



(51) International Patent Classification:
C08L 101/12 (2006.01) *H01B 1/12* (2006.01)
C08L 27/12 (2006.01) *C08J 3/02* (2006.01)
C08K 3/00 (2006.01)

(21) International Application Number:
PCT/US2010/031836

(22) International Filing Date:
21 April 2010 (21.04.2010)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
61/171,174 21 April 2009 (21.04.2009) US

(71) Applicant (for all designated States except US): **E. I. DU PONT DE NEMOURS AND COMPANY** [US/US];
1007 Market Street, Wilmington, Delaware 19898 (US).

(72) Inventor; and

(75) Inventor/Applicant (for US only): **HSU, Che-Hsiung**
[US/US]; 4803 Mermaid Boulevard, Wilmington,
Delaware 19808 (US).

(74) Agent: **LAMMING, John, H.**; E. I. du Pont de Nemours
and Company, Legal Patent Records Center, 4417 Lan-
caster Pike, Wilmington, Delaware 19805 (US).

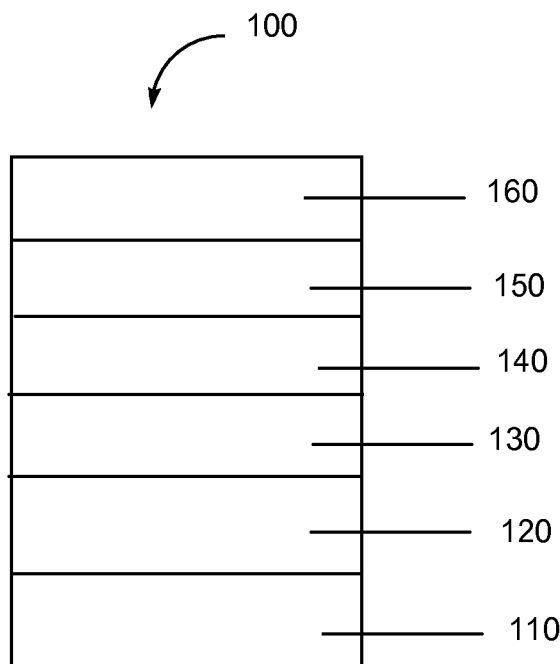
(81) Designated States (unless otherwise indicated, for every
kind of national protection available): AE, AG, AL, AM,
AO, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ,
CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO,
DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT,
HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP,
KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD,
ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI,
NO, NZ, OM, PE, PG, PH, PL, PT, RO, RS, RU, SC, SD,
SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR,
TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every
kind of regional protection available): ARIPO (BW, GH,

[Continued on next page]

(54) Title: ELECTRICALLY CONDUCTIVE POLYMER COMPOSITIONS AND FILMS MADE THEREFROM

FIG. 1



(57) Abstract: The present invention relates to electrically conductive polymer compositions, and their use in electronic devices. The compositions are an aqueous dispersion including: (i) at least one electrically conductive polymer doped with a non-fluorinated polymeric acid; (ii) at least one highly-fluorinated acid polymer; (iii) at least one water-compatible high-boiling organic solvent; and (iv) electrically insulative inorganic oxide nanoparticles.



GM, KE, LR, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— *without international search report and to be republished upon receipt of that report (Rule 48.2(g))*

TITLEELECTRICALLY CONDUCTIVE POLYMER COMPOSITIONS AND
FILMS MADE THEREFROM

5

RELATED APPLICATION

This application claims priority under 35 U.S.C. § 119(e) from Provisional Application No. 61/171,174 filed April 21, 2009 which is incorporated by reference in its entirety.

10

BACKGROUND INFORMATIONField of the Disclosure

This disclosure relates in general to aqueous dispersions of electrically conductive polymers containing solvent and additives, and their use in electronic devices.

15

Description of the Related Art

Electronic devices define a category of products that include an active layer. Organic electronic devices have at least one organic active layer. Such devices convert electrical energy into radiation such as light emitting diodes, detect signals through electronic processes, convert radiation into electrical energy, such as photovoltaic cells, or include one or more organic semiconductor layers.

20

Organic light-emitting diodes (OLEDs) are an organic electronic device comprising an organic layer capable of electroluminescence.

25

OLEDs containing conducting polymers can have the following configuration:

anode/hole injection layer/EL material/cathode

30

with additional layers between the electrodes. The anode is typically any material that has the ability to inject holes into the EL material, such as, for example, indium/tin oxide (ITO). The anode is optionally supported on a glass or plastic substrate. EL materials include fluorescent compounds,

fluorescent and phosphorescent metal complexes, conjugated polymers, and mixtures thereof. The cathode is typically any material (such as, e.g., Ca or Ba) that has the ability to inject electrons into the EL material.

Electrically conducting polymers having low conductivity in the range of 10^{-3} to 10^{-7} S/cm are commonly used as the hole injection layer in direct contact with an electrically conductive, inorganic oxide anode such as ITO.

Electrically conducting polymers which have the ability to carry a high current when subjected to a low electrical voltage, may have utility as electrodes for electronic devices. However, many conductive polymers have conductivities which are too low for use as electrodes such as the anode for OLEDs. Moreover, they generally have a work-function that is too low for effective hole injection as an anode. Having high conductivity and high work-function is also useful as cathode, for example, in Tantalum/Ta₂O₅ or Aluminum/Al₂O₃ capacitors. Furthermore, the mechanical strength of films made from the polymers, either self-standing or on a substrate, may not be sufficient for the electrode applications. In addition, the refractive index of these materials is generally low.

Accordingly, there is a continuing need for improved organic conductive materials.

SUMMARY

There is provided an aqueous dispersion comprising: (i) at least one electrically conductive polymer doped with at least one non-fluorinated polymeric acid; (ii) at least one highly-fluorinated acid polymer; (iii) at least one water-compatible high-boiling organic solvent; and (iv) electrically insulative inorganic oxide nanoparticles.

In another embodiment, there is provided a film formed from the above dispersion.

In another embodiment, electronic devices comprising at least one layer comprising the above film are provided.

BRIEF DESCRIPTION OF THE DRAWINGS

The invention is illustrated by way of example and not limitation in the accompanying figures.

Figure 1 is a schematic diagram of an organic electronic device.

Skilled artisans will appreciate that objects in the figures are illustrated for simplicity and clarity and have not necessarily been drawn to scale. For example, the dimensions of some of the objects in the figures may be exaggerated relative to other objects to help to improve understanding of embodiments.

DETAILED DESCRIPTION

There is provided an aqueous dispersion comprising: (i) at least one electrically conductive polymer doped with at least one non-fluorinated polymeric acid; (ii) at least one highly-fluorinated acid polymer; (iii) at least one water-compatible high-boiling organic solvent, and (iv) electrically insulative inorganic oxide nanoparticles. The above dispersion is referred to herein as the "new composite dispersion".

Many aspects and embodiments are described herein and are merely exemplary and not limiting. After reading this specification, skilled artisans will appreciate that other aspects and embodiments are possible without departing from the scope of the invention.

Other features and benefits of any one or more of the embodiments will be apparent from the following detailed description, and from the claims. The detailed description first addresses Definitions and Clarification of Terms followed by the Doped Electrically Conductive Polymer, the Highly-Fluorinated Acid Polymer, the Solvent, the Electrically Insulative Inorganic Oxide Nanoparticles, Additional Additives, Preparation of the New Composite Dispersion, Hole Injection Layers, Electronic Devices, and finally, Examples.

1. Definitions and Clarification of Terms Used in the Specification and Claims

Before addressing details of embodiments described below, some terms are defined or clarified.

The term "acid polymer" refers to a polymer having acidic groups.

The term "acidic group" refers to a group capable of ionizing to donate a hydrogen ion to a Brønsted base.

The term "aqueous" refers to a liquid that has a significant portion of water, and in one embodiment it is at least about 60% by weight water.

The term "conductive" or "electrically conductive" as it refers to a material, is intended to mean a material which is inherently or intrinsically capable of electrical conductivity without the addition of carbon black or conductive metal particles.

The term "conductor" and its variants are intended to refer to a layer material, member, or structure having an electrical property such that current flows through such layer material, member, or structure without a substantial drop in potential. The term is intended to include semiconductors. In some embodiments, a conductor will form a layer having a conductivity of at least 10^{-1} S/cm.

The term "doped" as it refers to an electrically conductive polymer, is intended to mean that the electrically conductive polymer has a polymeric counterion to balance the charge on the conductive polymer.

The term "doped conductive polymer" is intended to mean the conductive polymer and the polymeric counterion that is associated with it.

The term “electrically insulative” as it refers to inorganic oxide nanoparticles, is intended to mean that the addition of any amount of such nanoparticles to a composition or film does not increase the conductivity of such composition or film.

5 The term “electron transport” means when referring to a layer, material, member or structure, such a layer, material, member or structure that promotes or facilitates migration of negative charges through such a layer, material, member or structure into another layer, material, member or structure.

10 The prefix “fluoro” indicates that one or more available hydrogen atoms have been replaced with a fluorine atom. The terms “fully-fluorinated” and “perfluorinated” are used interchangeably and refer to a compound where all of the available hydrogens bonded to carbon have been replaced by fluorine. The term “highly-fluorinated” refers to a
15 compound in which at least 80% of the available hydrogens bonded to carbon have been replaced by fluorine. Such materials are referred to as being at least 80% fluorinated. The term “non-fluorinated” refers to a compound in which less than 25% of the available hydrogens bonded to carbon have been replaced by fluorine. Such materials are referred to as
20 being less than 25% fluorinated.

 The term “high-boiling” refers to an organic compound which is a liquid at room temperature and has a boiling point of greater than 120°C.

 The term “hole transport” when referring to a layer, material, member, or structure, is intended to mean such layer, material, member,
25 or structure facilitates migration of positive charges through the thickness of such layer, material, member, or structure with relative efficiency and small loss of charge.

 The term “layer” is used interchangeably with the term “film” and refers to a coating covering a desired area. The term is not limited by
30 size. The area can be as large as an entire device or as small as a specific functional area such as the actual visual display, or as small as a single sub-pixel. Layers and films can be formed by any conventional deposition

technique, including vapor deposition, liquid deposition (continuous and discontinuous techniques), and thermal transfer.

The term “nanoparticle” refers to a material having a particle size less than 50 nm at cumulative 50% volume distribution.

5 The term "organic electronic device" is intended to mean a device including one or more semiconductor layers or materials. Organic electronic devices include, but are not limited to: (1) devices that convert electrical energy into radiation (e.g., a light-emitting diode, light emitting diode display, diode laser, or lighting panel), (2) devices that detect signals
10 through electronic processes (e.g., photodetectors photoconductive cells, photoresistors, photoswitches, phototransistors, phototubes, infrared ("IR") detectors, or biosensors), (3) devices that convert radiation into electrical energy (e.g., a photovoltaic device or solar cell), and (4) devices that include one or more electronic components that include one or more
15 organic semiconductor layers (e.g., a transistor or diode).

The term “polar” refers to a molecule that has a permanent electric dipole.

The term “polymer” is intended to mean a material having at least one repeating monomeric unit. The term includes homopolymers having
20 only one kind, or species, of monomeric unit, and copolymers having two or more different monomeric units, including copolymers formed from monomeric units of different species.

The term “semiconductive” is intended to refer to a material having characteristics of a semiconductor; that is having electrical conductivity
25 greater than insulators but less than good conductors.

The term “water-compatible” as it refers to the solvent, is intended to mean that the solvent is soluble in, miscible with, or dispersible in water, to an extent such that a homogeneous mixture is formed.

The term “wetable” as it refers to a film, is intended to mean that an
30 organic solvent will spread evenly across the surface of the film.

The term “work function” is intended to mean the minimum energy needed to remove an electron from a conductive or semiconductive material to a point at infinite distance away from the surface. The work-

function can be obtained by UPS (Ultraviolet Photoemission Spectroscopy), Kelvin-probe contact potential differential measurement, or low intensity X-ray photoemission spectroscopy (LIXPS).

Although light-emitting materials may also have some charge transport properties, the terms "hole transport layer, material, member, or structure" and "electron transport layer, material, member, or structure" are not intended to include a layer, material, member, or structure whose primary function is light emission.

As used herein, the terms "comprises," "comprising," "includes," "including," "has," "having" or any other variation thereof, are intended to cover a non-exclusive inclusion. For example, a process, method, article, or apparatus that comprises a list of elements is not necessarily limited to only those elements but may include other elements not expressly listed or inherent to such process, method, article, or apparatus. Further, unless expressly stated to the contrary, "or" refers to an inclusive or and not to an exclusive or. For example, a condition A or B is satisfied by any one of the following: A is true (or present) and B is false (or not present), A is false (or not present) and B is true (or present), and both A and B are true (or present).

Also, use of "a" or "an" are employed to describe elements and components described herein. This is done merely for convenience and to give a general sense of the scope of the invention. This description should be read to include one or at least one and the singular also includes the plural unless it is obvious that it is meant otherwise.

Group numbers corresponding to columns within the Periodic Table of the elements use the "New Notation" convention as seen in the *CRC Handbook of Chemistry and Physics*, 81st Edition (2000-2001).

Unless otherwise defined, all technical and scientific terms used herein have the same meaning as commonly understood by one of ordinary skill in the art to which this invention belongs. In the Formulae, the letters Q, R, T, W, X, Y, and Z are used to designate atoms or groups which are defined within. All other letters are used to designate conventional atomic symbols. Group numbers corresponding to columns

within the Periodic Table of the elements use the “New Notation” convention as seen in the *CRC Handbook of Chemistry and Physics*, 81st Edition (2000).

To the extent not described herein, many details regarding specific materials, processing acts, and circuits are conventional and may be found in textbooks and other sources within the organic light-emitting diode display, lighting source, photodetector, photovoltaic, and semiconductive member arts.

2. Doped Electrically Conductive Polymers

The doped electrically conductive polymer has a polymeric counterion derived from a non-fluorinated polymeric acid to balance the charge on the conductive polymer.

a. Electrically Conductive Polymer

Any electrically conductive polymer can be used in the new composite dispersion. In some embodiments, the electrically conductive polymer will form a film which has a conductivity greater than 0.1S/cm. Thus, the new composite dispersions described herein can be used to form films having a conductivity greater than 100S/cm.

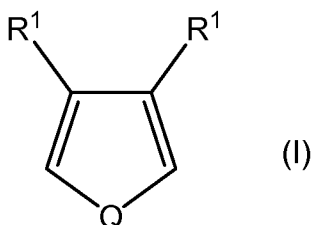
The conductive polymers suitable for the new composite dispersion are made from at least one monomer which, when polymerized alone, forms an electrically conductive homopolymer. Such monomers are referred to herein as “conductive precursor monomers.” Monomers which, when polymerized alone form homopolymers which are not electrically conductive, are referred to as “electrically insulative precursor monomers.” The conductive polymer can be a homopolymer or a copolymer. Conductive copolymers suitable for the new composite dispersion can be made from two or more conductive precursor monomers or from a combination of one or more conductive precursor monomers and one or more electrically insulative precursor monomers.

In some embodiments, the conductive polymer is made from at least one conductive precursor monomer selected from thiophenes, pyrroles, anilines, and polycyclic aromatics. The term “polycyclic

aromatic” refers to compounds having more than one aromatic ring. The rings may be joined by one or more bonds, or they may be fused together. The term “aromatic ring” is intended to include heteroaromatic rings. A “polycyclic heteroaromatic” compound has at least one heteroaromatic ring.

In some embodiments, the conductive polymer is made from at least one precursor monomer selected from thiophenes, selenophenes, tellurophenes, pyrroles, anilines, and polycyclic aromatics. The polymers made from these monomers are referred to herein as polythiophenes, poly(selenophenes), poly(tellurophenes), polypyrroles, polyanilines, and polycyclic aromatic polymers, respectively. The term “polycyclic aromatic” refers to compounds having more than one aromatic ring. The rings may be joined by one or more bonds, or they may be fused together. The term “aromatic ring” is intended to include heteroaromatic rings. A “polycyclic heteroaromatic” compound has at least one heteroaromatic ring. In some embodiments, the polycyclic aromatic polymers are poly(thienothiophenes).

In some embodiments, monomers contemplated for use to form the electrically conductive polymer in the new composite dispersion comprise Formula I below:



wherein:

Q is selected from the group consisting of S, Se, and Te;
R¹ is independently selected so as to be the same or different at each occurrence and is selected from hydrogen, alkyl, alkenyl, alkoxy, alkanoyl, alkythio,

aryloxy, alkylthioalkyl, alkylaryl, arylalkyl, amino,
 alkylamino, dialkylamino, aryl, alkylsulfinyl, alkoxyalkyl,
 alkylsulfonyl, arylthio, arylsulfinyl, alkoxycarbonyl,
 arylsulfonyl, acrylic acid, phosphoric acid, phosphonic
 5 acid, halogen, nitro, cyano, hydroxyl, epoxy, silane,
 siloxane, alcohol, benzyl, carboxylate, ether, ether
 carboxylate, amidosulfonate, ether sulfonate, ester
 sulfonate, and urethane; or both R¹ groups together may
 form an alkylene or alkenylene chain completing a 3, 4, 5,
 10 6, or 7-membered aromatic or alicyclic ring, which ring
 may optionally include one or more divalent nitrogen,
 selenium, tellurium, sulfur or oxygen atoms.

As used herein, the term "alkyl" refers to a group derived from an
 aliphatic hydrocarbon and includes linear, branched and cyclic groups
 15 which may be unsubstituted or substituted. The term "heteroalkyl" is
 intended to mean an alkyl group, wherein one or more of the carbon
 atoms within the alkyl group has been replaced by another atom, such as
 nitrogen, oxygen, sulfur, and the like. The term "alkylene" refers to an
 alkyl group having two points of attachment.

20 As used herein, the term "alkenyl" refers to a group derived from an
 aliphatic hydrocarbon having at least one carbon-carbon double bond, and
 includes linear, branched and cyclic groups which may be unsubstituted or
 substituted. The term "heteroalkenyl" is intended to mean an alkenyl
 group, wherein one or more of the carbon atoms within the alkenyl group
 25 has been replaced by another atom, such as nitrogen, oxygen, sulfur, and
 the like. The term "alkenylene" refers to an alkenyl group having two points
 of attachment.

As used herein, the following terms for substituent groups refer to
 the formulae given below:

30	"alcohol"	-R ³ -OH
	"amido"	-R ³ -C(O)N(R ⁶) R ⁶
	"amidosulfonate"	-R ³ -C(O)N(R ⁶) R ⁴ - SO ₃ Z
	"benzyl"	-CH ₂ -C ₆ H ₅

	"carboxylate"	$-R^3-C(O)O-Z$ or $-R^3-O-C(O)-Z$
	"ether"	$-R^3-(O-R^5)_p-O-R^5$
	"ether carboxylate"	$-R^3-O-R^4-C(O)O-Z$ or $-R^3-O-R^4-O-C(O)-Z$
	"ether sulfonate"	$-R^3-O-R^4-SO_3Z$
5	"ester sulfonate"	$-R^3-O-C(O)-R^4-SO_3Z$
	"sulfonimide"	$-R^3-SO_2-NH-SO_2-R^5$
	"urethane"	$-R^3-O-C(O)-N(R^6)_2$

where all "R" groups are the same or different at each occurrence and:

10 R^3 is a single bond or an alkylene group

R^4 is an alkylene group

R^5 is an alkyl group

R^6 is hydrogen or an alkyl group

p is 0 or an integer from 1 to 20

15 Z is H, alkali metal, alkaline earth metal, $N(R^5)_4$ or R^5

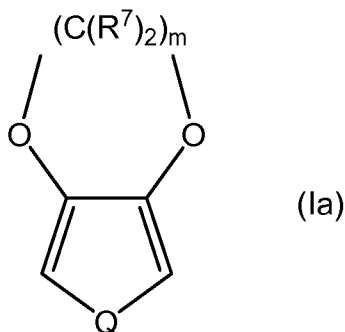
Any of the above groups may further be unsubstituted or substituted, and any group may have F substituted for one or more hydrogens, including perfluorinated groups. In some embodiments, the alkyl and alkylene groups have from 1-20 carbon atoms.

20 In some embodiments, in the monomer, both R^1 together form $—W-(CY^1Y^2)_m-W-$, where m is 2 or 3, W is O, S, Se, PO, NR^6 , Y^1 is the same or different at each occurrence and is hydrogen or fluorine, and Y^2 is the same or different at each occurrence and is selected from hydrogen, halogen, alkyl, alcohol, amidosulfonate, benzyl, carboxylate, ether, ether

25 carboxylate, ether sulfonate, ester sulfonate, and urethane, where the Y groups may be partially or fully fluorinated. In some embodiments, all Y are hydrogen. In some embodiments, the polymer is poly(3,4-ethylenedioxythiophene) ("PEDOT"). In some embodiments, at least one Y group is not hydrogen. In some embodiments, at least one Y group is a

30 substituent having F substituted for at least one hydrogen. In some embodiments, at least one Y group is perfluorinated.

In some embodiments, the monomer has Formula I(a):



wherein:

Q is selected from the group consisting of S, Se, and Te;

5 R^7 is the same or different at each occurrence and is selected from hydrogen, alkyl, heteroalkyl, alkenyl, heteroalkenyl, alcohol, amidosulfonate, benzyl, carboxylate, ether, ether carboxylate, ether sulfonate, ester sulfonate, and urethane, with the proviso that at least one R^7 is not hydrogen, and

10 m is 2 or 3.

In some embodiments of Formula I(a), m is two, one R^7 is an alkyl group of more than 5 carbon atoms, and all other R^7 are hydrogen.

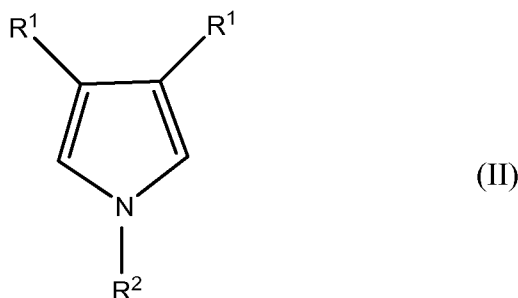
In some embodiments of Formula I(a), at least one R^7 group is fluorinated.

15 In some embodiments, at least one R^7 group has at least one fluorine substituent. In some embodiments, the R^7 group is fully fluorinated.

In some embodiments of Formula I(a), the R^7 substituents on the fused alicyclic ring on the monomer offer improved solubility of the monomers in water and facilitate polymerization in the presence of the fluorinated acid polymer.

20 In some embodiments of Formula I(a), m is 2, one R^7 is sulfonic acid-propylene-ether-methylene and all other R^7 are hydrogen. In some embodiments, m is 2, one R^7 is propyl-ether-ethylene and all other R^7 are hydrogen. In some embodiments, m is 2, one R^7 is methoxy and all other R^7 are hydrogen. In some embodiments, one R^7 is sulfonic acid
25 difluoromethylene ester methylene ($-\text{CH}_2-\text{O}-\text{C}(\text{O})-\text{CF}_2-\text{SO}_3\text{H}$), and all other R^7 are hydrogen.

In some embodiments, pyrrole monomers contemplated for use to form the electrically conductive polymer in the new composite dispersion comprise Formula II below.



5 where in Formula II:

R^1 is independently selected so as to be the same or different at each occurrence and is selected from hydrogen, alkyl, alkenyl, alkoxy, alkanoyl, alkythio, aryloxy, alkylthioalkyl, alkylaryl, arylalkyl, amino, alkylamino, dialkylamino, aryl, alkylsulfinyl, alkoxyalkyl, alkylsulfonyl, arylthio, arylsulfinyl, alkoxy carbonyl, arylsulfonyl, acrylic acid, phosphoric acid, phosphonic acid, halogen, nitro, cyano, hydroxyl, epoxy, silane, siloxane, alcohol, benzyl, carboxylate, ether, amidosulfonate, ether carboxylate, ether sulfonate, ester sulfonate, and urethane; or both R^1 groups together may form an alkylene or alkenylene chain completing a 3, 4, 5, 6, or 7-membered aromatic or alicyclic ring, which ring may optionally include one or more divalent nitrogen, sulfur, selenium, tellurium, or oxygen atoms; and

R^2 is independently selected so as to be the same or different at each occurrence and is selected from hydrogen, alkyl, alkenyl, aryl, alkanoyl, alkylthioalkyl, alkylaryl, arylalkyl, amino, epoxy, silane, siloxane, alcohol, benzyl, carboxylate, ether, ether carboxylate, ether sulfonate, ester sulfonate, and urethane.

In some embodiments, R^1 is the same or different at each occurrence and is independently selected from hydrogen, alkyl, alkenyl, alkoxy, cycloalkyl, cycloalkenyl, alcohol, benzyl, carboxylate, ether, amidosulfonate, ether carboxylate, ether sulfonate, ester sulfonate, urethane, epoxy, silane, siloxane, and alkyl substituted with one or more of

sulfonic acid, carboxylic acid, acrylic acid, phosphoric acid, phosphonic acid, halogen, nitro, cyano, hydroxyl, epoxy, silane, or siloxane moieties.

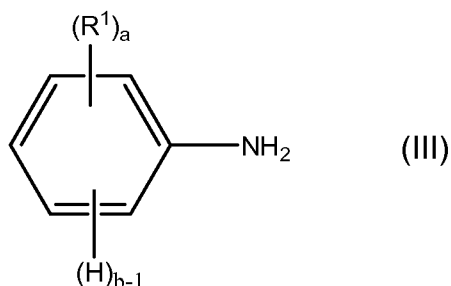
In some embodiments, R^2 is selected from hydrogen, alkyl, and alkyl substituted with one or more of sulfonic acid, carboxylic acid, acrylic acid, phosphoric acid, phosphonic acid, halogen, cyano, hydroxyl, epoxy, silane, or siloxane moieties.

In some embodiments, the pyrrole monomer is unsubstituted and both R^1 and R^2 are hydrogen. Unsubstituted polypyrrole is abbreviated herein as "PPy".

In some embodiments, both R^1 together form a 6- or 7-membered alicyclic ring, which is further substituted with a group selected from alkyl, heteroalkyl, alcohol, benzyl, carboxylate, ether, ether carboxylate, ether sulfonate, ester sulfonate, and urethane. These groups can improve the solubility of the monomer and the resulting polymer. In some embodiments, both R^1 together form a 6- or 7-membered alicyclic ring, which is further substituted with an alkyl group. In some embodiments, both R^1 together form a 6- or 7-membered alicyclic ring, which is further substituted with an alkyl group having at least 1 carbon atom.

In some embodiments, both R^1 together form $-O-(CHY)_m-O-$, where m is 2 or 3, and Y is the same or different at each occurrence and is selected from hydrogen, alkyl, alcohol, benzyl, carboxylate, amidosulfonate, ether, ether carboxylate, ether sulfonate, ester sulfonate, and urethane. In some embodiments, at least one Y group is not hydrogen. In some embodiments, at least one Y group is a substituent having F substituted for at least one hydrogen. In some embodiments, at least one Y group is perfluorinated.

In some embodiments, aniline monomers contemplated for use to form the electrically conductive polymer in the new composite dispersion comprise Formula III below.



wherein:

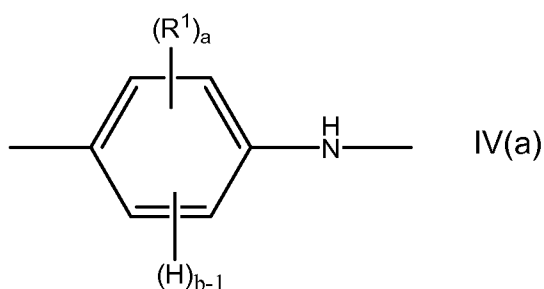
5 a is 0 or an integer from 1 to 4;

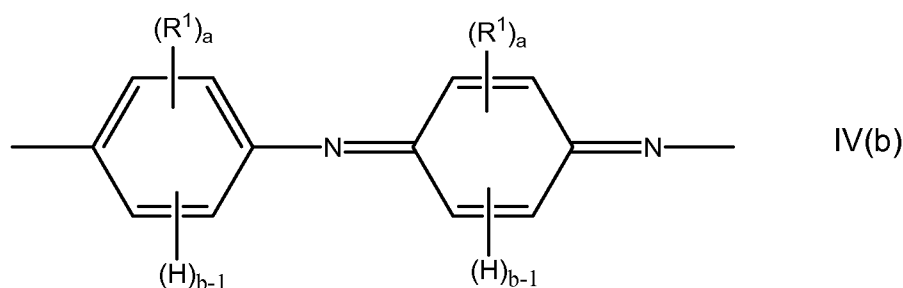
 b is an integer from 1 to 5, with the proviso that $a + b = 5$; and

R^1 is independently selected so as to be the same or different at each
 occurrence and is selected from hydrogen, alkyl, alkenyl, alkoxy, alkanoyl,
 alkythio, aryloxy, alkylthioalkyl, alkylaryl, arylalkyl, amino, alkylamino,
 10 dialkylamino, aryl, alkylsulfinyl, alkoxyalkyl, alkylsulfonyl, arylthio,
 arylsulfinyl, alkoxycarbonyl, arylsulfonyl, acrylic acid, phosphoric acid,
 phosphonic acid, halogen, nitro, cyano, hydroxyl, epoxy, silane, siloxane,
 alcohol, benzyl, carboxylate, ether, ether carboxylate, amidosulfonate,
 ether sulfonate, ester sulfonate, and urethane; or both R^1 groups together
 15 may form an alkylene or alkenylene chain completing a 3, 4, 5, 6, or
 7-membered aromatic or alicyclic ring, which ring may optionally include
 one or more divalent nitrogen, sulfur or oxygen atoms.

 When polymerized, the aniline monomeric unit can have Formula
 IV(a) or Formula IV(b) shown below, or a combination of both formulae.

20





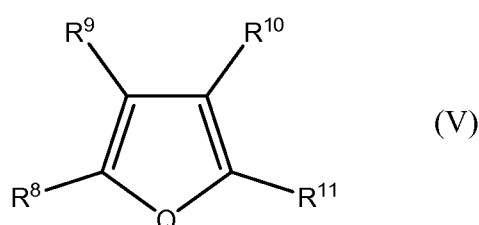
5 where a , b and R^1 are as defined above.

In some embodiments, the aniline monomer is unsubstituted and $a = 0$.

In some embodiments, a is not 0 and at least one R^1 is fluorinated.
In some embodiments, at least one R^1 is perfluorinated.

10 In some embodiments, fused polycyclic heteroaromatic monomers contemplated for use to form the electrically conductive polymer in the new composite dispersion have two or more fused aromatic rings, at least one of which is heteroaromatic. In some embodiments, the fused polycyclic heteroaromatic monomer has Formula V:

15



wherein:

Q is S, Se, Te, or NR^6 ;

20 R^6 is hydrogen or alkyl;

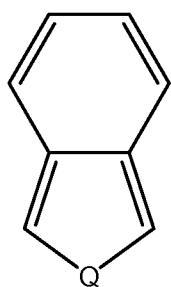
R^8 , R^9 , R^{10} , and R^{11} are independently selected so as to be the same or different at each occurrence and are selected from hydrogen, alkyl, alkenyl, alkoxy, alkanoyl, alkythio, aryloxy, alkylthioalkyl, alkylaryl, arylalkyl, amino, alkylamino, dialkylamino, aryl, alkylsulfinyl, alkoxyalkyl, alkylsulfonyl,

25

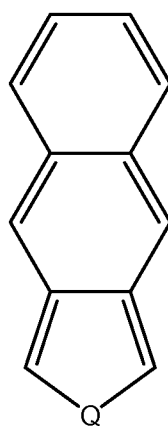
arylthio, arylsulfinyl, alkoxycarbonyl, arylsulfonyl, acrylic acid, phosphoric acid, phosphonic acid, halogen, nitro, nitrile, cyano, hydroxyl, epoxy, silane, siloxane, alcohol, benzyl, carboxylate, ether, ether carboxylate, amidosulfonate, ether sulfonate, ester sulfonate, and urethane; and

at least one of R^8 and R^9 , R^9 and R^{10} , and R^{10} and R^{11} together form an alkenylene chain completing a 5 or 6-membered aromatic ring, which ring may optionally include one or more divalent nitrogen, sulfur, selenium, tellurium, or oxygen atoms.

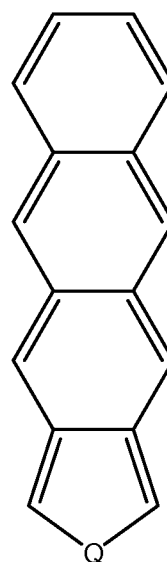
10 In some embodiments, the fused polycyclic heteroaromatic monomer has a formula selected from the group consisting of Formula V(a), V(b), V(c), V(d), V(e), V(f), V(g), V(h), V(i), V(j), and V(k):



(Va)

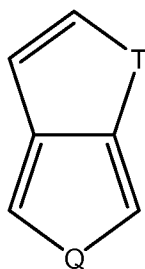


(Vb)

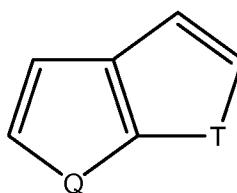


(Vc)

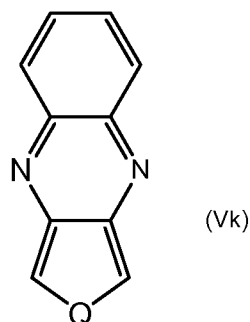
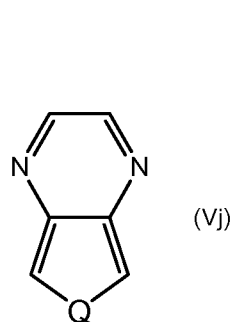
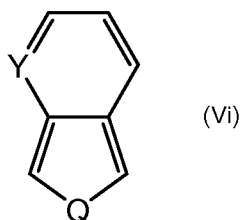
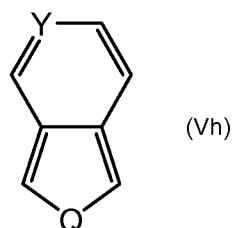
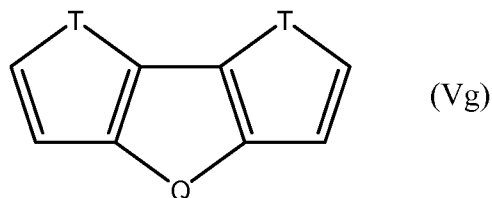
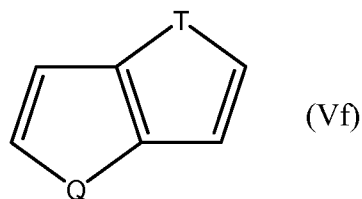
15



(Vd)



(Ve)



5

wherein:

Q is S, Se, Te, or NH; and

T is the same or different at each occurrence and is selected from

S, NR^6 , O, SiR^6_2 , Se, Te, and PR^6 ;

10

Y is N; and

R^6 is hydrogen or alkyl.

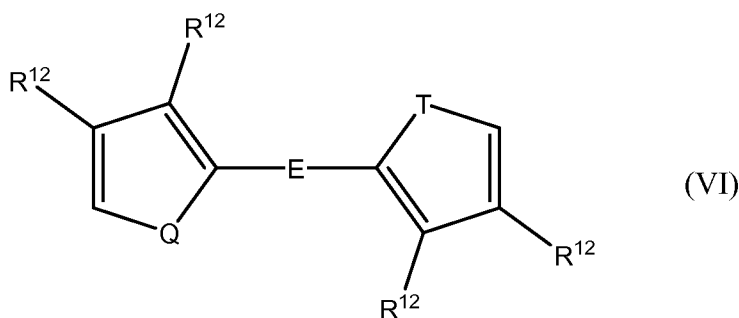
15

The fused polycyclic heteroaromatic monomers may be further substituted with groups selected from alkyl, heteroalkyl, alcohol, benzyl, carboxylate, ether, ether carboxylate, ether sulfonate, ester sulfonate, and urethane. In some embodiments, the substituent groups are fluorinated. In some embodiments, the substituent groups are fully fluorinated.

In some embodiments, the fused polycyclic heteroaromatic monomer is a thieno(thiophene). Such compounds have been discussed in, for example, *Macromolecules*, 34, 5746-5747 (2001); and

Macromolecules, 35, 7281-7286 (2002). In some embodiments, the thieno(thiophene) is selected from thieno(2,3-b)thiophene, thieno(3,2-b)thiophene, and thieno(3,4-b)thiophene. In some embodiments, the thieno(thiophene) monomer is further substituted with at least one group selected from alkyl, heteroalkyl, alcohol, benzyl, carboxylate, ether, ether carboxylate, ether sulfonate, ester sulfonate, and urethane. In some embodiments, the substituent groups are fluorinated. In some embodiments, the substituent groups are fully fluorinated.

In some embodiments, polycyclic heteroaromatic monomers contemplated for use to form the polymer in the new composite dispersion comprise Formula VI:



wherein:

Q is S, Se, Te, or NR^6 ;

T is selected from S, NR^6 , O, SiR^6_2 , Se, Te, and PR^6 ;

E is selected from alkenylene, arylene, and heteroarylene;

R^6 is hydrogen or alkyl;

R^{12} is the same or different at each occurrence and is selected from hydrogen, alkyl, alkenyl, alkoxy, alkanoyl, alkythio, aryloxy, alkylthioalkyl, alkylaryl, arylalkyl, amino, alkylamino, dialkylamino, aryl, alkylsulfinyl, alkoxyalkyl, alkylsulfonyl, arylthio, arylsulfinyl, alkoxycarbonyl, arylsulfonyl, acrylic acid, phosphoric acid, phosphonic acid, halogen, nitro, nitrile, cyano, hydroxyl, epoxy, silane, siloxane, alcohol, benzyl, carboxylate, ether, ether carboxylate, amidosulfonate, ether sulfonate, ester sulfonate, and urethane; or both R^{12} groups together may

form an alkylene or alkenylene chain completing a 3, 4, 5, 6, or 7-membered aromatic or alicyclic ring, which ring may optionally include one or more divalent nitrogen, sulfur, selenium, tellurium, or oxygen atoms.

5 In some embodiments, the electrically conductive polymer is a copolymer of a precursor monomer and at least one second monomer. Any type of second monomer can be used, so long as it does not detrimentally affect the desired properties of the copolymer. In some
10 embodiments, the second monomer comprises no more than 50% of the polymer, based on the total number of monomer units. In some embodiments, the second monomer comprises no more than 30%, based on the total number of monomer units. In some embodiments, the second monomer comprises no more than 10%, based on the total number of monomer units.

15 Exemplary types of second monomers include, but are not limited to, alkenyl, alkynyl, arylene, and heteroarylene. Examples of second monomers include, but are not limited to, fluorene, oxadiazole, thiadiazole, benzothiadiazole, phenylenevinylene, phenyleneethynylene, pyridine, diazines, and triazines, all of which may be further substituted.

20 In some embodiments, the copolymers are made by first forming an intermediate precursor monomer having the structure A-B-C, where A and C represent precursor monomers, which can be the same or different, and B represents a second monomer. The A-B-C intermediate precursor monomer can be prepared using standard synthetic organic techniques,
25 such as Yamamoto, Stille, Grignard metathesis, Suzuki, and Negishi couplings. The copolymer is then formed by oxidative polymerization of the intermediate precursor monomer alone, or with one or more additional precursor monomers.

In some embodiments, the electrically conductive polymer is
30 selected from the group consisting of a polythiophene, a polypyrrole, polyaniline, a polymeric fused polycyclic heteroaromatic, a copolymer thereof, and combinations thereof.

In some embodiments, the electrically conductive polymer is selected from the group consisting of poly(3,4-ethylenedioxythiophene), unsubstituted polypyrrole, unsubstituted polyaniline, poly(4-aminoindole), poly(7-aminoindole), poly(thieno(2,3-b)thiophene),
5 poly(thieno(3,2-b)thiophene), and poly(thieno(3,4-b)thiophene).

b. Non-Fluorinated Polymeric Acid

Any non-fluorinated polymeric acid, which is capable of doping the conductive polymer, can be used to make the new composite dispersions. In some embodiments, the non-fluorinated polymeric acid is less than 10%
10 fluorinated; in some embodiments, less than 1% fluorinated. In some embodiments, the non-fluorinated polymeric acid has no fluorines.

The use of such acids with conducting polymers such as polythiophenes, polyanilines and polypyrroles is well known in the art. Examples of acidic groups include, but are not limited to, carboxylic acid
15 groups, sulfonic acid groups, sulfonimide groups, phosphoric acid groups, phosphonic acid groups, and combinations thereof. The acidic groups can all be the same, or the polymer may have more than one type of acidic group.

In one embodiment, the acid is a non-fluorinated polymeric sulfonic acid. Some non-limiting examples of the acids are poly(styrenesulfonic acid) ("PSSA"), poly(2-acrylamido-2-methyl-1-propanesulfonic acid)
20 ("PAAMPSA"), and mixtures thereof.

The amount of non-fluorinated polymeric acid present is generally in excess of that required to counterbalance the charge on the conducting
25 polymer. In some embodiments, the ratio of acid equivalents of non-fluorinated polymeric acid to molar equivalents of conducting polymer is in the range of 1-5.

The amount of doped conducting polymer in the new composite dispersion is generally at least 0.1 wt.%, based on the total weight of the
30 dispersion. In some embodiments, the wt.% is from 0.2 to 5.

The conductivity of films made from the doped polymer should be at least 0.1S/cm.

c. Preparation of Doped Electrically Conductive Polymer

The doped electrically conductive polymer is formed by oxidative polymerization of the precursor monomer in the presence of the non-fluorinated polymeric acid in an aqueous medium. Oxidative polymerization of such monomers is well known. Oxidants such as sodium or potassium persulfate may be used. In some cases a catalyst, such as ferric sulfate can also be used. The resulting product is an aqueous dispersion of the doped electrically conductive polymer.

Some doped electrically conductive polymers are available commercially. Examples include PEDOT/PSSA, sold as Clevios™ (previously known as Baytron-P) by H.C. Starck, and PPy/PSSA sold by Aldrich Chemical.

3. Highly-fluorinated Acid Polymer

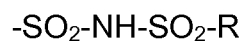
The highly-fluorinated acid polymer ("HFAP") is used to enhance the work-function of films made from the new composite dispersion. The HFAP can be any polymer which is highly-fluorinated and has acidic groups with acidic protons. The acidic groups supply an ionizable proton. In some embodiments, the acidic proton has a pKa of less than 3. In some embodiments, the acidic proton has a pKa of less than 0. In some embodiments, the acidic proton has a pKa of less than -5. The acidic group can be attached directly to the polymer backbone, or it can be attached to side chains on the polymer backbone. Examples of acidic groups include, but are not limited to, carboxylic acid groups, sulfonic acid groups, sulfonimide groups, phosphoric acid groups, phosphonic acid groups, and combinations thereof. The acidic groups can all be the same, or the polymer may have more than one type of acidic group. In some embodiments, the acidic groups are selected from the group consisting of sulfonic acid groups, sulfonamide groups, and combinations thereof.

In some embodiments, the HFAP is at least 90% fluorinated; in some embodiments, at least 95% fluorinated; in some embodiments, fully-fluorinated.

In some embodiments, the HFAP is water-soluble. In some embodiments, the HFAP is dispersible in water. In some embodiments, the HFAP is organic solvent wettable.

Examples of suitable polymeric backbones include, but are not limited to, polyolefins, polyacrylates, polymethacrylates, polyimides, polyamides, polyaramids, polyacrylamides, polystyrenes, and copolymers thereof, all of which are highly-fluorinated; in some embodiments, fully-fluorinated.

In one embodiment, the acidic groups are sulfonic acid groups or sulfonimide groups. A sulfonimide group has the formula:



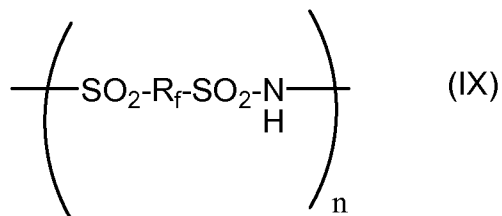
where R is an alkyl group.

In one embodiment, the acidic groups are on a fluorinated side chain. In one embodiment, the fluorinated side chains are selected from alkyl groups, alkoxy groups, amido groups, ether groups, and combinations thereof, all of which are fully fluorinated.

In one embodiment, the HFAP has a highly-fluorinated olefin backbone, with pendant highly-fluorinated alkyl sulfonate, highly-fluorinated ether sulfonate, highly-fluorinated ester sulfonate, or highly-fluorinated ether sulfonimide groups. In one embodiment, the HFAP is a perfluoroolefin having perfluoro-ether-sulfonic acid side chains. In one embodiment, the polymer is a copolymer of 1,1-difluoroethylene and 2-(1,1-difluoro-2-(trifluoromethyl)allyloxy)-1,1,2,2-tetrafluoroethanesulfonic acid. In one embodiment, the polymer is a copolymer of ethylene and 2-(2-(1,2,2-trifluorovinyl)oxy)-1,1,2,3,3,3-hexafluoropropoxy)-1,1,2,2-tetrafluoroethanesulfonic acid. These copolymers can be made as the corresponding sulfonyl fluoride polymer and then can be converted to the sulfonic acid form.

In one embodiment, the HFAP is homopolymer or copolymer of a fluorinated and partially sulfonated poly(arylene ether sulfone). The copolymer can be a block copolymer.

In one embodiment, the HFAP is a sulfonimide polymer having Formula IX:



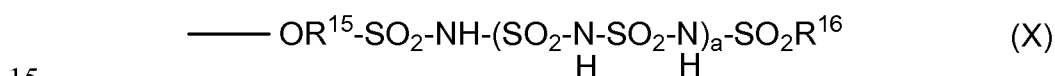
where:

R_f is selected from highly-fluorinated alkylene, highly-fluorinated
 5 heteroalkylene, highly-fluorinated arylene, and highly-fluorinated
 heteroarylene, which may be substituted with one or more ether
 oxygens; and

n is at least 4.

In one embodiment of Formula IX, R_f is a perfluoroalkyl group. In one
 10 embodiment, R_f is a perfluorobutyl group. In one embodiment, R_f contains
 ether oxygens. In one embodiment n is greater than 10.

In one embodiment, the HFAP comprises a highly-fluorinated
 polymer backbone and a side chain having Formula X:



15

where:

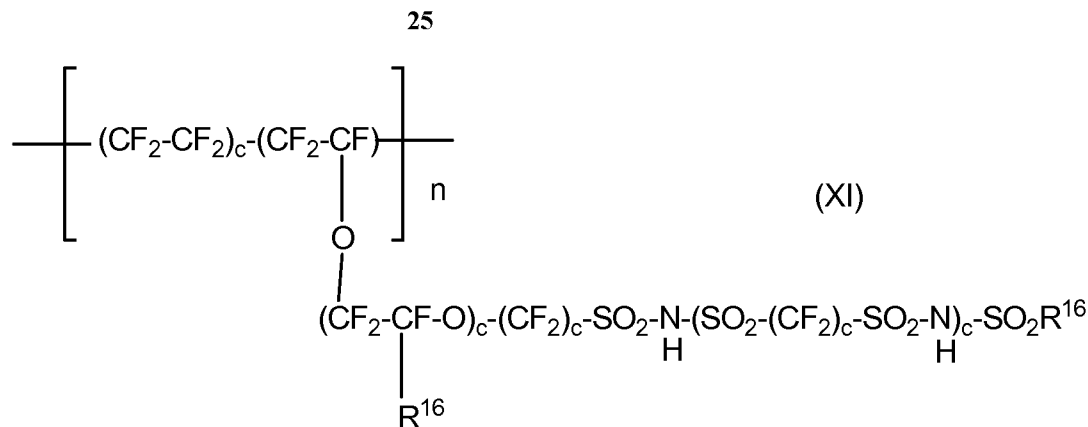
R^{15} is a highly-fluorinated alkylene group or a highly-fluorinated
 heteroalkylene group;

R^{16} is a highly-fluorinated alkyl or a highly-fluorinated aryl group;

20 and

a is 0 or an integer from 1 to 4.

In one embodiment, the HFAP has Formula XI:



where:

R^{16} is a highly-fluorinated alkyl or a highly-fluorinated aryl group;

5 c is independently 0 or an integer from 1 to 3; and

n is at least 4.

The synthesis of HFAPs has been described in, for example, A.

Feiring et al., J. Fluorine Chemistry 2000, 105, 129-135; A. Feiring et al.,
Macromolecules 2000, 33, 9262-9271; D. D. Desmarteau, J. Fluorine
10 Chem. 1995, 72, 203-208; A. J. Appleby et al., J. Electrochem. Soc. 1993,
140(1), 109-111; and Desmarteau, U.S. Patent 5,463,005.

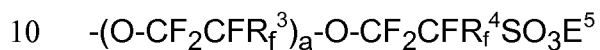
In one embodiment, the HFAP also comprises a repeat unit derived
from at least one highly-fluorinated ethylenically unsaturated compound.
The perfluoroolefin comprises 2 to 20 carbon atoms. Representative
15 perfluoroolefins include, but are not limited to, tetrafluoroethylene,
hexafluoropropylene, perfluoro-(2,2-dimethyl-1,3-dioxole), perfluoro-(2-
methylene-4-methyl-1,3-dioxolane), $\text{CF}_2=\text{CFO}(\text{CF}_2)_t\text{CF}=\text{CF}_2$, where t is 1
or 2, and $\text{R}_f'\text{OCF}=\text{CF}_2$ wherein R_f' is a saturated perfluoroalkyl group of
from 1 to about ten carbon atoms. In one embodiment, the comonomer is
20 tetrafluoroethylene.

In one embodiment, the HFAP is a colloid-forming polymeric acid.
As used herein, the term "colloid-forming" refers to materials which are
insoluble in water, and form colloids when dispersed into an aqueous
medium. The colloid-forming polymeric acids typically have a molecular
25 weight in the range of about 10,000 to about 4,000,000. In one
embodiment, the polymeric acids have a molecular weight of about
100,000 to about 2,000,000. Colloid particle size typically ranges from

2 nanometers (nm) to about 140 nm. In one embodiment, the colloids have a particle size of 2 nm to about 30 nm. Any highly-fluorinated colloid-forming polymeric material having acidic protons can be used.

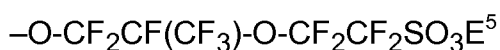
Some of the polymers described hereinabove may be formed in non-acid form, e.g., as salts, esters, or sulfonyl fluorides. They will be converted to the acid form for the preparation of conductive compositions, described below.

In some embodiments, HFAP include a highly-fluorinated carbon backbone and side chains represented by the formula



wherein R_f^3 and R_f^4 are independently selected from F, Cl or a highly-fluorinated alkyl group having 1 to 10 carbon atoms, $a = 0, 1$ or 2 , and E^5 . In some cases E^5 can be a cation such as Li, Na, or K, and be converted to the acid form.

15 In some embodiments, the HFAP can be the polymers disclosed in U.S. Patent No. 3,282,875 and in U.S. Patent Nos. 4,358,545 and 4,940,525. In some embodiments, the HFAP comprises a perfluorocarbon backbone and the side chain represented by the formula



20 where E^5 is as defined above. HFAPs of this type are disclosed in U.S. Patent No. 3,282,875 and can be made by copolymerization of tetrafluoroethylene (TFE) and the perfluorinated vinyl ether $CF_2=CF-O-CF_2CF(CF_3)-O-CF_2CF_2SO_2F$, perfluoro(3,6-dioxa-4-methyl-7-octenesulfonyl fluoride) (PDMOF), followed by conversion to sulfonate groups by hydrolysis of the sulfonyl fluoride groups and ion exchanged as necessary to convert them to the desired ionic form. An example of a polymer of the type disclosed in U.S. Patent Nos. 4,358,545 and 4,940,525 has the side chain $-O-CF_2CF_2SO_3E^5$, wherein E^5 is as defined above. This polymer can be made by copolymerization of

30 tetrafluoroethylene (TFE) and the perfluorinated vinyl ether $CF_2=CF-O-CF_2CF_2SO_2F$, perfluoro(3-oxa-4-pentenesulfonyl fluoride) (POPF), followed by hydrolysis and further ion exchange as necessary.

One type of HFAP is available commercially as aqueous Nafion® dispersions, from E. I. du Pont de Nemours and Company (Wilmington, DE).

In the new composite dispersion described herein, the ratio of acid equivalent of HFAP to acid equivalent of non-fluorinated doping acid is at least 0.1, and no greater than 2; in some embodiments, no greater than 1.

In some embodiments, the HFAP can be dissolved or dispersed in the high-boiling solvent.

10 4. Solvent

The solvent is a water-compatible high-boiling organic liquid. The boiling point of the solvent is at least 120°C at atmospheric pressure. In some embodiments, the boiling point is greater than 150°C; in some embodiments, greater than 170°C.

15 Examples of solvents include, but are not limited to ethylene glycol, diethylene glycol, propylene glycol, glycerol, dimethylsulfoxide, propylene glycol mono-propyl ether, dimethylacetamide, and N-methylpyrrolidone. Skilled artisans will be able to determine suitable solvents having the above properties. Mixtures of solvents may also be used.

20 The total solvent is generally present in the new composite dispersion in the amount of from 1 to 30 wt.%, based on the total weight of the dispersion; in some embodiments, from 5 to 20 wt.%, in some embodiments, from 2.5 to 10%.

25 5. Electrically Insulative Inorganic Oxide Nanoparticles

The inorganic oxide nanoparticles are electrically insulative and have a particle size no greater than 50 nm. The electrical conductivity of the oxides in compressed powder form is less than 1×10^{-10} S/cm.

In some embodiments, the particle size is no greater than 20 nm; in some embodiments, no greater than 10 nm; in some embodiments, no greater than 5 nm.

The oxide can be either a single oxide or mixture of two or more oxides. The shape of the nanoparticles can be, for example, spherical,

elongated, chains, needles, core-shell nanoparticles, or combinations thereof.

Examples of electrically insulative inorganic oxides include, but are not limited to, silicon oxide, titanium oxides, zirconium oxide, molybdenum trioxide, vanadium oxide, aluminum oxide, zinc oxide, samarium oxide, yttrium oxide, cesium oxide, cupric oxide, stannic oxide, antimony oxide, tantalum oxides, and the like. Combinations of two or more oxide nanoparticles can be used. In some embodiments, the electrically insulative inorganic oxide nanoparticles are selected from the group consisting of silicon dioxide, titanium dioxide, and combinations thereof.

The oxide nanoparticles can be made by the evaporation of the selected oxide, and multi-component oxides, or by vapor-phase hydrolysis of inorganic compounds, for example silicon tetrachloride. It can also be produced by sol-gel chemistry using hydrolyzable metal compounds, particularly alkoxides of various elements, to react with either by hydrolysis and polycondensation to form multi-component and multi-dimensional network oxides.

The weight percentage of electrically insulative inorganic oxide nanoparticles in the new dispersion is in the range of 1-20 wt.%, based on the total weight of the dispersion; in some embodiments, 5-15 wt%. The weight ratio of the electrically insulative inorganic oxide nanoparticles relative to the total of other solids (doped conducting polymer, HFAP, and optional additives) is at least 1.0; in some embodiments, at least 1.5. The weight ratio of electrically insulative inorganic oxide nanoparticles to conductive polymer is in the range of 1 to 15; in some embodiments, 5 to 10.

25

6. Optional Additives

In some embodiments, the new dispersion further comprises electrically semiconductive inorganic oxide nanoparticles. The semiconductive inorganic oxide nanoparticles can be added in order to increase the conductivity of the films made from the dispersion. In some embodiments, the electrical conductivity of the semiconductive oxides in the compressed powder form is greater than $1 \times 10^{-3} \text{ S/cm}$.

30

Examples of electrically semiconductive oxides include, but are not limited to, indium tin oxides, and zinc antimonates for further enhancement of electrical conductivity. Zinc antimonates, available from Nissan Chemical, Inc. as Celnax[®], are mixture of zinc oxide and antimony pentaoxide with formular ratio of ZnO/Sb₂O₅ from 0.8 to 1.2.

5 Combinations of two or more semiconductive oxide nanoparticles can be used.

The electrically semiconductive oxides are present in an amount no greater than 50% by weight, based on the total weight of inorganic oxide nanoparticles. In some embodiments, no greater than 25% by weight.

10

7. Preparation of the New Composite Dispersion and Films

In the following discussion, the doped conductive polymer, HFAP, solvent, electrically insulative inorganic oxide nanoparticles, and optional additives will be referred to in the singular. However, it is understood that more than one of any or all of these may be used.

15

The new composite dispersion is prepared by first forming the doped conductive polymer and then adding the HFAP, the solvent, the electrically insulative inorganic oxide nanoparticles, and optional additives in any order.

20

The doped electrically conductive polymer is generally formed by oxidative polymerization of the precursor monomer in the presence of the non-fluorinated polymeric acid in an aqueous medium. Many of these materials are commercially available. The HFAP can be first dissolved or dispersed in the solvent or a solvent/water mixture. The electrically insulative inorganic oxide nanoparticles can similarly be dispersed in water or a solvent/water mixture. These mixtures can then be added to an aqueous dispersion of the doped conductive polymer. The electrically insulative inorganic oxide nanoparticles can also be dispersed with the HFAP or with the doped conductive polymer.

25

30

Alternatively, the electrically insulative inorganic oxide nanoparticles can be added to the doped conductive polymer dispersion directly as a solid. The solvent and HFAP can be added to this mixture.

The optional additive, when present, can be added at any point. The additive can be added as a dispersion in water or a solvent/water mixture, or it can be added directly as a solid.

In some embodiments, the pH is increased either prior to or after
5 the addition of the electrically insulative oxide nanoparticles and, optionally, the additive. The pH can be adjusted by treatment with cation exchange resins and/or base resins prior to the addition of the electrically insulative inorganic oxide nanoparticles and, optionally, the additive. In
10 some embodiments, the pH is adjusted by the addition of aqueous base solution. Cations for the base can be, but are not limited to, alkali metal, alkaline earth metal, ammonium, and alkylammonium. In some embodiments, alkali metal is preferred over alkaline earth metal cations.

In some embodiments, the new composite dispersion consists essentially of: (i) at least one electrically conductive polymer doped with
15 at least one non-fluorinated polymeric acid; (ii) at least one highly-fluorinated acid polymer; (iii) at least one water-compatible high-boiling organic solvent, (iv) electrically insulative inorganic oxide nanoparticles; and (v) water.

In some embodiments, the new composite dispersion consists
20 essentially of: (i) at least one electrically conductive polymer doped with at least one non-fluorinated polymeric acid; (ii) at least one highly-fluorinated acid polymer; (iii) at least one water-compatible high-boiling organic solvent, (iv) electrically insulative inorganic oxide nanoparticles; (v)
water; and (vi) electrically semiconductive inorganic oxide nanoparticles.

25 Films made from the new composite aqueous dispersions described herein, are hereinafter referred to as "the new films described herein". The films can be made using any liquid deposition technique, including continuous and discontinuous techniques. Continuous
deposition techniques, include but are not limited to, spin coating, gravure
30 coating, curtain coating, dip coating, slot-die coating, spray coating, and continuous nozzle coating. Discontinuous deposition techniques include, but are not limited to, ink jet printing, gravure printing, and screen printing.

The films thus formed are smooth and relatively transparent. With the incorporation of inorganic oxide nanoparticles, the films can still have a conductivity greater than 10 S/cm; in some embodiments, greater than 50 S/cm; in some embodiments, greater than 100 S/cm.

5 Films containing highly-fluorinated materials generally have very low surface energies and are not wettable with organic solvents. Surprisingly and unexpectedly, the new films described herein are wettable with organic solvents. In some embodiments, the new films are wettable by a non-polar organic solvent with a contact angle less than 50°. 10 In some embodiments, the new films are wettable by toluene or p-xylene with a contact angle no greater than 40°; in some embodiments, no greater than 35°. In some embodiments, the new films are wettable by anisole with a contact angle no greater than 50°; in some embodiments, no greater than 45°. The methods for measuring contact angles are well 15 known.

 The new films described herein have high work function. In some embodiments, the work function is greater than 5.2; in some embodiments, greater than 5.4. Low intensity X-ray photoemission spectroscopy (LIXPS) is a technique that has been demonstrated to be 20 very useful in determining the work function of samples that are low in electrical conductivity or are sensitive to photon radiation, as described by Y. Yi, et. al., Journal of Applied Physics 100, 093719 (2006). Compared to Ultraviolet photoemission spectroscopy (UPS), the traditional work function measurement technique, this technique uses x rays of very low 25 intensity (one order of magnitude lower than typical X-ray in XPS for elemental analysis, two to three orders of magnitude lower than commercial UV sources in UPS) to circumvent artifacts introduced by photoradiation, such as charging or photochemical reaction, allowing accurate measurement of work function.

30

8. Hole Injection Layers

Organic light-emitting diodes (OLEDs) are an organic electronic device comprising an organic layer capable of electroluminescence. OLEDs can have the following configuration:

5 anode/hole injection layer/EL material/cathode

with additional layers between the electrodes. Electrically conducting polymers having low conductivity in the range of 10^{-3} to 10^{-7} S/cm are commonly used as the hole injection layers in direct contact with an electrically conductive, inorganic oxide anode such as ITO. However, films of the new composite dispersions having conductivity greater than 10 S/cm can serve both anode and hole injection layer functions.

In another embodiment of the invention, there are provided hole injection layers deposited from composite aqueous dispersions. The term "hole injection layer" or "hole injection material" is intended to mean electrically conductive or semiconductive materials and may have one or more functions in an organic electronic device, including but not limited to, planarization of the underlying layer, charge transport and/or charge injection properties, scavenging of impurities such as oxygen or metal ions, and other aspects to facilitate or to improve the performance of the organic electronic device. The term "layer" is used interchangeably with the term "film" and refers to a coating covering a desired area. The term is not limited by size. The area can be as large as an entire device or as small as a specific functional area such as the actual visual display, or as small as a single sub-pixel. Layers and films can be formed by any conventional deposition technique, including vapor deposition, liquid deposition (continuous and discontinuous techniques), and thermal transfer. Continuous deposition techniques, include but are not limited to, spin coating, gravure coating, curtain coating, dip coating, slot-die coating, spray coating, and continuous nozzle coating. Discontinuous deposition techniques include, but are not limited to, ink jet printing, gravure printing, and screen printing.

9. Electronic Devices

The new films described herein can be used in electronic devices where the high conductivity and high work-function is desired in combination with transparency. In some embodiments, the films are used as electrodes. In some embodiments, the films are used as transparent conductive coatings.

Examples of electronic devices include, but are not limited to: (1) a device that converts electrical energy into radiation (e.g., a light-emitting diode, light emitting diode display, diode laser, or lighting panel), (2) a device that detects a signal using an electronic process (e.g., a photodetector, a photoconductive cell, a photoresistor, a photoswitch, a phototransistor, a phototube, an infrared ("IR") detector, or a biosensors), (3) a device that converts radiation into electrical energy (e.g., a photovoltaic device or solar cell), (4) a device that includes one or more electronic components that include one or more organic semiconductor layers (e.g., a transistor or diode), (5) an electrolytic capacitor, or any combination of devices in items (1) through (5).

In some embodiments, the new films described herein are useful as an electrically conductive polymer cathode, for example, in Tantalum/Ta₂O₅ or Aluminum/Al₂O₃ capacitors.

In some embodiments, there are provided electronic devices comprising at least one electroactive layer positioned between two electrical contact layers, wherein the device further includes the new hole injection layer. The term "electroactive" when referring to a layer or material is intended to mean a layer or material that exhibits electronic or electro-radiative properties. An electroactive layer material may emit radiation or exhibit a change in concentration of electron-hole pairs when receiving radiation.

As shown in FIG. 1, one embodiment of a device, 100, has an anode layer 110, an electroactive layer 140, and a cathode layer 160. Also shown are three optional layers: hole injection layer 120; hole transport layer 130; and electron injection/transport layer 150.

The device may include a support or substrate (not shown) that can be adjacent to the anode layer 110 or the cathode layer 160. Most frequently, the support is adjacent the anode layer 110. The support can be flexible or rigid, organic or inorganic. Examples of support materials
5 include, but are not limited to, glass, ceramic, metal, and plastic films.

The anode layer 110 is an electrode that is more efficient for injecting holes compared to the cathode layer 160. Thus, the anode has a higher work-function than the cathode. The new films of this invention described herein are particularly suitable as the anode layer because of
10 their high conductivity and high work-function. In some embodiments, the new films have a conductivity of 100 S/cm or greater. In some embodiments, they have a conductivity of 200 S/cm or greater. The films are deposited onto substrates using a variety of techniques well-known to those skilled in the art. Typical deposition techniques include liquid
15 deposition (continuous and discontinuous techniques), and thermal transfer.

In some embodiments, the new films described herein are used alone as an anode without optional hole injection layer 120. In this embodiment, the new films of this invention serve the functions of both the
20 anode layer and the hole injection layer.

In some embodiments, the new films described herein are used as the top layer in a bilayer or multilayer anode. The other anode layers can include materials containing a metal, mixed metal, alloy, metal oxide or mixed oxide. Suitable materials include the mixed oxides of the Group 2
25 elements (i.e., Be, Mg, Ca, Sr, Ba, Ra), the Group 11 elements, the elements in Groups 4, 5, and 6, and the Group 8-10 transition elements. If the anode layer 110 is to be light transmitting, mixed oxides of Groups 12, 13 and 14 elements may be used. As used herein, the phrase "mixed oxide" refers to oxides having two or more different cations selected from
30 the Group 2 elements or the Groups 12, 13, or 14 elements. Examples of suitable materials include, but are not limited to, indium-tin-oxide ("ITO"), indium-zinc-oxide ("IZO"), aluminum-tin-oxide ("ATO"), aluminum-zinc-oxide ("AZO"), zirconium-tin-oxide ("ZTO"), gold, silver, copper, and nickel.

In some embodiments, the mixed oxide layer is patterned. The pattern may vary as desired. The layer can be formed in a pattern by, for example, using a discontinuous deposition technique. Alternatively, the layer can be applied as an overall layer (also called blanket deposit) and subsequently patterned using, for example, a patterned resist layer and wet chemical or dry etching techniques. Other processes for patterning that are well known in the art can also be used.

Optional hole injection layer 120 may be present adjacent to the anode layer 110. The term "hole injection layer" or "hole injection material" is intended to mean electrically conductive or semiconductive materials having conductivity usually in the range between 10^{-3} to 10^{-7} S/cm, but higher conductivity can be used for some device geometries. The hole injection layer may have one or more functions in an organic electronic device, including but not limited to, planarization of the underlying layer, charge transport and/or charge injection properties, scavenging of impurities such as oxygen or metal ions, and other aspects to facilitate or to improve the performance of the organic electronic device.

In some embodiments, the hole injection layer 120 comprises the new film described herein, where the conductivity is 10^{-3} S/cm or less.

In some embodiments, optional hole transport layer 130 is present between anode layer 110 and electroactive layer 140. In some embodiments, optional hole transport layer is present between a hole injection layer 120 and electroactive layer 140. Examples of hole transport materials for the hole transport layer have been summarized for example, in Kirk-Othmer Encyclopedia of Chemical Technology, Fourth Edition, Vol. 18, p. 837-860, 1996, by Y. Wang. Both hole transporting small molecules and polymers can be used. Commonly used hole transporting molecules include, but are not limited to: 4,4',4''-tris(N,N-diphenyl-amino)-triphenylamine (TDATA); 4,4',4''-tris(N-3-methylphenyl-N-phenyl-amino)-triphenylamine (MTDATA); N,N'-diphenyl-N,N'-bis(3-methylphenyl)-[1,1'-biphenyl]-4,4'-diamine (TPD); 4,4'-bis(carbazol-9-yl)biphenyl (CBP); 1,3-bis(carbazol-9-yl)benzene (mCP); 1,1-bis[(di-4-tolylamino) phenyl]cyclohexane (TAPC); N,N'-bis(4-methylphenyl)-N,N'-

bis(4-ethylphenyl)-[1,1'-(3,3'-dimethyl)biphenyl]-4,4'-diamine (ETPD);
tetrakis-(3-methylphenyl)-N,N,N',N'-2,5-phenylenediamine (PDA); α -
phenyl-4-N,N-diphenylaminostyrene (TPS); p-(diethylamino)benzaldehyde
diphenylhydrazone (DEH); triphenylamine (TPA); bis[4-(N,N-
5 diethylamino)-2-methylphenyl](4-methylphenyl)methane (MPMP);
1-phenyl-3-[p-(diethylamino)styryl]-5-[p-(diethylamino)phenyl] pyrazoline
(PPR or DEASP); 1,2-trans-bis(9H-carbazol-9-yl)cyclobutane (DCZB);
N,N,N',N'-tetrakis(4-methylphenyl)-(1,1'-biphenyl)-4,4'-diamine (TTB);
N,N'-bis(naphthalen-1-yl)-N,N'-bis-(phenyl)benzidine (α -NPB); and
10 porphyrinic compounds, such as copper phthalocyanine. Commonly used
hole transporting polymers include, but are not limited to,
polyvinylcarbazole, (phenylmethyl)polysilane, poly(dioxythiophenes),
polyanilines, and polypyrroles. It is also possible to obtain hole
transporting polymers by doping hole transporting molecules such as
15 those mentioned above into polymers such as polystyrene and
polycarbonate. In some cases, triarylamine polymers are used, especially
triarylamine-fluorene copolymers. In some cases, the polymers and
copolymers are crosslinkable. Examples of crosslinkable hole transport
polymers can be found in, for example, published US patent application
20 2005-0184287 and published PCT application WO 2005/052027. In some
embodiments, the hole transport layer is doped with a p-dopant, such as
tetrafluorotetracyanoquinodimethane and perylene-3,4,9,10-
tetracarboxylic-3,4,9,10-dianhydride.

Depending upon the application of the device, the electroactive
25 layer 140 can be a light-emitting layer that is activated by an applied
voltage (such as in a light-emitting diode or light-emitting electrochemical
cell), a layer of material that responds to radiant energy and generates a
signal with or without an applied bias voltage (such as in a photodetector).
In one embodiment, the electroactive material is an organic
30 electroluminescent ("EL") material. Any EL material can be used in the
devices, including, but not limited to, small molecule organic fluorescent
compounds, fluorescent and phosphorescent metal complexes,
conjugated polymers, and mixtures thereof. Examples of fluorescent

compounds include, but are not limited to, chrysenes, pyrenes, perylenes, rubrenes, coumarins, anthracenes, thiadiazoles, derivatives thereof, and mixtures thereof. Examples of metal complexes include, but are not limited to, metal chelated oxinoid compounds, such as tris(8-hydroxyquinolato)aluminum (Alq₃); cyclometalated iridium and platinum electroluminescent compounds, such as complexes of iridium with phenylpyridine, phenylquinoline, or phenylpyrimidine ligands as disclosed in Petrov et al., U.S. Patent 6,670,645 and Published PCT Applications WO 03/063555 and WO 2004/016710, and organometallic complexes described in, for example, Published PCT Applications WO 03/008424, WO 03/091688, and WO 03/040257, and mixtures thereof. In some cases the small molecule fluorescent or organometallic materials are deposited as a dopant with a host material to improve processing and/or electronic properties. Examples of conjugated polymers include, but are not limited to poly(phenylenevinylenes), polyfluorenes, poly(spirobifluorenes), polythiophenes, poly(p-phenylenes), copolymers thereof, and mixtures thereof.

Optional layer 150 can function both to facilitate electron injection/transport, and can also serve as a confinement layer to prevent quenching reactions at layer interfaces. More specifically, layer 150 may promote electron mobility and reduce the likelihood of a quenching reaction if layers 140 and 160 would otherwise be in direct contact. Examples of electron transport materials which can be used in the optional electron transport layer 150, include metal chelated oxinoid compounds, including metal quinolate derivatives such as tris(8-hydroxyquinolato)aluminum (AlQ), bis(2-methyl-8-quinolinolato)(p-phenylphenolato) aluminum (BAIq), tetrakis-(8-hydroxyquinolato)hafnium (HfQ) and tetrakis-(8-hydroxyquinolato)zirconium (ZrQ); and azole compounds such as 2-(4-biphenyl)-5-(4-t-butylphenyl)-1,3,4-oxadiazole (PBD), 3-(4-biphenyl)-4-phenyl-5-(4-t-butylphenyl)-1,2,4-triazole (TAZ), and 1,3,5-tri(phenyl-2-benzimidazole)benzene (TPBI); quinoxaline derivatives such as 2,3-bis(4-fluorophenyl)quinoxaline; phenanthrolines such as 4,7-diphenyl-1,10-phenanthroline (DPA) and 2,9-dimethyl-4,7-

diphenyl-1,10-phenanthroline (DDPA); and mixtures thereof. In some embodiments, the electron transport layer further comprises an n-dopant. Examples of n-dopants include, but are not limited to Cs or other alkali metals.

5 The cathode layer 160 is an electrode that is particularly efficient for injecting electrons or negative charge carriers. The cathode layer 160 can be any metal or nonmetal having a lower work function than the first electrical contact layer (in this case, the anode layer 110). The cathode 160, is an electrode that is particularly efficient for injecting electrons or
10 negative charge carriers. The cathode can be any metal or nonmetal having a lower work function than the anode. Materials for the cathode can be selected from alkali metals of Group 1 (e.g., Li, Cs), the Group 2 (alkaline earth) metals, the Group 12 metals, including the rare earth elements and lanthanides, and the actinides. Materials such as aluminum,
15 indium, calcium, barium, samarium and magnesium, as well as combinations, can be used. Li-containing organometallic compounds, LiF, Li₂O, Cs-containing organometallic compounds, CsF, Cs₂O, and Cs₂CO₃ can also be deposited between the organic layer and the cathode layer to lower the operating voltage. This layer may be referred to as an electron
20 injection layer.

 The cathode layer 160 is usually formed by a chemical or physical vapor deposition process. In some embodiments, the cathode layer will be patterned, as discussed above in reference to the anode layer 110.

 Other layers in the device can be made of any materials which are
25 known to be useful in such layers upon consideration of the function to be served by such layers.

 In some embodiments, an encapsulation layer (not shown) is deposited over the contact layer 160 to prevent entry of undesirable components, such as water and oxygen, into the device 100. Such
30 components can have a deleterious effect on the organic layer 140. In one embodiment, the encapsulation layer is a barrier layer or film. In one embodiment, the encapsulation layer is a glass lid.

Though not depicted, it is understood that the device 100 may comprise additional layers. Other layers that are known in the art or otherwise may be used. In addition, any of the above-described layers may comprise two or more sub-layers or may form a laminar structure.

5 Alternatively, some or all of anode layer 110, the hole injection layer 120, the hole transport layer 130, the electron transport layer 150, cathode layer 160, and other layers may be treated, especially surface treated, to increase charge carrier transport efficiency or other physical properties of the devices. The choice of materials for each of the component layers is
10 preferably determined by balancing the goals of providing a device with high device efficiency with device operational lifetime considerations, fabrication time and complexity factors and other considerations appreciated by persons skilled in the art. It will be appreciated that determining optimal components, component configurations, and
15 compositional identities would be routine to those of ordinary skill of in the art.

In one embodiment, the different layers have the following range of thicknesses: anode 110, 500-5000 Å, in one embodiment 1000-2000Å; optional hole injection layer 120, 50-2000 Å, in one embodiment 200-1000
20 Å; optional hole transport layer 130, 50 -2000 Å, in one embodiment 100-1000 Å; electroactive layer 140, 10-2000 Å, in one embodiment 100-1000 Å; optional electron transport layer 150, 50-2000 Å, in one embodiment 100-1000 Å; cathode 160, 200-10000 Å, in one embodiment 300-5000 Å. The location of the electron-hole recombination zone in the device, and
25 thus the emission spectrum of the device, can be affected by the relative thickness of each layer. Thus the thickness of the electron-transport layer should be chosen so that the electron-hole recombination zone is in the light-emitting layer. The desired ratio of layer thicknesses will depend on the exact nature of the materials used.

30 In operation, a voltage from an appropriate power supply (not depicted) is applied to the device 100. Current therefore passes across the layers of the device 100. Electrons enter the organic polymer layer, releasing photons. In some OLEDs, called active matrix OLED displays,

individual deposits of photoactive organic films may be independently excited by the passage of current, leading to individual pixels of light emission. In some OLEDs, called passive matrix OLED displays, deposits of photoactive organic films may be excited by rows and columns of electrical contact layers.

Although methods and materials similar or equivalent to those described herein can be used in the practice or testing of the present invention, suitable methods and materials are described below. All publications, patent applications, patents, and other references mentioned herein are incorporated by reference in their entirety. In case of conflict, the present specification, including definitions, will control. In addition, the materials, methods, and examples are illustrative only and not intended to be limiting.

It is to be appreciated that certain features of the invention which are, for clarity, described above and below in the context of separate embodiments, may also be provided in combination in a single embodiment. Conversely, various features of the invention that are, for brevity, described in the context of a single embodiment, may also be provided separately or in any subcombination. Further, reference to values stated in ranges include each and every value within that range.

EXAMPLES

General procedure for work function measurement:

1cmx1cm ITO were first cleaned with water and isopropanol and then UV-ozned for 5 minutes before spin-coating of each sample described in comparative examples and examples. Three drops of each dispersion sample was applied on each ITO substrate and then taken to 4,000rpm in 08 seconds on a spin-coater, and remained at the speed for one minute. The coated samples were then baked in air at 140°C for 7 minutes. Samples cooled down in air before being loaded one at a time into the chamber for Low Intensity X-ray Photoemission Spectroscopy (LIXPS). The sample is mounted on a titanium sample holder in a laminar

flow hood (in air). Electrical contact is verified by an ohmmeter probing the surface of the sample (on a corner) & the sample holder. The sample & holder is then pumped down from atmospheric pressure to UHV in the loadlock. The sample is moved to an analysis chamber with base pressure
5 around 2×10^{-11} Torr, and an operating pressure around 1×10^{-10} to 2×10^{-10} Torr.

The LIXPS experiments presented in this application were carried out in a commercially available integrated ultrahigh vacuum surface analysis system (SEPCS, Berlin, Germany) using XR50 X-ray source with
10 Mg anode (Mg $K\alpha$, 1253.6eV, gun to sample distance about 6cm) at 3W (out of full power of 200W).

General procedure for measurement of electrical resistance and calculation of electrical conductivity:

15 One drop of each dispersion sample was spread on a 3"x1" microscope slide to cover 2/3 area of the slide. Excess of liquid was tilted to one edge of the slide to be soaked-up by a tissue. Once a smooth, homogeneous layer of liquid was ensured, the slide was placed on a flat surface for initial drying at room temperature. The slide was then placed
20 on a hot plate set at 180°C for 10 minutes. The whole operation was carried out in air. The film containing slide was removed from the hot plate and the film was trimmed to a long strip with a razor blade. Width of the strip ranged from 0.2cm to 0.7cm and the length was about 3cm. Silver paste was then painted perpendicular to the length of the strip to
25 form four electrodes. The two inner parallel electrodes were about 0.3cm to 0.5 cm apart and were connected to a Keithley model 616 electrometer for measurement of voltage when a known current supplied by a Keithley model 225 Current Source was applied to the two other parallel electrodes. A series of corresponding current/voltage data obtained at
30 room temperature was recorded to see whether Ohm's law was followed. All the samples in Examples and Comparative Examples followed Ohm's law, which provided a more or less identical resistance for the corresponding current/voltage data. Once measured was done, the area

in the two inner electrodes was measured for thickness with a Profilometer. Since resistance, thickness, separation length of the two inner electrodes and the width of the filmstrip are known, electrical conductivity is then calculated. The conductivity unit is expressed as S/cm (Siemens per centimeter).

General procedure for contact angle measurement:

A couple drops of each composition liquid prepared in the Examples were placed on a 3"x2" microscope slide to cover two third of the surface. The liquid was left dried in air to form smooth film and then baked at 120°C in air for 10 minutes. A drop of p-xylene or anisole was then dropped on the film. The contact between the liquid and the film surface was captured on a display screen for determining the contact angle using a software program.

General procedure for nanoparticle size measurement:

Nanoparticle dispersed in a liquid was measured at various concentrations using Microtrac Nanoprac based on dynamic light scattering technique. The particle size is summarized in cumulative% of volume distribution.

Comparative Example A

This comparative example illustrates the properties of a conductive polymer doped with a non-fluorinated polymeric acid.

Baytron-P PH500 is an aqueous dispersion of PEDOT-PSSA from H. C. Starck GmbH (Leverkusen, Germany). PEDOT/PSSA is an abbreviation for poly (3,4-ethylene-dioxythiophene) doped with poly (styrenesulfonic acid), a nonfluorinated polymeric acid. According to the product brochure, the weight ratio of PEDOT to PSSA of the Baytron-P is 1:2.5. Gravimetric analysis shows that the Baytron-P contains 1.0%(w/w) in water. A small drop of Baytron-P PH500 was made into thin film for conductivity measurement, which was determined to be 0.85 S/cm. Since the conducting polymer doesn't have fluorinated component, the surface

is very wettable with toluene. The work function was measured to be 5.14eV.

Comparative Example B

5 This comparative example illustrates the properties of a conductive polymer doped with a non-fluorinated polymeric acid polymer in combination with a highly-fluorinated acid polymer.

 In this comparative example, the doped conductive polymer was Baytron-P PH500, as described in comparative example A. The HFAP was
10 a copolymer of tetrafluoroethylene (TFE) and perfluoro-3,6-dioxo-4-methyl-7-octenesulfonic acid (PSEPVE), referred to as p-(TFE-PSEPVE). The p-(TFE-PSEPVE) used for the blending was an aqueous colloidal dispersion having an acid equivalent (EW) of 1000. The EW means weight in gram of the polymer per one sulfonic acid group. A 25% (w/w) dispersion of p-
15 (TFE-PSEPVE) in water was made using a procedure similar to the procedure in US Patent 6,150,426, Example 1, Part 2, except that the temperature was approximately 270°C. The dispersion was diluted with water to form a 10.93% (w/w) dispersion for further use.

 0.7146g of the p-(TFE-PSEPVE) dispersion was added to 10.0037g
20 Baytron-P pH500. The resulting dispersion mixture was smooth and showed no sign of separation. The mixture contained 0.93%(w/w) PEDOT-PSSA, 0.73%(w/w) p-(TFE-PSEPVE) wherein the equivalent acid ratio between p-(TFE-PSEPVE) and PSSA was 0.2. The "equivalent ratio" as used herein, is intended to mean the ratio of the number of acid
25 equivalents of p-(TFE-PSEPVE) polymer to the number of acid equivalent of PSSA. A couple drops of the PEDOT-PSSA/p-(TFE-PSEPVE) dispersion were made into thin films. The work function was determined to be 5.85eV and the conductivity was determined to be 0.1S/cm at room temperature. The contact angle was 51degrees with p-xylene, and
30 61degrees with anisole. The contact angles are very high with both organic solvents, meaning that the surface is not wettable with either of the solvents. A drop of toluene placed on the film surface rolls around without spreading, showing that the surface is not wettable with toluene

either. The conductivity remains low as compared with the conductivity shown in comparative example 1, meaning that addition of p-(TFE-PSEPVE) only enhances the work function, but does not increase the conductivity or render the surface wettable.

5

Example 1

This example illustrates the properties of an aqueous dispersion of a conductive polymer doped with a non-fluorinated polymeric acid, a highly-fluorinated acid polymer, electrically insulative inorganic oxide
10 nanoparticles, and a water-compatible high-boiling organic solvent.

5.3584g of PEDOT-PSSA/p-(TFE-PSEPVE) prepared in Comparative Example B were added with 0.7737g of 21.2% (w/w) silica in ethylene glycol ("EG"). The silica in ethylene glycol is marketed as EG-ST by Nissan Chemical Company in Houston, Texas. Boiling point of
15 ethylene glycol at atmosphere pressure is ~200°C. The PEDOT-PSSA/p-(TFE-PSEPVE)/silica/EG dispersion contained 4.07% (w/w) total solid wherein 1.40% (w/w) is silica and the rest, 2.67%(w/w), is PEDOT-PSSA/p-(TFE-PSEPVE). The wt.% of silica with respect to total solid is 34.4%. The dispersion also contains 9.94%(w/w) ethylene glycol. EG has
20 a boiling point of 197.3°C and is soluble in water in all proportions.

A couple drops of the PEDOT-PSSA/p-(TFE-PSEPVE)/silica/EG dispersion were made into thin films and the work function was determined to be 5.68eV. The work function is still very high for OLED applications as a hole injection layer. The conductivity of the films was determined to be
25 117S/cm, which is about four orders of magnitude higher than the films in Comparative Example B. The contact angle dropped from 51° to 24° with p-xylene, and from 61° to 41° with anisole. The decrease of the contact angle is substantial, which means the film surface becomes wettable with both organic solvents from the addition of the silica nanoparticles.

30

Table 1 shows particle size of the silica dispersion in ethylene glycol at three concentrations. It has a particle size of about 3.9

nanometers (nm) at cumulative 50% volume distribution, which means that 50% by volume of the silica has a particle size of 3.9nm or less

Table 1. Particle Size Distribution

SAMPLE ID	RUN #	5%	16%	50%	84%	95%
EG-ST (21.2% silica)	RUN 1	3.310	3.500	4.000	4.650	5.150
	RUN 2	3.300	3.470	3.920	4.460	4.860
	RUN 3	3.270	3.410	3.770	4.210	4.430
	AVERAGE	3.293	3.460	3.897	4.440	4.813
EG-ST (10.6% silica)	RUN 1	3.270	3.410	3.790	4.260	4.530
	RUN 2	3.260	3.390	3.720	4.140	4.360
	RUN 3	3.260	3.380	3.700	4.120	4.340
	AVERAGE	3.263	3.393	3.737	4.173	4.410
EG-ST (5.3% silica)	RUN 1	3.270	3.410	3.780	4.270	4.560
	RUN 2	3.270	3.420	3.800	4.280	4.590
	RUN 3	3.270	3.410	3.780	4.260	4.550
	AVERAGE	3.270	3.413	3.787	4.270	4.567

5

Comparative Example C

This comparative example illustrates the properties of an aqueous dispersion of a conductive polymer doped with a non-fluorinated polymeric acid, a highly-fluorinated acid polymer and a high boiling solvent.

0.1493g ethylene glycol was added to 1.4372g of PEDOT-PSSA/p-(TFE-PSEPVE) dispersion prepared in Comparative Example B. It formed a smooth dispersion wherein it contains 0.84% (w/w) PEDOT-PSSA, 0.66%(w/w) p-(TFE-PSEPVE), and 9.41%(w/w) ethylene glycol. A drop of toluene was placed on film surfaces. The toluene only rolled around without spreading, showing that the surface is not wettable with a non-polar organic solvent. This result clearly illustrates that the wettability demonstrated in Example 1 is not attributed to ethylene glycol, but to the nanoparticles of the silica.

20

Comparative Example D

This comparative example illustrates the properties of a dispersion of a conductive polymer doped with a non-fluorinated polymeric acid and blended with a highly-fluorinated acid polymer.

- 5 1.4631g of the p-(TFE-PSEPVE) dispersion described in Comparative Example B was added to 10.0160g Baytron-P pH500. The resulting dispersion mixture was smooth and showed no sign of separation. The mixture contains 0.89%(w/w) PEDOT-PSSA, 1.39%(w/w) p-(TFE-PSEPVE) wherein the equivalent acid ratio between p-(TFE-PSEPVE) and
- 10 PSSA is 0.41. A couple drops of the PEDOT-PSSA/p-(TFE-PSEPVE) dispersion were made into thin films. The work function was determined to be 5.98eV and conductivity was determined to be 0.2S/cm at room temperature. Moreover, the contact angle was 50° with p-xylene and 58° with anisole. The contact angles are very high with both organic solvents,
- 15 meaning that the surface is not wettable with both organic solvents. A drop of toluene placed on the film surface rolls around without spreading, showing that the surface is not wettable with toluene either. The conductivity remains low as compared with the conductivity shown in Comparative Example A, meaning that addition of p-(TFE-PSEPVE) only
- 20 enhances the workfunction, but renders the surface not wettable.

Example 2

- This example illustrates the properties of an aqueous dispersion of a conductive polymer doped with a non-fluorinated polymeric acid, a highly-
- 25 fluorinated acid polymer, electrically insulative inorganic oxide nanoparticles, and a water-compatible high-boiling organic solvent.

- 5.7313g of PEDOT-PSSA/p-(TFE-PSEPVE) prepared in Comparative Example D was added with 1.1016g of 21.2% (w/w) silica in ethylene glycol. The silica in ethylene glycol is marketed as EG-ST by
- 30 Nissan Chemical Company in Houston, Texas. The PEDOT-PSSA/p-(TFE-PSEPVE)/silica dispersion contained 5.33% (w/w) total solid wherein 3.42% (w/w) is silica and the rest, 1.91%(w/w), is PEDOT-PSSA/p-(TFE-

PSEPVE). The wt.% of silica with respect to total solid is 64.2%. The dispersion also contains 12.7%(w/w) ethylene glycol.

A couple drops of the PEDOT-PSSA/p-(TFE-PSEPVE)/silica/EG dispersion were made into thin films and work-function was determined to be 5.75eV, which drops only 0.23eV with the silica when compared with the film made in Comparative Example D. The work function was still very high for OLED applications as a hole injection layer. The conductivity of the films were determined to be 100.3S/cm, which is about four order magnitude higher than the films in Comparative Example D where there is no ethylene glycol, a high boiling organic liquid for conductivity enhancement. The contact angle dropped from 50° to 29° with p-xylene and from 58° to 43° with anisole. The decrease of the contact angle is substantial, which means the film surface becomes wettable with both organic solvents from the addition of the silica nanoparticles.

A summary of all the examples is given in Table 2 below.

Table 2. Summary of Properties

Ex.	Silica wt%	Acid Equiv. Ratio	EG wt. %	Cond. S/cm	Wf EV	Wettability		
						toluene	p-xylene	anisole
Comp. A	none	--	none	0.85	5.14	wets	wets	
Comp. B	none	0.2	none	0.1	5.85		CA=51°	CA=61°
Comp. C	none	0.2	9.41			does not wet		
Comp. D	none	0.41	none	0.2	5.98		CA=50°	CA=58°
Ex. 1	34.4	0.2	9.94	117	5.68		CA=24°	CA=41°
Ex. 2	64.2	0.41	12.7	100.3	5.75		CA=29°	CA=43°

Silica wt% is based on total solids; acid equiv. ratio is acid equivalent ratio of p-(TFE-PSEPVE) to PSSA; EG wt% is based on total dispersion weight; Cond. is conductivity; Wf is work function; CA is contact angle.

Note that not all of the activities described above in the general description or the examples are required, that a portion of a specific activity may not be required, and that one or more further activities may be

performed in addition to those described. Still further, the order in which activities are listed are not necessarily the order in which they are performed.

In the foregoing specification, the concepts have been described
5 with reference to specific embodiments. However, one of ordinary skill in the art appreciates that various modifications and changes can be made without departing from the scope of the invention as set forth in the claims below. Accordingly, the specification and figures are to be regarded in an illustrative rather than a restrictive sense, and all such modifications are
10 intended to be included within the scope of invention.

Benefits, other advantages, and solutions to problems have been described above with regard to specific embodiments. However, the benefits, advantages, solutions to problems, and any feature(s) that may cause any benefit, advantage, or solution to occur or become more
15 pronounced are not to be construed as a critical, required, or essential feature of any or all the claims.

It is to be appreciated that certain features are, for clarity, described herein in the context of separate embodiments, may also be provided in combination in a single embodiment. Conversely, various features that
20 are, for brevity, described in the context of a single embodiment, may also be provided separately or in any subcombination.

The use of numerical values in the various ranges specified herein is stated as approximations as though the minimum and maximum values within the stated ranges were both being preceded by the word "about." In
25 this manner slight variations above and below the stated ranges can be used to achieve substantially the same results as values within the ranges. Also, the disclosure of these ranges is intended as a continuous range including every value between the minimum and maximum average values including fractional values that can result when some of components of
30 one value are mixed with those of different value. Moreover, when broader and narrower ranges are disclosed, it is within the contemplation of this invention to match a minimum value from one range with a maximum value from another range and vice versa.

49
CLAIMS

What is claimed is:

1. An aqueous dispersion comprising:
 - (i) at least one electrically conductive polymer doped with a non-fluorinated polymeric acid;
 - (ii) at least one highly-fluorinated acid polymer;
 - (iii) at least one water-compatible high-boiling organic solvent, and
 - (iv) electrically insulative inorganic oxide nanoparticles.
2. The dispersion of Claim 1, wherein the electrically conductive polymer is selected from the group consisting of polythiophenes, poly(selenophenes), poly(tellurophenes), polypyrroles, polyanilines, polycyclic aromatic polymers, copolymers thereof, and combinations thereof.
3. The dispersion of Claim 2, wherein the electrically conductive polymer is selected from the group consisting of a polyaniline, a polythiophene, a polypyrrole, a polymeric fused polycyclic heteroaromatic, copolymers thereof, and combinations thereof.
4. The dispersion of Claim 1, wherein the electrically conductive polymer is selected from the group consisting of unsubstituted polyaniline, poly(3,4-ethylenedioxythiophene), unsubstituted polypyrrole, poly(4-aminoindole), poly(7-aminoindole), poly(thieno(2,3-b)thiophene), poly(thieno(3,2-b)thiophene), and poly(thieno(3,4-b)thiophene).
5. The dispersion of Claim 1, wherein the highly-fluorinated acid polymer is at least 90% fluorinated.
6. The dispersion of Claim 1, wherein the highly-fluorinated acid polymer is selected from a sulfonic acid and a sulfonimide.

7. The dispersion of Claim 1, wherein the highly-fluorinated acid polymer is a perfluoroolefin having perfluoro-ether-sulfonic acid side chains.
8. The dispersion of Claim 1, wherein the highly-fluorinated acid polymer is selected from the group consisting of a copolymer of 1,1-difluoroethylene and 2-(1,1-difluoro-2-(trifluoromethyl)allyloxy)-1,1,2,2-tetrafluoroethanesulfonic acid and a copolymer of ethylene and 2-(2-(1,2,2-trifluorovinyl)oxy)-1,1,2,3,3,3-hexafluoropropoxy)-1,1,2,2-tetrafluoroethanesulfonic acid.
9. The dispersion of Claim 1, wherein the highly-fluorinated acid polymer is selected from a copolymer of tetrafluoroethylene and perfluoro(3,6-dioxo-4-methyl-7-octenesulfonic acid), and a copolymer of tetrafluoroethylene and perfluoro(3-oxo-4-pentenesulfonic acid).
10. The dispersion of Claim 1, wherein the acid equivalent ratio of the highly-fluorinated acid polymer to the non-fluorinated polymeric acid is no greater than 1.
11. The dispersion of Claim 1, wherein the solvent has a boiling point of greater than 120°C at atmosphere pressure.
12. The dispersion of Claim 1, wherein the solvent is present in an amount of from 1 to 30 wt.%, based on the total weight of the dispersion.
13. The dispersion of Claim 1, wherein the solvent is selected from the group consisting of ethylene glycol, propylene glycol, diethylene glycol, glycerol, dimethylsulfoxide, dimethylacetamide, N-methylpyrrolidone, and mixtures thereof.
14. A film made from the dispersion of Claim 1.

15. An electronic device comprising at least one layer made from the dispersion of Claim 1.

FIG. 1

