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(54) Title: METHOD OF MAKING MACROPOROUS ANION EXCHANGE RESINS



(57) Abstract: Methods of making macroporous anion exchange resins are described. The macroporous anion exchange resins are in the form of particles such as beads that contain a hydrophilic, crosslinked, (meth)acrylic-type polymeric material. Additionally, methods of purifying a negatively charged material using the macroporous anion exchange resins, methods of making chromatographic columns that contain the macroporous anion exchange resins, methods of making filter elements that contain the macroporous anion exchange resins, and methods of making porous composite materials that contain the macroporous anion exchange resins are described.

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METHOD OF MAKING MACROPOROUS ANION EXCHANGE RESINS

Technical Field

Methods of making and using a macroporous anion exchange resin are described.

Background

Ion exchange resins are widely used within the biotechnology industry for the large-scale separation and/or purification of various biological molecules such as proteins, enzymes, vaccines, DNA, RNA, and the like. The vast majority of the anion exchange resins are based on either styrene/divinylbenzene copolymers or crosslinked agarose. The hydrophobic backbone of styrene/divinylbenzene copolymers can be prone to non-specific interactions with a number of materials leading to impure products. Although crosslinked agarose resins are generally less susceptible to non-specific interactions, these materials tend to be fairly soft gels and are usually unsuitable for purifications conducted within a chromatographic column using a high flow rate.

Some known anion exchange resins are based on (meth)acrylic-type polymeric materials. Many of these anion exchange resins, however, are gels or have a relatively low capacity or low porosity.

Summary

Methods of making macroporous anion exchange resins, methods of purifying a negatively charged material using the macroporous anion exchange resins, methods of making chromatographic columns that contain the macroporous anion exchange resins, methods of making filter elements that contain the macroporous anion exchange resins, and methods of making porous composite materials that contain the macroporous anion exchange resins are described.

In one aspect, a method of forming a macroporous anion exchange resin is described. The method includes preparing an aqueous phase composition that contains (a) a monomer mixture; (b) a water-soluble porogen of Formula I



wherein R^1 is hydroxy, alkoxy, carboxy, acyloxy, or halo; each R^2 is independently an alkylene having 1 to 4 carbon atoms; R^3 is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl; and n is an integer of 1 to 1,000; and (c) an aqueous phase solvent mixture that includes water and a mono-alcohol having 1 to 4 carbon atoms. The mono-alcohol is present in an amount of at least 20 weight percent based on the total weight of the aqueous phase solvent mixture. The monomer mixture includes (1) a crosslinking monomer containing N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof; and (2) a positively charged ionic monomer. All of the monomers in the monomer mixture have a lipophilicity index that is less than or equal to 20. The method of forming the macroporous anion exchange resin further includes suspending the aqueous phase composition in a non-polar organic solvent, polymerizing the monomer mixture to form particles of polymeric material, and removing the porogen from the particles.

In a second aspect, a method of separating or purifying a negatively charged material is described. The method includes forming a macroporous anion exchange resin, contacting the macroporous anion exchange resin with negatively charged material, and adsorbing at least a portion of the negatively charged material on the macroporous anion exchange resin.

In a third aspect, a method of preparing a chromatographic column is described. The method includes forming a macroporous anion exchange resin and placing the macroporous anion exchange resin in a column.

In a fourth aspect, a method of preparing a filtration element is described. The method includes forming a macroporous anion exchange resin and disposing the macroporous anion exchange resin on a surface of a filtration medium.

In a fifth aspect, a method of making a porous composite material is described. The method includes forming a macroporous anion exchange resin and incorporating the macroporous anion exchange resin in a continuous, porous matrix.

The above summary of the present invention is not intended to describe each disclosed embodiment or every implementation of the present invention. The Figures, Detailed Description, and Examples that follow more particularly exemplify these embodiments.

Brief Description of the Drawings

The invention may be more completely understood in consideration of the following detailed description of various embodiments of the invention in connection with the accompanying drawings, in which:

Figure 1 shows a scanning electron micrograph of one exemplary macroporous anion exchange resin with a magnification of 15,000X. The macroporous anion exchange resin was prepared using a polyethylene glycol porogen having an average molecular weight of 600 grams/mole (g/mole).

Figure 2 shows a scanning electron micrograph of one exemplary macroporous anion exchange resin taken at with a magnification of 15,000X. The macroporous anion exchange resin was prepared using a polyethylene glycol porogen having an average molecular weight of 2,000 g/mole.

While the invention is amenable to various modifications and alternative forms, specifics thereof have been shown by way of example in the drawings and will be described in detail. It should be understood, however, that the intention is not to limit the invention to the particular embodiments described. On the contrary, the intention is to cover all modifications, equivalents, and alternatives falling within the spirit and scope of the invention.

Detailed Description of the Invention

Methods of making macroporous anion exchange resins are described. The macroporous anion exchange resins are in the form of particles such as beads that contain a hydrophilic, crosslinked, (meth)acrylic-type polymeric material. Additionally, methods of purifying a negatively charged material using the macroporous anion exchange resins, methods of making chromatographic columns that contain the macroporous anion exchange resins, methods of making filter elements that contain the macroporous anion exchange resins, and methods of making porous composite materials that contain the macroporous anion exchange resins are described.

The terms “a”, “an”, and “the” are used interchangeably with “at least one” to mean one or more of the elements being described.

The term "alkyl" refers to a monovalent group that is a radical of an alkane, which is a saturated hydrocarbon. The alkyl can be linear, branched, cyclic, or combinations thereof and typically has 1 to 20 carbon atoms. In some embodiments, the alkyl group contains 1 to 10 carbon atoms, 1 to 8 carbon atoms, 1 to 6 carbon atoms, or 1 to 4 carbon atoms. Examples of alkyl groups include, but are not limited to, methyl, ethyl, n-propyl, isopropyl, n-butyl, isobutyl, tert-butyl, n-pentyl, n-hexyl, cyclohexyl, n-heptyl, n-octyl, and ethylhexyl.

The term "alkylene" refers to a divalent group that is a radical of an alkane. The alkylene can be straight-chained, branched, cyclic, or combinations thereof. The alkylene typically has 1 to 20 carbon atoms. In some embodiments, the alkylene contains 1 to 10, 1 to 8, 1 to 6, or 1 to 4 carbon atoms. The radical centers of the alkylene can be on the same carbon atom (i.e., an alkylidene) or on different carbon atoms.

The term "acyloxy" refers to a monovalent group of formula $-\text{O}-(\text{CO})-\text{R}$ where R is an alkyl and (CO) denotes that the carbon is attached to the oxygen with a double bond. An exemplary acyloxy group is acetoxy where R is methyl.

The term "acyl" refers to a monovalent group of formula $-(\text{CO})-\text{R}$ where R is an alkyl and the (CO) denotes that the carbon is attached to the oxygen with a double bond. An exemplary acyl group is acetyl where R is methyl.

The term "carboxy" refers to a monovalent group of formula $-(\text{CO})\text{OH}$ where (CO) denotes that the carbon is attached to the oxygen with a double bond.

The term "carboxyalkyl" refers to an alkyl substituted with a carboxy group.

The term "halo" refers to fluoro, chloro, bromo, or iodo.

The term "haloalkyl" refers to an alkyl substituted with a halo group.

The term "(meth)acrylic" refers to a polymeric material that is the reaction product of a monomer composition that includes acrylic acid, methacrylic acid, derivatives of acrylic acid or methacrylic acid, or combinations thereof. As used herein, the term "(meth)acrylate" refers to monomers that are acrylic acid, methacrylic acid, derivatives of acrylic acid or methacrylic acid, or combinations thereof. Suitable derivatives include esters, salts, amides, nitriles, and the like that can be unsubstituted or substituted. Some of these derivatives can include an ionic group.

The term "(meth)acryloyl" refers to a monovalent group of formula

$\text{H}_2\text{C}=\text{CR}^b\text{-(CO)-}$ where R^b is hydrogen or methyl and (CO) denotes that the carbon is attached to the oxygen with a double bond.

The term “mono-alcohol” refers to an alcohol having a single hydroxy group. The alcohol is often of formula R-OH where R is an alkyl.

The terms “polymer” or “polymeric” refer to a material that is a homopolymer, copolymer, terpolymer, or the like. Likewise, the terms “polymerize” or “polymerization” refers to the process of making a homopolymer, copolymer, or the like.

The term “charged” refers to a material that has an ionic group as part of its chemical structure. A negatively charged material is an anion and a positively charged material is a cation. An oppositely charged counterion is typically associated with the ionic group. Adjusting the pH can alter the charge of some ionic groups.

The phrase “in the range of” includes the endpoints and all numbers between the endpoints. For example, the phrase in the range of 1 to 10 includes 1, 10, and all numbers between 1 and 10.

The term “water-soluble” used in reference to a porogen means that the porogen is miscible with the aqueous phase composition and does not partition out of an aqueous solution into a non-polar organic solvent to any appreciable extent. For example, less than 5 weight percent, less than 4 weight percent, less than 3 weight percent, less than 2 weight percent, or less than 1 weight percent of the porogen can be extracted from the aqueous solution into a non-polar organic solvent such as, for example, toluene and heptane.

As used herein, the term “room temperature” refers to temperatures in the range of 20°C to 25°C.

Unless otherwise indicated, all numbers expressing feature sizes, amounts, and physical properties used in the specification and claims are to be understood as being modified in all instances by the term “about.” Accordingly, unless indicated to the contrary, the numbers set forth are approximations that can vary depending upon the desired properties using the teachings disclosed herein.

The anion exchange resins are in the form of macroporous particles. As used herein, the term “macroporous” refers to particles that have a permanent porous structure even in the dry state. Although the resins can swell when contacted with a solvent, swelling is not needed to allow access to the interior of the particles through the porous structure. In contrast, gel-type resins do not have a permanent porous structure in the dry

state but must be swollen by a suitable solvent to allow access to the interior of the particles. Macroporous particles are further described in Sherrington, *Chem. Commun.*, 2275-2286 (1998) and Macintyre et al., *Macromolecules*, **37**, 7628-7636 (2004).

The method of making macroporous anion exchange resins involves the use of a porogen to vary or control the average pore size, the surface area, the anion exchange capacity, or a combination thereof. The average pore size, surface area, and anion exchange capacity are variables that can alter the effectiveness of an anion exchange resin for separating and/or purifying target molecules. Both the average pore size, which is characterized by the average pore diameter, and the surface area are measured by adsorption of nitrogen under cryogenic conditions. The anion exchange capacity refers to the amount of a negatively charged material (i.e., target molecule) that can adsorb on the anion exchange resin. Exemplary target molecules include, but are not limited to, biological molecules such as proteins, enzymes, nucleic acids, and the like. The anion exchange capacity can be given, for example, in terms of the amount of a biomolecule such as a protein (e.g., bovine serum albumin (BSA)) that can be adsorbed per unit volume of resin swollen in a solvent or per unit weight of the dry resin.

The anion exchange capacity tends to increase when the pores are large enough to accommodate the molecules of interest (i.e., target molecules). The largest anion exchange capacity for biological molecules often can be achieved by providing a large fraction of the total surface area of the anion exchange resin in the form of pores that are sufficiently large to allow access of the target molecules by diffusion.

For the separation of many biological target molecules, the largest anion exchange capacity typically can be achieved when the anion exchange resin has a distribution of pore sizes. The diameters of the pores are typically in the range of about 5 nanometers to about 500 nanometers. For the separation and/or purification of many biological target molecules, it is often desirable that at least some of the pores of the anion exchange resin have a diameter less than or equal to 200 nanometers. The methods of preparing macroporous anion exchange resins described herein provide particles in which at least some of the pores have a diameter less than or equal to 200 nanometers (e.g., in the range of 2 to 200 nanometers), less than or equal to 150 nanometers (e.g., in the range of 2 to 150 nanometers), or less than or equal to 100 nanometers (e.g., in the range of 2 to 100 nanometers).

The method of preparing the macroporous anion exchange resin includes forming an aqueous phase composition that includes (a) a monomer mixture that contains a crosslinking monomer and a positively charged ionic monomer; (b) a water-soluble porogen; and (c) an aqueous phase solvent mixture that contains water and a mono-alcohol. The method of preparing the macroporous anion exchange resin further includes suspending the aqueous phase composition in a non-polar organic solvent, polymerizing the monomer mixture to form particles of polymeric material, and removing the porogen from the anion exchange resin.

The anion exchange resins are the reaction products of a monomer mixture that contains a crosslinking monomer and a positively charged ionic monomer. The crosslinking monomer includes N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof. The positively charged monomer has an ethylenically unsaturated group capable of undergoing a free radical polymerization reaction as well as a positively charged group capable of interacting with a negatively charged material.

All or substantially all of the monomers in the monomer mixture have a lipophilicity index less than or equal to 20. As used herein, the term "lipophilicity index" or "LI" refers to an index for characterizing the hydrophobic or hydrophilic character of a monomer. The lipophilicity index is determined by partitioning a monomer in equal volumes (1:1) of a non-polar solvent (e.g., hexane) and a polar solvent (e.g., a 75:25 acetonitrile-water solution). The lipophilicity index is equal to the weight percent of the monomer remaining in the non-polar phase after partitioning. Monomers that are more hydrophobic tend to have a higher lipophilicity index; similarly, monomers that are more hydrophilic tend to have a lower lipophilicity index. Measurement of lipophilicity index is further described in Drtina et al., *Macromolecules*, **29**, 4486-4489 (1996).

As used herein with reference to the lipophilicity index of the monomer mixture being less than or equal to 20, the term "substantially all" means any monomer present with a lipophilicity index greater than 20 is present as an impurity. Any impurity with a lipophilicity index greater than 20 is present in an amount less than 2 weight percent, less than 1 weight percent, less than 0.5 weight percent, less than 0.2 weight percent, or less than 0.1 weight percent based on the total weight of the monomers in the monomer mixture. In some anion exchange resins, all or substantially all of the monomers in the

monomer mixture have a lipophilicity index no greater than 15, no greater than 10, no greater than 5, no greater than 3, or no greater than 1.

Suitable crosslinking monomers include N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof. These crosslinking monomers have at least two (meth)acryloyl groups that can react to crosslink one polymeric chain with another polymeric chain or that can react to crosslink one part of a polymeric chain with another part of the same polymeric chain. The crosslinking monomers are soluble in the aqueous phase composition and have a lipophilicity index less than or equal to 20.

Suitable N,N'-alkylenebis(meth)acrylamide crosslinking monomers include, but are not limited to, those having an alkylene group with 1 to 10, 1 to 8, 1 to 6, or 1 to 4 carbon atoms such as N,N'-methylenabisacrylamide, N,N'-methylenebismethacrylamide, N,N'-ethylenabisacrylamide, N,N'-ethylenebismethacrylamide, N,N'-propylenabisacrylamide, N,N'-propylenebismethacrylamide, N,N'-hexamethylenabisacrylamide, and N,N'-hexamethylenebismethacrylamide. Suitable N,N'-heteroalkylenebis(meth)acrylamide crosslinking monomers include, but are not limited to, N,N'-cystaminebisacrylamide, N,N'-piperazinebisacrylamide, and N,N'-piperazinebismethacrylamide. These crosslinking monomers are commercially available from various suppliers such as Sigma-Aldrich (Milwaukee, WI) and Polysciences, Inc. (Warrington, PA). Alternatively, these crosslinking monomers can be synthesized by procedures described in the art such as, for example, in Rasmussen, et al., *Reactive Polymers*, 16, 199-212 (1991/1992).

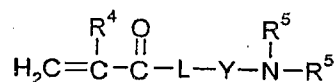
The monomer mixture includes greater than 10 weight percent crosslinking monomer based on the total weight of monomers in the monomer mixture. When lower amounts of the crosslinking monomer are used, the anion exchange resin tends to be in the form of a gel rather than in the form of macroporous particles. The rigidity or mechanical strength, which is measured by the differential pressure that the materials can withstand, tends to increase with the amount of crosslinking monomer included in the monomer mixture. Some monomer mixtures contain greater than 10 weight percent, at least 15 weight percent, at least 20 weight percent, at least 25 weight percent, or at least 30 weight percent crosslinking monomer.

The monomer mixture often contains up to 95 weight percent crosslinking monomer based on the total monomer weight. When the amount of the crosslinking monomer exceeds 95 weight percent, the anion exchange resin often has diminished anion exchange capacity because there is a corresponding decrease in the amount of the positively charged ionic monomer present in the monomer mixture. Some monomer mixtures contain up to 90 weight percent, up to 85 weight percent, up to 80 weight percent, up to 70 weight percent, up to 65 weight percent, up to 60 weight percent, up to 55 weight percent, up to 50 weight percent, up to 45 weight percent, or up to 40 weight percent crosslinking monomer.

Some monomer mixtures contain greater than 10 to 95 weight percent, greater than 10 to 90 weight percent, 20 to 90 weight percent, 20 to 80 weight percent, 25 to 80 weight percent, 25 to 75 weight percent, 25 to 70 weight percent, 25 to 60 weight percent, or 25 to 50 weight percent crosslinking monomer based on the total monomer weight.

The monomer mixture also includes a positively charged ionic monomer. The positively charged ionic monomer has at least one ethylenically unsaturated group capable of undergoing free radical polymerization. In some embodiments, the ethylenically unsaturated group is a (meth)acryloyl group or a vinyl group. The positively charged ionic monomer can be a weak base, a strong base, a salt of a weak base, a salt of a strong base, or combinations thereof. That is, the positively charged ionic monomer can be in a neutral state but capable of being charged if the pH is adjusted. When the pH is suitably adjusted, the resulting anion exchange resins have positively charged groups capable of interacting with negatively charged materials (i.e., anions). If the ionic monomer used to prepare a anion exchange resin includes a salt of a weak base or a salt of a strong base, the counter ions of these salts can be, but are not limited to, a halide (e.g., chloride), a carboxylate (e.g., acetate or formate), nitrate, phosphate, sulfate, bisulfate, methyl sulfate, or hydroxide.

Some exemplary ionic monomers are of amino (meth)acrylates or amino (meth)acrylamides of Formula II or quaternary ammonium salts thereof.



II

In Formula II, R^4 is hydrogen or methyl; L is oxy or $-NH-$; and Y is an alkylene (e.g., an alkylene having 1 to 10 carbon atoms, 1 to 6, or 1 to 4 carbon atoms). Each R^5 is independently hydrogen, alkyl, hydroxyalkyl (i.e., an alkyl substituted with a hydroxy), or aminoalkyl (i.e., an alkyl substituted with an amino). Alternatively, the two R^5 groups taken together with the nitrogen atom to which they are attached can form a heterocyclic group that is aromatic, partially unsaturated (i.e., unsaturated but not aromatic), or saturated, wherein the heterocyclic group can optionally be fused to a second ring that is aromatic (e.g., benzene), partially unsaturated (e.g., cyclohexene), or saturated (e.g., cyclohexane). The counter ions of the quaternary ammonium salts are often halides, sulfates, phosphates, nitrates, and the like.

In some embodiments of Formula II, both R^5 groups are hydrogen. In other embodiments, one R^5 group is hydrogen and the other is an alkyl having 1 to 10, 1 to 6, or 1 to 4 carbon atoms. In still other embodiments, at least one of R^5 groups is a hydroxy alkyl or an amino alkyl that have 1 to 10, 1 to 6, or 1 to 4 carbon atoms with the hydroxy or amino group being positioned on any of the carbon atoms of the alkyl group. In yet other embodiments, the R^5 groups combine with the nitrogen atom to which they are attached to form a heterocyclic group. The heterocyclic group includes at least one nitrogen atom and can contain other heteroatoms such as oxygen or sulfur. Exemplary heterocyclic groups include, but are not limited to imidazolyl. The heterocyclic group can be fused to an additional ring such as a benzene, cyclohexene, or cyclohexane. Exemplary heterocyclic groups fused to an additional ring include, but are not limited to, benzoimidazolyl.

Exemplary amino (meth)acrylates (i.e., L in Formula II is oxy) include N,N-dialkylaminoalkyl(meth)acrylates such as, for example, N,N-dimethylaminoethylmethacrylate, N,N-dimethylaminoethylacrylate, N,N-diethylaminoethylmethacrylate, N,N-diethylaminoethylacrylate, N,N-dimethylaminopropylmethacrylate, N,N-dimethylaminopropylacrylate, N-tert-butylaminopropylmethacrylate, N-tert-butylaminopropylacrylate and the like.

Exemplary amino (meth)acrylamides (i.e., L in Formula II is $-NH-$) include, for example, N-(3-aminopropyl)methacrylamide, N-(3-aminopropyl)acrylamide, N-[3-(dimethylamino)propyl]methacrylamide, N-(3-imidazolylpropyl)methacrylamide, N-(3-imidazolylpropyl)acrylamide, N-(2-imidazolethyl)methacrylamide, N-(1,1-dimethyl-3-

imidazolylpropyl)methacrylamide, N-(1,1-dimethyl-3-imidazolylpropyl)acrylamide, N-(3-benzoimidazolylpropyl)acrylamide, and N-(3-benzoimidazolylpropyl)methacrylamide.

Exemplary quaternary salts of the ionic monomers of Formula II include, but are not limited to, (meth)acrylamidoalkyltrimethylammonium salts (e.g., 3-methacrylamidopropyltrimethylammonium chloride and 3-acrylamidopropyltrimethylammonium chloride) and (meth)acryloxyalkyltrimethylammonium salts (e.g., 2-acryloxyethyltrimethylammonium chloride, 2-methacryloxyethyltrimethylammonium chloride, 3-methacryloxy-2-hydroxypropyltrimethylammonium chloride, 3-acryloxy-2-hydroxypropyltrimethylammonium chloride, and 2-acryloxyethyltrimethylammonium methyl sulfate).

Other monomers that can provide positively charged groups to an ion exchange resin include the dialkylaminoalkylamine adducts of alkenylazlactones (e.g., 2-(diethylamino)ethylamine, (2-aminoethyl)trimethylammonium chloride, and 3-(dimethylamino)propylamine adducts of vinyl dimethylazlactone) and diallylamine monomers (e.g., diallylammonium chloride and diallyldimethylammonium chloride).

The monomer mixture includes at least 5 weight percent of the positively charged monomer based on the total weight of monomers in the monomer mixture. When lower levels of the positively charged monomer are used, the anion exchange resin often has diminished anion exchange capacity. Some monomer mixtures contain at least 10 weight percent, at least 15 weight percent, at least 20 weight percent, at least 25 weight percent, at least 30 weight percent, or at least 35 weight percent of the positively charged monomer.

The monomer mixture often contains less than 90 weight percent of the positively charged ionic monomer based on the total weight of the monomers. When higher levels of the positively charged ionic monomer are used, the anion exchange resins tend to be gels rather than macroporous particles. That is, higher levels of positively charged ionic monomers are often accompanied by a corresponding decrease in the amount of crosslinking monomer. The rigidity and mechanical strength of the anion exchange resin tends to correlate with the amount of crosslinking monomer. Some monomer mixtures contain less than 90 weight percent, no greater than 85 weight percent, no greater than 80 weight percent, no greater than 75 weight percent, no greater than 70 weight percent, no greater than 65 weight percent, no greater than 60 weight percent, no greater than 55

weight percent, no greater than 50 weight percent, no greater than 45 weight percent, or no greater than 40 weight percent of the positively charged monomer.

Some monomer mixtures contain 5 to less than 90 weight percent, 10 to less than 90 weight percent, 20 to less than 90 weight percent, 30 to less than 90 weight percent, 30 to 80 weight percent, 40 to less than 90 weight percent, 40 to 80 weight percent, 50 to 80 weight percent, or 60 to 80 weight percent of the positively charged monomer based on the total monomer weight. The amount of positively charged monomer and crosslinking monomer can be balanced to provide an anion exchange resin with the desired combination of anion exchange capacity and mechanical strength.

For applications such as those that include the use of the macroporous ion exchange resins within a column, monomer mixtures containing 25 to 75 weight percent of the ionic monomer and 25 to 75 weight percent of the crosslinking monomer often provide the best balance of anion exchange capacity and mechanical strength. Some exemplary monomer mixtures include 35 to 75 weight percent of the positively charged ionic monomer and 25 to 65 weight percent of the crosslinking monomer, 40 to 75 weight percent of the positively charged ionic monomer and 25 to 60 weight percent of the crosslinking monomer, 50 to 75 weight percent of the positively charged ionic monomer and 25 to 50 weight percent of the crosslinking monomer, or 60 to 70 percent of the positively charged ionic monomer and 30 to 40 weight percent of the crosslinking monomer.

In some specific monomer mixtures, the crosslinking monomer is a N,N'-alkylenebis(meth)acrylamide and the positively charged ionic monomer is of Formula II. The monomer mixture includes 25 to 75 weight percent of the positively charged ionic monomer and 25 to 75 weight percent of the crosslinking monomer, 35 to 75 weight percent of the positively charged ionic monomer and 25 to 65 weight percent of the crosslinking monomer, 40 to 75 weight percent of the positively charged ionic monomer and 25 to 60 weight percent of the crosslinking monomer, 50 to 75 weight percent of the positively charged ionic monomer and 25 to 50 weight percent of the crosslinking monomer, or 60 to 70 percent of the positively charged ionic monomer and 30 to 40 weight percent of the crosslinking monomer. For example, the monomer mixture can contain 35 weight percent of the crosslinking monomer and 65 weight percent of the positively charged ionic monomer.

Although some monomer mixtures are free of monomers other than the crosslinking monomer and the positively charged ionic monomer, other monomer mixtures include a hydrophilic but non-ionic monomer having a single ethylenically unsaturated group. The hydrophilic, non-ionic monomer can be added, for example, for the purpose of adjusting the anion exchange capacity while maintaining the amount of crosslinking monomer constant. That is, the anion exchange capacity can be modified without significantly altering the amount of crosslinking, or the rigidity of the anion exchange resin. Additionally, the hydrophilic character of the anion exchange resins can be modified with the use of these non-ionic monomers.

Suitable hydrophilic, non-ionic monomers are typically present in amounts no greater than 50 weight percent based on the total weight of the monomers in the monomer mixture. In some anion exchange resins, the monomer mixture contains no greater than 40 weight percent, no greater than 20 weight percent, no greater than 10 weight percent, no greater than 5 weight percent, no greater than 2 weight percent, or no greater than 1 weight percent hydrophilic, non-ionic monomer based on the total weight of monomers.

Examples of non-ionic monomers that have a sufficiently low lipophilicity index include, but are not limited to, hydroxyalkyl(meth)acrylates such as 2-hydroxyethylacrylate, 3-hydroxypropylacrylate, 2-hydroxyethylmethacrylate (e.g., LI is 1), and 3-hydroxypropylmethacrylate (e.g., LI is 2); acrylamide (e.g., LI is less than 1) and methacrylamide (LI is less than 1); glycerol monomethacrylate and glycerol monoacrylate; N-alkyl(meth)acrylamides such as N-methylacrylamide (e.g., LI is less than 1), N,N-dimethylacrylamide (e.g., LI is less than 1), N-methylmethacrylamide, and N,N-dimethylmethacrylamide; N-vinylamides such as N-vinylformamide, N-vinylacetamide, and N-vinylpyrrolidone; acetoxyalkyl(meth)acrylates such as 2-acetoxyethylacrylate and 2-acetoxyethylmethacrylate (e.g., LI is 9); glycidyl(meth)acrylates such as glycidylacrylate and glycidylmethacrylate (e.g., LI is 11); and vinylalkylazlactones such as vinyl dimethylazlactone (e.g., LI is 15).

The monomer mixture is generally substantially free of hydrophobic monomers. More specifically, the monomer mixture is substantially free of monomers having a lipophilicity index greater than 20. Anionic exchange resins that are substantially free of hydrophobic monomers tend to have low non-specific adsorption of impurities such as non-target materials such as non-target proteins, lipids, and the like. Monomers that have

a lipophilicity index greater than 20 and that are generally not in the monomer mixture include, for example, ethyleneglycoldimethacrylate (LI is 25), phenoxyethylmethacrylate (LI is 32), trimethylolpropanetrimethacrylate (LI is 37), methylmethacrylate (LI is 39), ethylmethacrylate (LI is 53), butylmethacrylate (LI is 73), cyclohexylmethacrylate (LI is 90), laurylmethacrylate (LI is 97), and the like.

The aqueous phase composition usually contains at least 4 weight percent monomer mixture based on the total weight of the aqueous phase composition e.g., monomer mixture, porogen, and aqueous phase solvent mixture). In some embodiments, the aqueous phase composition can contain at least 10 weight percent or at least 15 weight percent monomer mixture. The aqueous phase composition usually contains up to 50 weight percent monomer mixture based on the total weight of the aqueous phase composition. In some embodiments, the aqueous phase composition can contain up to 40 weight percent, up to 30 weight percent, up to 25 weight percent, or up to 20 weight percent monomer mixture. For example, the aqueous phase composition can contain 5 to 30 weight percent, 5 to 25 weight percent, 5 to 20 weight percent, or 10 to 20 weight percent monomer mixture based on the total weight of the aqueous phase composition.

In addition to the monomer mixture, the aqueous phase composition includes a water-soluble porogen. The porogen facilitates the formation of a macroporous anion exchange resin that can be used for the purification and/or separation of biological molecules. The porogen is not a monomer and is free of groups such as ethylenically unsaturated groups that can undergo a free radical polymerization reaction with either the crosslinking monomer or the positively charged ionic monomer. The porogen, in general, is not covalently attached to the polymeric material and is usually removed after the polymerization reaction is complete. During the polymerization reaction, however, the porogen may covalently bond to the polymeric material of the anion exchange resin through a chain transfer reaction. Preferably, the porogen is not bonded to the polymeric material of the anion exchange resin. The porogen is an alkylene oxide or polyalkylene oxide of Formula I



wherein R^1 is hydroxy, alkoxy, carboxy, acyloxy, or halo; each R^2 is independently an alkylene having 1 to 4 carbon atoms; R^3 is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl; and n is an integer of 1 to 1,000.

In some exemplary porogens, both end groups (i.e., group $-R^1$ and group $-OR^3$) are hydroxy groups (i.e., R^1 is hydroxy and R^3 is hydrogen). In other exemplary porogens, R^1 is hydroxy and R^3 is an alkyl (e.g., an alkyl having 1 to 20, 1 to 10, 1 to 6, or 1 to 4 carbon atoms), haloalkyl (e.g., chloroalkyl such as chloromethyl), acyl (e.g., acetyl), or carboxyalkyl (e.g., carboxymethyl). That is, one end group is hydroxy and the other end group is an alkoxy, haloalkoxy, acyloxy, or carboxy (e.g., carboxyalkoxy, which is an alkoxy substituted with a carboxy). In other exemplary porogens, R^1 is an alkoxy (e.g., an alkoxy having 1 to 10, 1 to 6, or 1 to 4 carbon atoms) and R^3 is an alkyl (e.g., an alkyl having 1 to 10, 1 to 6, or 1 to 4 carbon atoms) or an acyl (e.g., acetyl). That is, one end group is an alkoxy and the other end group is an alkoxy or acyloxy. In still other exemplary porogens, R^1 is carboxy and R^3 is carboxy alkyl (e.g., carboxymethyl). That is, both end groups are carboxy ($-OR^3$ is carboxyalkoxy).

Group R^2 in Formula I is an alkylene such as, for example, methylene, ethylene, or propylene. Suitable porogens with ethylene R^2 groups include ethylene glycol and ethylene glycol based materials such as diethylene glycol, triethylene glycol, and higher homologs. The higher homologs of ethylene glycol are often referred to as polyethylene glycol (i.e., PEG) or polyethylene oxide (i.e., PEO). Other suitable porogens with propylene R^2 groups include propylene glycol and propylene glycol based materials such as dipropylene glycol, tripropylene glycol, and higher homologs. The higher homologs of propylene glycol are often referred to as polypropylene glycol (i.e., PPG) or polypropylene oxide (i.e., PPO). The porogens can be random or block copolymers of polyethylene oxide and polypropylene oxide.

Subscript n in Formula I can be an integer greater than 1, greater than 2, greater than 5, greater than 10, greater than 20, greater than 50, greater than 100, greater than 200, or greater than 500. For example, n can be an integer in the range of 1 to 1,000, in the range of 1 to 800, in the range of 1 to 600, in the range of 1 to 500, in the range of 1 to 200, or in the range of 1 to 100.

Some porogens are polyalkylene oxides having a molecular weight of at least 200 g/mole, at least 400 g/mole, at least 800 g/mole, at least 1,000 g/mole, at least 2,000 g/mole, 4,000 g/mole, at least 8,000 g/mole, or at least 10,000 g/mole. The polyalkylene oxide porogens often have an average molecular weight up to 20,000 g/mole, up to 16,000 g/mole, up to 12,000 g/mole, up to 10,000 g/mole, up to 8,000 g/mole, up to 6,000 g/mole

up to 4,000 g/mole, up to 2,000 g/mole, or up to 1,000 g/mole. For example, the polyalkylene oxide porogen typically has an average molecular weight in the range of 200 to 20,000 g/mole, in the range of 200 to 16,000 g/mole, in the range of 200 to 8,000 g/mole, in the range of 200 to 4,000 g/mole, in the range of 200 to 2,000 g/mole, or in the range of 200 to 1,000 g/mole.

In some methods of forming the anion exchange resin, a mixture of porogens can be used. For example, the porogen can be a mixture of a first porogen being alkylene glycol (i.e., n is equal to 1 in Formula I) and a second porogen that is a polyalkylene oxide (i.e., n is greater than 1 in Formula I). In a more specific example, the porogen can be a mixture of ethylene glycol with a polyethylene oxide with hydroxy end groups.

Polyalkylene oxides are commercially available that have end groups (i.e., groups $-R^1$ and $-OR^3$) selected from hydroxy, methoxy, a combination of hydroxy and methoxy, a combination of hydroxy and chloro, a combination of alkoxy and acetoxy, or at least one carboxy group. Such materials can be obtained, for example, from Sigma-Aldrich (Milwaukee, WI), Nektar (Huntsville, AL), and Dow Chemical (Midland, MI).

The method of preparing the anion exchange resin is an inverse suspension polymerization process. The aqueous phase composition, which includes (a) the monomer mixture, (b) the porogen, and (c) the aqueous phase solvent mixture, is dispersed or suspended as droplets in a non-polar organic solvent with the volume of the non-polar organic solvent typically being greater than the volume of the aqueous phase composition. The porogen is usually a liquid that can function as a conventional solvent for the monomer mixture within the aqueous phase composition. Useful porogens generally do not partition between the aqueous phase composition and the non-polar organic solvent to any appreciable extent (i.e., the porogen is not extracted in any appreciable amount from the aqueous phase composition into the non-polar solvent). For example, less than 5 weight percent, less than 4 weight percent, less than 3 weight percent, less than 2 weight percent, or less than 1 weight percent of the porogen can be extracted from the aqueous phase composition into the non-polar organic solvent such as toluene, heptane, or the like.

As the free radical polymerization reaction proceeds, many polymeric molecules are formed within each aqueous phase droplet. The polymeric molecules continue to grow and crosslink as the reaction proceeds. When the molecular weight becomes sufficiently large, a polymeric phase separates from the aqueous phase composition within the droplet.

Although not wanting to be bound by theory, it is believed that the pores are formed, at least in part, by the exclusion of the aqueous solvent from the polymeric material as the molecular weight increases. The point at which phase separation occurs can influence the average pore size and the pore size distribution. A later phase separation tends to favor the formation of anion exchange resin particles that have smaller pores and larger surface areas. Conversely, an earlier phase separation tends to favor the formation of anion exchange resin particles that have larger pores and smaller surface areas.

The point at which phase separation occurs can be influenced by the compatibility of the porogen with the forming polymeric material and the amount of porogen. Additionally, the point at which phase separation occurs can be influenced by the amount of crosslinking monomer present in the monomer mixture, with larger amounts of crosslinking monomer typically favoring earlier phase separation due to a more rapid increase in the molecular weight of the polymeric material.

Porogens that are compatible with the forming polymeric material (i.e., porogens that are good solvents for the forming polymeric material) tend to result in a later phase separation compared to porogens that are less compatible with the forming polymeric material (porogens that are poor solvents for the forming polymeric material). Porogens with a higher solubility for the forming polymeric material tend to result in the formation of anion exchange resin particles that have smaller pores and larger surface areas compared to porogens having a lower solubility for the forming polymeric material. Conversely, porogens with a lower solubility for the forming polymeric material tend to result in the formation of anion exchange particles that have larger pores and smaller surface areas compared to porogens having a greater solubility for the forming polymeric material.

The anion exchange resin can be designed for the target molecule of interest. That is, the anion exchange resin can be designed to optimize the anion exchange capacity for a particular target molecule. Anion exchange resins with larger pore sizes are often more suitable for larger target molecules. The molecular weight of the porogen, the end group of the porogen (i.e., groups $-R^1$ and $-OR^3$ in Formula I), the amount of the porogen, and the composition of the monomer mixture can affect the average pore size, surface area, and pore volume.

The addition of porogen tends to increase the surface area, pore size, and the anion exchange capacity (i.e., capacity for a target molecule) until a maximum binding capacity is reached for the particular choice of porogen and monomer composition. Further addition of porogen can either result in no change in the anion exchange capacity or can result in a decreased anion exchange capacity. A decreased anion exchange capacity is typically accompanied by a decrease in the surface area and an increase in the average pore size. As used herein, the term "maximum binding capacity" refers to the maximum anion exchange capacity for a particular target molecule and for a particular combination of porogen and monomer composition.

With porogens having hydroxy end groups and an average molecular weight up to about 1,000 g/mole, macroporous anion exchange resins can be prepared using, for example, up to 100 weight percent or more porogen based on the weight of monomers in the monomer mixture. Exemplary anion exchange resins can be prepared using up to 80 weight percent, up to 60 weight percent, up to 40 weight percent, up to 20 weight percent, or up to 10 weight percent porogen based on the weight of monomers in the monomer mixture.

If a polyethylene oxide with hydroxy end groups and an average molecular weight up to about 1,000 g/mole is used as a porogen, the porogen concentration is typically in the range of 0.1 to 20 weight percent based on the weight of the aqueous phase composition (e.g., the combined weight of the monomer mixture, porogen, and aqueous solvent mixture). For example, the amount of porogen can be in the range of 0.2 to 20 weight percent, 0.3 to 20 weight percent, 0.3 to 15 weight percent, 0.5 to 15 weight percent, 1 to 15 weight percent, or 2 to 15 weight percent based on the total weight of the aqueous phase composition.

Porogens with an average molecular weight greater than about 1,000 g/mole are typically used in a lower amount than porogens with a lower average molecular weight. With these higher molecular weight porogens, increasing the amount of porogen in the aqueous phase composition beyond the amount needed for maximum binding capacity often tends to increase the average pore size, decrease the surface area, and decrease the anion capacity. That is, the average pore size, the surface area, and the anion exchange capacity often cannot be maintained with the addition of larger amounts of porogen.

Porogens with alkoxy end groups are typically used in lower amounts than porogens with hydroxy end groups. Porogens with alkoxy end groups tend to be less soluble in an aqueous phase composition and less compatible with the forming polymeric material compared to porogens with hydroxy end groups. With these porogens having alkoxy end groups, increasing the amount of porogen in the aqueous phase composition beyond the amount needed for maximum binding capacity often tends to increase the average pore size, decrease the surface area, and decrease the anion exchange capacity. That is, the average pore size, the surface area, and the anion exchange capacity cannot be maintained with the addition of larger amounts of porogen.

The aqueous phase composition contains an aqueous solvent mixture that includes water plus a mono-alcohol having 1 to 4 carbon atoms. Suitable mono-alcohols include methanol, ethanol, n-propanol, iso-propanol, tert-butanol, or a combination thereof. The mono-alcohol contributes, at least partially, to the total porosity of the macroporous anion exchange resins. That is, the porosity of the ion exchange resins tends to be higher with the addition of the mono-alcohol (i.e., the mono-alcohol can function as both a solvent and as a co-porogen).

At least 20 weight percent of the aqueous phase solvent mixture can be a mono-alcohol. In some embodiments, at least 30 weight percent, at least 40 weight percent, or at least 50 weight percent of the aqueous phase solvent mixture can be the mono-alcohol. Up to 80 weight percent, up to 70 weight percent, or up to 60 weight percent of the aqueous phase solvent mixture can be the mono-alcohol. For example, the amount of mono-alcohol can be in the range of 20 to 80 weight percent, 30 to 80 weight percent, 40 to 80 weight percent, or 50 to 80 weight percent of the aqueous phase solvent mixture.

The aqueous phase solvent mixture can also contain additional co-solvents that are miscible with water and the mono-alcohol. Suitable aqueous phase co-solvents include, but are not limited to, dimethylsulfoxide, dimethylformamide, N-methylpyrrolidone, acetonitrile, and the like. The co-solvent can, for example, improve the solubility of some of the monomers such as the crosslinking monomer in the aqueous phase composition. The co-solvent can influence the phase separation behavior of the forming polymer, and will influence the porosity characteristics of the resultant anion exchange resin.

The aqueous phase composition is dispersed or suspended in a non-polar organic solvent. The volume ratio of non-polar organic solvent to the aqueous phase composition

is usually in the range of 2:1 to 6:1. The aqueous phase composition, which contains the monomer mixture and porogen, is often dispersed as relatively small droplets in the non-polar organic solvent. Besides functioning as an inert medium for dispersion of the aqueous phase composition, the primary purpose of the suspending medium (i.e., the non-polar organic solvent) is to dissipate the heat generated during the polymerization reaction. In some embodiments, the density of the suspension medium can be selected to be approximately the same as the aqueous phase composition. Approximately matching these densities tends to result in the formation of more spherical particles as well as more uniformly sized particles.

Suitable non-polar organic solvents are typically alkanes such as hexane, heptane, n-octane, isooctane, isododecane, and cyclohexane; halogenated hydrocarbons such as carbon tetrachloride, chloroform, and methylene chloride; aromatics such as benzene and toluene; low-viscosity silicone oils; or combinations thereof. For example, the non-polar organic solvent can be a mixture of heptane and methylene chloride or heptane and toluene.

A suspending agent (i.e., polymeric stabilizer) is often used to facilitate suspension of the aqueous phase composition droplets in the non-polar organic solvent. Unlike the porogen that is hydrophilic, the suspending agent usually has both hydrophobic and hydrophilic portions. The suspending agent functions to modify the interfacial tension between the aqueous phase composition and the non-polar organic solvent. Additionally, the suspending agent provides steric stabilization of the aqueous phase composition droplets. This steric stabilization tends to minimize or prevent the formation of agglomerated particles during the polymerization process.

Suitable suspending agents include sorbitan sesquioleate, polyethylene oxide (20) sorbitan trioleate, polyethylene oxide (20) sorbitan monooleate, sorbitan trioleate, sodium di-2-ethylhexylsulfosuccinate, a copolymer of isooctylacrylate and acrylic acid, a copolymer of hexylacrylate and sodium acrylate, a copolymer of isooctylacrylate and 2-acrylamidoisobutyramide, and the like. The amount of suspending agent can influence the size of the anion exchange resin (i.e., the use of larger amounts of suspending agent often results in the formation of smaller anion exchange resin particles). The amount of the suspending agent is generally 0.1 to 10 weight percent based on the total weight of the monomers in the monomer mixture. For example, the monomer mixture can contain 0.1

to 8 weight percent or 0.5 to 5 weight percent suspending agent based on the total weight of monomers.

The size of the anion exchange resin is determined, to a large extent, by the size of the aqueous phase composition droplets. The droplet size can be affected by variables such as the rate of agitation, the temperature, the amount of suspending agent, the choice of suspending agent, the choice of non-polar organic solvent, and the choice of any aqueous phase co-solvents. The rate of agitation, the type of suspending agent, and the amount of suspending agent can often be varied to control the aggregation or agglomeration of the resulting particles. A lack of aggregation is generally preferred.

An initiator can be added to the aqueous phase composition to commence the free radical polymerization reaction. The free radical initiator is usually soluble in the aqueous phase solvent mixture. Once the suspension has been formed, the free radical initiator can be activated thermally, photochemically, or through an oxidation-reduction reaction. The free radical initiator is often used in an amount of 0.02 to 10 weight percent based on the total weight of the monomers in the monomer mixture. In some examples, the free radical initiator is present in an amount of 2 to 6 weight percent based on the total weight of the monomers.

Suitable water-soluble thermal initiators include, for example, azo compounds, peroxides or hydroperoxides, persulfates, and the like. Exemplary azo compounds include 2,2'-azobis[2-(2-imidazolin-2-yl)propane] dihydrochloride, 2,2'-azobis(2-amidinopropane)dihydrochloride, and 4,4'-azobis-(4-cyanopentanoic acid). Examples of commercially available thermal azo compound initiators include materials available from DuPont Specialty Chemical (Wilmington, DE) under the "VAZO" trade designation such as VAZO 44, VAZO 56, and VAZO 68. Suitable peroxides and hydroperoxides include acetyl peroxide, tert-butyl hydroperoxide, cumene hydroperoxide, and peroxyacetic acid. Suitable persulfates include, for example, sodium persulfate and ammonium persulfate.

In other examples, the free radical initiator is a redox couple such as ammonium or sodium persulfate and N,N,N',N'-tetramethylethylenediamine (TMEDA); ammonium or sodium persulfate and ferrous ammonium sulfate; hydrogen peroxide and ferrous ammonium sulfate; cumene hydroperoxide and N,N-dimethylaniline; or the like. The polymerization temperature typically depends on the specific free radical initiator chosen and on the boiling point of the non-polar organic solvent. The polymerization temperature

is usually about 50 °C to about 150 °C for thermally initiated polymerizations. In some methods, the temperature is about 55 °C to about 100 °C. For redox or photochemically initiated polymerizations, the temperature can be close to room temperature or below, if desired. The polymerization time can be about 30 minutes to about 24 hours or more. Typically, a polymerization time of 2 to 4 hours is sufficient.

Once the free radical polymerization reaction has been initiated, the forming polymeric material tends to precipitate within the aqueous phase composition. Some of the aqueous phase composition such as the porogen can get trapped in the pores of polymeric material. The particles of polymeric material can be isolated, for example, by filtration or decantation. The particles of polymeric material can then be subjected to a series of washing steps to remove the porogen. Suitable solvents for removing the porogen include polar solvents such as, for example, water, acetone, alcohols (e.g., methanol, ethanol, n-propanol, and iso-propanol), dimethylsulfoxide, dimethylformamide, N-methylpyrrolidone, acetonitrile, and the like. The resulting anion exchange resins can be dried using any suitable method, if desired. In some methods, the resulting anion exchange resins can be fractionated using techniques such as screening, sedimentation, and air classification.

The macroporous anion exchange resin particles can have an irregular shape or can be spherical or roughly spherical. In some examples, the macroporous anion exchange resin particles are beads. The average size of the particles can be determined using techniques such as light scattering or electron microscopy with image analysis. The particles usually have an average size of at least 10 micrometers. For example, the particles can have an average size of at least 20 micrometers, at least 30 micrometers, at least 40 micrometers, at least 50 micrometers, or at least 60 micrometers. The particles usually have an average size no greater than 2,000 micrometers, no greater than 1,000 micrometers, no greater than 500 micrometers, or no greater than 200 micrometers. In some applications, the macroporous anion exchange resins have an average particle size of 10 to 2,000 micrometers, 20 to 2,000 micrometers, 20 to 500 micrometers, 50 to 500 micrometers, 20 to 200 micrometers, 50 to 200 micrometer, 50 to 100 micrometers, 50 to 75 micrometers, 50 to 70 micrometers, or 60 to 70 micrometers.

If the average size of the macroporous anion exchange resin particles is less than about 10 micrometers or less than about 20 micrometers, then the back pressure in a

chromatographic column filled with the particles may become unacceptably large, especially for the large columns (e.g., columns with a diameter greater than about 5 cm) that can be used for the purification or separation of large biological molecules. Although the average particle size can be as large as 2,000 micrometers, the average particle size for some applications (e.g., applications in which the macroporous anion exchange resins are placed in large columns) is often no greater than 200 micrometers. If the average particle size is larger, the efficiency of the chromatographic process may be low, especially for the purification or separation of large biological molecules such as proteins that often have low diffusion rates into the pores of the macroporous anion exchange resin. For example, to achieve the same degree of separation or purity with larger anion exchange resins that can be obtained using anion exchange resins of 20 to 200 micrometers, a greater amount of the resin, a longer chromatographic column, a slower flow rate, or a combination thereof may be needed.

The porosity and surface area of the anion exchange resin particles can be characterized by adsorbing nitrogen onto the surface of the particles at various relative pressures under cryogenic conditions (i.e., a sample of the anion exchange resin within a tube is subjected to a vacuum and the tube is placed in liquid nitrogen for cooling). Nitrogen is adsorbed on the surface of the sample at multiple relative pressures (e.g., from about 0.0 to about 1.0) and then desorbed at multiple relative pressures. BJH theory, which is further described in E.P. Barrett, L.S. Joyner, and P.P. Halenda, *J. Am. Chem. Soc.*, **73**, 373 (1951), can be used to relate the amount of nitrogen adsorbed or desorbed at the multiple relative pressures to pores having pore diameters in the range of about 2 to about 200 nanometers. The pore volume, surface area, and average pore diameter can be calculated. As used herein, the term "pore volume" refers to the cumulative pore volume calculated using BJH theory from the adsorption of nitrogen at various relative pressures from about 0.0 to about 1.0. As used herein, the term "surface area" refers to the cumulative surface area calculated using BJH theory from the adsorption of nitrogen at various relative pressures from about 0.0 to about 1.0. As used herein, the term "average pore diameter" is the average pore diameter measured using BJH theory from the adsorption of nitrogen at various relative pressures from about 0.0 to about 1.0.

The macroporous anion exchange resins have a distribution of pore sizes. The pore diameters can be up to 500 nanometers or larger. The anion exchange resins have

pores in the size range that can be measured using nitrogen adsorption techniques. That is, at least some of the pores have a diameter less than 200 nanometers, less than 150 nanometers, or less than 100 nanometers. The average pore diameter measured by nitrogen adsorption is typically at least 2 nanometers, at least 5 nanometers, at least 10 nanometers, at least 20 nanometers, or at least 30 nanometers. The average pore diameter can be up to 200 nanometers, up to 100 nanometers, or up to 80 nanometers. For example, the average pore diameters can be in the range of 10 to 200 nanometers, in the range of 10 to 100 nanometers, in the range of 10 to 80 nanometers, in the range of 20 to 100 nanometers, or in the range of 20 to 80 nanometers.

The pore volume is often at least 0.10 cubic centimeters per gram. For example, the pore volume can be at least 0.15 cubic centimeters per gram, at least 0.20 cubic centimeters per gram, or at least 0.25 cubic centimeters per gram. The pore volume can be in the range of 0.10 to 2 cubic centimeters per gram, in the range of 0.15 to 2 cubic centimeters per gram, or in the range of 0.2 to 2 cubic centimeters per gram resulting from pores having a diameter no greater than 200 nanometers. The pores are large enough to accommodate the biological materials but small enough to provide adequate surface area and anion exchange capacity.

The surface area is usually at least 20 m²/g, at least 30 m²/g, or at least 40 m²/g. The surface area is often in the range of 20 to 200 m²/g, in the range of 30 to 200 m²/g, in the range of 20 to 100 m²/g, in the range of 30 to 100 m²/g, or in the range of 40 to 200 m²/g.

The anion exchange capacity of an anion exchange resin can be given in terms of the amount of a protein such as bovine serum albumin (BSA) that can be adsorbed. More particularly, some anion exchange resins have a bovine serum albumin anion exchange capacity that is at least 5 mg/mL (i.e., 5 milligrams of bovine serum albumin per milliliter of anion exchange resin). For example, some anion exchange resins have a bovine serum albumin anion exchange capacity that is at least 15 mg/mL, at least 20 mg/mL, at least 25 mg/mL, at least 30 mg/mL, or at least 40 mg/mL. More particularly, some anion exchange resins have a bovine serum albumin anion exchange capacity of 5 to 100 mg/mL, 5 to 70 mg/mL, 20 to 70 mg/mL, 20 to 60 mg/mL, 30 to 60 mg/mL, or 30 to 50 mg/mL.

The anion exchange resins prepared using the methods described herein are hydrophilic and usually have a low non-specific adsorption (i.e., anion exchange resins

prepared from monomer with low LI tend to have low non-specific adsorption). The anion exchange resins typically adsorb various negatively charged materials through interaction with the positively charged groups on the anion exchange resin and typically adsorb little, if any, material on the non-ionic portions of the anion exchange resin. This low non-specific adsorption can advantageously result in better separation or purification of negatively charged target materials from other materials in a sample. In some examples, the charged target materials are impurities such as anionic proteins, nucleic acids, endotoxins, lipids, phospholipids, or the like that need to be removed from a protein solution (e.g., an antibody or IgG solution).

In a second aspect, a method of separating or purifying a negatively charged material is described. The method includes forming a macroporous anion exchange resin, contacting the macroporous anion exchange resin with negatively charged material, and adsorbing at least a portion of the negatively charged material on the macroporous anion exchange resin. The macroporous anion exchange resin is formed by preparing an aqueous phase composition that contains (a) a monomer mixture; (b) a water-soluble alkylene oxide or polyalkylene oxide porogen of Formula I; and (c) an aqueous phase solvent mixture that includes water and a mono-alcohol having 1 to 4 carbon atoms. The mono-alcohol is present in an amount of at least 20 volume percent based on the volume of the aqueous phase solvent mixture. The monomer mixture includes (1) a crosslinking monomer containing N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide or a combination thereof; and (2) a positively charged ionic monomer. Substantially all of the monomers in the monomer mixture have a lipophilicity index less than or equal to 20. The formation of the macroporous anion exchange resin further includes suspending the aqueous phase composition in a non-polar organic solvent, polymerizing the monomer mixture to form particles of polymeric material, and removing the porogen from the particles.

A sample containing negatively charged materials can be contacted with an anion exchange resin at a pH where the anion exchange resin has positively charged groups (e.g., at a pH of 1 to 10). In general, in order to get effective adsorption of the negatively charged material to the anion exchange resin, a pH of at least about 1 to 2 pH units above the pK of the material (or pI for a protein) can be used. To release the adsorbed material from the anion exchange resin, if desired, the pH can be lowered at least 1 to 2 pH units,

or more. Alternatively, when the charged material is a biomolecule, the sample can be contacted with the anion exchange resin in a low ionic strength buffer (e.g., a 5 to 20 millimolar buffer salt) at an appropriate pH (e.g., at a pH of about 6-8 for BSA). To release the adsorbed biomolecule, a high ionic strength buffer is contacted with the anion exchange resin. In some embodiments, the high ionic strength buffer includes that same buffer composition used to adsorb the material plus 1 molar sodium chloride. The adsorption and release processes are typically performed at temperatures near room temperature.

Buffer salts useful for controlling pH include, but are not limited to, sodium phosphate, sodium carbonate, sodium bicarbonate, sodium borate, sodium acetate, and TRIS (tris(hydroxymethyl)aminomethane). Other suitable buffers include "Good's" buffers such as MOPS (3-morpholinopropanesulfonic acid), EPPS (4-(2-hydroxyethyl)piperazine-1-propanesulfonic acid), MES (2-morpholinoethanesulfonic acid), and others.

Some samples include a biological molecule that can be separated from the other sample constituents or that can be purified. Suitable biological molecules include, for example, proteins, enzymes, vaccines, DNA, and RNA. Adjusting the pH of the sample can alter the charge of some biological molecules.

In a third aspect, a method of preparing a chromatographic column is described. The method includes forming a macroporous anion exchange resin and placing the macroporous anion exchange resin in a column. The macroporous anion exchange resin is formed by preparing an aqueous phase composition that contains (a) a monomer mixture; (b) a water-soluble alkylene oxide or polyalkylene oxide porogen of Formula I; and (c) an aqueous phase solvent mixture that includes water and a mono-alcohol having 1 to 4 carbon atoms. The mono-alcohol is present in an amount of at least 20 volume percent based on the volume of the aqueous phase solvent mixture. The monomer mixture includes (1) a crosslinking monomer containing N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide or a combination thereof; and (2) a positively charged ionic monomer. Substantially all of the monomers in the monomer mixture have a lipophilicity index less than or equal to 20. The formation of the macroporous anion exchange resin further includes suspending the aqueous phase composition in a non-polar

organic solvent, polymerizing the monomer mixture to form particles of polymeric material, and removing the porogen from the particles.

The anion exchange resin particles prepared by the method described herein tend to be fairly rigid and have the mechanical strength needed for use in chromatographic columns of any suitable dimension and under any suitable flow rates and pressure conditions. The particles can be used, for example, in a chromatographic column with high flow rates. The anion exchange resins are suitable for use under the differential pressure conditions that are commonly encountered in chromatographic columns. As used herein, the term "differential pressure" refers to the pressure drop across a chromatographic column. For example, chromatographic columns used for the downstream purification or separation of therapeutic proteins can be used with superficial velocities (e.g., flow rates) such as at least 150 cm/hr, at least 250 cm/hr, at least 500 cm/hr, or at least 700 cm/hr to increase productivity. Faster flow rates typically lead to higher productivity.

In small chromatographic columns (e.g., columns with a diameter less than about 5 cm), the packed bed of anion exchange resin is well supported by the column wall. In such columns, anion exchange resins having a relatively wide range of rigidity can withstand differential pressures in excess of 200 psi (1,380 kPa). However, in large chromatographic columns (e.g., columns with a diameter greater than about 5 cm), the packed bed of anion exchange resin has less support from the column wall (e.g., a smaller fraction of the resin is in contact with the wall surfaces of the column). In such columns, anion exchange resins with higher rigidity tend to be able to withstand differential pressures of at least 25 psi (173 kPa). Some anion exchange resins can withstand a differential pressure of 50 psi (345 kPa) to 200 psi (1,380 kPa).

Suitable columns are known in the art and can be constructed of such materials as glass, polymeric material, stainless steel, titanium and alloys thereof, or nickel and alloys thereof. Methods of filling the column to effectively pack the anion exchange resin in the column are known in the art.

The chromatographic columns can be part of an analytical instrument such as a liquid chromatograph. When packed with the anion exchange resin, the chromatographic column can be used to separate an ionic material from non-ionic materials or to separate

one ionic material from another ionic material with a different charge density. The amount of the ionic material in the sample can be determined.

The chromatographic columns can be part of a preparative liquid chromatographic system to separate or purify an ionic material. The preparative liquid chromatographic system can be a laboratory scale system, a pilot plant scale system, or an industrial scale system.

In a fourth aspect, a method of preparing a filtration element is described. The method includes forming a macroporous anion exchange resin and disposing the macroporous anion exchange resin on a surface of a filtration medium. The macroporous anion exchange resin is formed by preparing an aqueous phase composition that contains (a) a monomer mixture; (b) a water-soluble alkylene oxide or polyalkylene oxide porogen of Formula I; and (c) an aqueous phase solvent mixture that includes water and a mono-alcohol having 1 to 4 carbon atoms. The mono-alcohol is present in an amount of at least 20 volume percent based on the volume of the aqueous phase solvent mixture. The monomer mixture includes (1) a crosslinking monomer containing N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide or a combination thereof; and (2) a positively charged ionic monomer. Substantially all of the monomers in the monomer mixture have a lipophilicity index less than or equal to 20. The formation of the macroporous anion exchange resin further includes suspending the aqueous phase composition in a non-polar organic solvent, polymerizing the monomer mixture to form particles of polymeric material, and removing the porogen from the particles.

The filter element can be positioned within a housing to provide a filter cartridge. Suitable filtration medium and systems that include a filter cartridge are further described, for example, in U.S. Patent No. 5,468,847 (Heilmann et al.), incorporated herein by reference. Such a filter cartridge can be used to purify or separate biomolecules. In this aspect, less rigid particles or smaller macroporous particles can be utilized than in the chromatographic column format due to the lower pressure drops inherent in the filter cartridge system.

The filtration medium can have a single filtration layer or multiple filtration layers and can be prepared from glass or polymeric fibers (e.g., polyolefin fibers such as polypropylene fibers). In some embodiments, the filtration medium includes a coarse pre-filtration layer and one or more finer filtration layers. For example, the filtration medium

can include a coarse pre-filtration layer and then a series of additional filtration layers with progressively smaller average pore sizes. The anion exchange resin can be positioned on the layer of the filtration medium having the smallest average pore size.

Selection of the pore size of the filtration medium depends on the size of the anion exchange resin. Typically the pore size of the filtration medium is selected to be smaller than the average diameter of the anion exchange resin. However, a portion of the anion exchange resin can penetrate into the filtration medium.

The filtration medium can be in the form of vertical pleated filters such as those described in U.S. Patent No. 3,058,594 (Hultgren). In other embodiments, the filtration medium is in the form of horizontal, compound radially pleated filters such as those described in U.S. Patent No. 4,842,739 (Tang et al.), incorporated herein by reference. A horizontal arrangement of the pleats can be desirable in applications where a filter cartridge containing the filtration medium is used in the vertical direction. Such an arrangement can reduce the loss of the anion exchange resin from the filter element during use and storage.

In a fifth aspect, a method of making a porous composite material is described. The method includes forming a macroporous anion exchange resin and incorporating the macroporous anion exchange resin in a continuous, porous matrix. The macroporous anion exchange resin is formed by preparing an aqueous phase composition that contains (a) a monomer mixture; (b) a water-soluble alkylene oxide or polyalkylene oxide porogen of Formula I; and (c) an aqueous phase solvent mixture that includes water and a mono-alcohol having 1 to 4 carbon atoms. The mono-alcohol is present in an amount of at least 20 volume percent based on the volume of the aqueous phase solvent mixture. The monomer mixture includes (1) a crosslinking monomer containing N'N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide or a combination thereof; and (2) a positively charged ionic monomer. Substantially all of the monomers in the monomer mixture have a lipophilicity index less than or equal to 20. The formation of the macroporous anion exchange resin further includes suspending the aqueous phase composition in a non-polar organic solvent, polymerizing the monomer mixture to form particles of polymeric material, and removing the porogen from the particles.

The continuous, porous matrix is typically a woven or non-woven fibrous web, porous fiber, porous membrane, porous film, hollow fiber, or tube. Suitable continuous,

porous matrixes are further described in U.S. Patent No. 5,993,935 (Rasmussen et al.), incorporated herein by reference.

A continuous, porous matrix that is a fibrous web can provide such advantages as, for example, large surface area, ease of manufacture, low material cost, and a variety of fiber textures and densities. Although a wide range of fiber diameters is suitable, the fibers often have an average diameter of 0.05 micrometers to 50 micrometers. The web thickness can be varied to fit the end use application (e.g., about 0.2 micrometers to about 100 cm).

The composite material can be prepared, for example, using melt-blowing methods. For example, a molten polymeric material can be extruded to produce a stream of melt blown fibers. The anion exchange resin can be introduced into the stream of fibers and intermixed with the fibers. The mixture of fibers and anion exchange resin can be collected on a screen such that a web is formed. The anion exchange resin can be dispersed within the fibrous web. In some embodiments, the anion exchange resin can be dispersed uniformly throughout the fibrous web.

The composite material can also be prepared with a fibrillated polymer matrix such as fibrillated polytetrafluoroethylene (PTFE). Suitable methods are more fully described in U.S. Patent Nos. 4,153,661 (Ree et al.); 4,565,663 (Errede et al.); 4,810,381 (Hagen et al.); and 4,971,736 (Hagen et al.), all of which are incorporated herein by reference. In general, these methods involve blending the anion exchange resin with a polytetrafluoroethylene dispersion to obtain a putty-like mass, subjecting the putty-like mass to intensive mixing at a temperature of 5 °C to 100 °C to cause fibrillation of the PTFE, biaxially calendaring the putty-like mass, and drying the resultant sheet.

In another method of preparing the composite material, the anion exchange resin can be dispersed in a liquid and then blended with a thermoplastic polymer at a temperature sufficient to form a homogenous mixture. The homogeneous mixture can be placed in a mold having a desired shape. Upon cooling of the mixture, the liquid can be phase separated leaving a thermoplastic polymeric matrix that contain dispersed anion exchange resin particles. This method is further described in U.S. Patent No. 4,957,943 (McAllister et al.), incorporated herein by reference.

The amount of anion exchange resin incorporated into the continuous, porous matrix is at least 1 volume percent, at least 5 volume percent, at least 10 volume percent,

at least 20 volume percent, at least 30 volume percent, at least 40 volume percent, or at least 50 volume percent based on the volume of the resulting composite. The amount of anion exchange resin incorporated into the continuous, porous matrix can contain up to 99 volume percent, up to 95 volume percent, up to 90 volume percent, up to 85 volume percent, or up to 80 volume percent based on the volume of the resulting composite.

Composites having a larger amount of anion exchange resin tend to have a larger anion exchange capacity.

The foregoing describes the invention in terms of embodiments foreseen by the inventor for which an enabling description was available, notwithstanding that insubstantial modifications of the invention, not presently foreseen, may nonetheless represent equivalents thereto.

EXAMPLES

These examples are merely for illustrative purposes only and are not meant to be limiting on the scope of the appended claims. All parts, percentages, ratios, and the like in the examples are by weight, unless noted otherwise. Solvents and other reagents used were obtained from Sigma-Aldrich Chemical Company (Milwaukee, WI) unless otherwise noted.

Test Methods

Anion Exchange Capacity

A 50 volume percent slurry of anion exchange beads in DI (deionized) water was prepared by mixing the beads with water, centrifuging the mixture at 3,000 relative centrifugal force (rcf) for 20 minutes, and then adjusting the amount of water so that the total volume was twice that of the packed bead bed. The slurry was mixed well to suspend the beads, then a 400 microliter sample of the slurry was pipetted into a 5 milliliter cellulose acetate CENTREX MF centrifugal micro-filter having a pore size of 0.45 micrometer. The micro-filter was obtained from Schleicher & Schuell through VWR, Eagan, MN. The water was removed from the slurry on the micro-filter by centrifugation at 3,000 rcf for 5 minutes. A solution of 4 mL of 10 mM MOPS at pH 7.5 was mixed with the beads on the micro-filter. The liquid was removed by centrifugation again at 3,000 rcf for 10 minutes. The filtrates were discarded. A 4.5 mL sample of BSA (about 9 mg/mL)

(commercially available from Sigma-Aldrich, St. Louis, MO) in the same MOPS buffer was added to the micro-filter containing the beads. The mixture was tumbled overnight and then the supernatant was removed from the beads by centrifugation at 3,000 rcf for 15 minutes.

The filtrate was analyzed by UV spectroscopy, comparing the adsorbance at 280 nm to that of the starting BSA solution; the difference was used to calculate the BSA anion exchange capacity of the beads. Assays were run in triplicate and averaged.

Surface Area and Porosity Measurements

Approximately 0.1–1.0 g of each sample was transferred to a 1.3 centimeter (0.5 inch) diameter sample tube available from Micromeritics, Inc. of Norcross, GA and degassed using a system commercially available from Micromeritics under the trade designation VACPREP 061 for 24 hours at 100°C under vacuum (below 10 mTorr or 0.015 mbar). After degassing, the samples were allowed to cool for 10 minutes under vacuum at ambient temperature (i.e., 20°C to 25°C), and then loaded onto a surface area and porosity analyzer commercially available from Micromeritics under the trade designation TRISTAR 3000.

A 45 point adsorption / 40 point desorption isotherm was set up with relative pressures (P/P_0) starting at about 0.0 up to about 1.0 with a tighter distribution of points between 0.95 and 1.0 (See Table for Target Pressures and Points). No first “pressure fixed dose” was set. The maximum volume increment was set at 10.00 cc/g at STP, the “absolute pressure tolerance” was set at 5 mm Hg, and the “relative pressure tolerance” was set at 2.0%. “Fast evacuation” and “leak test” options were not used. With the dewar of liquid nitrogen lowered (i.e., the sample was not in the liquid nitrogen), an evacuation time of 0.5 hours was implemented during the free space measurement. The dewar was raised for analysis (i.e., the tube containing the sample was placed in liquid nitrogen). At 77.350 K (the temperature of liquid nitrogen), P_0 was measured at 120 min intervals during the analysis. The gas adsorptive properties using a standard Pstat versus temperature table for nitrogen gas were set at the following values: non-ideality factor, 0.0000620; density conversion factor, 0.0015468; molecular cross-sectional area, 0.162 nm². BJH adsorption/desorption cumulative pore volumes and cumulative surface areas were calculated for pores between 17Å–2,000 Å diameter (corresponding to pores

between 2 and 200 nanometers), and based on quantity of N₂ adsorbed at each relative pressure during the 45 adsorption points and 40 desorption points.

The following table indicates the adsorption and desorption points used for the analysis. The cumulative surface area and cumulative pore volume during adsorption are reported below for various examples.

Table of Target Pressures and Points

Point	Relative Pressure (P/Po)	BJH Adsorption	BJH Desorption
1	0.060	X	
2	0.080	X	
3	0.120	X	
4	0.140	X	
5	0.160	X	
6	0.200	X	
7	0.250	X	
8	0.300	X	
9	0.350	X	
10	0.400	X	
11	0.450	X	
12	0.500	X	
13	0.550	X	
14	0.600	X	
15	0.650	X	
16	0.700	X	
17	0.740	X	
18	0.770	X	
19	0.800	X	
20	0.820	X	
21	0.840	X	
22	0.860	X	
23	0.875	X	
24	0.890	X	
25	0.905	X	
26	0.915	X	
27	0.925	X	
28	0.933	X	
29	0.940	X	
30	0.947	X	
31	0.953	X	
32	0.959	X	
33	0.964	X	
34	0.968	X	
35	0.971	X	
36	0.974	X	

Point	Relative Pressure (P/Po)	BJH Adsorption	BJH Desorption
37	0.977	X	
38	0.980	X	
39	0.982	X	
40	0.984	X	
41	0.986	X	
42	0.988	X	
43	0.989	X	
44	0.990	X	
45	1.000		
46	0.990		X
47	0.989		X
48	0.988		X
49	0.986		X
50	0.984		X
51	0.982		X
52	0.980		X
53	0.977		X
54	0.974		X
55	0.971		X
56	0.968		X
57	0.964		X
58	0.959		X
59	0.953		X
60	0.947		X
61	0.940		X
62	0.933		X
63	0.925		X
64	0.915		X
65	0.905		X
66	0.890		X
67	0.875		X
68	0.860		X
69	0.840		X
70	0.820		X
71	0.800		X
72	0.770		X
73	0.740		X
74	0.700		X
75	0.650		X
76	0.600		X
77	0.550		X
78	0.500		X
79	0.450		X
80	0.400		X
81	0.350		X
82	0.300		X
83	0.250		X

Point	Relative Pressure (P/Po)	BJH Adsorption	BJH Desorption
84	0.200		X
85	0.140		X

Table of Abbreviations

<u>Abbreviation or Trade Designation</u>	<u>Description</u>
MBA	N,N'-methylenebisacrylamide
MAPTAC	[3-(methacryloylamino)propyl]trimethylammonium chloride used as a 50 percent by weight solution in water.
APTAC	(3-acrylamidopropyl)trimethylammonium chloride used as a 75 percent by weight solution in water
DMAPMA	N-[3-(dimethylamino)propyl]methacrylamide
DMA	N,N-dimethylacrylamide
TMEDA	N,N,N',N'-tetramethylethylenediamine.
BSA	Bovine serum albumin.
PEG 400	Polyethyleneglycol with hydroxy end groups having an average molecular weight 400 g/mole
PEG 600	Polyethylene glycol with hydroxy end groups, average molecular weight 600 g/mole
PEG 1000	Polyethylene glycol with hydroxy end groups, average molecular weight 1,000 g/mole
PEG 2000	Polyethylene glycol with hydroxy end groups, average molecular weight 2,000 g/mole
PEG 3400	Polyethylene glycol with hydroxy end groups, average molecular weight 3,400 g/mole
IPA	Isopropanol

Example 1

A 50:50 by weight MAPTAC/MBA copolymer was prepared by reverse-phase suspension polymerization using a polyethylene glycol porogen (PEG 400) in the aqueous phase.

A polymeric stabilizer (0.28 grams), toluene (132 mL), and heptane (243 mL) were added to a flask equipped with a mechanical stirrer (stirring rate 450 rpm), nitrogen inlet, thermometer, heating mantel with temperature controller, and condenser. The polymeric stabilizer was a 91.8: 8.2 by weight copolymer of isooctylacrylate and 2-acrylamidoisobutyramide (prepared as described in Rasmussen, et al., *Makromol. Chem., Macromol. Symp.*, **54/55**, 535-550 (1992)). The non-aqueous solution in the flask was heated to 35°C with stirring, and sparged with nitrogen for 15 minutes.

An aqueous solution was prepared that contained MBA (7.0 grams), MAPTAC (14.0 grams of a 50 percent by weight aqueous solution), methanol (35 mL), PEG 400 (15 mL), and deionized water (38 mL). This second solution was stirred and heated at 30 °C to 35°C to dissolve the MBA. Sodium persulfate (1.12 grams dissolved in 5 mL deionized water) was added to the second solution with additional stirring. The aqueous solution was added to the reaction flask containing the non-aqueous solution. The resulting mixture was stirred and nitrogen sparged for 5 minutes.

TMEDA (1.12 mL) was added to initiate the polymerization. The reaction temperature quickly rose to 42.6°C, then slowly subsided. The reaction mixture was stirred for a total of 2.3 hours from the time of TMEDA addition, filtered using a sintered glass funnel, washed with acetone (2 X 250 mL), methanol (2 X 250 mL), and acetone (1 X 250 mL) and dried at room temperature under vacuum to yield 15.8 grams of colorless particles.

Based on scanning electron micrographs, the resin was in the form of spherical particles ranging from about 20 to 200 micrometers in diameter. The protein anion exchange capacity was measured according to the procedure described in the Test Methods using BSA as the protein. The data is shown in Table 1.

Prior to porosity measurements, the resin was subjected to additional washing to remove any remaining porogen. Approximately 5 mL of the resin particles were mixed with 40 mL of 1:1 solution of acetonitrile and water based on volume. The mixture was tumbled for 3 days. The sample was filtered, washed with acetone (3 X 100 mL), and

then dried under vacuum. Surface area and porosity were measured as described in the Test Methods. The data is shown in Table 1.

Comparative Example C1

Anion exchange beads were prepared as described in Example 1, except that the PEG 400 (porogen) was replaced by methanol in the aqueous solution. Anion exchange capacity for the protein BSA is shown in Table 1.

Example 2

For Example 2, the same procedure used for Example 1 was followed except that the amounts of each monomer (MBA and MAPTAC) were doubled. Anion exchange capacity for the protein BSA and porosity measurements are shown in Table 1.

Example 3

For Example 3, the same procedure used for Example 1 was followed except that the amounts of each monomer (MBA and MAPTAC) were doubled, the only solvent in the non-aqueous phase was heptane (536 mL), IPA (80 mL) was used instead of methanol, and the total aqueous phase was 150 mL. Anion exchange capacity for the protein BSA and porosity measurements are shown in Table 1.

Example 4

For Example 4, the same procedure used for Example 1 was followed except that the total amount of monomers was doubled, and the monomers were MBA, MAPTAC, and DMA. The amount of each monomer in the monomer mixture was 35 weight percent MBA, 30 weight percent MAPTAC, and 35 weight percent DMA. Anion exchange capacity for the protein BSA and porosity measurements are shown in Table 1.

Example 5

For Example 5, the same procedure used for Example 4 was followed except that the only solvent in the non-aqueous phase was heptane (536 mL) and IPA was used in place of methanol. Anion exchange capacity for the protein BSA and porosity measurements are shown in Table 1.

Example 6

For Example 6, the same procedure used for Example 1 was followed except that the total amount of monomers was doubled. The amount of each monomer in the monomer mixture was 70 weight percent MBA and 30 weight percent MAPTAC. Anion exchange capacity for the protein BSA and porosity measurements are shown in Table 1.

Example 7

For Example 7, the same procedure used for Example 6 was followed except that the only solvent in the non-aqueous phase was heptane (536 mL), IPA (40 mL) was used in place of methanol, and the total aqueous phase was 110 mL. Anion exchange capacity for the protein BSA and porosity measurements are shown in Table 1.

Table 1

Example	Anion Exchange Capacity for BSA (mg/mL)	BJH Cumulative Pore Volume (cc/g)	BJH Cumulative Surface Area (m ² /g)
C1	10	NM	NM
1	72	0.68	174
2	79	0.71	192
3	30	0.17	42
4	97	0.51	137
5	86	0.65	152
6	86	0.69	221
7	46	0.59	176

NM = not measured

Examples 8-12

For Examples 8-12, the same procedure used for Example 2 was followed except that the molecular weight of the PEG was varied as indicated in Table 2 and the total polymerization time was reduced to 1 hour after addition of the TMEDA. Anion exchange capacity for the protein BSA and porosity measurements are listed in Table 2.

The scanning electron micrograph of the surface of Example 9 is shown in Figure 1 at a magnification of 15,000X. Figure 2 shows a scanning electron micrograph of the surface of Example 11 at a magnification of 15,000X.

Table 2

Example	PEG	Anion Exchange Capacity for BSA (mg/mL)	BJH Cumulative Surface Area (m ² /g)	BJH Cumulative Pore Volume (cc/g)
8	400	68	124	0.49
9	600	95	93	0.46
10	1000	66	87	0.36
11	2000	8	2	0.01
12	3400	12	4	0.02

Example 13

For Example 13, the same procedure as used in Example 6 was used, except that APTAC was used in place of MAPTAC, the only solvent in the non-aqueous phase was heptane (536 mL), IPA (95 mL) was used in place of methanol and the total aqueous phase was 160 mL. Anion exchange capacity for BSA was 46 mg/mL.

Example 14

A 65:35 by weight DMAPMA/MBA copolymer was prepared by the general procedure of Example 1 using PEG 400 as porogen in the aqueous phase. The only solvent in the non-aqueous phase was heptane (536 mL). The aqueous phase consisted of MBA (9.8 g), DMAPMA (18.2 g), glacial acetic acid (6.15 ml), PEG 400 (15 ml), IPA (95 ml), DI water (43.85 ml), and sodium persulfate (0.55 g). Anion exchange capacity for BSA was 40 mg/mL.

Comparative Example C2

For Comparative Example C2, the procedure of Example 16 was repeated except that the PEG 400 was replaced with IPA (15 ml). Anion exchange capacity for BSA was 3 mg/mL.

WE CLAIM:

1. A method of preparing a macroporous anion exchange resin, the method comprising:

forming an aqueous phase composition comprising

- a) a monomer mixture comprising
 - i) a crosslinking monomer comprising N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof; and
 - ii) a positively charged ionic monomer,

wherein substantially all the monomers in the monomer mixture have a lipophilicity index less than or equal to 20; and

- b) a water-soluble porogen of Formula I



wherein

R^1 is hydroxy, alkoxy, carboxy, acyloxy, or halo;

each R^2 is independently an alkylene having 1 to 4 carbon atoms;

R^3 is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl;

n is an integer of 1 to 1,000; and

- c) an aqueous phase solvent mixture comprising water and a mono-alcohol having 1 to 4 carbon atoms, wherein the mono-alcohol is present in an amount of at least 20 weight percent based on a total weight of the aqueous phase solvent mixture;

suspending the aqueous phase composition in a non-polar organic solvent;

polymerizing the monomer mixture to form particles of polymeric material; and

removing the porogen from the particles to form a macroporous anion exchange resin.

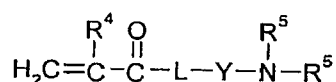
2. The method of claim 1, wherein the macroporous anion exchange resin has at least some pores having a diameter less than or equal to 200 nanometers.

3. The method of claim 2, wherein the macroporous anion exchange resin has a pore volume of at least 0.10 cubic centimeters per gram and a surface area of at least 20 m²/g.

4. The method of claim 1, wherein the crosslinking monomer is present in an amount greater than 10 weight percent based on the total weight of the monomers in the monomer mixture.

5. The method of claim 1, wherein the crosslinking monomer is present in an amount of 25 to 75 weight percent based on a total weight of monomers in the monomer mixture and the positively charged ionic monomer is present in an amount of 25 to 75 weight percent based on the total weight of the monomers in the monomer mixture.

6. The method of claim 1, wherein the positively charged ionic monomer is of Formula II or a quaternary ammonium salt thereof



II

wherein

R⁴ is hydrogen or methyl;

L is oxy or -NH-;

Y is an alkylene; and

each R⁵ is independently hydrogen, alkyl, hydroxy alkyl, amino alkyl, or the two R⁵ groups taken together with the nitrogen atom to which they are attached form a heterocyclic group that is aromatic, partially unsaturated, or saturated, wherein the heterocyclic group can optionally be fused to a second ring that is aromatic, partially unsaturated, or saturated.

7. The method of claim 1 wherein R² is ethylene or propylene.

8. The method of claim 1, wherein R¹ is hydroxy and R³ is hydrogen or R¹ is hydroxy and R³ is alkyl.

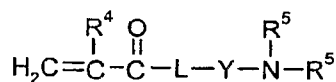
9. The method of claim 1, wherein the porogen comprises a polyethylene oxide with a molecular weight no greater than 1,000 g/mole.

10. The method of claim 9, wherein the polyethylene oxide has hydroxy end groups.
11. The method of claim 1, wherein the porogen comprises a mixture of a first porogen comprising an alkylene glycol and a second porogen comprising a polyalkylene oxide.
12. The method of claim 11, wherein the first porogen comprises ethylene glycol and the second porogen comprises polyethylene oxide with hydroxy end groups.
13. The method of claim 1, wherein the mono-alcohol is present in an amount of at least 50 percent based on the total weight of the aqueous phase solvent mixture.
14. A method of separating or purifying a negatively charged material, the method comprising:
preparing a macroporous anion exchange resin, the preparing comprising
forming an aqueous phase composition comprising
 - a) a monomer mixture comprising
 - i) a crosslinking monomer comprising N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof; and
 - ii) a positively charged ionic monomer,
 wherein substantially all of the monomers in the monomer mixture have a lipophilicity index less than or equal to 20; and
 - b) a water-soluble porogen of Formula I

$$R^1-(R^2-O)_n-R^3 \quad (I)$$
 wherein
 - R¹ is hydroxy, alkoxy, carboxy, acyloxy, or halo;
 - each R² is independently an alkylene having 1 to 4 carbon atoms;
 - R³ is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl;
 - n is an integer of 1 to 1,000; and
 - c) an aqueous phase solvent mixture comprising water and a mono-alcohol having 1 to 4 carbon atoms, wherein the mono-alcohol is present in an amount of

at least 20 weight percent based on a total weight of the aqueous phase solvent mixture;
 suspending the aqueous phase composition in a non-polar organic solvent;
 polymerizing the monomer mixture to form particles of polymeric material; and
 removing the porogen from the particles to form the macroporous anion exchange resin;
 contacting the macroporous anion exchange resin with negatively charged material; and
 adsorbing at least a portion of the negatively charged material on the macroporous anion exchange resin.

15. The method of claim 14, wherein the positively charged ionic monomer is of Formula II or a quaternary ammonium salt thereof



II

wherein

R⁴ is hydrogen or methyl;

L is oxy or -NH-;

Y is an alkylene; and

each R⁵ is independently hydrogen, alkyl, hydroxy alkyl, amino alkyl, or the two R⁵ groups taken together with the nitrogen atom to which they are attached form a heterocyclic group that is aromatic, partially unsaturated, or saturated, wherein the heterocyclic group can optionally be fused to a second ring that is aromatic, partially unsaturated, or saturated.

16. The method of claim 14, wherein the negatively charged material is a biological molecule.

17. The method of claim 16, wherein the biological molecule is a protein.

18. A method of preparing a chromatographic column, the method comprising:
 preparing a macroporous anion exchange resin, the preparing comprising

forming an aqueous phase composition comprising

- a) a monomer mixture comprising
 - i) a crosslinking monomer comprising N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof; and
 - ii) a positively charged ionic monomer,

wherein substantially all the monomers in the monomer mixture have a lipophilicity index less than or equal to 20; and

- b) a water-soluble porogen of Formula I



wherein

R^1 is hydroxy, alkoxy, carboxy, acyloxy, or halo;

each R^2 is independently an alkylene having 1 to 4 carbon atoms;

R^3 is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl;

n is an integer of 1 to 1,000; and

- c) an aqueous phase solvent mixture comprising water and a mono-alcohol having 1 to 4 carbon atoms, wherein the mono-alcohol is present in an amount of at least 20 weight percent based on a total weight of the aqueous phase solvent mixture;

suspending the aqueous phase composition in a non-polar organic solvent;

polymerizing the monomer mixture to form particles of polymeric material;

removing the porogen from the particles to form the macroporous anion exchange resin; and

placing the macroporous anion exchange resin in a column.

19. A method of preparing a filtration element, the method comprising preparing a macroporous anion exchange resin, the preparing comprising:

forming an aqueous phase composition comprising

- a) a monomer mixture comprising
 - i) a crosslinking monomer comprising N,N'-alkylenebis(meth)acrylamide, N,N'-heteroalkylenebis(meth)acrylamide, or a combination thereof; and

ii) a positively charged ionic monomer,
wherein substantially all the monomers in the monomer mixture have a lipophilicity index less than or equal to 20; and

b) a water-soluble porogen of Formula I



wherein

R^1 is hydroxy, alkoxy, carboxy, acyloxy, or halo;

each R^2 is independently an alkylene having 1 to 4 carbon atoms;

R^3 is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl;

n is an integer of 1 to 1,000; and

c) an aqueous phase solvent mixture comprising water and a mono-alcohol having 1 to 4 carbon atoms, wherein the mono-alcohol is present in an amount of at least 20 weight percent based on a total weight of the aqueous phase solvent mixture;

suspending the aqueous phase composition in a non-polar organic solvent;

polymerizing the monomer mixture to form particles of polymeric material;

removing the porogen from the particles to form the macroporous anion exchange resin; and
disposing the macroporous anion exchange resin on a surface of a filtration medium.

20. A method of making a porous composite material, the method comprising preparing a macroporous anion exchange resin, the preparing comprising:

forming an aqueous phase composition comprising

a) a monomer mixture comprising

i) a crosslinking monomer comprising N,N' -alkylenebis(meth)acrylamide, N,N' -heteroalkylenebis(meth)acrylamide, or a combination thereof; and

ii) a positively charged ionic monomer,

wherein substantially all the monomers in the monomer mixture have a lipophilicity index less than or equal to 20; and

b) a water-soluble porogen of Formula I



wherein

R^1 is hydroxy, alkoxy, carboxy, acyloxy, or halo;

each R^2 is independently an alkylene having 1 to 4 carbon atoms;

R^3 is hydrogen, alkyl, carboxyalkyl, acyl, or haloalkyl;

n is an integer of 1 to 1,000; and

c) an aqueous phase solvent mixture comprising water and a mono-alcohol having 1 to 4 carbon atoms, wherein the mono-alcohol is present in an amount of at least 20 weight percent based on a total weight of the aqueous phase solvent mixture;

suspending the aqueous phase composition in a non-polar organic solvent;

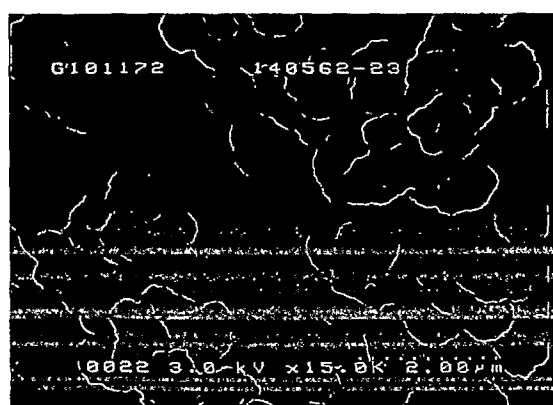
polymerizing the monomer mixture to form particles of polymeric material;

removing the porogen from the particles to form the macroporous anion exchange

resin; and

incorporating the macroporous anion exchange resin in a continuous, porous matrix.

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*Fig. 1**Fig. 2*