below  $0\text{ }^{\circ}\text{C}$ . The mixture was stirred at this temperature for 40 min. Bis[2-(*N,N*-dimethylamino)-ethyl] ether (364.0 mL) was added to the reaction mixture at  $-10\text{ }^{\circ}\text{C}$  and stirred for 15 min. 4-Trifluoromethylbenzoyl chloride (261.0 mL) was added to the reaction mixture at  $-10\text{ }^{\circ}\text{C}$  and stirred for 20 min. The reaction mixture was warmed to room temperature and stirred for 20 h. The reaction mixture was poured into 10% aqueous hydrochloric acid (4.0 L) and stirred for 15 min. The aqueous solution was partitioned three times with ethyl acetate (1.0 L) each time. The ethyl acetate extracts were combined and washed three times first with brine (1.0 L), 10% aqueous sodium hydroxide (1.0 L) and then brine (1.0 L) again. The recovered ethyl acetate extract was dried with sodium sulfate, filtered and concentrated to provide an oil residue. Methanol (1.0 L) was added to the residue and the flask was scratched to provide colorless crystals. The crystals (347.0 g) were collected by vacuum filtration. NMR analysis of the colorless crystals indicated a structure that was consistent with (3,5-dibromophenyl)(4-(trifluoromethyl)phenyl)methanone.

## Step 2

**[0213]** The product from Step 1, (264.4 g), dimethyl succinate (102.0 mL) and toluene (2 L) were added to a reaction flask. The mixture was stirred until the solids dissolved at room temperature under nitrogen protection. Solid potassium *tert*-butoxide (110.0 g) was added followed by toluene (2.0 L) and the mixture was stirred at room temperature for 2 hours. Water (2.0 L) was carefully added to the mixture with stirring followed by concentrated hydrochloric acid (120.0 mL) and the mixture was stirred for 10 min. The aqueous solution was then



partitioned three times with ethyl acetate (1.0 L) each time. The ethyl acetate extracts were combined, dried with sodium sulfate, filtered and concentrated under vacuum to provide an oily residue. Hexanes (1.0 L) was added to the residue to produce a cream colored precipitate. The precipitate (237.9 g) was collected by vacuum filtration. NMR analysis of the cream colored solid indicated a structure consistent with (E)-4-(3,5-dibromophenyl)-3-(methoxycarbonyl)-4-(4-(trifluoromethyl)phenyl)but-3-enoic acid.

### Step 3

**[0214]** The product from Step 2, (7.8 g) was added to a reaction flask and dissolved in toluene (200 mL). Acetic anhydride (2.1 mL) was added and the mixture was heated to reflux for 3 h. The reaction mixture was cooled to room temperature and the solvent was removed under vacuum to provide an oily residue. The residue was dissolved in methanol (200 mL) and concentrated hydrochloric acid (1 mL) was added. The methanolic solution was heated to reflux for 6 h. The solution was cooled to room temperature and the solvent was removed under vacuum to provide a dark colored oil. The oil was passed through a plug of silica gel (Grade 60, 230-400 mesh) and eluted with a 4:1 (v:v) hexane :ethyl acetate mixture. Fractions containing the desired material were grouped and concentrated to provide a yellow colored oil. The oil was used directly in the next step.

### Step 4

**[0215]** The oil (5.3 g) from Step 3 was added to a reaction flask and dissolved in anhydrous tetrahydrofuran (50 mL) and cooled to 0 °C. Methylmagnesium chloride (14.1 mL) was added drop-wise and the reaction mixture was warmed to room temperature and stirred for 2 h. The reaction mixture was poured into 10 weight percent aqueous hydrochloric acid (100.0 mL) and stirred for 30 min. The aqueous solution was partitioned three times with ethyl acetate (50 mL) each time. The ethyl acetate extracts were combined, dried with sodium sulfate, filtered and concentrated to provide an oily residue. The residue was passed through a plug of silica gel (Grade 60, 230-400 mesh) and eluted with a 9:1 (v:v) hexane ethyl acetate mixture. Fractions containing the desired material were grouped and concentrated under vacuum to provide an oily residue (0.7 g) which was used directly in the next step.

### Step 5

**[0216]** The oil (0.7 g) from Step 4 was added to a reaction flask and dissolved in toluene (20.0 mL). Bismuth triflate (10.0 mg) was added and the mixture was heated to reflux for 2 h. The reaction mixture was cooled to room temperature and the solvent was removed under vacuum. The recovered residue was passed through a plug of silica gel (Grade 60, 230-400 mesh) and

eluted with a 4:1 (v:v) hexane ethyl acetate mixture. Fractions containing the desired material were grouped and concentrated to provide an oily residue. Hexanes was added to produce a precipitate. The precipitate (0.5 g) was collected by vacuum filtration. A cream colored solid was obtained as the product. NMR analysis of the cream solid indicated a structure consistent with 2-bromo-7,7-dimethyl-9-(trifluoromethyl)-7H-benzo[c]fluoren-5-ol.

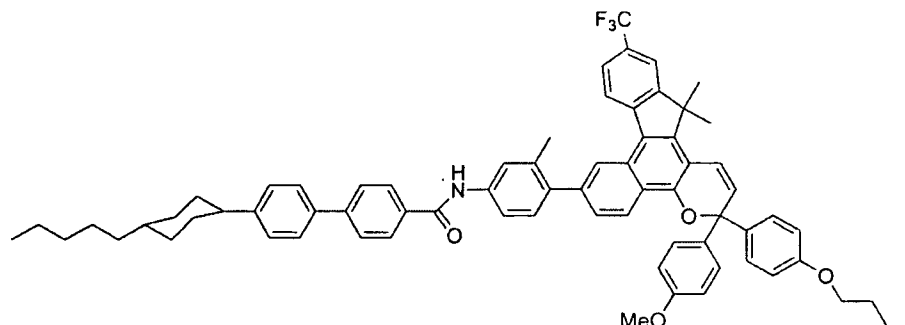
#### Step 6

**[0217]** To a reaction flask containing a chloroform solution (600 mL) of the product from Step 5, (0.5 g) and *p*-toluene sulfonic acid (20.0 mg) was added 1-(4-fluorophenyl)-1-(4-(piperidin-1-yl)phenyl)-prop-2-yn-1-ol (0.5 g). The solution was heated to reflux for 4 h. The reaction mixture was passed through a silica gel (Grade 60, 230-400 mesh) plug and eluted with CHCl<sub>3</sub>. Fractions containing the desired material were grouped and concentrated to provide a grey colored solid (0.4 g) which was used directly in the next step. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-7-bromo-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### Step 7

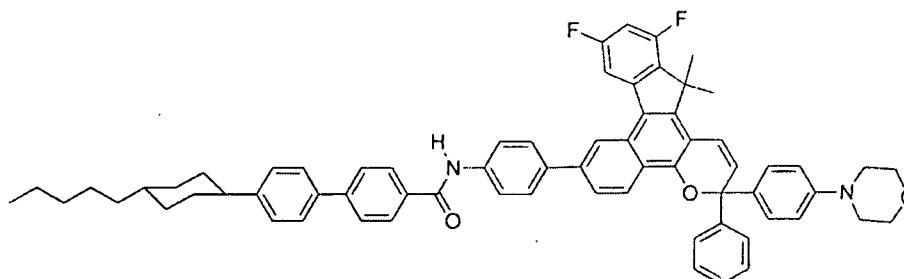
**[0218]** The product from Step 6, (0.3 g) and N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide (0.2 g; product from Step 5 of Example 12) were added to a reaction flask and dissolved in tetrahydrofuran (20.0 mL). A solution of potassium fluoride (0.2 g) in water (20.0 mL) and was added and the resulting solution was degassed by bubbling nitrogen for 10 min. Dichlorobis(triphenylphosphine)palladium(II) (0.03 g) was added and the resulting mixture was heated to reflux for 18 h. The reaction mixture was cooled to room temperature and diluted with ethyl acetate (100.0 mL). The mixture was filtered through a bed of Celite and the filtrate was collected and concentrated under vacuum to provide an oily residue. The residue was purified by silica gel and eluted with a 9:1(v:v) hexane acetone mixture. Fractions containing the desired material were grouped and concentrated. The residue was dissolved in a minimum amount of dichloromethane and added drop-wise to methanol (25 mL) to produce a precipitate. The precipitate (0.2 g) was collected by vacuum filtration. NMR analysis of the precipitate indicated a structure that was consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 18



[0219] The procedures from Step 1 to 7 of Example 17 were followed except that in Step 6, 1-(4-butoxyphenyl)-1-(4-methoxyphenyl)-prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol. A solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-butoxyphenyl)-3-(4-methoxyphenyl)-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

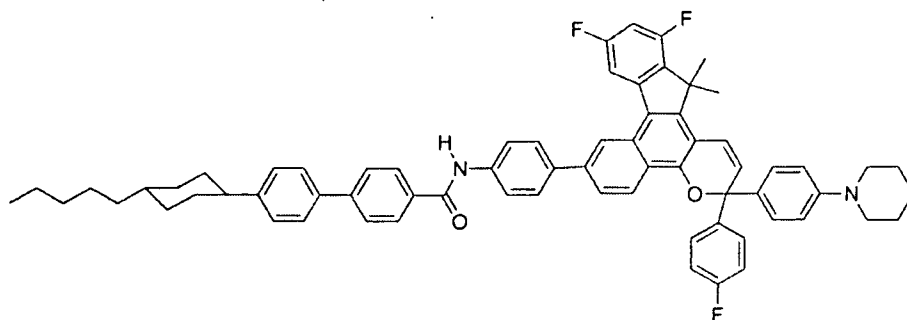
## EXAMPLE 19



[0220] The procedures from Step 1 to 7 of Example 17 were followed except that in Step 1, 3,5-difluorobenzoyl chloride was used in place of 4-trifluoromethylbenzoyl chloride, in Step 6, 1-phenyl-1-(4-morpholinophenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-(piperidin-1-yl)phenyl)prop-2-yn-1-ol and in Step 7, N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. After Step 7, a blue colored photochromic dye was isolated using CombiFlash<sup>®</sup> Rf from Teledyne ISCO. A bluish solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-(N-morpholinyl)phenyl)-3-phenyl-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-

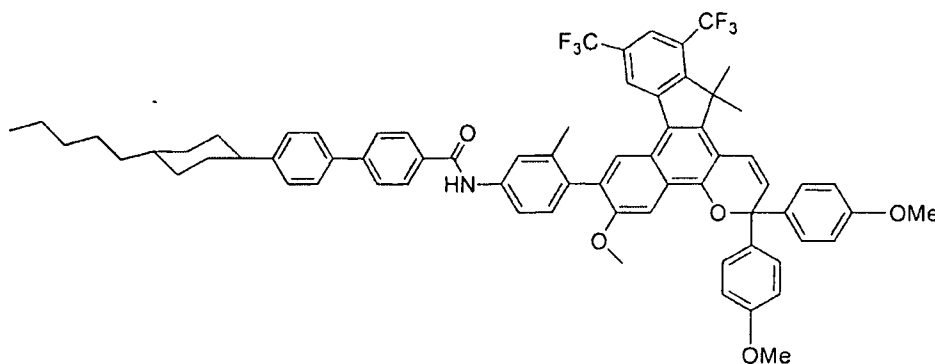
ylcarboxamido)phenyl)-10,12-difluoro-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 20



**[0221]** The procedures from Example 17 were followed except that in Step 1, 3,5-difluorobenzoyl chloride was used in place of 4-trifluoromethylbenzoyl chloride and in Step 7, N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. After Step 7, a blue colored photochromic dye was isolated using CombiFlash<sup>®</sup> Rf from Teledyne ISCO. A bluish solid was obtained as the product. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-difluoro-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 21



**Step 1**

[0222] Magnesium (Mg) turnings (13.5 g) were added to a reaction flask under N<sub>2</sub>. A portion (30 mL) of a solution of 4-bromo-1,2-dimethoxybenzene [100 g (66.3 mL)] dissolved in anhydrous tetrahydrofuran (THF, 200 mL) was added into the reaction flask with stirring. Di-bromo ethane (DBE, 1 mL) was added and the resulting mixture started to boil. The flask was put into an ice bath and the rest of the remainder of the solution of 4-bromo-1,2-dimethoxybenzene was added drop wise into the reaction mixture. THF (100 mL) was added. 2,2'-Oxybis(N,N-dimethylethanamine) [82 g (98 mL)] was added drop wise and the mixture was stirred for ~10 minutes. Then a solution of 3,5-bis(trifluoromethyl)benzoyl chloride [141 g (92.4 mL)] in THF (200 mL) was added drop wise with stirring and a white solid formed. After stirring overnight, the reaction mix was added into ice-water (1.5 L) with 10 wt% NaCl, stirred for 15-20 min. and then acidified to pH ~4 using HCl. The resulting mixture was extracted with EtOAc (1 L) and the recovered organic layer was passed through anhydrous MgSO<sub>4</sub>. The solvent was evaporated and the resulting dark thick gummy material was used for the next step.

**Step 2**

[0223] 3,4-Dimethoxy-3',5'-bistrifluoromethylbenzophenone (157 g) and dimethyl succinate [80 g (73 mL)] were added to a reaction flask (3 L) under N<sub>2</sub>. THF (1 L) was added. Potassium t-butoxide (52 g) was added over 0.5-1 h to control the temperature of the reaction mixture, which was kept at 15-20 °C in an ice-water bath. The reaction mixture was added into ice-water (1.5 L) with 10 wt% NaCl. The resulting mixture was stirred for 15-20 min., acidified to pH ~4 using HCl and then extracted with EtOAc (1 L). The recovered organic layer was passed through anhydrous MgSO<sub>4</sub>. The solvent was evaporated and the resulting dark thick gummy material was used for the next step. NMR showed that the product had a structure consistent with a mixture of *E* and *Z* isomers of 4-(3,5-bis(trifluoromethyl)phenyl)-4-(3,4-dimethoxyphenyl)-3-(methoxycarbonyl)but-3-enoic acid.

**Step 3**

[0224] The product of Step 2, (197 g) and acetic anhydride [270 g (250 mL)] were added to a reaction flask containing CH<sub>2</sub>Cl<sub>2</sub> (1 L). Bismuth triflate (18.2 g) was added and the reaction mixture was stirred at room temperature for ½ h. The solution was filtered and solvent was evaporated to provide a dark colored product. Iso-propanol (0.5 L) wash of the bulk gummy material generated off-white crystallized compound which was isolated and dried under vacuum (135 g). NMR showed that the product had a structure consistent with methyl 4-acetoxy-1-(3,5-bis(trifluoromethyl)phenyl)-6,7-dimethoxy-2-naphthoate.

**Step 4**

**[0225]** The product from Step 3 (135 g) was added to a reaction flask and dissolved in THF (1 L) and then MeMgCl [525 mL (22 wt% in THF)] was added drop wise with stirring under N<sub>2</sub> atmosphere. The reaction mixture was stirred at room temperature for ~3 h. The reaction mixture was added into ice-water (1.5 L) with 10 wt% NaCl, stirred for ~15 min and then acidified to pH ~4 using HCl. The resulting mixture was extracted with EtOAc (1 L). The recovered organic layer was washed with 10 wt% aqueous NaHCO<sub>3</sub> solution (0.5 L) and passed through anhydrous MgSO<sub>4</sub>. The solvent was evaporated and the resulting dark thick gummy material was solidified using a 0.5 L MeOH wash. The product was isolated and dried under vacuum (101 g). NMR showed that the product had a structure consistent with 4-(3,5-bis(trifluoromethyl)phenyl)-6,7-dimethoxy-3-(prop-1-en-2-yl)naphthalen-1-ol.

**Step 5**

**[0226]** The product from Step 4, (180 g) and bismuth triflate (13.12 g) were added together to a reaction flask containing xylene (1.8 L). The reaction mixture was refluxed with stirring under N<sub>2</sub> overnight. The resulting solution was filtered and the solvent was evaporated to obtain a dark colored product. The product was passed through a silica gel plug column using a mixture of EtOAc:Hexanes, 1:3 (v:v). The product was isolated after a hexane (0.5 L) wash and dried under vacuum (105 g). NMR showed that the product had a structure consistent with 2,3-dimethoxy-7,7-dimethyl-8,10-bis(trifluoromethyl)-7H-benzo[c]fluoren-5-ol.

**Step 6**

**[0227]** 1.4 (M) MeMgBr in a mixture of Toluene/THF (75/25) (860 mL) and 2,6-dimethylpiperidine [40.8 g (50 mL)] were added to a reaction flask under N<sub>2</sub> and THF (559 mL) was added. The product of Step 5 (108 g) was added in several portions with stirring. The resulting reaction mixture was refluxed overnight. The resulting reaction mixture was added into ice-water (2 L) with 10 wt% NaCl and a precipitate formed. The mixture was acidified with 1(N) HCl and a light brown colored oil formed. The mixture was extracted with EtOAc (1 L). The organic layer was recovered and washed with 10 wt% aqueous NaHCO<sub>3</sub> solution (0.5 L) and passed through anhydrous MgSO<sub>4</sub>. The solvent was evaporated and the resulting dark thick gummy material was solidified by using a hexanes wash. The product was isolated and dried under vacuum (64 g). NMR showed that the product had a structure consistent with 3-methoxy-7,7-dimethyl-8,10-bis(trifluoromethyl)-7H-benzo[c]fluorene-2,5-diol.

## Step 7

[0228] The product from Step 6 (10 g) was added to a reaction flask containing  $(\text{CH}_2)_2\text{Cl}_2$  (0.2 L) under nitrogen. The mixture was heated to reflux and p-Toluenesulfonic acid (0.044 g) was added to the reaction mixture with stirring. A solution of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol (6.2 g) in  $(\text{CH}_2)_2\text{Cl}_2$  (60 ml) was added slowly to the reaction mixture with stirring. The resulting reaction mixture was refluxed overnight, washed with an aqueous  $\text{NaHCO}_3$  solution and dried over anhydrous  $\text{MgSO}_4$ . Solvent was evaporated and the product was dissolved in minimum volume of  $\text{CH}_2\text{Cl}_2$  and passed through a silica gel plug column using  $\text{CH}_2\text{Cl}_2$  as an eluting solvent. The solvent was evaporated and the product was crystallized out using diethyl ether as a solvent. The product was isolated and dried under vacuum (12 g). NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-hydroxy-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 8

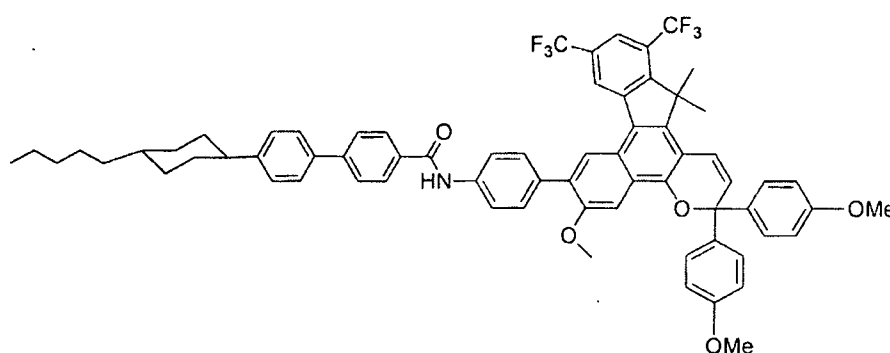
[0229] The product from Step 7 (10 g) was added to a reaction flask and dissolved in  $\text{CH}_2\text{Cl}_2$  (200 ml) and then  $\text{Et}_3\text{N}$  [4.3 g (6 mL)] was added with stirring. Trifluoromethanesulfonic anhydride [4.9 g (3.0 mL)] was added drop wise with stirring under a  $\text{N}_2$  atmosphere at  $0^\circ\text{C}$ . When addition was done the temperature of the reaction mixture was brought to about  $23^\circ\text{C}$  and the mixture was stirred for an hour. The reaction mixture was evaporated and the resulting residue was dissolved in a  $\text{CH}_2\text{Cl}_2$  and passed through a silica gel plug column. Solvent was evaporated and the recovered precipitate was washed with hexanes. The product was isolated and dried under vacuum (10 g). NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(trifluoromethanesulfonyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran..

## Step 9

[0230] The product from Step 8 (5 g) and N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide (3.8 g; from Step 5 of Example 12) were added to a reaction flask and dissolved in THF (0.15 L). Water (0.15 L) was added and the reaction mixture turned hazy. Potassium fluoride (1.8 g) was added with stirring and nitrogen was passed through the solution for ~15 min,  $\text{PdCl}_2(\text{PPh}_3)_2$  (0.3 g) was added and the reaction was heated to reflux with stirring for ~2 h. The reaction mixture was cooled to room temperature and ~100 mL of ethyl acetate was added. The recovered organic layer was filtered through CELITE<sup>®</sup> filter aid and dried with anhydrous  $\text{MgSO}_4$ . Solvent was evaporated and the resulting dark colored gummy material was dissolved in  $\text{CH}_2\text{Cl}_2$ . The

solution was passed through a column using  $\text{CH}_2\text{Cl}_2$  as the first eluting solvent and then EtOAc:Hexanes (2:8) (v:v). The product was isolated and dried under vacuum (4.7 g). NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 22



## Step 1

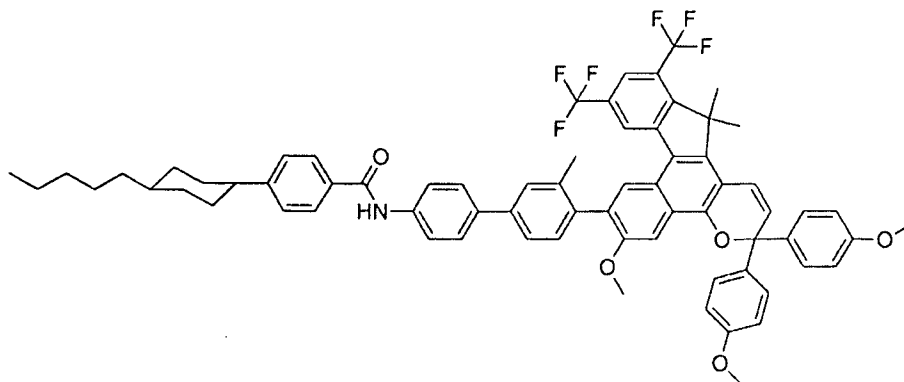
**[0231]** The procedures from Step 3 to Step 5 of Example 12 were followed except that in Step 5, 4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline was used in place of 3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline. NMR showed that the product had a structure consistent with 4'-(4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-[1,1'-biphenyl]-4-carboxamide.

## Step 2

**[0232]** The procedures from Step 9 of Example 21 were followed except that 4'-(4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-[1,1'-biphenyl]-4-carboxamide was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.



## EXAMPLE 23



## Step 1

**[0233]** The procedures from Steps 4 and 5 of Example 12 were followed except that in Step 4, 4-(trans-4-pentylcyclohexyl)benzoic acid was used in place of 4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid and in Step 5, 4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline was used in place of 3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline. NMR showed that the product had a structure consistent with 4-(trans-4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl) benzamide.

## Step 2

**[0234]** The product of Step 1 (37 g) and 1,4-dibromo-2-methylbenzene (23.34 g) were added to a reaction flask and dissolved in THF (0.37 L) and water (0.29 L) was added. Potassium acetate (KOAc) (76.37 g) was added into the reaction mixture with stirring. Nitrogen was passed through the solution for ~20 min. To the reaction mixture was added  $\text{PdCl}_2(\text{PPh}_3)_2$  (2.73 g) and the reaction was heated to reflux with stirring for ~2 h. The reaction mixture was cooled to room temperature and then ~200 mL of ethyl acetate was added. The recovered organic layer was filtered through CELITE<sup>®</sup> filter aid, dried with anhydrous  $\text{MgSO}_4$  and the solvent was evaporated under vacuum. The recovered residue was recrystallized using THF and Ethanol. NMR showed that the product had a structure consistent with N-(4'-bromo-3'-methyl-[1,1'-biphenyl]-4-yl)-4-(trans-4-pentylcyclohexyl)benzamide.

## Step 3

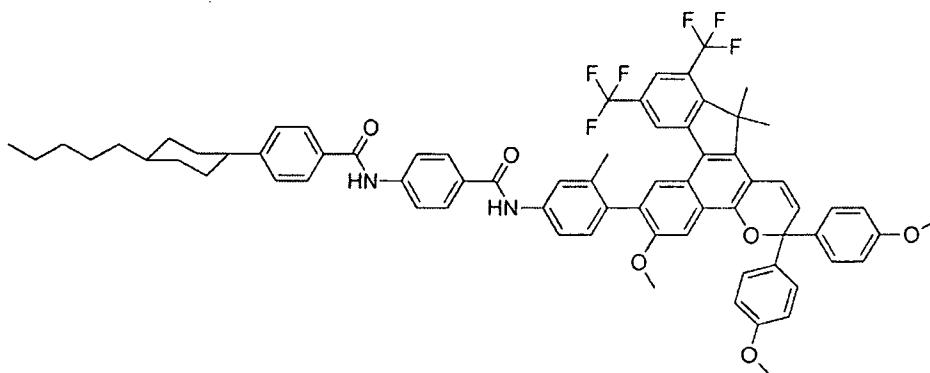
**[0235]** The product from Step 2 (20 g) and 4,4,4',4',5,5,5',5'-octamethyl-2,2'-bi(1,3,2-dioxaborolane) (19.59 g) were added to a reaction flask containing 2-methyltetrahydrofuran (0.5 L). Potassium acetate (KOAc) (9.46 g) was added with stirring. Nitrogen was passed through the solution for ~20 min. To the reaction mixture was added  $\text{PdCl}_2(\text{PPh}_3)_2$  (5.41 g) and the

reaction was heated to reflux with stirring for ~16 h. The reaction mixture was cooled to room temperature and washed with 0.5 L of 10 wt% aqueous NaCl solution. The recovered organic layer was dried over anhydrous MgSO<sub>4</sub>, filtered and the solvent was evaporated out. The recovered residue was dissolved in CH<sub>2</sub>Cl<sub>2</sub> and passed through a silica gel plug column using CH<sub>2</sub>Cl<sub>2</sub> as the eluting solvent. The product was recrystallized from a mixture of THF and methanol. NMR showed that the product had a structure consistent with N-(3'-methyl-4'-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)-[1,1'-biphenyl]-4-yl)-4-(trans-4-pentylcyclohexyl)benzamide.

#### Step 4

**[0236]** The procedures from Steps 1 to 9 of Example 21 were followed except that in Step 9, the product of Step 3 (above) was used in place of N-(3-methyl-4-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(2-methyl-4-(4-(4-(trans-4-pentylcyclohexyl)benzamido)phenyl)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

#### EXAMPLE 24



#### Step 1

**[0237]** The procedures from Steps 4 and 5 of Example 12 were followed except that in Step 4, 4-(trans-4-pentylcyclohexyl)benzoic acid was used in place of 4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid and in Step 5, 4-aminobenzoic acid was used in place of 3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline. NMR showed that the product had a structure consistent with 4-(4-(trans-4-pentylcyclohexyl)benzamido)benzoic acid.

#### Step 2

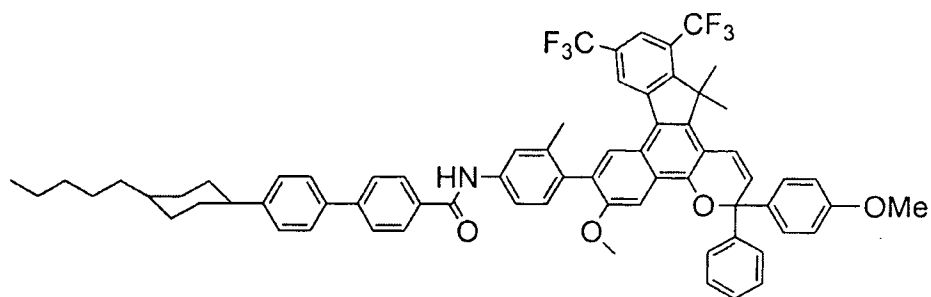
**[0238]** The procedure from Step 3 of Example 27 was followed except that 4-(4-(trans-4-pentylcyclohexyl)benzamido)benzoic acid was used in place of 4-((trans,trans)-4'-pentyl-[1,1'-

bi(cyclohexane)]-4-carboxamido)benzoic acid. NMR showed that the product had a structure consistent with N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4-(4-(trans-4-pentylcyclohexyl) benzamido)benzamide.

### Step 3

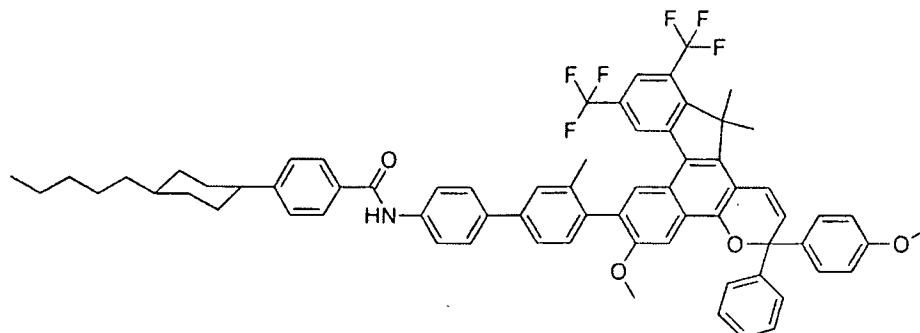
**[0239]** The procedures from Steps 1 to 9 of Example 21 were followed except that in Step 9, the product of Step 2 (above) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(2-methyl-4-(4-(4-(trans-4-pentylcyclohexyl)benzamido)benzamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

### EXAMPLE 25



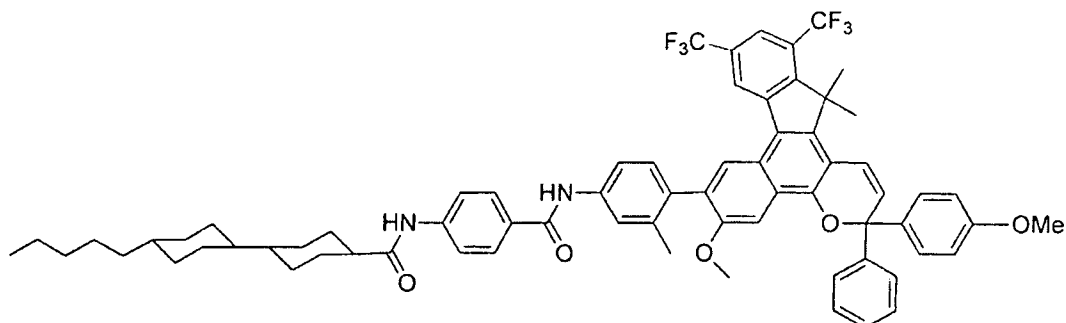
**[0240]** The procedures from Steps 1 to 9 of Example 21 were followed except that in Step 7, 1-(4-methoxyphenyl)-1-phenyl-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-phenyl-6-methoxy-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 26



**[0241]** The procedures from Steps 1 to 9 of Example 21 were followed except that in Step 7, 1-(4-methoxyphenyl)-1-phenyl-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, N-(3'-methyl-4'-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)-[1,1'-biphenyl]-4-yl)-4-(trans-4-pentylcyclohexyl)benzamide (from Step 3 of Example 23) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-phenyl-6-methoxy-7-(2-methyl-4-(4-(trans-4-pentylcyclohexyl)benzamido)phenyl)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 27



## Step 1

**[0242]** Into a reaction flask containing CH<sub>2</sub>CH<sub>2</sub> (100mL) were added (trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid (10 g) and methyl 4-aminobenzoate (6.7 g). N,N'-Dicyclohexylcarbodiimide (DCC)(10.3 g), 4-(Dimethylamino)pyridine (DMAP)(2.9 g) and

Dodecylbenzenesulfonic acid (DBSA)(6.5 g) were added with stirring under a N<sub>2</sub> atmosphere. After stirring about 20 min. a white precipitate formed. The white solid was filtered and washed with CH<sub>2</sub>Cl<sub>2</sub> three times and the solid was used for the next step without any further purification.

#### Step 2

**[0243]** Methyl 4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxamido)benzoate (16.8 g) was added to a reaction flask containing MeOH (500 mL). A 50 wt% aqueous NaOH (32.8 g) was added to the reaction mixture with stirring and the mixture was refluxed for ~5h. The reaction mixture was cooled to room temperature and poured into ice cold water (1 L) and then acidified to pH ~3 with conc. HCl. A white solid formed and was filtered, washed with water followed by a MeOH wash. A solid product was isolated and dried in a vacuum oven (15.4 g). NMR showed that the product had a structure consistent with 4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxamido)benzoic acid.

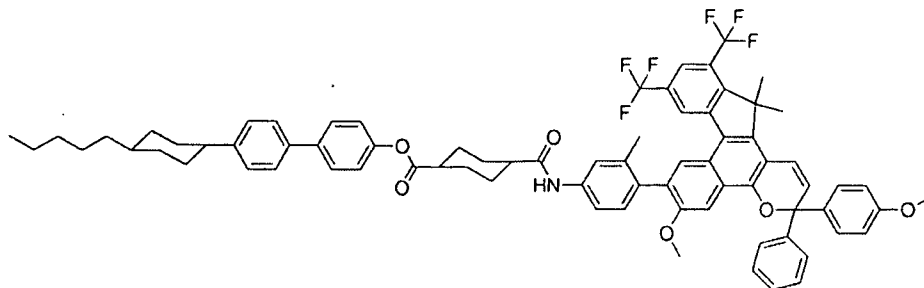
#### Step 3

**[0244]** The procedure from Step 1 of this example was followed except that: the product of Step 2 and 3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)aniline were used in place of (trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid and methyl 4-aminobenzoate, respectively; dodecylbenzenesulfonic acid was not used; the reaction was stirred for 100 h. instead of 20 min. the precipitated ; and a light yellow waxy material was recovered and washed with hexanes to obtain the product. NMR showed that the product had a structure consistent with (trans,trans)-N-(4-((3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)carbonyl)phenyl)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxamide.

#### Step 4

**[0245]** The procedure from Steps 1 to 9 of Example 21 were followed except that in Step 7, 1-(4-methoxyphenyl)-1-phenyl-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, the product of Step 3 (above) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-phenyl-6-methoxy-7-(2-methyl-4-(4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxamido)benzamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 28



## Step 1

**[0246]** To a reaction flask containing 1,4-dioxane (12.5 L) and water (372 ml) was added 1-bromo-4-(4-pentylcyclohexyl)benzene (3000 g), 4-hydroxyphenylboronic acid (1350 g),  $K_2CO_3$  (5500 g) and  $Pd(PPh_3)_4$  (44.84 g) and the resulting mixture was stirred at 110°C for 12 hours. After the solution was cooled to ambient temperature it was poured into water (65 L) with stirring. A grey solid was obtained after filtration, The solid was washed with water, dissolved in THF (12.5 L), passed through active carbon (350 g) and filtered through CELITE® filter aid. The filtrate was concentrated the resulting residue was poured into 4 L of methanol with stirring. A white solid was obtained after filtration and it was washed with methanol and dried to give 1840 g of product. NMR showed that the product had a structure consistent with 4'-((trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl). This procedure was repeated to produce enough product for the next step.

## Step 2

**[0247]** To a reaction flask containing DMF (25.00 L) was added the product of Step 1 (2.6 Kg), trans-cyclohexane-1,4-dicarboxylic acid (2.78 Kg), DBSA (1.31 Kg) and DMAP (0.59 Kg). The resulting mixture was stirred for 3 h. DCC (1.75 Kg) was added in portions and the resulting mixture was stirred for 30 h at ambient temperature. A solid formed and was filtered and washed with DMF. The recovered product was processed in three batches by dissolving each batch in THF (30 L) with stirring and then filtered through CELITE® filter aid. The filtrate was concentrated and the resulting residue was poured into 4 L of ethanol with stirring. A white solid formed which was recovered by filtration, washed with ethanol and dried to provide 588 g of product. NMR showed that the product had a structure consistent with trans-4-(((4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)oxy)carbonyl)cyclohexanecarboxylic acid.

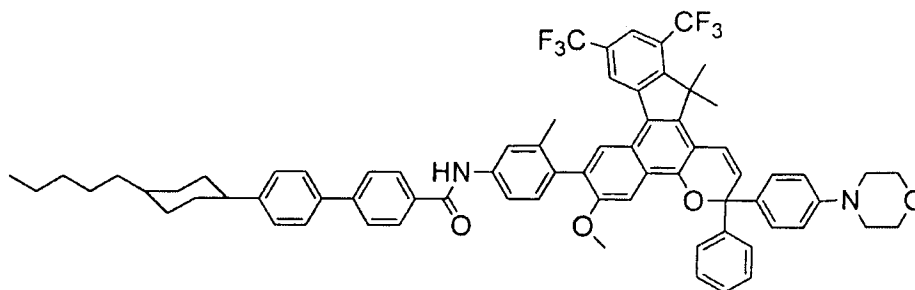
## Step 3

[0248] The procedures from Steps 4 and 5 of Example 12 were followed except that in Step 4, the product from Step 2 (above) was used in place of 4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid. NMR showed that the product had a structure consistent with trans-4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl 4-((3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)carbamoyl)cyclohexanecarboxylate.

## Step 4

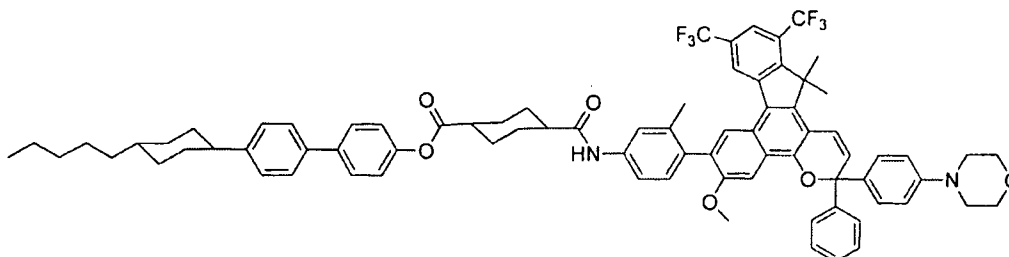
[0249] The procedures of Steps 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-methoxyphenyl)-1-phenyl-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, the product of Step 3 (above) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-phenyl-6-methoxy-7-(2-methyl-4-(trans-4-(((4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)oxy)carbonyl)cyclohexanecarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 29



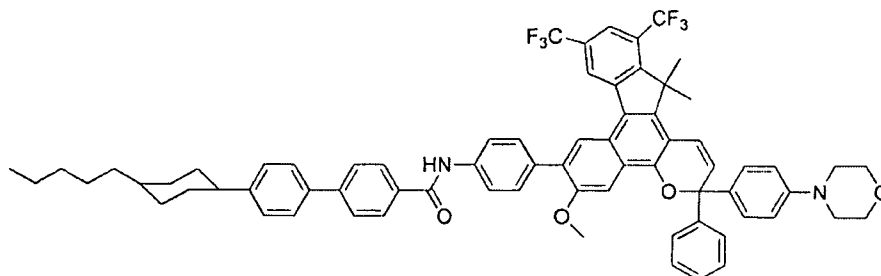
[0250] The procedures of Steps 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-morpholinophenyl)-1-phenylprop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-N-morpholinylphenyl)-3-phenyl-6-methoxy-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)carboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 30



**[0251]** The procedures of Steps 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-morpholinophenyl)-1-phenylprop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, trans-4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl 4-((3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)carbamoyl)cyclohexanecarboxylate (from Step 3 of Example 28) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3-(4-N-morpholinophenyl)-3-phenyl-6-methoxy-7-(2-methyl-4-(trans-4-(((4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)oxy)carbonyl)cyclohexanecarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 31

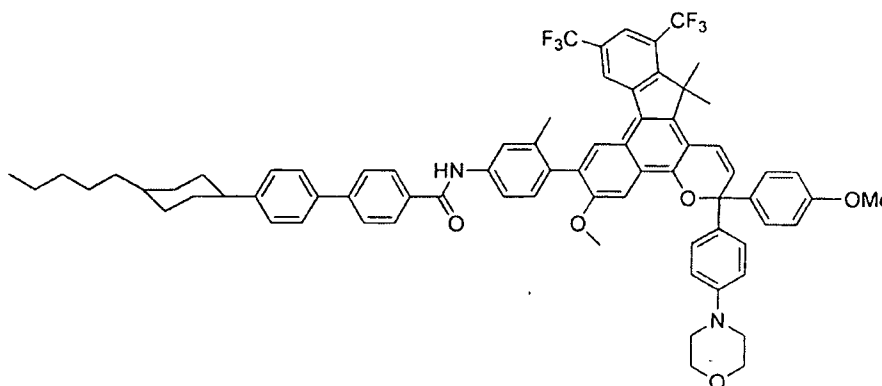


**[0252]** The procedures of Step 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-morpholinophenyl)-1-phenylprop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol in Step 7 and in Step 9, N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide (from Step 1 of Example 22) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product



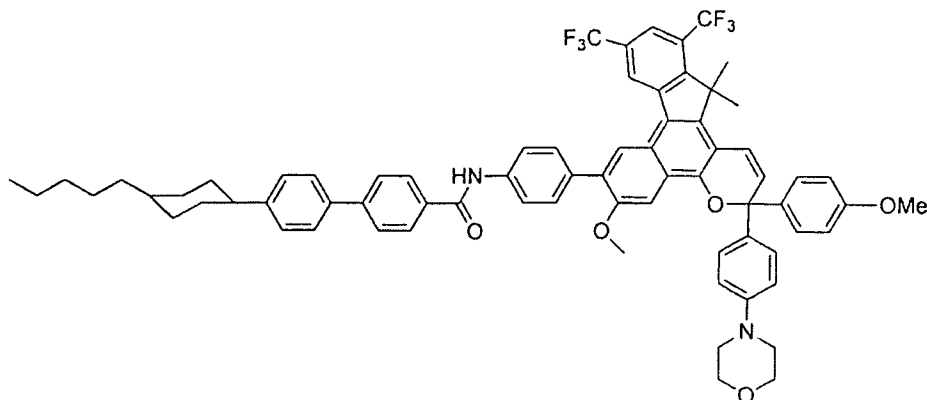
had a structure consistent with 3-(4-N-morpholinophenyl)-3-phenyl-6-methoxy-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 32



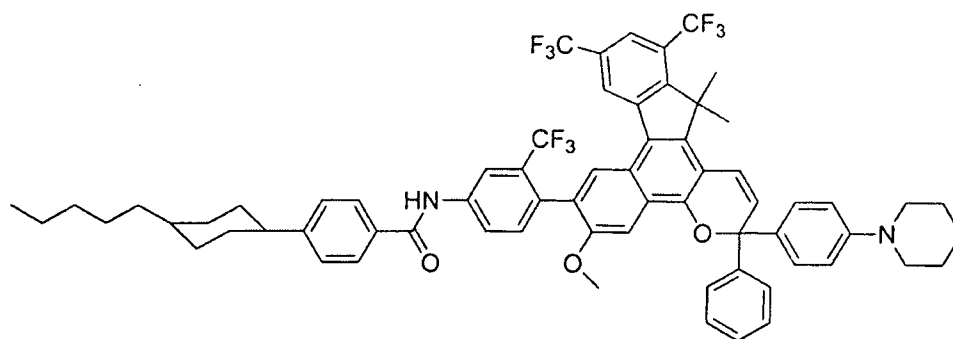
[0253] The procedures of Step 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-methoxyphenyl)-1-(4-morpholinophenyl)-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-N-morpholinophenyl)-3-(4-methoxyphenyl)-6-methoxy-7-(2-methyl-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 33



[0254] The procedures of Steps 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-methoxyphenyl)-1-(4-morpholinophenyl)-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, 4'-(4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-[1,1'-biphenyl]-4-carboxamide (from Step 1 of Example 22) was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3-(4-N-morpholinophenyl)-3-(4-methoxyphenyl)-6-methoxy-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 34



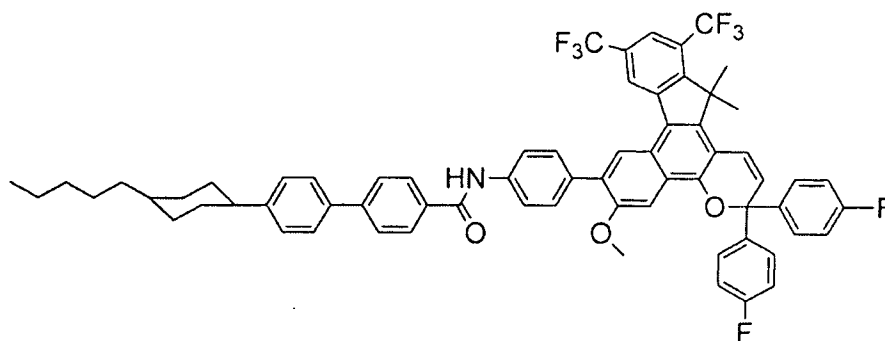
## Step 1

**[0255]** The procedures from Step 3 to 5 of Example 12 were followed except that in Step 3, 4-bromo-3-(trifluoromethyl)aniline was used in place of 4-bromo-3-methylaniline and in Step 4, 4-(4-pentylcyclohexyl)benzoic acid was used in place of 4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxylic acid. NMR showed that the product had a structure consistent with 4-(4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)-3-(trifluoromethyl)phenyl)benzamide.

## Step 2

**[0256]** The procedures of Steps 1 to 9 from Example 21 were followed except that in Step 7, 1-(4-morpholinophenyl)-1-(4-phenyl)prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, 4-(4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)-3-(trifluoromethyl)phenyl)benzamide was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-carboxamide. NMR showed that the product had a structure consistent with 3-phenyl-3-(4-(piperidin-1-yl)phenyl)-6-methoxy-7-(4-(4-(trans-4-pentylcyclohexyl)benzamido)-2-(trifluoromethyl)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

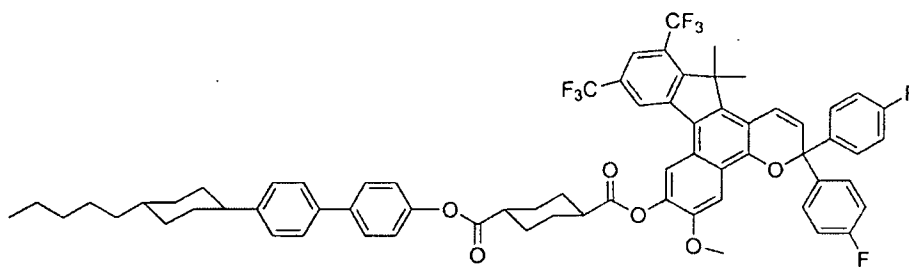
## EXAMPLE 35



**[0257]** The procedures of Steps 1 to 9 from Example 21 were followed except that in Step 7, 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 9, 4'-(4-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-[1,1'-biphenyl]-4-carboxamide was used in place of N-(3-methyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-4'-(4-pentylcyclohexyl)-[1,1'-biphenyl]-4-

carboxamide. NMR showed that the product had a structure consistent with 3,3-bis(4-fluorophenyl)-6-methoxy-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)carboxamido)phenyl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 36



## Step 1

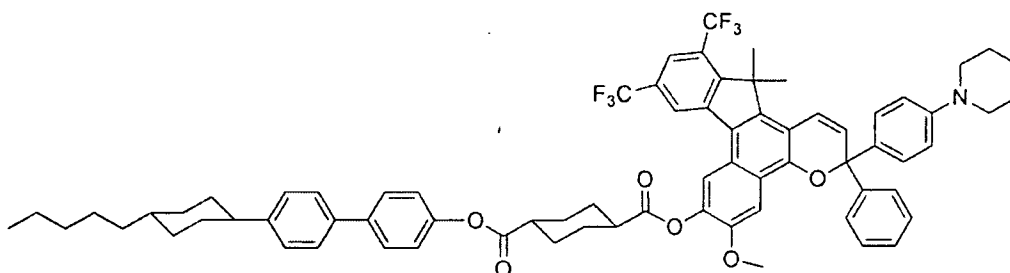
**[0258]** The procedures from Steps 1 to 7 of Example 21 were followed except that in Step 7, 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3,3-bis(4-fluorophenyl)-6-methoxy-7-hydroxy-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 2

**[0259]** The product of Step 1 (4.0 g) was dissolved into a minimum volume of  $\text{CH}_2\text{Cl}_2$  in a reaction flask and the following were added: 1,3-dicyclohexylcarbodiimide (DCC) (1.46 g), 4-(dimethylamino)pyridine (DMAP) (0.43 g) and dodecylbenzenesulfonic acid (DBSA) (0.96 g). The resulting mixture was stirred for a couple of minutes and trans-4-(((4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)oxy)carbonyl)cyclohexanecarboxylic acid (3.7 g) (from Step 2 of Example 28) was added. Enough  $\text{CH}_2\text{Cl}_2$  was added to make the mixture less viscous and stirrable. The reaction mixture was stirred overnight. A white solid precipitate formed and was removed by filtration. The filtrate was evaporated and the residue was collected as the crude product. The recovered product was dissolved in toluene and the white precipitate was removed by filtration. The toluene solution was passed through a silica gel plug column using  $\text{CH}_2\text{Cl}_2$  as the eluting solvent. Solvent was evaporated to concentrate the solution which was added to vigorously stirred MeOH to precipitate the solid product. The product (5 g) was recrystallized from diethyl ether. NMR analysis showed that the product had a structure consistent with 3,3-bis(4-fluorophenyl)-6-methoxy-7-(trans-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-

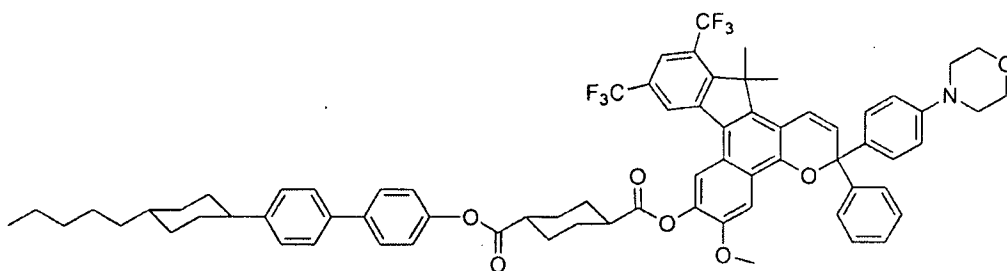
biphenyl]-4-yloxy carbonyl)cyclohexanecarbonyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 37



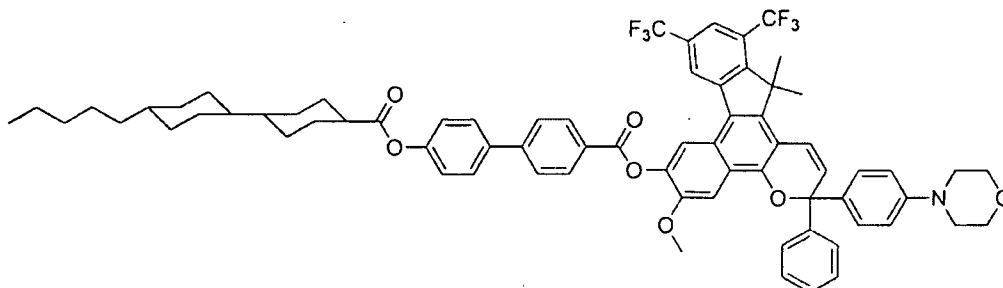
[0260] The procedures from Steps 1 to 7 of Example 21 were followed except that in Step 7, 1-(4-phenyl)-1-(4-N-piperidinylphenyl)prop-2-yn-1-ol was used in place of 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-(piperidin-1-yl)phenyl)-3-phenyl-6-methoxy-7-(trans-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yloxy carbonyl)cyclohexanecarbonyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 38



[0261] The procedures from Steps 1 to 7 of Example 21 were followed except that in Step 7, (4-morpholinophenyl)-1-(4-phenyl)-1-prop-2-yn-1-ol was used in place of 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-(N-morpholino)phenyl)-3-phenyl-6-methoxy-7-(trans-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yloxy carbonyl)cyclohexanecarbonyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 39



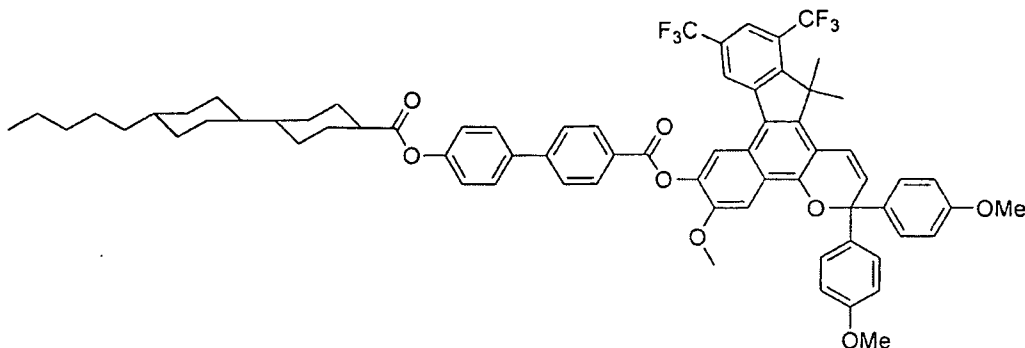
## Step 1

**[0262]** The procedures from Steps 1 to 7 of Example 21 were followed except that in Step 7, (4-N-morpholinophenyl)-1-(4-phenyl)-1-prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-(N-morpholino)phenyl)-3-phenyl-6-methoxy-7-hydroxy-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 2

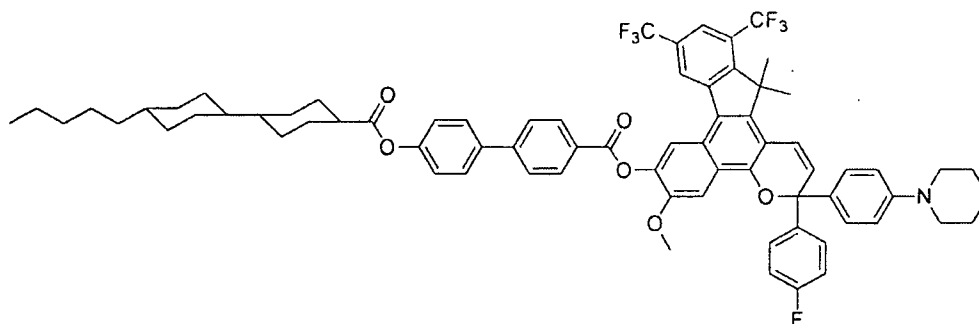
**[0263]** The procedures from Steps 4, 5, 6 and 7 of Example 1 were followed except that in Step 5, the product from Step 1 (above) was used in place of 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-13-methoxy-13-ethyl-6-methoxy-7-hydroxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran and in Step 7, (trans, trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid was used in place of 4-(4-(trans)-pentylcyclohexyl)benzoic acid. NMR showed that the product had a structure consistent with 3-(4-(N-morpholino)phenyl)-3-phenyl-6-methoxy-7-(4-(4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)benzoyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 40



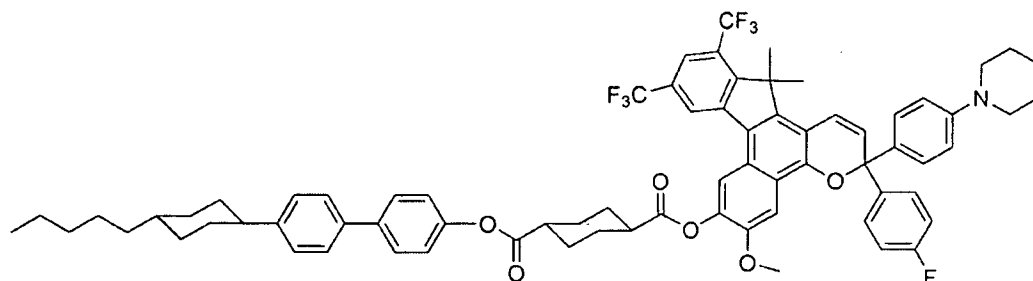
[0264] The procedures from Steps 1 and 2 of Example 39 were followed except that in Step 1, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of (4-morpholinophenyl)-1-(4-phenyl)-1-prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)benzoyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 41



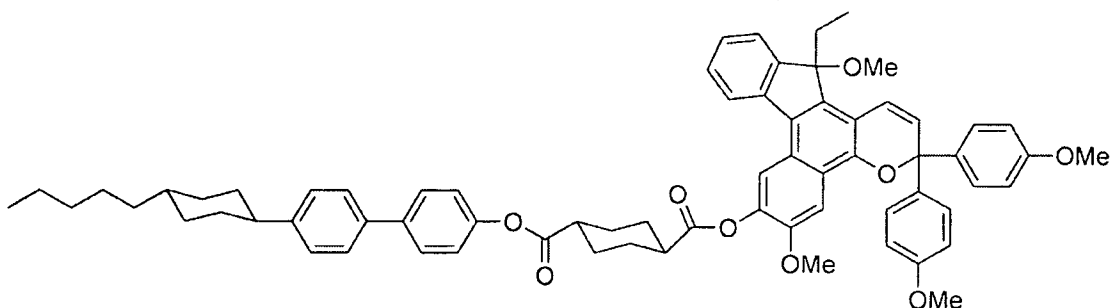
[0265] The procedures from Step 1 and 2 of Example 39 were followed except that in Step 1, 1-(4-fluorophenyl)-1-(4-(piperidin-1-yl)phenyl)prop-2-yn-1-ol was used in place of (4-morpholinophenyl)-1-(4-phenyl)-1-prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-6-methoxy-7-(4-(4-((trans,trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)benzoyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 42



[0266] The procedures from Steps 1 and 2 of Example 36 were followed except that in Step 1, 1-(4-fluorophenyl)-1-(4-N-piperidinyl)prop-2-yn-1-ol was used in place of 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-6-methoxy-7-(trans-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yloxy)carbonyl)cyclohexanecarbonyloxy)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 43



## Step 1

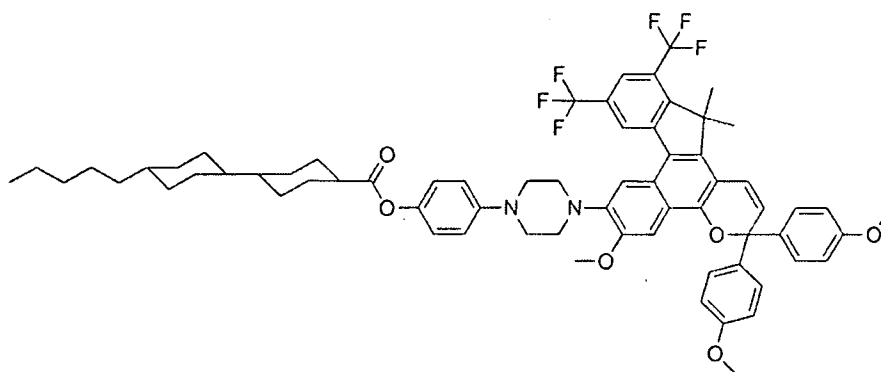
[0267] The procedures from Steps 1 to 3 of Example 1 were followed except that in Step 3, 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl)prop-2-yn-1-ol in step 3. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-13-methoxy-13-ethyl-6-methoxy-7-hydroxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.



## Step 2

**[0268]** The procedure from Step 2 of Example 36 was followed except that the product from Step 1 (above) was used in place of 3,3-bis(4-fluorophenyl)-6-methoxy-7-hydroxy-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6,13-dimethoxy-7-(trans-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yloxy)carbonyl)cyclohexanecarbonyloxy)-13-ethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 44



## Step 1

**[0269]** To a reaction flask containing methylenechloride (350 ml) was added 2,3-dimethoxy-7,7-dimethyl-8,10-bis(trifluoromethyl)-7H-benzo[c]fluoren-5-ol (13.0 g) (product from Step 5 of Example 21), 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol (7.6 g) and *p*TSA (0.05 g) and stirred for 1 hour. The reaction mixture was washed with an aqueous solution of NaHCO<sub>3</sub>, dried over magnesium sulfate, concentrated and used directly in the next step.

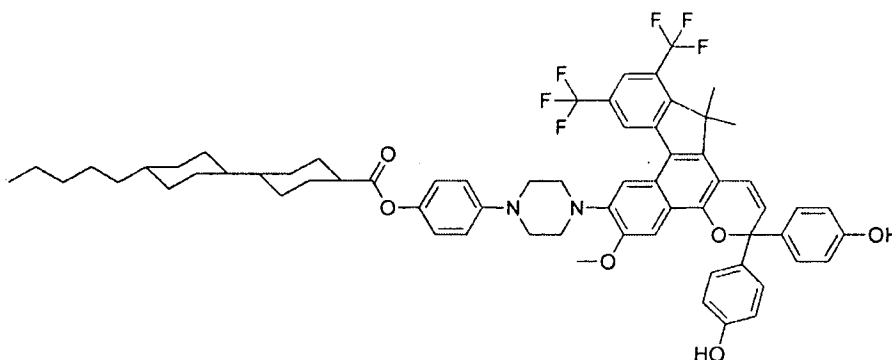
## Step 2

**[0270]** The product of Step 1 (10.0 g) and 4-(piperazin-1-yl)phenol (3.02 g) was added to a reaction flask and dried in a vacuum oven at 110 °C. THF (250 ml) was added under the protection of nitrogen. A solution of MeLi / ethyl ether (1.6 M, 21 ml) in 60 ml of THF was added slowly over 35 minutes at 0 °C. After TLC showed that the reaction was completed, 100 ml of water was added. 2N HCl was used to adjust the pH to 5. Extraction was done using ethyl acetate. The recovered organic layer was dried over MgSO<sub>4</sub>, filtered over silica gel and concentrated. The product was used in the next step without further purification.

## Step 3

**[0271]** A mixture of (trans, trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid (2 g), the product from Step 2 (3 g), *N,N*-dicyclohexylcarbodiimide (0.9 g), 4-dimethylaminopyridine (0.3 g) and methylene chloride (30 ml) was stirred in a reaction flask at room temperature overnight. The solids in the reaction mixture were removed by filtration. The filtrate was washed with water several times, dried and then concentrated. The recovered residue was recrystallized from a mixture of methylene chloride/methanol. The crystalline product was collected by vacuum filtration (3.01 g). NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 45



## Step 1

**[0272]** The procedure of Step 1 of Example 44 was followed except that 1,1-bis(4-((tetrahydro-2H-pyran-2-yl)oxy)phenyl)prop-2-yn-1-ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol. The resulting product was not purified and used in the next step.

## Step 2

**[0273]** The product from Step 1 was mixed with ethanol (140 ml) and PTSA (0.14 g) in a reaction flask. After refluxing for 4 hours, the reaction mixture was extracted using ethyl acetate and water. The organic layer was collected, dried and concentrated to provide a solid (11.9 g). The recovered solid was dissolved in THF (60 ml) in a reaction flask. Triisopropylsilyl triflate (14 g) was added. Pyridine (12 g) was added slowly. The mixture was stirred at room temperature for 16 hours. All solvent was removed and the resulting residue was dissolved in

dichloromethane (100 mL), washed with 0.1 M hydrochloric acid (2 x 30 mL) and brine (3 x 50 mL), dried and concentrated. The product was recrystallized from methanol to provide crystals as the product (14.8 g). NMR showed that the product had a structure consistent with 3,3-bis(4-triisopropylsiloxyphenyl)-6,7-dimethoxy-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

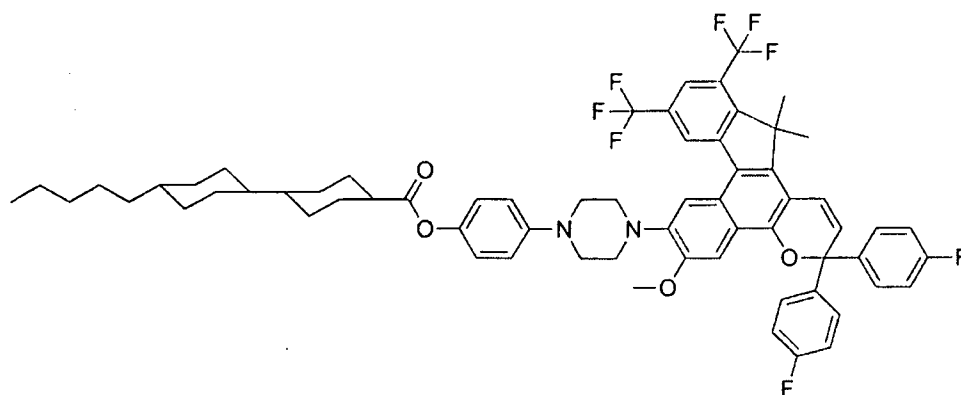
### Step 3

**[0274]** The procedures of Steps 2 and 3 of Example 44 were followed except that product from Step 2 (above) was used in place of the product from Step 1 of Example 44. NMR showed that the product had a structure consistent with 3,3-bis(4-triisopropylsiloxyphenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carbonyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

### Step 4

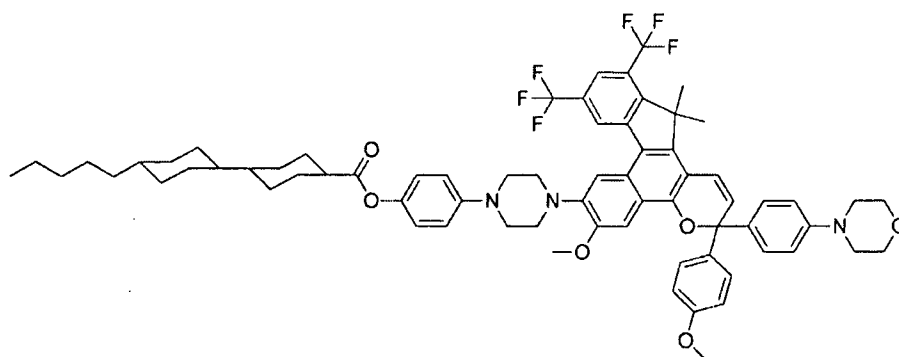
**[0275]** To a reaction flask was added the product of Step 3 (1.10 g), tetrabutylammonium fluoride trihydrate (TBAF) (0.30 g), THF (11 mL) and water (5.5 mL). The resulting mixture was stirred at room temperature for 3 h. Ethyl acetate (5 mL) was added and the resulting organic layer was collected and concentrated. The residue was purified by CombiFlash<sup>®</sup> Rf from Teledyne ISCO followed by recrystallization from methylene chloride and hexanes. A solid (0.44 g) was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-hydroxyphenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carbonyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

### EXAMPLE 46



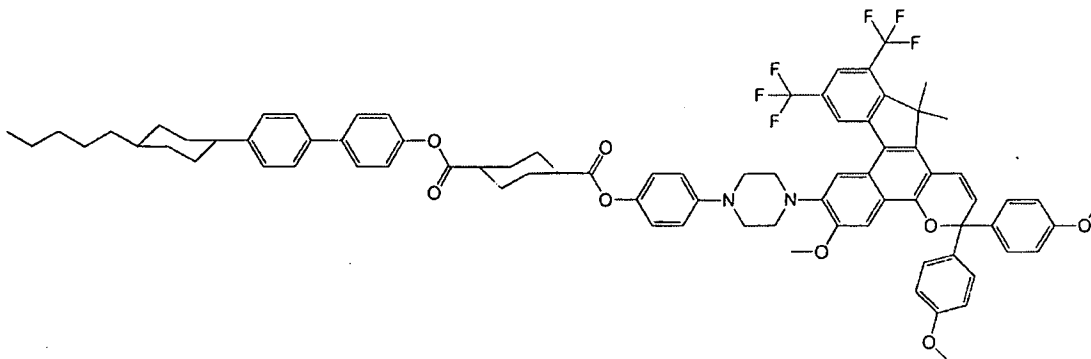
**[0276]** The procedures from Steps 1 to 3 of Example 1 were followed except that in Step 3, 1,1-bis(4-fluorophenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3,3-bis(4-fluorophenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carbonyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 47



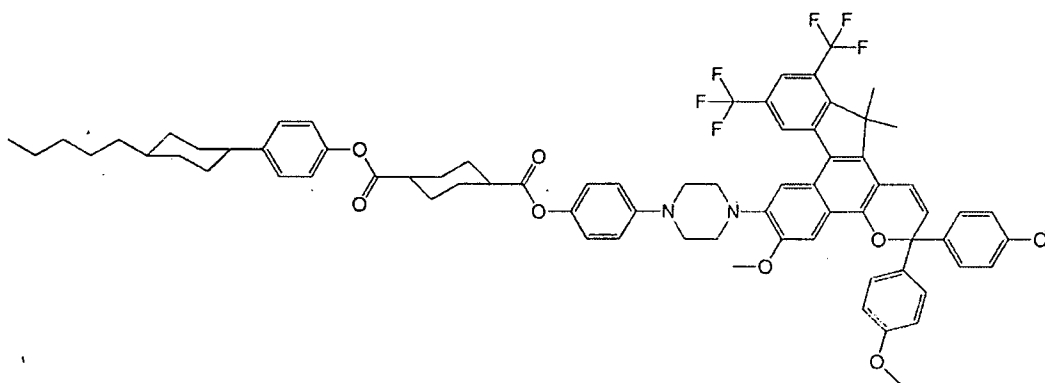
**[0277]** The procedures from Steps 1 to 3 of Example 1 were followed except that 1-(4-methoxyphenyl)-1-(4-morpholinophenyl)prop-2-yn-1-ol was used in place of 1-(4-fluorophenyl)-1-(4-piperidin-1-yl-phenyl)-prop-2-yn-1-ol. NMR showed that the product had a structure consistent with 3-(4-methoxyphenyl)-3-(4-N-morpholinophenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carbonyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 48



**[0278]** The procedure from Step 3 of Example 44 was followed except that trans-4-(((4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)oxy)carbonyl)cyclohexanecarboxylic acid, the product of Step 2 of Example 28 was used in place of (trans, trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-(trans-4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-yl)oxy)carbonyl)cyclohexanecarbonyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 49



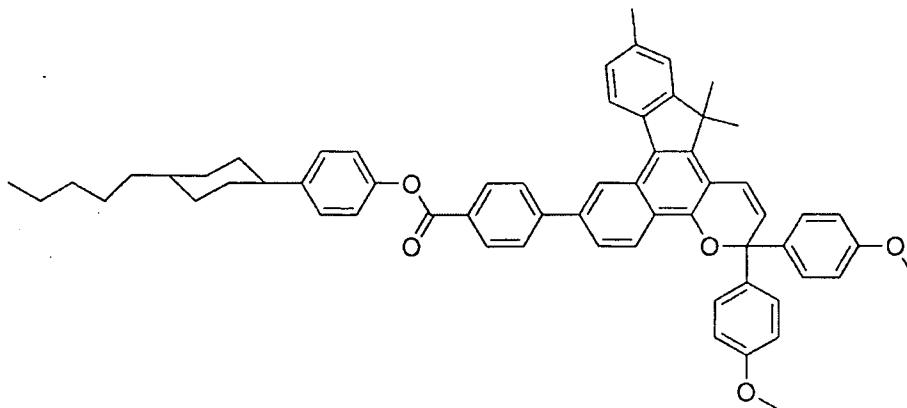
## Step 1

**[0279]** The procedures from Steps 1 and Step 2 of Example 28 were followed except that 4-(trans-4-pentylcyclohexyl)phenol was used in place of 4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ol. NMR showed that the product had a structure consistent with trans-4-(((4-(trans-4-pentylcyclohexyl)phenoxy)carbonyl)cyclohexanecarboxylic acid.

## Step 2

**[0280]** The procedure from Step 3 of Example 44 was followed except that product from Step 1 (above) was used in place of (trans, trans)-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxylic acid. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-(trans-4-(4-(trans-4-pentylcyclohexyl)-phenyloxycarbonyl)-cyclohexanecarbonyloxy)phenyl)piperazin-1-yl)-10,12-di(trifluoromethyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 50



## Step 1

**[0281]** 3-Bromo-4'-methylbenzophenone (50 g), dimethyl succinate (34.5 g) and toluene (1 liter) were added to a reaction flask under a nitrogen blanket. The mixture was stirred at room temperature until the solids were dissolved. Solid potassium t-butoxide (22.4 g) was added and the mixture was stirred at room temperature for 4 hours. The resulting reaction mixture was poured into 1 L of water and the aqueous layer, which contained the product, was collected. The toluene layer was extracted with 200 ml water. The combined water solution was washed with toluene. HCl (2 N, 20 mL) was added to the water solution. Yellow oil precipitated. The resulting mixture was extracted with ethyl acetate, dried over magnesium sulfate, concentrated and dried in vacuum. Yellow glassy oil (55 g) was obtained as product. It was used directly in the next step.

## Step 2

**[0282]** The product of Step 1 (55 g) and acetic anhydride (300 m) was mixed and refluxed in a reaction flask for 1 hour.. The acetic anhydride was removed from the reaction mixture by vacuum evaporation and 55 grams of oil was obtained as the product. It was used directly in the next step.

## Step 3

**[0283]** To a reaction flask containing the 55 grams of oil obtained from Step 2 was added methanol (300 mL) and HCl (12 N, 1 ml). The mixture was refluxed for four hours. Methanol was removed by vacuum evaporation. The recovered oil was dissolved in methylene chloride, washed with sodium bicarbonate saturated water, dried over magnesium sulfate, concentrated and dried in vacuum. The resulting oil (51 g) was used directly in the next step.

**Step 4**

**[0284]** The product (51 g) from Step 3 was dissolved in 500 ml of anhydrous THF in an oven dried reaction flask. The resulting mixture was stirred at room temperature and 1.6 M toluene/THF (1:1) solution of methyl magnesium bromide (265 ml) was added dropwise. After the addition, the mixture was stirred at room temperature for about 16 hours. The reaction mixture was poured into 2 L of ice water. The pH value of the mixture was adjusted to ~2 using HCl (12 N). Ethyl acetate (500 mL) was added and the resulting organic layer was separated, dried over magnesium sulfate, concentrated and dried in vacuum. The recovered product (50 g of oil) was used directly in the next step.

**Step 5**

**[0285]** The product from Step 4 (50 g) and xylene (300 mL) were added to a reaction flask. p-Toluenesulfonic acid (1 g) was added and the resulting mixture was refluxed for eight hours. Xylene was removed by vacuum evaporation and the resulting oily product was dissolved in ethyl acetate, washed with water, dried over magnesium sulfate and concentrated. A small portion of the product (50 g of oil) contained four naphthol isomers as observed from HPLC. The product (1.8 g) was purified using a CombiFlash<sup>®</sup> Rf from Teledyne ISCO. After separation, three components were obtained. NMR analysis showed the products to have structures consistent with: 2,3-dimethoxy-7,7-dimethyl-7H-benzo[c]fluoren-5-ol (0.32 g); 4-bromo-7,7,9-trimethyl-7H-benzo[c]fluoren-5-ol (0.08 g); and a mixture of isomers (0.36 g) of 10-bromo-3,7,7-trimethyl-7H-benzo[c]fluoren-5-ol and 2-bromo-7,7,9-trimethyl-7H-benzo[c]fluoren-5-ol.

**Step 6**

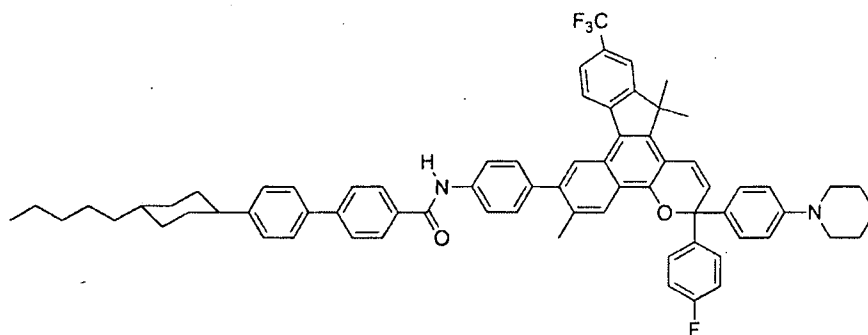
**[0286]** To a reaction flask containing the mixture of isomers from Step 5, (0.36 g) was added 0.27 grams of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol, a few crystals of p-toluenesulfonic acid and methylene chloride(10 ml). The mixture was stirred at room temperature for 18 hours. The formation of a blue dye and a purple dye was observed from TLC. The product was purified using a CombiFlash<sup>®</sup> Rf from Teledyne ISCO. A product (0.5 g) with two isomers as observed from HPLC was obtained. It was used directly in the next step.

**Step 7**

**[0287]** To a reaction flask containing the product from Step 6 (0.5 g) were added: 4-(4-trans-pentylcyclohexyl)phenyl 4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)benzoate (0.39 g); potassium fluoride (0.19 g); dichlorobis(triphenylphosphine)palladium (II) (0.012 g); THF (20 mL) and water (20 mL). The mixture was degassed, protected by nitrogen and heated to reflux for 18 hours. TLC showed the formation of a grey dye and a purple dye. The mixture was extracted

using methylene chloride and water. The organic layer was recovered, isolated, dried over magnesium sulfate and concentrated. The resulting product was purified using CombiFlash<sup>®</sup> Rf from Teledyne ISCO. The grey dye was obtained as a green solid (0.25 g, less polar). The purple dye was obtained as an off-white solid (0.18 g, more polar). NMR analysis showed the less polar grey dye to have a structure consistent with 3,3-bis(4-methoxyphenyl)-7-(4-(4-(trans-4-pentylcyclohexyl)phenoxy)carbonyl)phenyl)-11-methyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 51



## Step 1

**[0288]** Magnesium (3.2 g) and THF (50 ml) were added to a reaction flask. A portion (20 mL) of a mixture of 1-bromo-4-(trifluoromethyl) benzene (30 g) and THF (200 ml) was added to the reaction flask. A few drops of dibromoethane were also added to the flask. After the solvent in the reaction flask started to boil the remainder of the 1-bromo-4-(trifluoromethyl) benzene and THF was added drop wise. Ice water was used occasionally to help the reaction mixture stay at around room temperature. After the addition, the mixture was stirred at room temperature for two hours. 3-bromo-4-methylbenzonitrile (26 g) was then added to the reaction mixture. The resulting mixture was stirred at room temperature over night. 3 N HCl (200 ml) was added and the resulting mixture was stirred for 4 hours. The resulting organic layer was collected, concentrated and passed through a plug column using a mixture of 90/10 (v:v) Hexanes/ethyl acetate. White crystals (19 g) were obtained as the product. NMR showed that the product had a structure consistent with 3-bromo-4-methyl-4'-trifluoromethylbenzophenone.

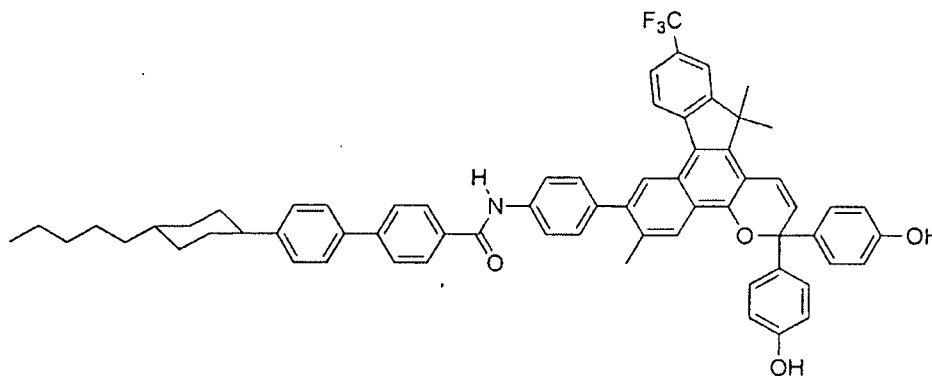
## Step 2

**[0289]** The procedures from Steps 1 to 7 of Example 50 were followed except that in Step 1, 3-bromo-4-methyl-4'-trifluoromethylbenzophenone was used in place of 3-bromo-4'-methylbenzophenone and in Step 6, 1-(4-fluorophenyl)-1-(4-(piperidin-1-yl)phenyl)prop-2-yn-1-



ol was used in place of 1,1-bis(4-methoxyphenyl)prop-2-yn-1-ol and in Step 7, 4'-(4-trans-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-[1,1'-biphenyl]-4-carboxamide was used in place of 4-(4-trans-pentylcyclohexyl)phenyl 4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)benzoate. Two photochromic products were obtained. The desired product was the less polar product as observed on TLC using 20/80 ethyl acetate/hexane. NMR showed that the product had a structure consistent with 3-(4-fluorophenyl)-3-(4-(piperidin-1-yl)phenyl)-6-methyl-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 52



## Step 1

[0290] The procedures from Steps 1 to 3 of Example 50 were followed except that in Step 1, 3-bromo-4-methyl-4'-trifluoromethylbenzophenone was used in place of 3-bromo-4'-methylbenzophenone and the oil product was dissolved in ethyl acetate in an uncovered evaporating dish and left in the functioning hood over the weekend. The crystals that formed were collected and washed with small amounts of ethyl acetate and then diisopropyl ether. NMR analysis showed the crystalline product to have a structure consistent with methyl 7-bromo-4-hydroxy-6-methyl-1-(4-(trifluoromethyl)phenyl)-2-naphthoate.

## Step 2

[0291] The procedures from Steps 4 to 5 of Example 50 were followed except that in Step 4, the product of Step 1 (above) was used in place of the oily mixture. The resulting product was used directly in the next step.

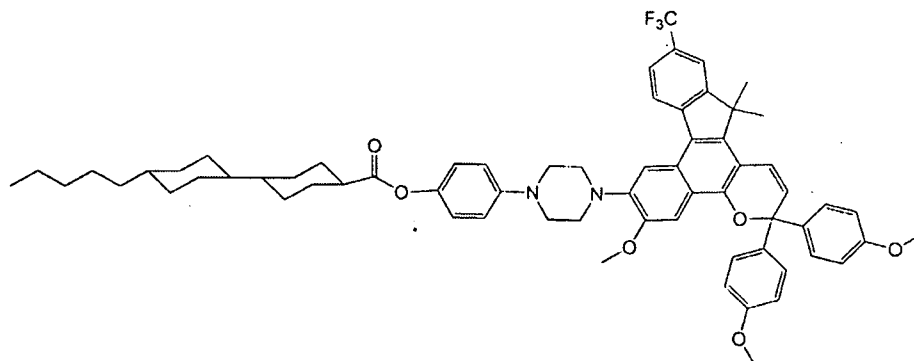
## Step 3

[0292] The product from Step 2 (above) (1 g) was added to a reaction flask. To the flask were added 1,1-bis(4-((tetrahydro-2H-pyran-2-yl)oxy)phenyl)prop-2-yn-1-ol (1 g), p-toluenesulfonic acid (a few crystals) and methylene chloride (10 ml). The mixture was stirred at room temperature for 17 hours. Methanol (20 ml) was added and the resulting mixture was refluxed for one hour. Ethyl acetate (200 ml) and water (100 ml) were added and the recovered organic layer was collected, dried over magnesium sulfate and concentrated. The product was passed through a silica gel plug column using ethyl acetate/hexanes with a gradient ratio from 2/8 to 5/5. A grey solid (0.93 g) was obtained as the product. NMR showed that the product had a structure consistent with 3,3-bis(4-hydroxyphenyl)-6-methyl-7-bromo-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 4

[0293] The procedure from Step 7 of Example 50 was followed except that 3,3-bis(4-hydroxyphenyl)-6-methyl-7-bromo-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran from Step 3 (above) was used in place of the dye mixture and 4'-(4-trans-pentylcyclohexyl)-N-(4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)-[1,1'-biphenyl]-4-carboxamide was used in place of 4-(4-trans-pentylcyclohexyl)phenyl 4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)benzoate. One photochromic product was obtained and was collected by CombiFlash<sup>®</sup> Rf from Teledyne ISCO as a grey solid. NMR showed that the product had a structure consistent with 3,3-bis(4-hydroxyphenyl)-6-methyl-7-(4-(4'-(trans-4-pentylcyclohexyl)-[1,1'-biphenyl]-4-ylcarboxamido)phenyl)-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 53



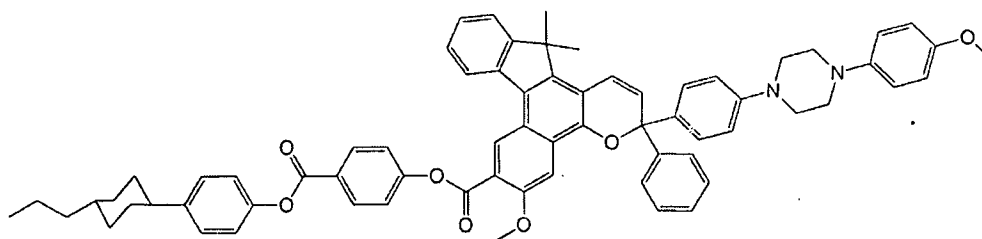
## Step 1

**[0294]** The procedures of Steps 1 to 5 from Example 21 were used except that 4-trifluoromethylbenzoyl chloride was used in place of 3,5-bis(trifluoromethyl)benzoyl chloride. NMR showed that the product had a structure consistent with 2,3-dimethoxy-7,7-dimethyl-9-(trifluoromethyl)-7H-benzo[c]fluoren-5-ol.

## Step 2

**[0295]** The procedures from Example 44 were used except that 2,3-dimethoxy-7,7-dimethyl-9-(trifluoromethyl)-7H-benzo[c]fluoren-5-ol was used in place of 2,3-dimethoxy-7,7-dimethyl-8,10-bis(trifluoromethyl)-7H-benzo[c]fluoren-5-ol in Step 1. NMR showed that the product had a structure consistent with 3,3-bis(4-methoxyphenyl)-6-methoxy-7-(4-(4-(trans,trans-4'-pentyl-[1,1'-bi(cyclohexane)]-4-carboxyloxy)phenyl)piperazin-1-yl)-11-trifluoromethyl-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 54



## Step 1

**[0296]** The procedures from Steps 2 to 8 of Example 21 were followed except that in Step 2, 3,4-dimethoxybenzophenone was used in place of 3,4-dimethoxy-3',5'-bistrifluoromethylbenzophenone. NMR showed that the product had a structure consistent with 3-phenyl-3-(4-(4-methoxyphenyl)piperazin-1-yl)phenyl)-13,13-dimethyl-6-methoxy-7-trifluoromethanesulfonyloxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 2

**[0297]** The product of Step 1, zinc cyanide (1.71 g), zinc acetate (0.1 g), zinc (0.036 g), dimethylformamide (DMF) (40 mL), water (0.4 mL), 1,1'-bis(diphenylphosphino)ferrocene (0.02 g) and tris(dibenzylideneacetone)dipalladium (0.013 g) were added to a reaction flask degassed and stirred under the protection of nitrogen. The reaction flask was kept in an oil bath maintained at a temperature of 90-100 °C. After 12 hours 1,1'-bis(diphenylphosphino)ferrocene (0.05 g) and tris(dibenzylideneacetone)dipalladium (0.032 g) were added. After 24 more hours, the reaction mixture was diluted with ethyl acetate (300 mL), filtered over a thin layer of silica gel

and concentrated. The resulting product was purified by CombiFlash<sup>®</sup> Rf from Teledyne ISCO using 2/8 (v/v) ethyl acetate/hexanes. A green solid (5.6 g) was recovered as the product. An NMR spectrum showed that the product had a structure consistent with 3-phenyl-3-(4-(4-methoxyphenyl)piperazin-1-yl)phenyl)-13,13-dimethyl-6-methoxy-7-cyano-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

### Step 3

**[0298]** The product of Step 2 was added to a reaction flask containing methylene chloride (50 mL) and stirred at -78 °C under the protection of dry nitrogen. Diisobutylaluminium hydride (8.2 mL) was added to the reaction flask in one portion. The reaction was stirred at -78 °C to -10 °C for 2 hours and then quenched with 1 M HCl (10 ml). The resulting mixture was then washed with water, dried over magnesium sulfate and concentrated. The resulting product was purified by CombiFlash<sup>®</sup> Rf from Teledyne ISCO using 3/7 ethyl acetate/hexanes (v/v). A green solid (3.5 g) was recovered as the product. An NMR spectrum showed that the product had a structure consistent with 3-phenyl-3-(4-(4-methoxyphenyl)piperazin-1-yl)phenyl)-13,13-dimethyl-6-methoxy-7-formal-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

### Step 4

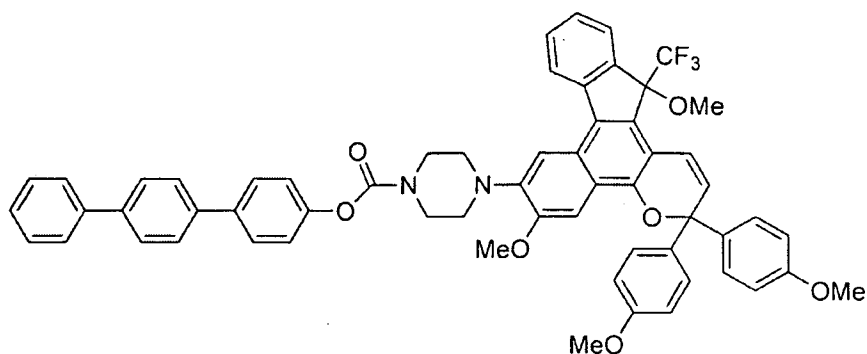
**[0299]** The product of Step 3 (2.86 g), resorcinol (0.54 g), t-butanol (5 g), acetic acid (7 drops) and 1,4-dioxane (10 mL) were added to a reaction flask and maintained at 80°C. Sodium chlorite (0.69 g) in water (2 mL) was added in one portion. The reaction mixture was stirred for 10 minutes, poured into 500 ml cold water at room temperature and the precipitated solid was collected by vacuum filtration. The resulting product was purified by CombiFlash<sup>®</sup> Rf from Teledyne ISCO using 40/1-40/4 (v/v) methylene chloride/acetone blend. An NMR spectrum showed that the recovered yellow solid (1.3 g) had a structure consistent with 3-phenyl-3-(4-(4-methoxyphenyl)piperazin-1-yl)phenyl)-13,13-dimethyl-6-methoxy-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran-7-carboxylic acid.

### Step 5

**[0300]** The product of Step 4 (0.51 g), 4-hydroxybenzoic acid 4-(4-pentyl-trans-cyclohexyl)phenyl ester (0.3 g), dicyclohexyl carbodiimide (0.15 g), 4-(dimethylamino)-pyridine (10 mg) and dichloromethane (5 mL) were added to a reaction flask and stirred at room temperature for 2 hours. A precipitate formed and was removed by filtration and the filtered solution was concentrated and purified by CombiFlash<sup>®</sup> Rf from Teledyne ISCO using 8/2 (v/v) hexanes/ethyl acetate. An NMR spectrum showed that the final product, a green solid (0.30 g), had a structure consistent with 3-(4-(4-methoxyphenyl)piperazin-1-yl)-3-phenyl-6-methoxy-7-(4-

((4-(trans-4-propylcyclohexyl)phenoxy)carbonyl)phenyloxycarbonyl)-13,13-dimethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 55



## Step 1

**[0301]** The procedures of Steps 3 and 4 of Example 13 were followed except that in Step 4, piperazine was used in place of 4-(piperazin-1-yl)phenol. NMR analysis of the product indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-7-piperazine-6,13-trimethoxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 2

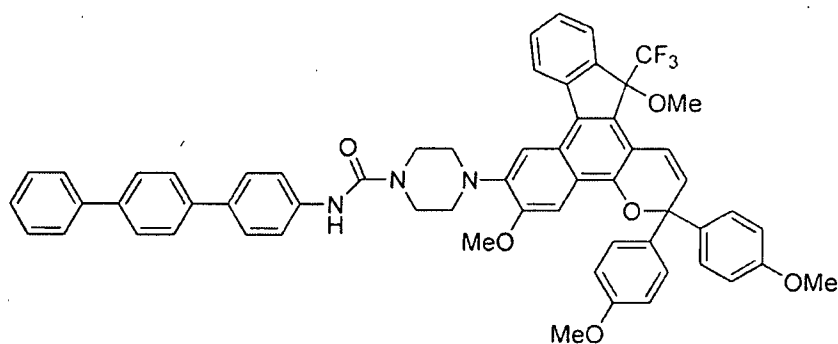
**[0302]** The product from Step 1 of Example 55, 3,3-bis(4-methoxyphenyl)-7-piperazine-6,13-trimethoxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran (3.08 g) was dissolved in dichloromethane (40 mL) in a reaction flask. Pyridine (0.5 mL) was added followed by 4-bromophenyl chloroformate (0.75 mL) and the resulting mixture was stirred for 4 h at room temperature, poured into saturated sodium bicarbonate and stirred for 10 min. The aqueous solution was partitioned three times with ethyl acetate (100 mL) each time. The ethyl acetate extracts were combined, dried with sodium sulfate and concentrated under vacuum to provide an oily residue. The residue was passed through a plug of silica gel and eluted with 4:1 (v:v) hexane ethyl acetate mixture. Fractions containing the desired material were grouped and concentrated to provide a solid (0.8 g). NMR analysis of the solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-7-((4-bromophenyloxycarbonyl))piperazine-6,13-trimethoxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Step 3

**[0303]** The product from Step 2 3,3-bis(4-methoxyphenyl)-7-((4-bromophenyloxycarbonyl))piperazine-6,13-trimethoxy-13-trifluoromethyl-3,13-dihydro-

indeno[2',3':3,4]naphtho[1,2-b]pyran (0.80 g) and 4-biphenylboronic acid (0.25 g) were dissolved in 1,2-dimethoxyethane (20 mL) in a reaction flask. A solution of sodium bicarbonate (0.25 g) in water (3.5 mL) was added and the solution was degassed by bubbling nitrogen for 10 min. Tetrakis(triphenylphosphine) palladium (0) (0.03 g) was added and the solution was heated to reflux for 18 h, cooled to room temperature and filtered through a bed of CELITE<sup>®</sup> filtering aid. The filtrate was collected and concentrated to provide an oily residue. The residue was purified by column chromatography using 4:1 (v:v) hexane:ethyl acetate mixtures as the eluant. Fractions containing the desired material were grouped and concentrated to provide an oil. The oil was dissolved in a minimum amount of dichloromethane and added to vigorously stirred methanol. The resulting precipitate was collected by vacuum filtration and dried to provide a grey colored solid (0.45 g). NMR analysis of the grey solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-7-(4-([1,1':4',1''-terphenyl]-4-ylloxycarbonyl)piperazin-1-yl)-6,13-dimethoxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## EXAMPLE 56



[0304] The procedures from Steps 1 to 3 from Example 55 were followed except that in Step 2, 4-bromophenyl isocyanate was used in place of 4-bromophenyl chloroformate. NMR analysis of the purple solid indicated a structure that was consistent with 3,3-bis(4-methoxyphenyl)-7-(4-([1,1':4',1''-terphenyl]-4-ylcarbamoyl)piperazin-1-yl)-6,13-dimethoxy-13-trifluoromethyl-3,13-dihydro-indeno[2',3':3,4]naphtho[1,2-b]pyran.

## Part 2 – Photochromic Property Testing

### Part 2A – Test Square Preparation

[0305] Testing was done with the compounds described in Examples 1-56, except that Examples 10, 20, 23, 38 & 48 were not tested. Testing was done in the following manner: A

quantity of compound calculated to yield a  $1.5 \times 10^{-3}$  molal solution was added to a flask containing 50 grams of a monomer blend of 4 parts ethoxylated bisphenol A dimethacrylate (BPA 2EO DMA), 1 part poly(ethylene glycol) 600 dimethacrylate, and 0.033 weight percent 2,2'-azobis(2-methyl propionitrile) (AIBN). Each compound was dissolved into the monomer blend by stirring and gentle heating, if necessary. After a clear solution was obtained, the sample was degassed in a vacuum oven for 5-10 minutes at 25 torr. Using a syringe, the sample was poured into a flat sheet mold having an interior dimension of 2.2 mm $\pm$ 0.3 mm  $\times$  6 inch (15.24 cm)  $\times$  6 inch (15.24 cm). The mold was sealed and placed in a horizontal airflow, programmable oven to ramp from 40° C. to 95° C. over a 5 hour interval, hold the temperature at 95° C. for 3 hours, ramp down to 60° C. over a 2 hour interval and then hold at 60° C. for 16 hours. After curing, the mold was opened, and the polymer sheet was cut into 2 inch (5.1 cm) test squares using a diamond blade saw.

#### Part 2B – Response Testing

**[0306]** Prior to response testing on an optical bench, the test squares from Part 2A were conditioned by exposing them to 365 nm ultraviolet light for 10 minutes at a distance of about 14 cm from the source in order to pre-activate the photochromic compounds in samples. The UVA irradiance at the sample surface was measured with a Licor Model Li-1800 spectroradiometer and found to be 22.2 Watts per square meter. The samples were then placed under a halogen lamp (500 W, 120V) for about 10 minutes at a distance of about 36 cm from the lamp in order to bleach, or inactivate, the photochromic compounds in the samples. The illuminance at the sample was measured with the Licor spectroradiometer and found to be 21.9 Klux. The samples were then kept in a dark environment for at least 1 hour prior to testing in order to cool and continue to fade back to a ground state.

**[0307]** The optical bench was fitted with an Newport Model #67005 300-watt Xenon arc lamp, and Model 69911 power supply, Vincent Associates (model VS25S2ZM0R3 with VMM-D4 controller) high-speed computer controlled shutter, a Schott 3 mm KG-2 band-pass filter, which removed short wavelength radiation, neutral density filter(s) to attenuate light from the xenon lamp, a fused silica condensing lens for beam collimation, and a fused silica water cell/sample holder for maintaining sample temperature in which the test sample to be tested was inserted. The temperature in the water cell was controlled with a pumped water circulation system in which the water passed through copper coils that were placed in the reservoir of a chiller unit. The water cell used to hold test samples contained fused silica sheets on the front and back facings in order to eliminate spectral change of the activation or monitoring light beams. The

filtered water passing through the water cell was maintained at 72° F.±2° for photochromic response testing. A Newport Model 689456 Digital Exposure Timer was used to control the intensity of the xenon arc lamp during activation of the sample.

**[0308]** A broadband light source for monitoring response measurements was positioned in a perpendicular manner to a surface of the cell assembly. Increased signal of shorter visible wavelengths was obtained by collecting and combining separately filtered light from a 100-Watt tungsten halogen lamp (controlled by a Lambda UP60-14 constant voltage powder supply) with a split-end, bifurcated fiber optical cable. Light from one side of the tungsten halogen lamp was filtered with a Schott KG1 filter to absorb heat and a Hoya B-440 filter to allow passage of the shorter wavelengths. The other side of the light was either filtered with a Schott KG1 filter or unfiltered. The light was collected by focusing light from each side of the lamp onto a separate end of the split-end, bifurcated fiber optic cable, and subsequently combined into one light source emerging from the single end of the cable. A 4" light pipe was attached to the single end of the cable to insure proper mixing. After passing through the sample, the light was refocused into a 2-inch integrating sphere and fed to an Ocean Optics S2000 spectrophotometer by fiber optic cables. Ocean Optics SpectraSuite and PPG proprietary software were used to measure response and control the operation of the optical bench.

**[0309]** Irradiance for response testing of the samples on the optical bench was established at the sample surface using an International Light Research Radiometer, Model IL-1700 with a detector system comprising a Model SED033 detector, B Filter and diffuser. The output display of the radiometer was corrected (factor values set) against a Licor 1800-02 Optical Calibration Calibrator in order to display values representing Watts per square meter UVA. The irradiance at the sample point for initial response testing was set at to 3.0 Watts per square meter UVA and approximately 8.6 Klux illuminance. During sample response testing, if a sample darkened beyond an acceptable detection capability limit, the irradiance was lowered to 1.0 Watts per square meter UVA or the sample was remade at a one-half concentration in the copolymer. Adjusting the output of the filtered xenon arc lamp was accomplished by increasing or decreasing the current to the lamp through the controller and/or by adding or removing neutral density filters in the light path. The test samples were exposed to the activation light at 31° normal to its surface while being perpendicular to the monitoring light.

**[0310]** Samples were activated in the 73° F(22.8°C) controlled water cell for 30 minutes, then allowed to fade under room light conditions until the change in optical density of the activated sample faded to ¼ of its highest dark (saturated) state or for a maximum of 30 minutes of fade.



**[0311]** Change in optical density ( $\Delta OD$ ) from the bleached state to the darkened state was determined by establishing the initial transmittance, opening the shutter from the Xenon lamp to provide ultraviolet radiation to change the test lens from the bleached state to an activated (i.e., darkened) state. Data was collected at selected intervals of time, measuring the transmittance in the activated state, and calculating the change in optical density according to the formula:  $\Delta OD = \log(\% T_b / \% T_a)$ , where  $\% T_b$  is the percent transmittance in the bleached state,  $\% T_a$  is the percent transmittance in the activated state and the logarithm is to the base 10.

**[0312]** The  $\lambda_{\max\text{-vis}}$  in the visible light range is the wavelength in the visible spectrum at which the maximum absorption of the activated form of the photochromic compound occurs. The  $\lambda_{\max\text{-vis}}$  was determined by testing the photochromic test square in a Varian Cary 4000 UV-Visible spectrophotometer or comparable equipment.

**[0313]** The  $\Delta OD/\text{Min}$ , which represents the sensitivity of the photochromic compound's response to UV light, was measured over the first five (5) seconds of UV exposure, then expressed on a per minute basis. The saturation optical density ( $\Delta OD$  at saturation) was taken under identical conditions except UV exposure was continued for a total of 30 minutes. The fade half life is the time interval in seconds for the  $\Delta OD$  of the activated form of the photochromic compound in the test squares to reach one half the  $\Delta OD$  measured after thirty minutes, or after saturation or near-saturation was achieved, at room temperature after removal of the source of activating light, e.g., by closing the shutter. Results are listed in Table I.

TABLE 1 – Photochromic Performance Test Results

Example #	$\lambda_{\max\text{-vis}}$ (nm)	Sensitivity ( $\Delta OD/\text{Min}$ )	$\Delta OD$ at saturation	T $\frac{1}{2}$ (sec)
1	618	0.29	0.34	88
2	616	0.28	0.34	90
3	580	0.31	0.33	85
4	583	0.28	0.32	90
5	625	0.33	0.35	67
6	581	0.33	0.33	65
7	558	0.12	0.19	185
8	615	0.14	0.17	87
9	607	0.22	0.26	87
11	583	0.28	0.27	61

12	452	0.378	0.425	79
13	487	0.41	0.42	63
14	482	0.44	0.39	57
15	486	0.39	0.41	70
16	479	0.04	0.05	---
17	613	0.41	0.42	63
18	556	0.46	0.43	65
19	580	0.654	0.818	113
21	453	0.378	0.241	35
22	460	0.58	0.36	38
24	453	0.37	0.24	36
25	448	0.59	0.52	76
26	448	0.564	0.496	71
27	448	0.55	0.50	78
28	448	0.55	0.52	80
29	602	0.41	0.37	62
30	603	0.37	0.36	66
31	603	0.51	0.44	64
32	607	0.27	0.16	30
33	596	0.35	0.20	33
34	634	0.40	0.32	44
35	439	0.88	0.72	98
36	426	0.47	0.35	53
37	616	0.36	0.23	30
39	605	0.37	0.29	44
40	561	0.28	0.17	31
41	614	0.28	0.15	25
42	612	0.25	0.14	27
43	580	0.32	0.32	68
44	482	0.70	0.61	55
45	482	0.86	0.46	24

46	455	0.99	1.21	134
47	513	0.35	0.31	51
49	485	0.63	0.59	59
50	574	0.86	0.91	125
51	610	0.50	0.55	78
52	572	0.49	0.43	54
53	477	0.65	1.09	140
54	623	0.53	0.78	173
55	479	0.32	0.32	61
56	483	0.37	0.36	61

Part 3 – Dichroic Property Testing

Part 3A – Liquid Crystal Cell Preparation

**[0314]** The average absorption ratio of each of the compounds of Examples 1- 56 except Examples 10, 12 and 27 was determined according to the CELL METHOD described as follows.

**[0315]** A cell assembly having the following configuration was obtained from Design Concepts, Inc. Each of the cell assemblies was formed from two opposing glass substrates that are spaced apart with a glass bead spacer having a diameter of 20 microns +/- 1 micron. The inner surfaces of each of the glass substrates had oriented polyimide coating thereon to provide for the alignment of a liquid crystal material as discussed below. Two opposing edges of the glass substrates were sealed with an epoxy sealant, leaving the remaining two edges open for filling.

**[0316]** The gap between the two glass substrates of the cell assembly was filled with a liquid crystal solution containing the one of the compounds of the above Examples. The liquid crystal solution was formed by mixing the following components in the weight percents listed below with heating, if necessary, to dissolve the test material.

<u>Material</u>	<u>Weight Percent</u>
Licristal™ E7	97-99.5
Example Compound	0.5-3

### Part 3B – Liquid Crystal Cell Testing

**[0317]** An optical bench was used to measure the optical properties of the cell and derive the absorption ratios for each of the Test Materials. The filled cell assembly was placed on the optical bench with an activating light source (an Oriel Model 66011 300-Watt Xenon arc lamp fitted with a Vincent Associates (model VS25S2ZM0R3 with VMM-D4 controller) high-speed computer controlled shutter that momentarily closed during data collection so that stray light would not interfere with the data collection process, a Schott 3 mm KG-1 band-pass filter, which removed short wavelength radiation, neutral density filter(s) for intensity attenuation and a condensing lens for beam collimation) positioned at a 30° to 35° angle of incidence a surface of the cell assembly.

**[0318]** A broadband light source for monitoring response measurements was positioned in a perpendicular manner to a surface of the cell assembly. Increased signal of shorter visible wavelengths was obtained by collecting and combining separately filtered light from a 100-Watt tungsten halogen lamp (controlled by a Lambda UP60-14 constant voltage powder supply) with a split-end, bifurcated fiber optical cable. Light from one side of the tungsten halogen lamp was filtered with a Schott KG1 filter to absorb heat and a Hoya B-440 filter to allow passage of the shorter wavelengths. The other side of the light was either filtered with a Schott KG1 filter or unfiltered. The light was collected by focusing light from each side of the lamp onto a separate end of the split-end, bifurcated fiber optic cable, and subsequently combined into one light source emerging from the single end of the cable. A 4" light pipe was attached to the single end of the cable to insure proper mixing.

**[0319]** Polarization of the light source was achieved by passing the light from the single end of the cable through a Moxtek, Proflux Polarizer held in a computer driven, motorized rotation stage (Model M-061-PD from Polytech, PI). The monitoring beam was set so that the one polarization plane (0°) was perpendicular to the plane of the optical bench table and the second polarization plane (90°) was parallel to the plane of the optical bench table. The samples were run in air, at room temperature (73° F ± 0.3° F or better (22.8° C ± 0.1°)) maintained by the lab air conditioning system or a temperature controlled air cell.

**[0320]** To conduct the measurements, the cell assembly and the coating stack were exposed to 6.7 W/m<sup>2</sup> of UVA from the activating light source for 5 to 15 minutes to activate the Test Material. An International Light Research Radiometer (Model IL-1700) with a detector system (Model SED033 detector, B Filter, and diffuser) was used to verify exposure prior to each test. Light from the monitoring source that was polarized to the 0° polarization plane was then

passed through the coated sample and focused on a 1" integrating sphere, which was connected to an Ocean Optics S2000 spectrophotometer using a single function fiber optic cable. The spectral information, after passing through the sample, was collected using Ocean Optics SpectraSuite and PPG propriety software. While the photochromic-dichroic material was activated, the position of the polarizer was rotated back and forth to polarize the light from the monitoring light source to the 90° polarization plane and back. Data was collected for approximately 10 to 300 seconds at 5-second intervals during activation. For each test, rotation of the polarizers was adjusted to collect data in the following sequence of polarization planes: 0°, 90°, 90°, 0°, etc.

**[0321]** Absorption spectra were obtained and analyzed for each cell assembly using the Igor Pro software (available from WaveMetrics). The change in the absorbance in each polarization direction for each cell assembly was calculated by subtracting out the 0 time (i.e., unactivated) absorbance measurement for the cell assembly at each wavelength tested. Average absorbance values were obtained in the region of the activation profile where the response of the above Examples was saturated or nearly saturated (i.e., the regions where the measured absorbance did not increase or did not increase significantly over time) for each cell assembly by averaging absorbance at each time interval in this region. The average absorbance values in a predetermined range of wavelengths corresponding  $\lambda_{\text{max-vis}} \pm 5$  nm were extracted for the 0° and 90° polarizations, and the absorption ratio for each wavelength in this range was calculated by dividing the larger average absorbance by the small average absorbance. For each wavelength extracted, 5 to 100 data points were averaged. The average absorption ratio for the Test Material was then calculated by averaging these individual absorption ratios.

**[0322]** For the Examples listed in Table 2 the above-described procedure was run at least twice. The tabled value for the Average Absorption Ratio represents an average of the results obtained from the runs measured at the wavelength indicated. The results of these tests are present in Table 2 below.

TABLE 2 – Absorption Ratio (AR) Test Data

Example #	Wavelength (nm)	Absorption Ratio
1	625	6.35
2	625	6.17

3	580	7.14
4	580	6.78
5	620	5.89
6	580	4.56
7	564	6.83
8	624	5.85
9	610	6.20
11	581	2.65
13	480	7.6
14	480	6.0
15	484	1.48
16	489	7.04
17	611	6.33
18	556	7.13
19	590	6.04
20	608	5.78
21	453	7.01
22	461	6.75
23	453	6.42
24	452	6.51
25	446	7.02
26	446	6.57
28	448	6.58
29	601	6.75

30	602	6.29
31	600	6.46
32	603	6.4
33	604	6.07
34	625	6.05
35	442	6.45
36	541	4.36
37	622	4.42
38	603	3.93
39	600	5.41
40	565	6.23
41	619	5.52
42	619	4.09
43	581	5.56
44	481	5.88
45	485	6.74
46	462	5.21
47	510	4.83
48	481	6.00
49	485	5.98
50	576	7.19
51	475	5.63
52	565	8.50
53	611	6.95

54	625	6.01
55	479	5.6
56	482	6.1

Part 3C – Preparation of Coatings for Aligned Liquid Crystal Coated Substrates

Part 3C-1 – Preparation of Primer

**[0323]** Into a 250 mL amber glass bottle equipped with a magnetic stir-bar following materials were added in the order and amounts indicated:

Polyacrylate polyol (15.2334 g) (Composition D of Example 1 in U.S. Patent 6,187,444, which polyol disclosure is incorporated herein by reference);

Polyalkylenecarbonate diol (40.0000 g) T-5652 from Asahi Kasei Chemicals;

DESMODUR<sup>®</sup> PL 340 (33.7615 g) from Bayer Material Science;

TRIXENE<sup>®</sup> BI 7960 (24.0734 g) from Baxenden);

Polyether modified polydimethylsiloxane (0.0658 g) BYK<sup>®</sup>-333 from BYK-Chemie GmbH);

Urethane catalyst (0.8777 g) KKAT<sup>®</sup> 348 from King Industries;

$\gamma$ -Glycidoxypropyltrimethoxysilane (3.5109 g) A-187 from Momentive Performance Materials;

Light stabilizer (7.8994 g) TINUVIN<sup>®</sup> 928 from Ciba Specialty Chemicals; and

1-Methyl-2-pyrrolidinone (74.8250 g) from Sigma-Aldrich).

**[0324]** The mixture was stirred at room temperature for 2 hrs to yield a solution having 50 weight % final solids based on the total weight of the solution.

Part 3C-2 – Preparation of Alignment Coating Components

**[0325]** The photo-alignment coating component, Staralign 2200CP10 was purchased from Ventico and diluted to 2% solution with cyclopentanone solvent. The rubbed-alignment coating component was a 10 weight percent solution of polyvinyl alcohol (PVA) having a molecular weight of about 61,000 g/mole in water.



Part 3C-3 - Liquid Crystal Coating Components and Formulations

[0326] Liquid crystal monomers (LCM) used for monomer solution include the following:

LCM-1 is 1-(6-(6-(6-(6-(6-(6-(6-(6-(8-(4-(4-(4-(8-acryloyloxyhexylloxy)benzoyloxy)phenyloxycarbonyl)phenoxy)octyloxy)-6-oxohexyloxy)-6-oxohexyloxy)-6-oxohexyloxy)-6-oxohexyloxy)-6-oxohexyloxy)-6-oxohexyloxy)-6-oxohexyloxy)-6-oxohexan-1-ol which was prepared according to the procedures described in Example 17 of U.S. Patent Publication 2009/0323011, which liquid crystal monomer disclosure is incorporated herein by reference.

LCM-2 is commercially available RM257 reported to be 4-(3-acryloyloxypropyloxy)-benzoic acid 2-methyl-1,4-phenylene ester, available from EMD Chemicals, Inc., having the molecular formula of  $C_{33}H_{32}O_{10}$ .

LCM-3 is commercially available RM105 reported to be 4-methoxy-3-methylphenyl 4-(6-(acryloyloxy)hexyloxy)benzoate, available from EMD Chemicals, Inc., having the molecular formula of  $C_{23}H_{26}O_6$ .

LCM-4 is commercially available RM82 reported to be 2-methyl-1,4-phenylene bis(4-(6-(acryloyloxy)hexyloxy)benzoate), available from EMD Chemicals, Inc., having the molecular formula of  $C_{39}H_{44}O_{10}$ .

[0327] Liquid crystal coating formulation (LCCF) was prepared as follows: to a suitable flask containing a mixture of anisole (3.4667 g) and BYK<sup>®</sup>-346 additive (0.0347 g, reported to be a polyether modified poly-dimethyl-siloxane available from BYK Chemie, USA), was added LCM-1 (1.3 g), LCM-2 (1.3 g), LCM-3 (1.3 g), LCM-4 (1.3 g), 4-methoxyphenol (0.0078 g), and IRGACURE<sup>®</sup> 819 (0.078 g, a photoinitiator available from Ciba-Geigy Corporation) and the Example compounds listed in Table 3 at a total concentration of 6.3 mmol per 100 g of LCCF. When the combination of Example 1 and Example 25 were tested together, each was used in a concentration of 3.15 mmol per 100 g of LCCF. The resulting mixture was stirred for 2 hours at 80°C and cooled to about 26°C.

Part 3C-4: Transitional Layer Coating Formulation (TLCF)

[0328] The TLCF was prepared as follows:

In a 50 mL amber glass bottle equipped with a magnetic stir-bar following materials were added:

Hydroxy methacrylate (1.242 g) from Sigma-Aldrich;  
 Neopentyl glycol diacrylate (13.7175 g), SR247 from Sartomer;  
 Trimethylolpropane trimethacrylate (2.5825 g) SR350 from Sartomer;  
 DESMODUR® PL 340 (5.02 g) from Bayer Material Science;  
 IRGACURE®-819 (0.0628 g) from Ciba Speciality Chemicals;  
 DAROCUR® TPO (0.0628 g; from Ciba Speciality Chemicals,  
 Polybutyl acrylate (0.125 g),  
 3-Aminopropylpropyltrimethoxysilane (1.4570 g) A-1100 from Momentive Performance  
 Materials; and  
 200 proof absolute anhydrous Ethanol (1.4570 g) from Pharmaco-Aaper.

The mixture was stirred at room temperature for 2 hrs.

#### Part 3C-5: Protective Coating Formulation (PCF)

[0329] The PCF (Hard Coat) was prepared as follows: Charge 1 was added to a clean dry beaker and placed in an ice bath at 5C with stirring. Charge 2 was added and an exotherm raised the temperature of the reaction mixture to 50C. The temperature of the resulting reaction mixture was cooled to 20-25C and Charge 3 was added with stirring. Charge 4 was added to adjust the pH from about 3 to about 5.5. Charge 5 was added and the solution was mixed for half an hour. The resulting solution was filtered through a nominal 0.45 micron capsule filter and stored at 4°C until use.

#### Charge 1

glycidoxypropyltrimethoxysilane	32.4 grams
methyltrimethoxysilane	345.5 grams

#### Charge 2

Solution of deionized water (DI) with nitric acid (nitric acid 1g/7000g)	292 grams
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#### Charge 3

DOWANOL® PM solvent	228 grams
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#### Charge 4

TMAOH (25% tetramethylammonium hydroxide in methanol)	0.45 grams
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#### Charge 5

BYK®-306 surfactant	2.0 grams
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Part 3C-6 – Procedures Used for Preparing Coating Stacks Reported in Table 3

Part 3C-6A - Substrate Preparation

**[0330]** Square substrates measuring 5.08 cm by 5.08 cm by 0.318 cm (2 inches (in.) by 2 in. by 0.125 in.) prepared from CR-39<sup>®</sup> monomer were obtained from Homalite, Inc. Each substrate prepared from CR-39<sup>®</sup> monomer was cleaned by wiping with a tissue soaked with acetone and dried with a stream of air.

**[0331]** Each of the aforementioned substrates was corona treated by passing on a conveyor belt in Tantec EST Systems Serial No. 020270 Power Generator HV 2000 series corona treatment equipment with a high voltage transformer. The substrates were exposed to corona generated by 53.99 KV, 500 Watts while traveling on a conveyor at a belt speed 3 ft/min.

Part 3C-6B - Coating Procedure for Primer

**[0332]** The primer solution was applied to the test substrates by spin-coating on a portion of the surface of the test substrate by dispensing approximately 1.5 mL of the solution and spinning the substrates at 500 revolutions per minute (rpm) for 3 seconds, followed by 1,500 rpm for 7 seconds, followed by 2,500 rpm for 4 seconds. A spin processor from Laurell Technologies Corp. (WS-400B-6NPP/LITE) was used for spin coating. Afterwards, the coated substrates were placed in an oven maintained at 125° C for 60 minutes. The coated substrates were cooled to about 26° C. The substrate was corona treated by passing on a conveyor belt in Tantec EST Systems Serial No. 020270 Power Generator HV 2000 series corona treatment equipment with a high voltage transformer. The dried primer layer were exposed to corona generated by 53.00 KV, 500 Watts while traveling on a conveyor at a belt speed 3 ft/min.

Part 3C-6C - Coating Procedure for Alignment Materials

**[0333]** The 2wt% Stalalign 2200 solution and the 10wt% PVA solution prepared in Part 3C-2 were individually applied to the test substrates by spin-coating on a portion of the surface of the test substrate by dispensing approximately 1.0 mL of the solution and spinning the substrates at 800 revolutions per minute (rpm) for 3 seconds, followed by 1,000 rpm for 7 seconds, followed by 4,000 rpm for 4 seconds. A spin processor from Laurell Technologies Corp. (WS-400B-6NPP/LITE) was used for spin coating. Afterwards, the coated substrates were placed in an oven maintained at 120° C for 30 minutes. The coated substrates were cooled to about 26°C.

**[0334]** The dried photo-alignment layer (PAL) on each of the substrates was at least partially ordered by exposure to linearly polarized ultraviolet radiation using a DYMAX<sup>®</sup> UVC-6 UV/conveyor system by DYMAX<sup>®</sup> Corp. having a 400 Watt power supply. The light source was

oriented such that the radiation was linearly polarized in a plane perpendicular to the surface of the substrate. The amount of ultraviolet radiation that each photoalignment layer was exposed to was measured using a UV Power Puck™ High energy radiometer from EIT Inc (Serial No. 2066) and was as follows: UVA 0.121W/cm<sup>2</sup> and 5.857 J/cm<sup>2</sup>; UVB 0.013 W/cm<sup>2</sup> and 0.072 J/cm<sup>2</sup>; UVC 0 W/cm<sup>2</sup> and 0 J/cm<sup>2</sup>; and UVV 0.041 W/cm<sup>2</sup> and 1.978 J/cm<sup>2</sup>. After ordering at least a portion of the photo-orientable polymer network, the substrates were cooled to about 26° C and kept covered.

**[0335]** The dried rubbed-alignment layer (R-AL) on each of the substrates was at least partially ordered by rubbing the surface of the coating with velvet material attached to a handle in one direction at least once. An air stream was applied to the rubbed surface to remove any dust or debris from the process.

#### Part 3C-6D – Coating Procedure for Liquid Crystal Coating Formulations

**[0336]** The Liquid Crystal Coating Formulations (“LCCF”) described in Part 3C-3 were each spin coated at a rate of 300 revolutions per minute (rpm) for 6 seconds, followed by 800rpm for 6 seconds onto the at least partially ordered alignment materials of Part 3C-6C on the test substrates. Each coated square substrate was placed in an oven at 50°C for 20 minutes and each coated lens was placed in an oven at 50°C for 30 minutes. Afterwards substrates were cured under an ultraviolet lamp in the Irradiation Chamber BS-03 from Dr. Gröbel UV-Elektronik GmbH in a nitrogen atmosphere for 30 minutes at a peak intensity of 11-16 Watts/m<sup>2</sup> of UVA. Post curing of the coated substrates was completed at 105°C for 3 hours.

#### Part 3C-6E – Coating Procedure for Transitional Layer

**[0337]** The Transitional layer solution prepared in Part 3C-4 was spin coated at a rate of 1,400 revolutions per minute (rpm) for 7 seconds onto the cured LCCF coated substrates. Afterwards, the lenses were cured under an ultraviolet lamp in the Irradiation Chamber BS-03 from Dr. Dr. Gröbel UV-Elektronik GmbH in a nitrogen atmosphere for 30 minutes at a peak intensity of 11-16 Watts/m<sup>2</sup> of UVA. Post curing of the coated substrates was completed at 105°C for 3 hours.

#### Part 3C-6F – Coating Procedure for the Protective Coating (Hard Coat)

**[0338]** The hard coat solution prepared in Part 3C-5 was spin coated at a rate of 2,000 revolutions per minute (rpm) for 10 seconds onto the cured tie layer coated substrates. Post curing of the coated substrates was completed at 105°C for 3 hours.

[0339] The absorption ratios (AR) for the different coating stacks prepared with the Examples of the present invention in the liquid crystal coating formulation (LCCF) is reported in Table 3. The Examples were formulated into the LCCF and applied to alignment layers that were either photo-aligned layers (PAL) or rubbed-aligned layers (R-AL). Other coatings were applied to the substrate and/or the LCCF layer. An "x" in Table 3 indicates that the coating was present in the stack of coatings on the substrates. The absorption ratios were determined for each coating stack. The low AR reported for Example 30 having a R-AL, Transition Layer and Hard Coat may be due to poor alignment of the example on the rubbed pva coating.

Table 3 – Absorption Ratio Results for Different Coating Stacks

Example # in LCCF	Primer	Alignment Layer	Transition Layer	Hard Coat	AR
1		PAL			4.21
3		PAL			4.82
4		PAL			4.65
4		PAL	x		4.64
4	x	PAL			5.17
4	x	PAL	x		4.99
4		R-AL			4.81
4		R-AL	x		4.89
5		PAL			3.22
5	x	PAL			3.46
5	x	PAL	x		3.30
13		PAL			4.9
20		PAL			5.45
22		PAL			5.07
22		PAL	x		4.90
22		R-AL			4.59
22		R-AL	x		4.57
23		PAL			4.04
24		PAL			3.07
24	x	PAL			3.05
26		PAL			4.13

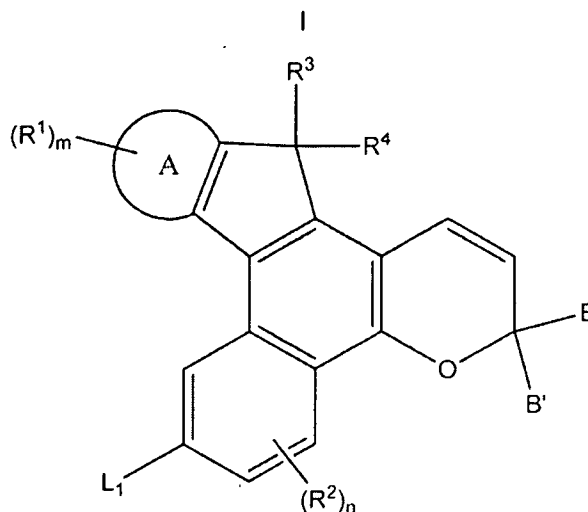
29		PAL			4.21
29		PAL	x		4.03
29		R-AL			4.08
29		R-AL	x		4.00
30		PAL			5.01
30		PAL	x		4.90
30		PAL	x	x	4.85
30		R-AL			4.80
30		R-AL	x	x	0.56
32		PAL			3.54
32	x	PAL			3.88
33		PAL			4.45
33		PAL	x	x	4.33
33	x	PAL			4.74
35		PAL			4.98
35		PAL	x		5.05
35		R-AL			4.78
35		R-AL	x	x	4.73
40		PAL			3.37
40	x	PAL			3.73
40	x	PAL		x	3.76
42		PAL			3.4
43		PAL			4.1
46		PAL			4.01
46	x	PAL			4.00
46	x	PAL		x	3.80
47		PAL			3.66
53		PAL			3.48
1 & 25	x	PAL			3.89

[0340] The present invention has been described with reference to specific details of particular embodiments thereof. It is not intended that such details be regarded as limitations upon the

scope of the invention except insofar as to the extent that they are included in the accompanying claims.

## WHAT IS CLAIMED IS:

1. A compound represented by the following Formula I,



wherein,

(A) Ring-A is selected from unsubstituted aryl, substituted aryl, unsubstituted fused ring aryl, substituted fused ring aryl, unsubstituted heteroaryl, and substituted heteroaryl;

(B) (i) m is selected from 0 to a total number of positions to which R<sup>1</sup> can be bonded to Ring-A, and R<sup>1</sup>, for each m, is independently selected from, L<sub>2</sub> as described hereinafter, and a chiral or achiral group selected from formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxy carbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkyloxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino, and

(ii) n is selected from 0 to 3, and R<sup>2</sup>, for each n, is independently a chiral or achiral group selected from, formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxy carbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkyloxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted



aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino;

(C)  $R^3$  and  $R^4$  are each independently selected from, hydrogen, hydroxyl, and a chiral or achiral group selected from optionally substituted heteroalkyl, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, optionally substituted heterocycloalkyl, halogen, optionally substituted amino, carboxy, alkylcarbonyl, alkoxycarbonyl, optionally substituted alkoxy, and aminocarbonyl, or

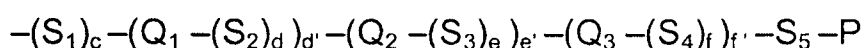
one of  $R^3$  and  $R^4$  is a bond, one of  $R^3$  and  $R^4$  is oxygen, and  $R^3$  and  $R^4$  together form oxo, or

$R^3$  and  $R^4$  together with any intervening atoms form a group selected from optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl;

(D) B and B' are each independently selected from hydrogen,  $L_3$  as described hereinafter, halogen, and a chiral or achiral group selected from metallocenyl, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, optionally substituted heteroalkyl, optionally substituted alkoxy, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted heterocycloalkyl, and optionally substituted cycloalkyl, or B and B' taken together with any intervening atoms form a group selected from optionally substituted cycloalkyl and optionally substituted heterocycloalkyl; and

(E)  $L_1$ ,  $L_2$  and  $L_3$  are each independently selected from a chiral or achiral lengthening group represented by the following Formula II,

II



wherein,

(i)  $Q_1$ ,  $Q_2$ , and  $Q_3$  are each independently for each occurrence a divalent group chosen from, an unsubstituted or a substituted aromatic group, an unsubstituted or a substituted alicyclic group, and an unsubstituted or a substituted heterocyclic group, wherein each substituent is independently chosen from, a group represented by P, liquid crystal mesogens, halogen, poly( $C_1$ - $C_{18}$  alkoxy),  $C_1$ - $C_{18}$  alkoxycarbonyl,  $C_1$ - $C_{18}$  alkylcarbonyl,  $C_1$ - $C_{18}$  alkoxycarbonyloxy, aryloxycarbonyloxy, perfluoro( $C_1$ - $C_{18}$ )alkoxy, perfluoro( $C_1$ - $C_{18}$ )alkoxycarbonyl, perfluoro( $C_1$ - $C_{18}$ )alkylcarbonyl, perfluoro( $C_1$ - $C_{18}$ )alkylamino, di-(perfluoro( $C_1$ - $C_{18}$ )alkyl)amino, perfluoro( $C_1$ - $C_{18}$ )alkylthio,  $C_1$ - $C_{18}$  alkylthio,  $C_1$ - $C_{18}$  acetyl,  $C_3$ - $C_{10}$  cycloalkyl,  $C_3$ - $C_{10}$  cycloalkoxy, a straight-chain or branched  $C_1$ - $C_{18}$  alkyl group that is mono-substituted with cyano, halo, or  $C_1$ - $C_{18}$  alkoxy, or poly-substituted

with halo, and a group comprising one of the following formulae:  $-M(T)_{(t-1)}$  and  $-M(OT)_{(t-1)}$ , wherein M is chosen from aluminum, antimony, tantalum, titanium, zirconium and silicon, T is chosen from organofunctional radicals, organofunctional hydrocarbon radicals, aliphatic hydrocarbon radicals and aromatic hydrocarbon radicals, and t is the valence of M,

(ii) c, d, e, and f are each independently an integer selected from 0 to 20, inclusive; and  $S_1$ ,  $S_2$ ,  $S_3$ ,  $S_4$ , and  $S_5$  are each independently for each occurrence a spacer unit chosen from:

(1)  $-(CH_2)_g-$ ,  $-(CF_2)_h-$ ,  $-Si(Z)_2(CH_2)_g-$ ,  $-(Si(CH_3)_2O)_h-$ , wherein Z is independently chosen for each occurrence from hydrogen,  $C_1$ - $C_{18}$  alkyl,  $C_3$ - $C_{10}$  cycloalkyl and aryl; g is independently chosen for each occurrence from 1 to 20; h is a whole number from 1 to 16 inclusive;

(2)  $-N(Z)-$ ,  $-C(Z)=C(Z)-$ ,  $-C(Z)=N-$ ,  $-C(Z')-C(Z')-$  or a single bond, wherein Z is independently chosen for each occurrence from hydrogen,  $C_1$ - $C_{18}$  alkyl,  $C_3$ - $C_{10}$  cycloalkyl and aryl, and Z' is independently chosen for each occurrence from  $C_1$ - $C_{18}$  alkyl,  $C_3$ - $C_{10}$  cycloalkyl and aryl; and

(3)  $-O-$ ,  $-C(O)-$ ,  $-C\equiv C-$ ,  $-N=N-$ ,  $-S-$ ,  $-S(O)-$ ,  $-S(O)(O)-$ ,  $-(O)S(O)-$ ,  $-(O)S(O)O-$ ,  $-O(O)S(O)O-$ , or straight-chain or branched  $C_1$ - $C_{24}$  alkylene residue, said  $C_1$ - $C_{24}$  alkylene residue being unsubstituted, mono-substituted by cyano or halo, or poly-substituted by halo,

provided that when two spacer units comprising heteroatoms are linked together the spacer units are linked so that heteroatoms are not directly linked to each other, and

provided that when  $S_1$  is linked to Formula I and  $S_5$  is linked to P,  $S_1$  and  $S_5$  are each linked so that two heteroatoms are not directly linked to each other;

(iii) P is chosen from: hydroxy, amino,  $C_2$ - $C_{18}$  alkenyl,  $C_2$ - $C_{18}$  alkynyl, azido, silyl, siloxy, silylhydride, (tetrahydro-2H-pyran-2-yl)oxy, thio, isocyanato, thioisocyanato, acryloyloxy, methacryloyloxy, 2-(acryloyloxy)ethylcarbonyl, 2-(methacryloyloxy)ethylcarbonyl, aziridinyl, allyloxycarbonyloxy, epoxy, carboxylic acid, carboxylic ester, acryloylamino, methacryloylamino, aminocarbonyl,  $C_1$ - $C_{18}$  alkyl aminocarbonyl, aminocarbonyl( $C_1$ - $C_{18}$ )alkyl,  $C_1$ - $C_{18}$  alkyloxycarbonyloxy, halocarbonyl, hydrogen, aryl, hydroxy( $C_1$ - $C_{18}$ )alkyl,  $C_1$ - $C_{18}$  alkyl,  $C_1$ - $C_{18}$  alkoxy, amino( $C_1$ - $C_{18}$ )alkyl,  $C_1$ - $C_{18}$  alkylamino, di-( $C_1$ - $C_{18}$ )alkylamino,  $C_1$ - $C_{18}$  alkyl( $C_1$ - $C_{18}$ )alkoxy,  $C_1$ - $C_{18}$  alkoxy( $C_1$ - $C_{18}$ )alkoxy, nitro, poly( $C_1$ - $C_{18}$ )alkyl ether, ( $C_1$ - $C_{18}$ )alkyl( $C_1$ - $C_{18}$ )alkoxy( $C_1$ - $C_{18}$ )alkyl, polyethyleneoxy, polypropyleneoxy, ethylenyl, acryloyl, acryloyloxy( $C_1$ - $C_{18}$ )alkyl, methacryloyl, methacryloyloxy( $C_1$ - $C_{18}$ )alkyl, 2-chloroacryloyl, 2-phenylacryloyl, acryloyloxyphenyl, 2-chloroacryloylamino, 2-phenylacryloylamino, oxetanyl, glycidyl,

cyano, isocyanato(C<sub>1</sub>-C<sub>18</sub>)alkyl, itaconic acid ester, vinyl ether, vinyl ester, a styrene derivative, main-chain and side-chain liquid crystal polymers, siloxane derivatives, ethyleneimine derivatives, maleic acid derivatives, fumaric acid derivatives, unsubstituted cinnamic acid derivatives, cinnamic acid derivatives that are substituted with at least one of methyl, methoxy, cyano and halogen, or substituted or unsubstituted chiral or non-chiral monovalent or divalent groups chosen from steroid radicals, terpenoid radicals, alkaloid radicals and mixtures thereof, wherein the substituents are independently chosen from C<sub>1</sub>-C<sub>18</sub> alkyl, C<sub>1</sub>-C<sub>18</sub> alkoxy, amino, C<sub>3</sub>-C<sub>10</sub> cycloalkyl, C<sub>1</sub>-C<sub>18</sub> alkyl(C<sub>1</sub>-C<sub>18</sub>)alkoxy, fluoro(C<sub>1</sub>-C<sub>18</sub>)alkyl, cyano, cyano(C<sub>1</sub>-C<sub>18</sub>)alkyl, cyano(C<sub>1</sub>-C<sub>18</sub>)alkoxy or mixtures thereof, or P is a structure having from 2 to 4 reactive groups, or P is an unsubstituted or substituted ring opening metathesis polymerization precursor, or P is a substituted or unsubstituted photochromic compound; and

(iv) d', e' and f' are each independently chosen from 0, 1, 2, 3, and 4, provided that a sum of d' + e' + f' is at least 2.

2. The compound of claim 1, wherein,

(A) Ring-A is selected from unsubstituted aryl and substituted aryl;

(B) (i) R<sup>1</sup>, for each m, is independently selected from, L<sub>2</sub>, formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl and optionally substituted amino, and

(ii) R<sup>2</sup>, for each n, is independently selected from, formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl and optionally substituted amino;

(C) R<sup>3</sup> and R<sup>4</sup> are each independently selected from, hydrogen, hydroxy, and chiral and achiral groups selected from optionally substituted heteroalkyl, optionally substituted alkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, halogen, optionally substituted amino, carboxy, alkylcarbonyl, alkoxy carbonyl, optionally substituted alkoxy, and aminocarbonyl, or

one of R<sup>3</sup> and R<sup>4</sup> is a bond, one of R<sup>3</sup> and R<sup>4</sup> is oxygen, and R<sup>3</sup> and R<sup>4</sup> together form oxo, or

$R^3$  and  $R^4$  together with any intervening atoms form a group selected from optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl;

(D) B and B' are each independently selected from  $L_3$ , hydrogen, halogen, chiral or achiral groups selected from optionally substituted alkyl, optionally substituted alkenyl, optionally substituted heteroalkyl, optionally substituted alkoxy, optionally substituted aryl, optionally substituted heteroaryl, and optionally substituted cycloalkyl, or B and B' taken together with any intervening atoms form a group selected from optionally substituted cycloalkyl and optionally substituted heterocycloalkyl; and

(E)  $L_1$ ,  $L_2$  and  $L_3$  are each independently selected from said chiral or achiral lengthening group represented by Formula II, wherein,

(i)  $Q_1$ ,  $Q_2$ , and  $Q_3$  are each independently for each occurrence a divalent group selected from optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl, wherein each substituent is independently selected from,

P, liquid crystal mesogens, halogen, poly( $C_1$ - $C_{12}$  alkoxy),  $C_1$ - $C_{12}$  alkoxy carbonyl,  $C_1$ - $C_{12}$  alkyl carbonyl, perfluoro( $C_1$ - $C_{12}$ )alkoxy, perfluoro( $C_1$ - $C_{12}$ )alkoxy carbonyl, perfluoro( $C_1$ - $C_{12}$ )alkyl carbonyl,  $C_1$ - $C_{18}$  acetyl,  $C_3$ - $C_7$  cycloalkyl,  $C_3$ - $C_7$  cycloalkoxy, straight-chain  $C_1$ - $C_{12}$  alkyl, and branched  $C_1$ - $C_{12}$  alkyl,

wherein said straight-chain  $C_1$ - $C_{12}$  alkyl and branched  $C_1$ - $C_{12}$  alkyl are mono-substituted with a group selected from, halogen, and  $C_1$ - $C_{12}$  alkoxy, or

wherein said straight-chain  $C_1$ - $C_{12}$  alkyl and branched  $C_1$ - $C_{12}$  alkyl are poly-substituted with at least two groups independently selected from halogen;

(ii) c, d, e, and f are each independently an integer chosen from 1 to 10; and  $S_1$ ,  $S_2$ ,  $S_3$ ,  $S_4$ , and  $S_5$  are each independently for each occurrence a spacer unit selected from:

(1) substituted or unsubstituted alkylene, substituted or unsubstituted haloalkylene,  $-\text{Si}(\text{CH}_2)_g-$ , and  $-\text{Si}[(\text{CH}_3)_2\text{O}]_h-$ , wherein g for each occurrence is independently chosen from an integer from 1 to 10; h for each occurrence is independently chosen from an integer from 1 to 8; and said substitutes for the alkylene and haloalkylene are independently selected from  $C_1$ - $C_{12}$  alkyl,  $C_3$ - $C_7$  cycloalkyl and phenyl;

(2)  $-\text{N}(\text{Z})-$ ,  $-\text{C}(\text{Z})=\text{C}(\text{Z})-$ , and a single bond, wherein Z for each occurrence is independently selected from hydrogen,  $C_1$ - $C_{12}$  alkyl,  $C_3$ - $C_7$  cycloalkyl and phenyl; and

(3)  $-\text{O}-$ ,  $-\text{C}(=\text{O})-$ ,  $-\text{C}\equiv\text{C}-$ ,  $-\text{N}=\text{N}-$ ,  $-\text{S}-$ , and  $-\text{S}(=\text{O})-$ ;

provided that when two spacer units comprising heteroatoms are linked together the spacer units are linked so that heteroatoms of the first spacer unit are not directly linked to the heteroatoms of the second spacer unit, and

provided that when  $S_1$  is linked to Formula I and  $S_5$  is linked to P,  $S_1$  and  $S_5$  are each linked so that two heteroatoms are not directly linked to each other;

(iii) P for each occurrence is selected from hydroxy, amino,  $C_2$ - $C_{12}$  alkenyl,  $C_2$ - $C_{12}$  alkenyl, silyl, siloxy, (tetrahydro-2H-pyran-2-yl)oxy, isocyanato, acryloyloxy, methacryloyloxy, epoxy, carboxylic acid, carboxylic ester,  $C_1$ - $C_{12}$  alkyloxycarbonyloxy, halocarbonyl, hydrogen, aryl, hydroxy( $C_1$ - $C_{12}$ )alkyl,  $C_1$ - $C_{12}$  alkyl,  $C_1$ - $C_{12}$  alkoxy, ethylene, acryloyl, acryloyloxy( $C_1$ - $C_{12}$ )alkyl, methacryloyl, methacryloyloxy( $C_1$ - $C_{12}$ )alkyl, oxetanyl, glycidyl, vinyl ether, siloxane derivatives, unsubstituted cinnamic acid derivatives, cinnamic acid derivatives that are substituted with at least one of methyl, methoxy, cyano and halogen, and substituted or unsubstituted chiral or non-chiral monovalent or divalent groups chosen from steroid radicals, wherein each substituent is independently chosen from  $C_1$ - $C_{12}$  alkyl,  $C_1$ - $C_{12}$  alkoxy, amino,  $C_3$ - $C_7$  cycloalkyl,  $C_1$ - $C_{12}$  alkyl( $C_1$ - $C_{12}$ )alkoxy, or fluoro( $C_1$ - $C_{12}$ )alkyl, or P is a structure having from 2 to 4 reactive groups; and

(iv)  $d'$ ,  $e'$  and  $f'$  are each independently chosen from 0, 1, 2, 3, and 4, provided that a sum of  $d' + e' + f'$  is at least 2.

3. The compound of claim 2, wherein,

(B) (i)  $R^1$ , for each  $m$ , is independently selected from,  $L_2$ , alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heterocycloalkyl and optionally substituted amino, and

(ii)  $R^2$ , for each  $n$ , is independently selected from, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, optionally substituted alkyl, boronic acid ester, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted alkoxy, optionally substituted heterocycloalkyl and optionally substituted amino;

(C)  $R^3$  and  $R^4$  are each independently selected from, hydrogen, hydroxy, and chiral groups selected from optionally substituted heteroalkyl, optionally substituted alkyl, optionally substituted aryl, optionally substituted cycloalkyl, halogen, carboxy, alkylcarbonyl, alkoxy carbonyl, optionally substituted alkoxy, and aminocarbonyl, or

one of R<sup>3</sup> and R<sup>4</sup> is a bond, one of R<sup>3</sup> and R<sup>4</sup> is oxygen, and R<sup>3</sup> and R<sup>4</sup> together form oxo, or

R<sup>3</sup> and R<sup>4</sup> together with any intervening atoms form optionally substituted cycloalkyl;

(D) B and B' are each independently selected from L<sub>3</sub>, hydrogen, chiral groups selected from optionally substituted alkyl, optionally substituted alkenyl, optionally substituted aryl, optionally substituted heteroaryl, and optionally substituted cycloalkyl, or wherein B and B' are taken together with any intervening atoms to form a group selected from optionally substituted cycloalkyl; and

(E) L<sub>1</sub>, L<sub>2</sub> and L<sub>3</sub> are each independently selected from said chiral or achiral lengthening group represented by Formula II, wherein,

(i) Q<sub>1</sub>, Q<sub>2</sub>, and Q<sub>3</sub> are each independently for each occurrence a divalent group selected from optionally substituted aryl, optionally substituted heteroaryl, optionally substituted cycloalkyl, and optionally substituted heterocycloalkyl, wherein each substituent is independently selected from,

P, C<sub>1</sub>-C<sub>6</sub> alkoxy, carbonyl, perfluoro(C<sub>1</sub>-C<sub>6</sub>)alkoxy, C<sub>3</sub>-C<sub>7</sub> cycloalkyl, C<sub>3</sub>-C<sub>7</sub> cycloalkoxy, straight-chain C<sub>1</sub>-C<sub>6</sub> alkyl, and branched C<sub>1</sub>-C<sub>6</sub> alkyl,

wherein said straight-chain C<sub>1</sub>-C<sub>6</sub> alkyl and branched C<sub>1</sub>-C<sub>6</sub> alkyl are mono-substituted with a group selected from halogen and C<sub>1</sub>-C<sub>12</sub> alkoxy, or

wherein said straight-chain C<sub>1</sub>-C<sub>6</sub> alkyl and branched C<sub>1</sub>-C<sub>6</sub> alkyl are poly-substituted with at least two groups independently selected from halogen;

(ii) c, d, e, and f are each independently an integer chosen from 1 to 10; and S<sub>1</sub>, S<sub>2</sub>, S<sub>3</sub>, S<sub>4</sub>, and S<sub>5</sub> are each independently for each occurrence a spacer unit selected from:

(1) substituted or unsubstituted alkylene;

(2) -N(Z)-, -C(Z)=C(Z)-, and a single bond, wherein Z for each occurrence is independently selected from hydrogen and C<sub>1</sub>-C<sub>6</sub> alkyl; and

(3) -O-, -C(=O)-, -C≡C-, and -N=N-, -S-;

provided that when two spacer units comprising heteroatoms are linked together the spacer units are linked so that heteroatoms of the first spacer unit are not directly linked to the heteroatoms of the second spacer unit, and

provided that when S<sub>1</sub> is linked to Formula I and S<sub>5</sub> is linked to P, S<sub>1</sub> and S<sub>5</sub> are each linked so that two heteroatoms are not directly linked to each other;

(iii) P for each occurrence is independently selected from hydroxy, amino, C<sub>2</sub>-C<sub>6</sub> alkenyl, C<sub>2</sub>-C<sub>6</sub> alkenyl, siloxy, (tetrahydro-2H-pyran-2-yl)oxy, isocyanato, acryloyloxy, methacryloyloxy, epoxy, carboxylic acid, carboxylic ester, C<sub>1</sub>-C<sub>6</sub> alkyloxycarbonyloxy, hydrogen, aryl, hydroxy(C<sub>1</sub>-C<sub>6</sub>)alkyl, C<sub>1</sub>-C<sub>6</sub> alkyl, ethylene, acryloyl, acryloyloxy(C<sub>1</sub>-C<sub>12</sub>)alkyl, oxetanyl, glycidyl, vinyl ether, siloxane derivatives, and substituted or unsubstituted chiral or non-chiral monovalent or divalent groups chosen from steroid radicals, wherein each substituent is independently chosen from C<sub>1</sub>-C<sub>6</sub> alkyl, C<sub>1</sub>-C<sub>6</sub> alkoxy, amino, C<sub>3</sub>-C<sub>7</sub> cycloalkyl.

4. The compound of claim 3, wherein,

(B) (i) R<sup>1</sup>, for each m, is independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and CF<sub>3</sub>, and

(ii) R<sup>2</sup>, for each n, is independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and CF<sub>3</sub>;

(C) R<sup>3</sup> and R<sup>4</sup> are each independently selected from, methyl, ethyl, propyl and butyl;

(D) B and B' are each independently selected from phenyl substituted with one or more groups independently selected from aryl, heteroaryl, heterocycloalkyl, alkyl, alkenyl, alkynyl, alkoxy, halogen, amino, alkylcarbonyl, carboxy, and alkoxy carbonyl; and

(E) L<sub>1</sub> is selected from said chiral or achiral lengthening group represented by Formula II, wherein,

(i) Q<sub>1</sub> is unsubstituted aryl,  
Q<sub>2</sub> for each occurrence are each independently chosen from optionally substituted aryl,

Q<sub>3</sub> is optionally substituted cycloalkyl;

(ii) e for each occurrence is 1,

f is 1,

S<sub>3</sub> for each occurrence is a single bond,

S<sub>4</sub> is a single bond, and

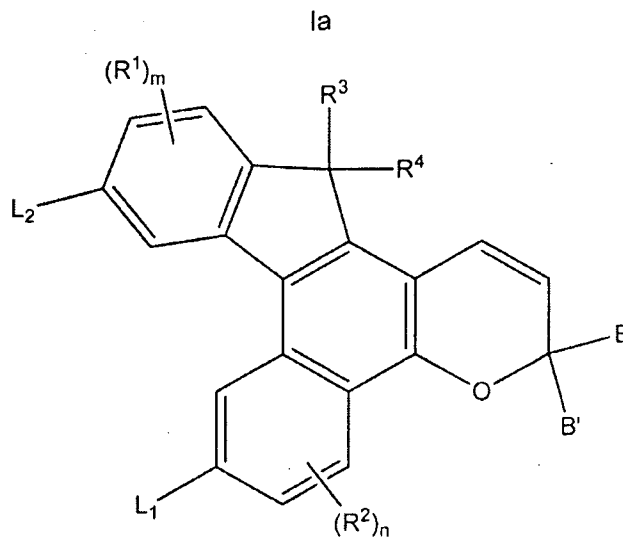
S<sub>5</sub> is -(CH<sub>2</sub>)<sub>g</sub>-, wherein g is from 1 to 20;

(iii) P is hydrogen; and

(iv) e' is 1 or 2, and

f' is 1.

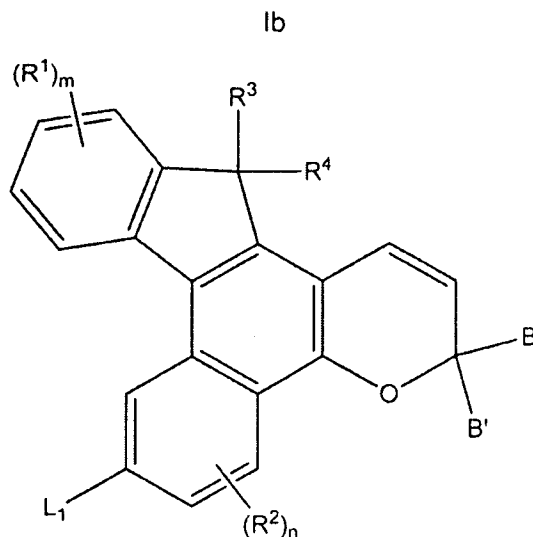
5. The compound of claim 1, wherein said compound is represented by the following Formula Ia,



wherein  $m$  is from 0 to 3, and each  $R^1$  is selected, independently for each  $m$ , from formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxy carbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkoxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino.



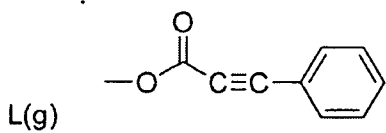
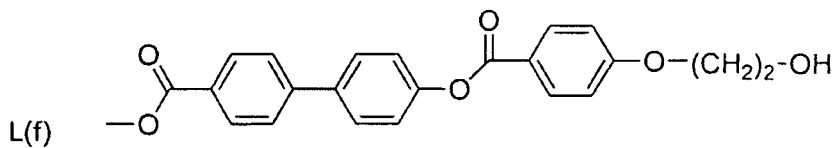
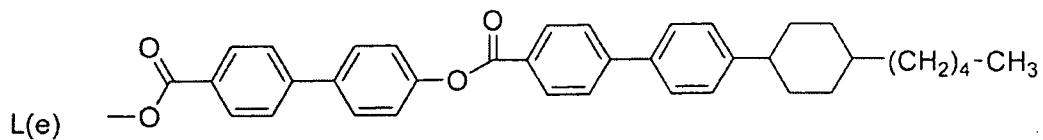
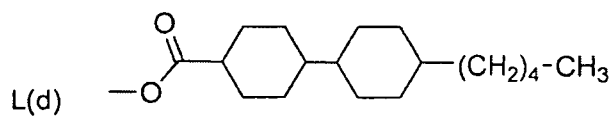
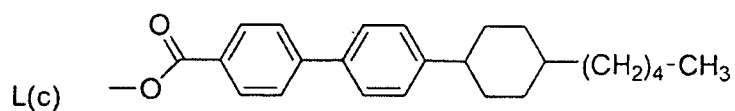
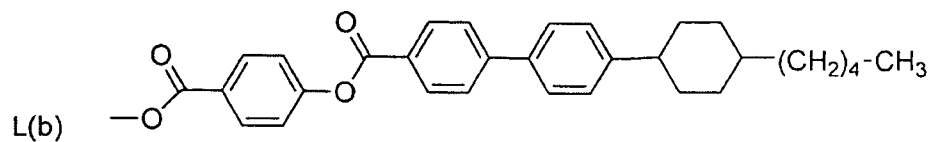
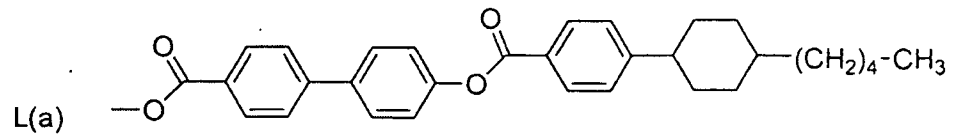
6. The compound of claim 1, wherein said compound is represented by the following Formula Ib,

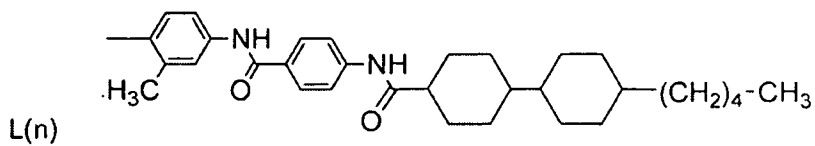
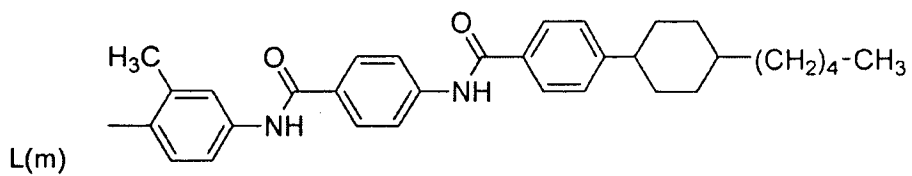
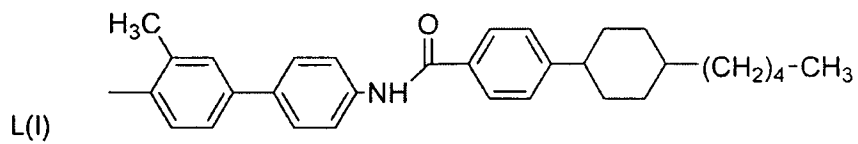
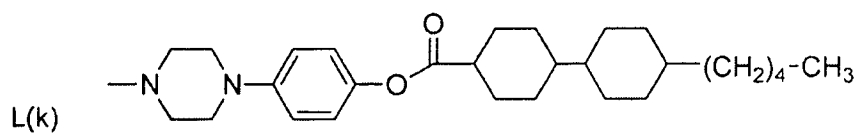
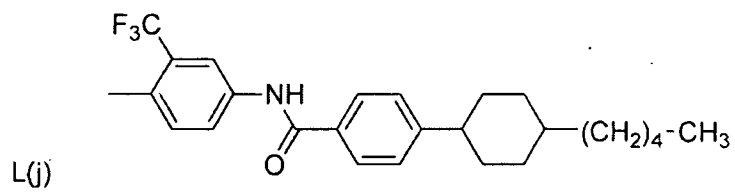
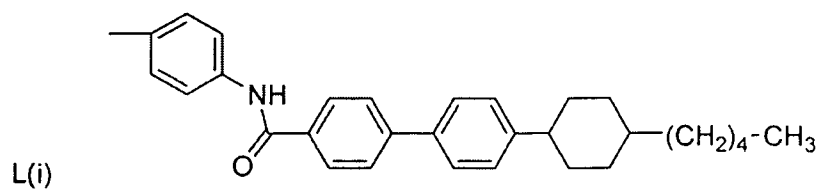
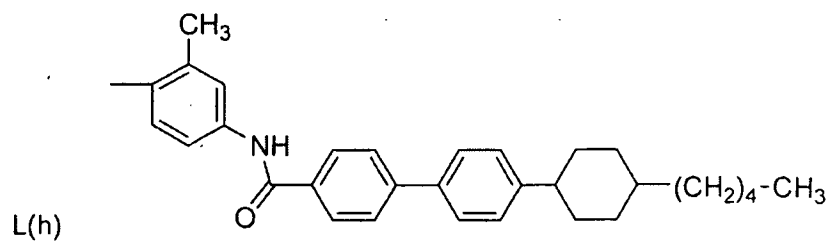


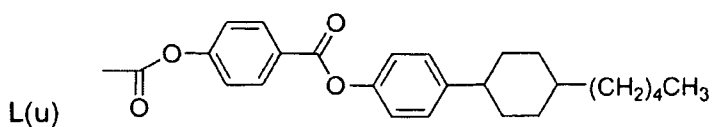
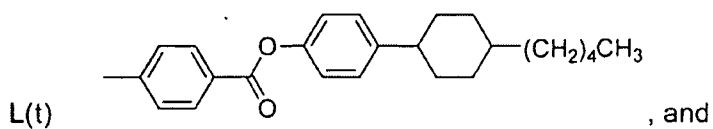
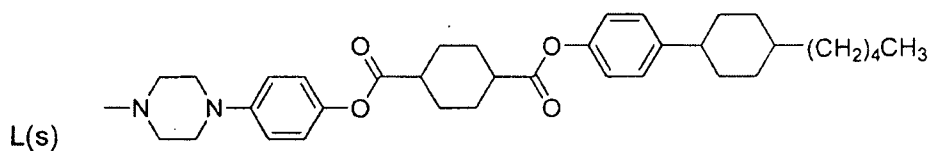
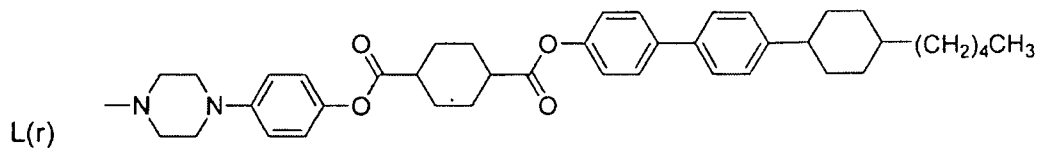
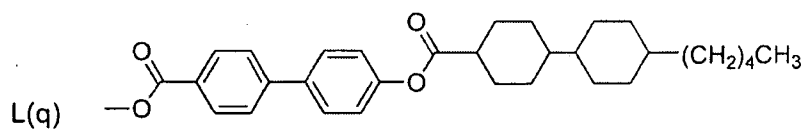
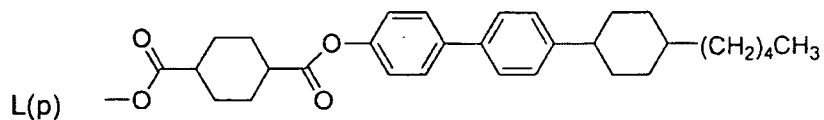
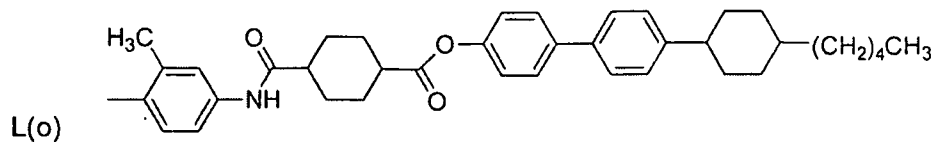
wherein,

- (B) (i)  $m$  is from 0 to 3, and  $R^1$  is selected, independently for each  $m$ , from formyl, alkylcarbonyl, alkoxy carbonyl, aminocarbonyl, arylcarbonyl, aryloxy carbonyl, aminocarbonyloxy, alkoxy carbonylamino, aryloxy carbonylamino, boronic acid, boronic acid esters, cycloalkoxy carbonylamino, heterocycloalkoxy carbonylamino, heteroaryloxy carbonylamino, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, halogen, optionally substituted cycloalkyl, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted alkoxy, optionally substituted heteroalkyl, optionally substituted heterocycloalkyl, and optionally substituted amino; and
- (C)  $B$  and  $B'$  are each independently selected from hydrogen, halogen, and chiral or achiral groups selected from metallocenyl, optionally substituted alkyl, optionally substituted alkenyl, optionally substituted alkynyl, optionally substituted heteroalkyl, optionally substituted alkoxy, optionally substituted aryl, optionally substituted heteroaryl, optionally substituted heterocycloalkyl, and optionally substituted cycloalkyl, or wherein  $B$  and  $B'$  are taken together with any intervening atoms to form a group selected from optionally substituted cycloalkyl and optionally substituted heterocycloalkyl.

7. The compound of claim 6, wherein L<sub>1</sub> is selected from the following formulas,







8. The compound of claim 7, wherein,

(B) (i)  $R^1$ , for each m, is independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and  $CF_3$ , and

(ii)  $R^2$ , for each n, is independently selected from, methyl, ethyl, bromo, chloro, fluoro, methoxy, ethoxy and  $CF_3$ ;

(C) R<sup>3</sup> and R<sup>4</sup> are each independently selected from, methyl, ethyl, propyl and butyl;  
and

(D) B and B' are each independently selected from phenyl substituted with one or more groups independently selected from aryl, heteroaryl, heterocycloalkyl, alkyl, alkenyl, alkynyl, alkoxy, halogen, amino, alkylcarbonyl, carboxy, and alkoxy carbonyl.

9. The compound of claim 1, wherein said compound is a photochromic compound.

10. A photochromic composition comprising the compound of claim 9 and optionally at least one other photochromic compound, wherein said composition comprises:

- (a) a single photochromic compound;
- (b) a mixture of photochromic compounds;
- (c) a material comprising at least one photochromic compound;
- (d) a material to which at least one photochromic compound is chemically bonded;
- (e) material (c) or (d) further comprising a coating to substantially prevent contact of the at least one photochromic compound with external materials;
- (f) a photochromic polymer; or
- (g) mixtures thereof.

11. A photochromic composition comprising at least one compound of claim 9 incorporated into at least a portion of an organic material, said organic material being a polymeric material, an oligomeric material, a monomeric material or a mixture or combination thereof.

12. The photochromic composition of claim 11 wherein said polymeric material comprises liquid crystal materials, self-assembling materials, polycarbonate, polyamide, polyimide, poly(meth)acrylate, polycyclic alkene, polyurethane, poly(urea)urethane, polythiourethane, polythio(urea)urethane, polyol(allyl carbonate), cellulose acetate, cellulose

diacetate, cellulose triacetate, cellulose acetate propionate, cellulose acetate butyrate, polyalkene, polyalkylene-vinyl acetate, poly(vinylacetate), poly(vinyl alcohol), poly(vinyl chloride), poly(vinylformal), poly(vinylacetal), poly(vinylidene chloride), poly(ethylene terephthalate), polyester, polysulfone, polyolefin, copolymers thereof, and/or mixtures thereof.

13. The photochromic composition of claim 11 wherein the photochromic composition further comprises at least one additive chosen from dyes, alignment promoters, antioxidants, kinetic enhancing additives, photoinitiators, thermal initiators, polymerization inhibitors, solvents, light stabilizers, heat stabilizers, mold release agents, rheology control agents, leveling agents, free radical scavengers, gelators and adhesion promoters.

14. The photochromic composition of claim 11 comprising a coating composition chosen from liquid crystal materials, self-assembling materials and film forming materials.

15. A photochromic article comprising a substrate and a photochromic compound according to claim 9 connected to at least a portion of a substrate.

16. The photochromic article of claim 15 comprising an optical element, said optical element being at least one of an ophthalmic element, a display element, a window, a mirror, packaging material and an active or passive liquid crystal cell element.

17. The photochromic article of claim 16, wherein the ophthalmic element comprises corrective lenses, non-corrective lenses, contact lenses, intra-ocular lenses, magnifying lenses, protective lenses, or visors.

18. The photochromic article of claim 15 wherein the substrate comprises a polymeric material and the photochromic material is incorporated into at least a portion of the polymeric material.

19. The photochromic article of claim 18 wherein the photochromic material is blended with at least a portion of the polymeric material, bonded to at least a portion of the polymeric material, and/or imbibed into at least a portion of the polymeric material.

20. The photochromic article of claim 15 wherein the photochromic article comprises a coating or film connected to at least a portion of the substrate, said coating or film comprising the photochromic material.

21. The photochromic article of claim 20 wherein said substrate is formed from organic materials, inorganic materials, or combinations thereof.

22. The photochromic article of claim 15 further comprising at least one additional at least partial coating chosen from photochromic coatings, anti-reflective coatings, linearly polarizing coatings, transitional coatings, primer coatings, adhesive coatings, reflective coatings, antifogging coatings, oxygen barrier coatings, ultraviolet light absorbing coatings, and protective coatings.

23. A photochromic article comprising  
a substrate;  
at least a partial coating of one alignment material;  
at least one additional at least partial coating of a liquid crystal material;  
and  
at least one compound of claim 9.

24. The photochromic article of claim 23 further comprising at least one additive chosen from dichroic dyes, non-dichroic dyes, alignment promoters, antioxidants, kinetic enhancing additives, photoinitiators, thermal initiators, polymerization inhibitors, solvents, light stabilizers, heat stabilizers, mold release agents, rheology control agents, leveling agents, free radical scavengers, gelators and adhesion promoters.

25. The photochromic article of claim 23, wherein the substrate is selected from glass, quartz, and polymeric organic materials.

26. The photochromic article of claim 23, wherein the at least one alignment material comprises a polymer network orientable by exposure to at least one of: a magnetic field, an electric field, linearly polarized infrared radiation, linearly polarized ultraviolet radiation, linearly polarized visible radiation and a shear force.

27. The photochromic article of claim 23, wherein said liquid crystal material is a liquid crystal polymer.

28. The photochromic article of claim 23, further comprising at least one primer coating, transitional coating, protective coating or a combination thereof.

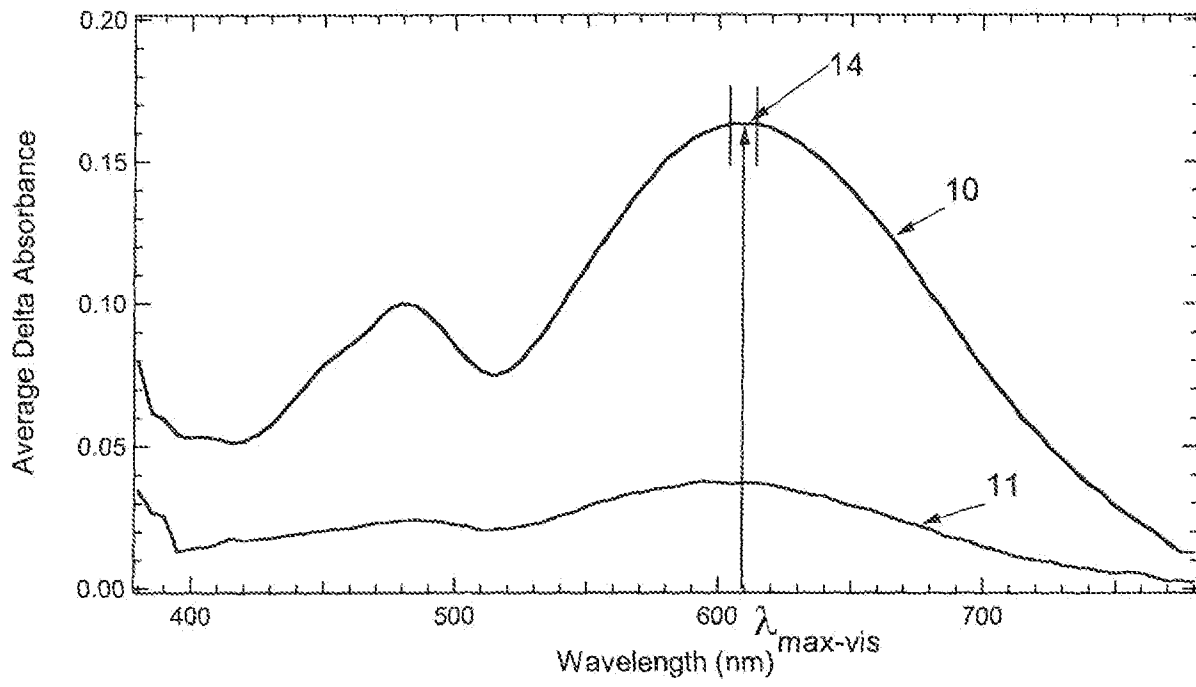
29. The photochromic article of claim 28, wherein the transitional coating comprises an acrylate polymer.

30. The photochromic article of claim 28, wherein the protective coating comprises at least one siloxane derivative.

31. The photochromic article of claim 28, wherein the at least one primer coating comprises a polyurethane.



FIG. 1



# INTERNATIONAL SEARCH REPORT

International application No PCT/US2011/062783
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**A. CLASSIFICATION OF SUBJECT MATTER**  
 INV. G03C1/73 C07D311/94 C09K9/02  
 ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)  
 G03C C07D C09K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2010/014010 A1 (HE ET AL.) 21 January 2010 (2010-01-21) paragraphs [0113] - [0181], [0233] -----	1-4,6-31
A	WO 2005/005570 A1 (TRANSITIONS OPTICAL) 20 January 2005 (2005-01-20) page 64; compounds R,S,T,X,Z claims 8,28,56-69 -----	1-31

Further documents are listed in the continuation of Box C.

See patent family annex.

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Date of the actual completion of the international search

28 December 2011

Date of mailing of the international search report

04/01/2012

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Magrizo, Simeon

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Information on patent family members

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