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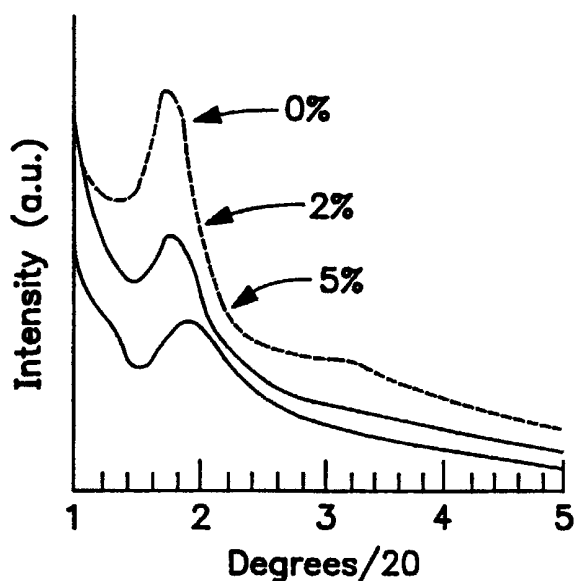
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(54) Title: COMBINED POROUS ORGANIC AND INORGANIC OXIDE MATERIALS PREPARED BY NON-IONIC SURFACTANT TEMPLATING ROUTE



(57) Abstract: A method for the preparation of quasi-crystalline, porous inorganic and organic oxide materials possessing uniform framework-confined mesopores in the range 1 to 12 nm prepared using an organic silane, such as (RO)₃SiR₁. The method uses an interaction between various nonionic poly(oxyalkylene) polymer based surfactants and neutral inorganic oxide precursors at ambient reaction temperatures. Exemplary surfactants are alkyl-polyethylene oxides and alkylphenyl-polyethylene oxides. Exemplary inorganic oxide precursors are single metal and double metal alkoxides including tetraethylorthosilicate (TEOS). Recovery of the template can be achieved through solvent extraction where the solvent may be water, an organic solvent, a mixture of organic solvents, or a mixture of water and organic solvent(s). The porous products produced may be used as absorbents, ion-exchangers, catalyst, catalyst supports or composites.

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COMBINED POROUS ORGANIC AND INORGANIC OXIDE MATERIALS
PREPARED BY NON-IONIC SURFACTANT TEMPLATING ROUTE

Government Rights

None

BACKGROUND OF INVENTION:

(1) Field of Invention:

5 This invention relates to the synthesis of
crystalline, combined porous inorganic and organic oxide
materials possessing uniform framework-confined
mesopores in the range 1 to 10² nm. The organic oxide
precursors are hydrolyzable organic silanes which are
10 incorporated into the framework. In particular, the
present invention relates to such materials where the
formation of the mesoporous structure is accomplished by
a self-assembly mechanism involving complexation and/or
hydrogen (H) bonding between aqueous or alcoholic
15 emulsions of various nonionic poly(oxyalkylene) based
surfactants and various mixed neutral inorganic and
organic oxide precursors. This is followed by
hydrolysis and subsequent condensation of hydrolysis
products at ambient reaction temperatures. This
20 templating approach allows for the removal of template
through solvent extraction.

(2) Description of Prior Art:

Modern human activities rely greatly upon
porous solids of both natural and synthetic design. The
25 pore structures of such solids are generally formed
during crystallization or during subsequent treatments.
These solid materials are classified depending upon
their predominant pore sizes: (i) microporous, with pore
sizes < 1.0 nm; (ii) macroporous, with pore sizes
30 exceeding 50.0 nm; and mesoporous, with pore sizes
intermediate between 1.0 and 50.0 nm. Macroporous
solids find limited use as adsorbents or catalysts owing
to their low surface areas and large non-uniform pores.

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Micro- and mesoporous solids however, are widely utilized in adsorption, separation technologies and catalysis. There is an ever increasing demand for new, highly stable well defined mesoporous materials because of the need for ever higher accessible surface areas and pore volumes in order that various chemical processes may be made more efficient or indeed, accomplished at all.

Porous materials may be structurally amorphous, para-crystalline or crystalline. Amorphous materials, such as silica gel or alumina gel, do not possess long range crystallographic order, whereas para-crystalline solids such as γ - or η - alumina are semi-ordered, producing broad X-ray diffraction peaks. Both these classes of materials exhibit very broad pore distributions predominantly in the mesoporous range. This wide pore distribution however, limits the effectiveness of catalysts, adsorbents and ion-exchange systems prepared from such materials.

Zeolites and some related molecular sieves, such as alumino-phosphates and pillar interlayered clays, possess rigorously uniform pore sizes. Zeolites are highly crystalline microporous aluminosilicates where the lattice of the material is composed of IO_4 tetrahedra (I=Al, Si) linked by sharing the apical oxygen atoms. Cavities and connecting channels of uniform size form the pore structures which are confined within the specially oriented IO_4 tetrahedra (Breck, D. W., *Zeolite Molecular Sieves: Structure, Chemistry and Use*; Wiley and Sons; London, pages 1 to 100 (1974)). Zeolites are considered as a subclass of molecular sieves owing to their ability to discriminate small molecules and perform chemistry upon them. Molecular sieves in general are materials with crystalline frameworks in which tetrahedral Si and/or Al atoms of a zeolite or zeolitic lattice are entirely or in part substituted by other atoms such as B, Ga, Ge, Ti, Zr, V,

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Fe or P. Negative charge is created in the zeolite framework by the isomorphous substitution of Si^{4+} ions by Al^{3+} or similar ions. In natural zeolites, this charge is balanced by the incorporation of exchangeable alkali or alkaline earth cations such as Na^+ , K^+ , Ca^{2+} . Synthetic zeolites utilize these and other cations such as quaternary ammonium cations and protons as charge balancing ions. Zeolites and molecular sieves are generally prepared from aluminosilicate or phosphate gels under hydrothermal reaction conditions. Their crystallization, according to the hereafter discussed prior art, is accomplished through prolonged reaction in an autoclave for 1-50 days and oftentimes, in the presence of structure directing agents (templates). The correct selection of template is of paramount importance to the preparation of a desired framework and pore network. A wide variety of organic molecules or assemblies of organic molecules with one or more functional groups are known in the prior art to provide more than 85 different molecular sieve framework structures. (Meier et al., *Atlas of Zeolite Structure types*, Butterworth, London, pages 451 to 469 (1992)).

Recent reviews on the use of templates and the corresponding structures produced, as well as the mechanisms of structure direction have been produced by Barrer et al., *Zeolites*, Vol. 1, 130 - 140, (1981); Lok et al., *Zeolites*, Vol. 3, 282 - 291, (1983); Davis et al., *Chem Mater.*, Vol. 4, 756 - 768, (1992) and Gies et al., *Zeolites*, Vol 12, 42 - 49, (1992). For example, U. S. Pat. No. 3,702,886 teaches that an aluminosilicate gel (with high Si/Al ratio) crystallized in the presence of quaternary tetrapropyl ammonium hydroxide template to produce zeolite ZSM-5. Other publications teach the use of different organic templating agents and include; U. S. Pat. No. 3,709,979, wherein quaternary cations such as tetrabutyl ammonium or tetrabutyl phosphonium ions crystallize ZSM-11 and U. S. Pat. No. 4,391,785

demonstrates the preparation of ZSM-12 in the presence of tetraethyl ammonium cations. Other prior art teaches that primary amines such as propylamine and *i*-propylamine (U. S. Pat. No. 4,151,189), and diamines such as diaminopentane, diaminohexane and diaminododecane (U. S. Pat. No. 4,108,881) also direct the synthesis of ZSM-5 type structure. Hearmon *et al* (Zeolites, Vol. 10, 608 -611, (1990)) however, point out that the protonated form of the template molecule is most likely responsible for the framework assembly.

Thus the synthesis and characterization of mesoporous molecular sieves, high surface area metal oxides (800 to $1400 \text{ m}^2\text{g}^{-1}$) with uniform pore sizes (20 to 100 Å in diameter), have in recent years commanded much attention in the field of materials chemistry (Kresge, C. T., *et al.*, 359, 710 (1992); Monnier, A., *et al.*, Science, 261, 1299 (1993); Tanev, P. T., *et al.*, Science 267, 865 (1995); Tanev, P. T., *et al.*, Chem. Mater. 8, 2068 (1996); Bagshaw, S. A., *et al.*, Science, 269, 1242 (1995); and Prouzet, E., *et al.*, Angew. Chem. Int. Ed. Eng. 36, 516 (1997). These materials can be prepared by the assembly and subsequent co-condensation of metal oxide precursor molecules (such as TEOS, $\text{Si}(\text{OEt})_4$) around structure directing micelles consisting of surfactant molecules which can be either charged (such as alkyltrimethylammonium ions (Kresge, C. T., *et al.*, Nature, 359, 710 (1992); and Monnier, A., *et al.*, Science, 261, 1299 (1993)) or electrically neutral (such as primary alkylamines (Prouzet, E., *et al.*, Angew. Chem. Int. Ed. Eng. 36, 516 (1997); Brunel, D., *et al.*, Stud. Surf. Sci. Catal. 97, 173 (1995); and U.S. Patent No. 5,622,684 to Pinnavaia *et al.*).

Focus has recently been put on researching methods to functionalize these materials in order to make mesostructured oxides useful for chemical applications. The chemical modification of mesoporous molecular sieves was first achieved by the incorporation

or grafting of suitable moieties onto the surface of a preformed mesostructured oxide (Brunel, D., et al., Stud. Surf. Sci. Catal. 97, 173 (1995); and Cauvel, A., et al., AIP Conf. Proc. 354-477 (1996)), producing highly effective adsorbents (Mercier, L., et al., Adv. Mater. 9, 500 (1997); and Feng, X., et al., Science 276, 923 (1997)) and catalysts (Tanev, P. T., et al., Nature 368, 321 (1994); and Maschmeyer, T., et al., Nature 378, 159 (1995)). U.S. Patent Nos. 5,446,182 and 5,318,846 to Bruening et al describe various silane compounds with a liquid covalently bonded through an organic space to a solid support. The silane compounds disclosed in these patents can be starting materials for the compounds of the present invention and they are incorporated by reference herein. All of these compounds are "hydrolyzable" organic silicon alkoxides, commonly referred to as "silanes". The patents describe them in reactions with preformed solid substrates (silica gel, for instance). In this instance the silicon compound is grafted to the surface of the substrate rather than an integral part of the matrix. An alternate synthetic strategy was subsequently reported in which functional organic groups were directly incorporated into the mesostructures by a one-step process involving the co-condensation of tetraethoxysilane (TEOS) and organosilane ($\text{Si}(\text{OEt})_3\text{R}$, where R is a functionalized organic group) in the presence of structure-directing alkyltrimethylammonium surfactant micelles (Burkett, S. L., et al., J. Chem. Soc. Chem. Commun. 1367 (1996); Fowler, C. E., et al., J. Chem. Soc. Chem. Commun. 1769 (1997); Lim, M. H., et al., Chem. Mater. 10, 467 (1998); Van Rhijn, W. M., et al., J. Chem. Soc., Chem. Commun. 317 (1998)). This technique appears to be a convenient improvement over post-synthesis functionalization because the preparation of ordered porous materials with controlled chemical composition can be achieved by adjusting the

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stoichiometry of the synthesis mixture. Since charge-bearing ammonium surfactants are used as structure-directing agents in this technique, an acid leaching technique was required to remove the surfactant (by ion-exchange) from the electrically charged frameworks, the result of which sometimes leading to the structural decomposition of the materials (Burkett, S. L., et al., J. Chem. Soc. Chem. Commun. 1367 (1996)). By using a non-electrostatic assembly strategy to prepare such functionalized mesostructures, the resulting frameworks would be electrostatically neutral, allowing the removal of the structure-directing surfactant by simple solvent extraction. Such an approach was demonstrated by Macquarrie for the preparation of ordered hybrid organic-inorganic silicas, in which a charge-neutral surfactant (dodecylamine) was used to assemble the mesostructures, then extracted out of the pore channels using hot ethanol (Macquarrie, D. J., J. Chem. Soc., Chem. Commun. 1961-1962 (1996)).

There is a need for improvements in the preparation of organic-inorganic metal oxide compositions which in particular are active for metal binding. The prior art structures are difficult to synthesize or have pores which are especially useful for metal binding.

OBJECTS OF THE INVENTION

It is therefore an object of the present invention to provide a new approach to the design and synthesis of mixed porous inorganic and organic metal oxide compositions with well defined mesoporosity, and controlled elementary particle size. Further, it is an object of the present invention to provide inexpensive templates, precursors and methods. Further, it is an object of the present invention to provide a template system that allows for facile recovery and thereby recycling of the template from the condensed organic-inorganic structure via solvent extraction. Further, it

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is an object of the present invention to provide a template system that affords mesoporous materials through lower cost, lower toxicity than either quaternary ammonium or amine surfactants and template biodegradability. It is a further object of the present invention to provide for the preparation of functionalized non-layered mesoporous structures of inorganic-organic oxide materials. Yet another objective is to provide for non-layered mesoporous structures of inorganic oxide materials derived from metals other than silicon, that are not accessible through the prior art. These and other objects will become increasingly apparent by reference to the following description and the drawings.

SUMMARY OF THE INVENTION

The present invention relates to a synthetic, semi-crystalline inorganic oxide composition prepared by a method comprising reacting an inorganic oxide precursor and a hydrolyzable organic silane in the presence of water and a structure-directing template which comprises a poly(oxyalkylene) based surfactant having a hydrophobic and hydrophilic moiety, the composition having at least one resolved x-ray reflection corresponding to a lattice spacing of 3 to 40 nm, framework confined pores between about 1 and 35 nm, and a surface area between 100 and 1500 m²g⁻¹ and with the hydrolyzed organic silane moiety incorporated into the framework pore walls. The organic functional groups of the inorganic-organic oxide materials allow their use as adsorbents for the removal of organics from water, as trapping agents for the removal of toxic metal ions from water, as immobilized acids or bases and as heterogeneous catalysts for a wide range of organic reactions.

The present invention also relates to a method for the preparation of a synthetic, semi-crystalline hybrid organic-inorganic silicon oxide composition which

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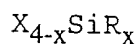
comprises:

(a) providing a mixture of (i) a silicon oxide precursor; (ii) a neutral polymeric surfactant which comprises poly(oxyalkylene) polymer as a template
5 having a hydrophobic and a hydrophilic moiety; and (iii) a hydrolyzable organic alkoxy silane;

(b) mixing the solution to form a precipitated composition in the presence of a solvent comprising water; and

10 (c) removing the surfactant from the precipitated composition by solvent extraction to form the organic-inorganic silicon oxide composition.

The silane compound used in preparing the compositions has the formula:



15 where X = 1, 2 or 3. Compounds where X is 1 are preferred. X can be an alkoxide or a halide.

The initial inorganic oxide precursor can be an alkoxide, a halide or a 1,3-diketonate. Preferred is
20 the alkoxide. The hydrolyzable organic silane provides the hydrolyzed organic silane, organic groups which are a sulfur containing ligand moiety.

Brief Description of the Drawings

25 Figures 1A and 1B are graphs of powder patterns for (Figure 1A) MSU-1 (inorganic) (dotted curve) and MP-MSU-1 (organic-inorganic) materials (solid curves); and for (Figure 1B) MSU-2 (dotted curve) and MP-MSU-2 materials (solid curves). The percentages denote the mercaptopropylsilyl group substitution in the mesostructures synthesis mixtures.
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Figures 2A, 2B, 2C and 2D - Left: N₂ adsorption isotherms of (Figure 2A) MSU-1 (dotted curve) and MP-MSU-1 materials (solid curves), and of (Figure 2B) MSU-2 (dotted curve) and MP-MSU-2 materials (solid curves).
35 Right: Background-subtracted Horvath-Kawazoe pore diameter (r) distributions of (Figure 2C) MSU-1 (dotted curve) and MP-MSU-1 materials (solid curves), and of

(Figure 2D) MSU-2 (dotted curve) and MP-MSU-2 materials (solid curves).

Figure 3 is a representative chemical structure of a secondary fatty alcohol poly-ethoxylate (TERGITOL).

Figure 4A is a representative chemical structure of an alkyl phenol poly-ethoxylate (TRITON XTM). Figure 4B is IGEPAL RC-760.

Figure 5 is a representative chemical structure of a fatty acid ethoxylate.

Figure 6 is a representative chemical structure of an ethylene oxide-propylene oxide-ethylene oxide tri-block co-polymer (PLURONIC 64LTM).

Figure 7 is a representative chemical structure of the ethylene diamine propylene oxide-ethylene oxide derivative (TETRONIC).

Figure 8 is a representative chemical structure of a primary fatty amine poly-ethoxylate.

Figure 9 is a representative chemical structure of a fatty acid PPO/PEO block co-polymer.

Figure 10 is a representative chemical structure of a sorbitan ethoxylate.

DESCRIPTION OF PREFERRED EMBODIMENTS

The terms framework-confined and textural porosity are herein defined. Framework-confined uniform pores are pores formed by the nucleation and crystallization of the framework elementary particles and are typically highly regular cavities and channels confined by the solid framework. The size of these cavities and channels is predetermined by the thermodynamically favored assembly routes. Textural porosity is that which can be attributed to voids and channels between elementary particles and/or aggregates of such particles (grains). Each elementary particle in the case of molecular sieves is composed of a certain number of framework unit cells each in turn containing framework-confined uniform pores. Textural porosity is

formed during crystal growth and segregation or during subsequent thermal treatment or acid leaching. The size of the textural pores is determined by the size, shape and the number of interfacial contacts of these particles or aggregates. Thus, the size of the textural pores is generally one or two orders of magnitude larger than that of the framework-confined pores and is proportional to the elementary particle size.

One skilled in the arts of powder X-ray diffraction (XRD), Scanning Electron Microscopy (SEM), Transmission Electron Microscopy (TEM) and adsorption/desorption can determine the existence of and differentiate between framework-confined and textural mesoporosities. The crystallographic distance between repeat units in the elementary particles and some information about the arrangement of such repeat units can be obtained from XRD. Particle sizes and shapes and preliminary information regarding textural mesoporosity can be established by SEM and TEM. Analysis of the N₂ or Ar adsorption-desorption isotherms of the solid material can indicate both framework-confined and textural mesoporosities. Textural mesoporosity is evidenced by the presence of a Type IV isotherm exhibiting a well defined hysteresis loop in the relative pressure region $P_i/P_0 > 0.5$ (Sing et al., *Pure Appl. Chem.*, Vol. 57, 603-619, (1985)). This behavior is common for a variety of para-crystalline materials and freeze-dried pillared layered solids. Framework-confined mesoporosity is characterized by a sharp adsorption uptake followed by a hysteresis loop in the 0.3-0.4 P_i/P_0 region. This hysteresis corresponds to capillary condensation in the framework-confined mesopores.

The present invention provides a new route to the synthesis of organic-inorganic metal oxide compositions with well defined framework-confined mesopores and large elementary particle size. The

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5 compositions produced in the current invention are distinguished from those of the prior art by the virtue of the method of preparation of the present invention, the subsequent architecture of the mesoporous structure and the range of templated organic-substituted metal oxides other than silica that is afforded by this route. Formation of the mesoporous network is accomplished by interaction (complexation and/or hydrogen-bonding) between a nonionic poly(oxyalkylene)polymer based surfactant template and neutral inorganic and organic precursors, followed by hydrolysis and subsequent condensation of the inorganic reaction product under either ambient or elevated temperature reaction conditions and the subsequent removal of the solvent phase and the template. The compositions also have textural mesoporosity.

10 The present invention particularly provides a preferred nonionic route to the preparation of quasi-crystalline inorganic-organic oxide compositions comprising (a) preparing a homogeneous solution or emulsion of a nonionic poly(oxyalkylene)polymer surfactant by stirring, sonicating or shaking at standard temperature and pressure (STP); (b) addition of one or more of each of neutral inorganic and organic precursors with stirring at standard temperatures and pressures (STP) to the emulsion of step (a) at ambient temperature to form a precipitated semi-crystalline product; (c) separating the solvent and the hydrolyzing agent from the precipitated product by filtration or centrifugation; and (d) extracting the template through solvent extraction whereby the solvent is either water or ethanol.

25 The present invention thus provides a new route to inorganic and organic oxide crystalline materials with uniform well defined framework-confined mesopores and controlled elementary particle size that can be utilized as adsorbents, metal ion traps, solid

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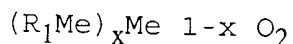
acids and bases, and catalysts and catalyst supports for the catalytic conversion of organic substrates. According to the method of the present invention, the formation of the mesoporous structure is accomplished by interaction (complexation and/or hydrogen bonding) between template molecules within micellar aggregates of nonionic poly(oxyalkylene) polymer templates and neutral organic and inorganic oxide precursors, followed by hydrolysis and cross linking of IO_x units, where I is a central metallic or non-metallic element coordinated to x oxygen atoms ($2 \leq x \leq 6$). This interaction is most likely to occur between an I-OH unit and the terminal OH function of each surfactant molecule, or between the I-OH unit and the array of lone pair electrons on the template polar segment. The polar segment of the template in the present invention is flexible and appears to act in the fashion of a crown ether complexing a I-OH unit, thereby stabilizing a site of nucleation for subsequent condensation of the mesoporous quasi-crystalline organic and inorganic oxide product, although the inventors do not want to be bound to any particular theory.

The prior art does not describe the preparation of micro-, meso-, or macro-porous inorganic oxide compositions by such a nonionic mechanism involving crystallization of organic and inorganic oxide precursors around well defined micelles of nonionic polymeric surfactants. Specifically, the present result is achieved by using micelles of a nonionic surfactant to template and assemble neutral inorganic and organic reactant precursors into a mesoporous framework structure. Complexation and/or hydrogen bonding between the template and the reagent is believed to be the primary driving force of the assembly of the framework in the current invention. The aforementioned method consists of the formation of a solid precipitate by the mixing of a solution or emulsion of a poly(oxyalkylene)

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based polymer, nonionic surfactant, with a neutral inorganic, usually inorganic alkoxide, and an organic oxide precursor in the presence of a hydrolyzing agent, followed by aging and crystallization under stirring, sonication or shaking at ambient temperature for at least 16 h. The template may be recovered by extraction with ambient temperature alcohol or hot water whose temperature exceeds the cloud point of the template.

The molar ratio of inorganic and organic oxide precursor to surfactant is between 10:1 and 20:1 depending upon the specific template being used. The concentration of surfactant in solution is between 0.003 mol L⁻¹ and 0.4 mol L⁻¹ again depending upon the surfactant being used and the pore size desired. The crystalline inorganic-organic oxide composition of the present invention upon removal of the template has the preferred composition:



wherein Me is at least one metal such as Al, Ga or Fe; or Ge, Ti, V, Sb or Zr; W or Mo; wherein at least some of Me are Si which is derived from an organic alkoxy silane, R₁ is the organic group; O is oxygen and x is the molar stoichiometry of Me between about 0.001 and 0.999, respectively. The product can be hydrated.

Preferably, the method comprises the formation of an organic/inorganic solution by the mixing of an aqueous or alcoholic solution of nonionic surfactant with the desired amount of Si-alkoxide, Me-Si double alkoxide, mixtures of Si- and Me-alkoxides or pure Me alkoxides (where Me= Al, Ca, Cr, Fe, Ga, Ge, Mg, Mo, Nb, Sb, Sn, Ti, V, W, or Zr) and organic alkoxy silane, followed by aging and subsequent precipitation under stirring for at least 16 h. The template is preferably a nonionic (neutral) polyethylene oxide based molecule that possesses one of many different molecular

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structures and the hydrolyzing agent is preferably water.

The template may be removed from the condensed reaction products by solvent extraction of the template from the air dried material using an organic solvent such as an alcohol or using hot water.

The new synthesis method involves the preparation of solutions or emulsions of a surfactant template compound and reaction of this solution with liquid di-, tri-, tetra-, penta- or hexa-valent metal or metalloid hydrolyzable reagents including an organic silane in the presence of a hydrolysing agent under stirring, sonication or shaking, until formation of the desired precipitated product is achieved and recovering the solid material. There are four basic types of preferred surfactant molecules that are described herein. The alkyl-polyethylene oxides; such as are related to the Tergitol 15-S-m products (Figure 3) are derived from the reaction of ethylene oxide with a primary or secondary alcohol and possess the basic formula $R_n-O(EO)_mH$ where R is a hydrophobic alkyl group with n ranging from 1 to at least 20 carbon atoms, EO is a hydrophilic ethylene oxide unit (OCH_2CH_2) with m ranging from about 7 to 40, preferably at least 20.

The alkyl-phenyl polyethylene oxides; such as IGEPAL-RC (Figure 4B), BRIJ and TRITON-X (Figure 4A); possess the same range of structures as the alkyl-polyethylene oxides, with the exception that the primary (IGEPAL RC), secondary or tertiary (TRITON X) R group is bound to the EO units through a hydrophobic phenoxy group (PhO). These molecules then, have the basic formula; $R_n-Ph-O(EO)_mH$, preferably where m is 8 to 10 and n is 8.

The polyethylene oxide (PEO)-polypropylene oxide (PPO) molecules; such as Pluronic (Figure 6), are derived from the addition of hydrophobic propylene oxide to propylene glycol followed by the addition of

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hydrophilic ethylene oxide. They are defined as PEO_n - PPO_m - PEO_n tri-block co-polymers wherein n is controlled by length to constitute from 10% to 80% by weight of the final product. The order of the PEO and PPO units may be reversed in order to produce the PPO_m - PEO_n - PPO_m triblock co-polymers; Pluronic-R. Preferably n is 30 and m is 13.

A fourth basic PEO based surfactant type is derived by from the substitution of the hydrogens of ethylene diamine by ethylene oxide and propylene oxide units to form the X shaped, Tetronic, molecules (Figure 7) with basic formula ; $((EO)_n-(PO)_m)_2-NCH_2CH_2N-((PO)_m-(EO)_n)_2$. The order of the PEO and PPO groups in these molecules may also be reversed to form Tetronic-R. Preferably m is 13 and n is 30. Figures 5, 8 and 9 show other useful polymers.

The preferred preparation procedures of the said compositions comprise steps as follows:

(i) preparing a solution of the desired template under stirring, in a solvent that is either water for the preparation of silicon dioxide, or alcohol for the preparation of metal oxide compositions from more reactive alkoxide precursors;

(ii) addition of the desired metal oxide precursor(s) and one or more organic alkoxy silane(s) to the surfactant solution under stirring, sonication or shaking. The metal oxide precursor(s) and organic alkoxy silane(s) can be added simultaneously or in any order to the template solution;

(iii) preparation of a solution of the hydrolysing agent in the alcohol used in step (i). The hydrolysing agent is water;

(iv) very slow addition of the hydrolysing agent to the template/inorganic-organic precursor solution under stirring. (iii and

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iv are not required if templated silica is being prepared);

(v) aging of the total solution for at least 16 h up to 48 h at room temperature;

5 (vi) separation of the product from the supernatant liquid by filtration or centrifugation;

(vii) air drying of the product followed by optional heat treatment at 373° K; and

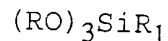
10 (viii) separation of the template by extraction with an organic solvent, a mixture of solvents, or hot water or a mixture thereof. The preferred extraction solvent is ethanol.

15 The inorganic oxide precursors are single or double metal alkoxide compounds, The list of preferred alkoxides includes but not exclusively: aluminum(III) ethoxide, aluminum(III) isopropoxide, aluminum(III) *n*-, *sec*- or *tert*- butoxide, antimony(III) isopropoxide, antimony(III) *n*-butoxide, calcium(II) ethoxide, calcium(II) isopropoxide, calcium(II) *tert*- butoxide, chromium(IV) isopropoxide, chromium(IV) *tert*- butoxide, copper(II) methoxyethoxide, gallium(III) isopropoxide, germanium(IV) ethoxide, germanium(IV) isopropoxide, indium(III) isopropoxide, iron(III) ethoxide, iron(III) isopropoxide, iron(III) *tert*- butoxide, lead(II) isopropoxide, lead(II) *tert*- butoxide, magnesium(II) ethoxide, manganese(II) isopropoxide, molybdenum(V) isopropoxide, niobium(V) ethoxide, silicon(IV) methoxide, silicon(IV) ethoxide, silicon(IV) propoxide, silicon(IV) butoxide, silicon(IV) hexoxide, strontium(II) ethoxide, tin(IV) isopropoxide, titanium(IV) ethoxide, titanium(IV) propoxide, titanium(IV) isopropoxide, titanium(IV) butoxide, titanium(IV) octadecoxide, tungsten(VI) ethoxide, tungsten(VI) isopropoxide, vanadium(V) triisopropoxide oxide, zinc(II) isopropoxide, zinc(II) *tert*- butoxide,

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zirconium(IV) *n*- propoxide, zirconium(IV) isopropoxide, zirconium(IV) butoxide, zirconium(IV) *tert*- butoxide, aluminum(III) silicon(IV) alkoxide, titanium(IV) silicon(IV) polyethoxide and other mixtures
5 of the aforementioned alkoxide compounds. The alcohols used in step (i) of the preparation art correspond to the alcoholate ligand from which the metal alkoxide is derived. The alcohols thus preferred are methanol, ethanol, *n*- and isopropanol and *n*-, *sec*-, *tert*-,
10 butanol. The alcohols contain 1 to 4 carbon atoms.

The organic silanes which are useful are those which will react to form the mesoporous structure. Included are preferred silanes of the formula:



15 where R is a lower alkyl group (1 to 8 carbon atoms) and R₁ can be an organic group which can be an alkyl, alkoxy, alkenyl or alkynyl, cycloaliphatic, aromatic group containing 1 to 25 carbon atoms. R₁ can include
20 substituents of O, N or S and can provide a hydroxide, an aldehyde, acid, base, sulfide, cyanide, mercaptan and the like. Examples of basic moieties especially useful as catalysts include amines and pyridyl groups. Useful acidic functionalities include carboxylic acids, sulfonic acids, and furoinated sulfonic acids. R₁ can
25 contain a halogen selected from the group consisting of F, I, Br or Cl and the R₁ group can be further reacted at the halogen group. The preferred R₁ contain moieties which are metal binding to provide selective adsorption of metal ions from solution. Especially useful metal
30 trapping agents include organic groups containing chelating ligands such as ethylene diamines, ethylene diamine tri- and tetra acetate, cyclic and bicyclic polyethers known as crown ethers and cryptans and the like. The mixed metal alkoxides and organic-alkoxy
35 silanes can be obtained commercially. Alternatively, they may be specifically prepared for use in forming the desired compositions. For instance, desired mixed metal

alkoxides may be prepared by reaction of the parent alkoxides in desired molar ratios under reflux for 3 - 4 hours. Functional organosilanes can be prepared by hydrosilylation of olefins.

5 Other preferred silanes are of the class $RO_2Si(R_2)_2$ where R_2 can be the same as R_1 . The general formula is $Si(OR)_{4-n}(R)_n$ where n is 1, 2 or 3. Preferably R_1 or R_2 contains a functional group selected from a metal, vinyl, cyano, amino, mercapto, halogen (usually
10 Cl or Br), aldehyde, ketone acid (including sulfuric and F-sulfuric acid or base group). The metals help form structures where the metal is removable and provides increased receptivity to the metal removed. Preferably R_1 or R_2 is a functional group.

15 Examples of commercially available functional silanes which can be used are:

3-(N-allylamino)propyltrimethoxy-silane;

O-allyloxy(polyethyleneoxy)-trimethylsilane;

N-(2-aminoethyl)-3-aminopropylmethyl-dimethoxysilane;

20 N-(2-aminoethyl)-3-aminopropyltri-methoxysilane N-[3-(trimethoxysilyl)propyl]ethylenediamine;

N-(6-aminoethyl)aminopropyl-trimethoxysilane;

2-[Methoxy(polyethyleneoxy)propyl]trimethoxysilane;

(3-Trimethoxysilylpropyl)diethylene-triamine 95%;

25 Trivinylmethoxysilane;

3-Cyanopropyl dimethylmethoxysilane;

3-Cyanopropyltriethoxysilane;

(3-Cyclopentadienylpropyl)triethoxysilane;

Diphenyldiethoxysilane;

30 Diphenyldimethoxysilane;

Diphenylsilanediol;

Diphenylvinylethoxysilane;

(Mercaptomethyl)dimethylethoxysilane;

(Mercaptomethyl)methyldiethoxysilane;

35 3-Mercaptopropylmethyl dimethoxysilane;

3-Mercaptopropyltriethoxysilane;

3-Mercaptopropyltriethoxysilane;

- 3-Methacryloxypropyldimethylethoxy-silane;
3-Methacryloxypropyldimethylmethoxysilane;
3-Methacryloxypropylmethyldiethoxy-silane;
3-Methacryloxypropylmethyldimethoxysilane;
5 3-Methacryloxypropyltrimethoxysilane;
Methylphenyldimethoxysilane;
Methyl [2- (3-trimethoxysilylpropylamino) -ethylamino] -3-
propionate (65% in methanol);
7-Oct-1-enyltrimethoxysilane;
10 Phenethyltrimethoxysilane;
N-Phenylaminopropyltrimethoxysilane;
Phenyldimethylethoxysilane;
Phenyltriethoxysilane;
Phenyltrimethoxysilane;
15 Phenylvinyl diethoxysilane;
N- [3- (triethoxysilyl)propyl] -4,5-dihydro-imidazole;
2- (Trimethoxysilyl) ethyl-2-Pyridine;
Trimethoxysilylpropyldiethylenetriamine (95%);
N[(3-trimethoxysilyl)propyl]ethylene-diamine triacetic
20 acid, trisodium salt (50% in water);
N- (3-trimethoxysilylpropyl) pyrrole;
Triphenylsilanol;
Vinyl dimethylethoxysilane;
Vinylmethyldiethoxysilane;
25 Vinyltriethoxysilane;
Vinyltrimethoxysilane;
3-Cyanopropyl dimethylmethoxysilane;
3-Cyanopropyltriethoxysilane;
(3-Cyclopentadienylpropyl) triethoxysilane;
30 Diphenyldimethoxysilane;
Diphenylsilanediol;
Diphenylvinylethoxysilane;
(Mercaptomethyl) dimethylethoxysilane;
(Mercaptomethyl) methyldiethoxysilane;
35 3-Mercaptopropylmethyldimethoxysilane;
3-Mercaptopropyltrimethoxysilane;
3-Mercaptopropyltriethoxysilane;

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- 3-Methacryloxypropyldimethylethoxy-silane;
3-methacryloxypropyldimethylmethoxysilane;
3-Methacryloxypropylmethyldiethoxy-silane;
3-Methacryloxypropylmethyldimethoxysilane;
5 3-Methacryloxypropyltrimethoxysilane;
Methylphenyldimethoxysilane;
Methyl [2- (3-trimethoxysilylpropylamino) -ethylamine] -3-
propionate (65% in methano);
7-Oct-1-3nyltrimethoxysilane;
10 Phenethyltrimethoxysilane;
N-phenylaminopropyltrimethoxysilane;
Phenyldimethylethoxysilane;
Phenyltriethoxysilane;
Phenyltrimethoxysilane;
15 Phenylvinyl diethoxysilane;
N- [3- (triethoxysilyl)propyl] -4,5-dihydro-imidazole;
2- (Trimethoxysilyl) ethyl -2-pyridine;
Trimethoxysilylpropyl diethylenetriamine (95%);
N- [(3-trimethoxysilyl)propyl] ethylene-diamine triacetic
20 acid, trisodium salt (50% in water);
N- (3-trimethoxysilylpropyl) pyrrole;
Triphenylsilanol;
Vinyl dimethylethoxysilane;
Vinyl methyldiethoxysilane;
25 Vinyl triethoxysilane;
Vinyl trimethoxysilane.
- N- (trimethoxysilylpropyl) ethylene-diamine, triacetic
acid, trisodium salt;
30 4-Aminobutyldimethylmethoxysilane;
4-Aminobutyltriethoxysilane (95%);
N- (2-aminoethyl) -3-aminopropylmethyldi-methoxysilane;
 $H_2NCH_2CH_2CH_2SiOEt$ 3-aminopropyl dimethylethoxysilane;
3-Aminopropylmethyldiethoxysilane;
35 3-Aminopropyl diisopropylethoxysilane;
3-Aminopropyltriethoxysilane;
3-Aminopropyltrimethoxysilane;

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N-(triethoxysilylpropyl)urea (50% in methanol).

N-[3-(triethoxysilyl)propyl]phthalamic acid (95%).

5 The above list is not meant to be limiting, but merely intended to provide examples of easily obtainable functional silanes useful in preparing the compositions of this invention. In general, any functional organosilane may be incorporated into the porous inorganic and organic oxide materials embraced by the present art. Functional organo groups on the silane moiety that are especially useful include acids and bases for catalytic applications, dye chromophores for sensing, and complexants for binding metal ions. In the latter case the bound metal ions may be recovered by ion exchange or subsequently used in the immobilized state as catalysts for organic chemical transformation.

10 The reaction of the inorganic precursor, organic precursor and the template solution is preferably achieved between 10° C and 80°C under stirring for periods between 0.5 and 16 hours. The pH can be acidic, basic, or neutral, but near-neutral pH values are preferred. With co-surfactants such as mesitylene or xylenes the templating micelles may be swelled to produce increased pore sizes. Other non-polar solvents can be used for this purpose.

25 Aging of the reaction mixture may be achieved at room temperature either under stirring, sonication or shaking or by being left to stand for at least 24 h. More specifically, the reacting occurs through complexation or H-bonding between a neutral nonionic template and neutral inorganic oxide precursors, followed by hydrolysis and crosslinking of IO_x units at ambient or elevated reaction temperatures. The complexation, or H-bonding most likely occurs between the terminal OH group of the template molecules and the hydrolyzable ligand on the inorganic and organic precursor molecules, or between the inorganic and organic precursor molecules and the electron lone pairs

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of the ethylene oxide groups in the hydrophilic head group of the template molecules.

The templated inorganic-organic oxide compositions of the present invention can be combined with other components, for example, zeolites, clays, inorganic oxides or organic polymers or mixtures thereof. In this way adsorbents, ion-exchangers, catalysts, catalyst supports or composite materials with a wide variety of properties may be prepared. Additionally, one skilled in the art may impregnate or encapsulate transition metal macrocyclic molecules such as porphyrins or phthalocyanines containing a wide variety of catalytically active metal centers.

Additionally, the surfaces of the compositions can be functionalized in order to produce catalytic, hydrophilic or hydrophobic surfaces. The surfaces may be functionalized after synthesis by reaction with various chlorides, fluorides, silylating or alkylating reagents.

The following are specific examples of the present invention intended to illustrate but not to limit the invention.

The following Examples show the co-condensation of tetraethoxysilane (TEOS) and organotrialkoxysilane $(RO)_3SiR_1$ assembled in the presence of structure-directing non-ionic polyethyleneoxide surfactant micelles provides a convenient neutral pH synthesis methodology for the one-step preparation of organically functionalized mesostructured materials.

In particular the examples show preparation of organically functionalized mesoporous molecular sieves using uncharged non-ionic alkylpolyethyleneoxide surfactants as structure-directing agents, namely TERGITOL 15-S-12 $(CH_3(CH_2)_{14}(OCH_2CH_2)_{12}OH)$ and TRITON-X100 $((CH_3)_3C(CH_3)_2CCH_2C_6H_4(OCH_2CH_2)_{10}OH)$.

EXAMPLES 1 AND 2

The non-functionalized inorganic mesostructured silicas MSU-1 and MSU-2 were prepared according to previously published assembly techniques (Prouzet, E., et al., Angew. Chem. Int. Ed. Eng. 36, 516 (1997); U.S. Patent No. 5,622,684), using TERGITOL 15-S-12 and TRITON-X, respectively, as structure-directing surfactants. Functionalized derivatives of MSU-1 and MSU-2 (MP-MSU-1 and MP-MSU-2) were synthesized by stirring TEOS and mercaptopropyltrimethoxysilane (MPTMS) in solutions of TERGITOL 15-S-12 (0.02 mol L⁻¹) or TRITON-X100 (0.027 mol L⁻¹) until a clear mixture formed. The solutions were then transferred to a thermostated water bath set at 308 K and NaF was added to catalyze the condensation of the siloxane molecules (the molar composition of each mixture was 0.1 surfactant : 1-x TEOS : x MPTMS : 0.02 NaF, where x = 0, 0.02 or 0.05). After aging for 24 hours, the resulting powders were filtered, air dried and the surfactants removed from the mesostructure pores by Soxhlet extraction over ethanol for 24 hours. The functionalized mesostructures assembled using TERGITOL-15-S-12 were thus labeled as MP-MSU-1-2% (x = 0.02) and MP-MSU-1-5% (x = 0.05), while those prepared from TRITON-X100 were designated as MP-MSU-2-2% (x = 0.02) and MP-MSU-2-5% (x = 0.05). The mesostructures were characterized by powder X-ray diffraction (XRD), N₂ sorptometry, elemental analysis (for S), ²⁹Si MAS-NMR and scanning electron microscopy (SEM). The materials' physical properties obtained from these techniques are given in Table 1.

TABLE 1

Sample	d_{100} lattice spacing / Å	BET surface area / m^2g^{-1}	Pore diameter / Å ^a	S content / mmol g^{-1}	Organo- silane content ^b
MSU-1	51	1225	32	0	0
MP-MSU-1-2%	50	943	26	0.40	2.6%
MP-MSU-1-5%	48	858	22	0.87	5.8%
MSU-2	66	1018	41	0	0
MP-MSU-2-2%	50	1176	27	0.47	3.0%
MP-MSU-2-5%	40	763	-	1.1	7.7%

^aMeasured using the Horvath-Kawazoe pore size distribution model (Horvath, G., et al., J. Chem. Eng. Jap. 16, 470 (1983)).

^bPercentage of Si atoms present as organosilane with respect to total Si content.

The low angle powder X-ray diffraction patterns of the MSU-1 and MSU-2 materials (Figure 1) featured dominant first order (d_{100}) diffraction peaks (with d-spacings of 51 and 66 Å, respectively, see Table 1) and broad, low intensity second order (d_{200}) peaks at higher incidence angle. These represent features typical of ordered mesostructured oxides with "wormlike" pore channel structures, as expected of materials assembled using either neutral (Tanev, P. T., et al., Science 267, 865 (1995); and Tanev, P. T., et al. Chem. Mater. 8,2068 (1996)) or non-ionic surfactants (Bagshaw, S. A., et al., Science 269, 1242 (1995); and Prouzet, E., et al., Angew., Chem. Int. Ed. Eng. 36, 516 (1997)). As organosilane moieties are incorporated into the mesostructures, the d_{100} peaks of the materials become shifted to higher diffraction angles (Figure 1), indicating progressive contractions of the lattice d-spacings upon functional group loading (Table 1). Although this effect is slight for the MP-MSU-1

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mesostructures (a contraction of only 6% from MSU-1 to MP-MSU-1-5%), significant contraction of the MSU-2 lattice is observed (by 39% from MSU-2 to MP-MSU-2-5%). Moreover, the intensities of the (100) peaks for the functionalized materials were lower in intensity compared to their respective parent mesostructures, and the higher order (200) reflections are no longer detected. Both of these observations suggest that, although crystallographic order is maintained in the MP-incorporated materials, the addition of organosilane molecules to the mesostructure syntheses mixtures causes perturbation of the surfactant micelle structures in solution, giving rise to the assembly of materials with decreased crystallographic ordering. The relatively strong lyophilic interactions between the organosilane molecules and the hydrophobic core of the assembly micelles (particularly in the case of TRITON-X) are likely to result in the "diving" of the organosilane molecules to a greater depth within the micelle than do the TEOS molecules. This will cause the micelle structure to "open-up" and allow TEOS molecules to migrate deeper within the micelle, where they subsequently crosslink with the organosilane functionalities. The perturbations thus caused to the micelle organization thus results in the assembly of more disordered materials.

As shown by the dotted lines, the N₂ adsorption isotherms of MSU-1 (Figure 2A) and MSU-2 (Figure 2B) both featured well-resolved inflexions at partial pressures between 0.3 and 0.6, demonstrating the existence of uniform mesopore channels with diameters of 32 Å (Figure 2C) and 41 Å (Figure 2D), respectively, as calculated using the Horvath-Kawazoe pore size distribution model (Horvath, G., et al., J. Chem. Eng. Jap 16, 470 (1983)). No appreciable hysteresis loops were observed in any of the isotherms' desorption branches, denoting the absence of bottlenecking in the

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pore channels. The surfactant extraction technique was thus effective in removing the surfactant from the pore channels without damaging the structure of the synthesized materials. The large BET surface areas measured were likewise consistent with the presence of highly porous materials (Table 1). As shown by the solid lines, the isotherms of the organic functionalized derivatives MP-MSU-1-2% (Figure 2A) and MP-MSU-2-2% (Figure 2B) were also indicative of mesoporosity, but the shifts observed in the positions of the inflexions (to between 0.1 and 0.3) show that constrictions in the pore channels have arisen. This can be attributed to both the lattice contractions and to the presence of the mercaptopropyl (MP) moieties which line the pore channel walls, thus reducing the pore diameters and volumes of the mesostructures (Figures 2C and 2D). Despite pore constriction, the organic functionalized materials nonetheless retained the very high surface areas characteristic of mesoporous molecular sieves (Table 1).

As shown by the solid lines, the isotherms of the increasingly loaded MP-MSU-1-5% and MP-MSU-2-5% mesostructures demonstrated an even greater constriction of the pores (Table 1), resulting in further reduction of total pore volume in MP-MSU-1-5% (Figure 2B) and no discernable porosity in MP-MSU-2-5% (Figure 2D). The significant decreases in surface areas for both of these materials (Table 1) further substantiate these observations. Since all of the functionalized materials are shown to exhibit crystallographic ordering according to their XRD patterns (Figures 1A and 1B), the incremental featurelessness observed in their N_2 isotherms can be explained by the influence of the increasing amounts of mercaptopropyl groups lining the framework channels, disrupting the uniformity of the pores and reducing their diameters.

The SEM images of the materials revealed aggregates of ultrafine spherical particles with a

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"cotton ball"-like morphology. The particles appeared to be quite uniform in size with diameters averaging about 0.3 μm for all compositions. The minute sizes of these particles creates significant textural porosity within the mesostructure aggregates, resulting in notable sloping of the nitrogen adsorption curves beyond the mesopore inflexions, as well as significant nitrogen uptake observed at relative pressures approaching 1 (Figures 2A and 2B).

The ^{29}Si MAS-NMR spectra of the functionalized mesostructured (recorded with a 600 s pulse delay to allow the full relaxation of the Si magnetization between acquisitions) denoted the presence of the following Si sites: Q^4 signals at -110 ppm ($(\text{SiO})_4\text{Si}$), Q^3 signals at -101 ppm ($(\text{SiO})_3\text{SiOH}$) (both corresponding to framework silica derived from hydrolyzed TEOS), and T^2 and T^3 signals (at -60 and -65 ppm, respectively) corresponding to the organosilane (mercaptopropylsilane) silicon atoms (Burkett, S. L, et al., J. Chem. Soc., Chem. Commun. 1367 (1996)). In all cases, the Q^4/Q^3 signal intensity ratios were close to 1.5, while the intensities of the T^2 and T^3 signals increased as a function of organosilane loading in the materials. By comparing the integrations of these NMR signals, in combination with the elemental analysis results (for S content), the functional group content in the mesostructure was deduced and expressed in Table 1 both in terms of S content and organosilane percentage. Although the amount of organosilane incorporated into the MP-MSU-1 materials was found to be close than expected on the basis of the stoichiometry of the solution reaction mixture, the functional group loading in MP-MSU-2-2% and MP-MSU-2-5% exceeded this content by a factor of about 1.5 (Table 1). This suggests that preferential assembly of the organosilane molecules has occurred at the interface of the TRITON-X micelles. Since the overall yield of the materials syntheses is

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relatively low (about 25%), the partitioning of both framework-building molecules (TEOS and MPTMS) at the interface of the micelle template thus appears to be an important synthesis parameter for these materials. This apparent partitioning effect may be explained by the greater hydrophobicity of the TRITON-X micelle core (consisting of a branched octane and a phenyl group compared to that of TERGITOL-15-S-12 (composed of an alkyl chain), resulting in greater affinity of the assembly surfactant towards the organosilane molecules. The dramatic lattice contractions observed in the TRITON-X-assembled mesostructures is likely related to this phenomenon, since the MPTMS molecules may penetrate deep into the micelles because of strong lyophilic interactions.

Despite the relatively low yields of the synthesis procedure, the one-step preparation of functionalized mesoporous silica by non-ionic surfactant assembly presents a clear advantage over methodologies involving charged quaternary ammonium surfactants, namely that it does not necessitate the use of potentially destructive acid leaching to remove the framework-bound surfactant from the mesostructures. The extraction of the non-ionic surfactant can thus be readily achieved by the straightforward washing of the as-synthesized materials with a suitable solvent (such as ethanol). Moreover, the assembly process described in this paper is achieved under neutral pH conditions, unlike the other direct-synthesis approaches which were performed in alkaline environments (Burkett, S. L., et al., *J. Chem. Soc., Chem. Commun.* 1367 (1996); Fowler, C. E., et al., *J. Chem. Soc., Chem. Commun.* 1769 (1997); Lim, M. H., et al., *Chem. Matr.* 10, 467 (1998); and Van Rhijn, W. M., et al., *J. Chem. Soc., Chem. Commun.* 317 (1998)). This feature connotes the possibility of incorporating organic functionalities that would be unstable or otherwise reactive under non-neutral pH

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conditions such as strongly electrophilic functionalities.

EXAMPLE 3

5 Chloroalkyl functionalities have been successfully incorporated into mesostructured frameworks following the synthetic protocol described in Examples 1 and 2 as evidenced by XRD. These were prepared by stirring TEOS and chloropropyl trimethoxysilane in solutions of TERGITOL 15-S-12 (0.02 mol L⁻¹) and TRITON-10 X100 (0.027 mol L⁻¹) until a clear mixture formed.

Samples:

These were prepared following exactly the same protocol as that described in Examples 1 and 2, except that an equimolar quantity of 15 chloropropyltrimethoxysilane was used as the organosilane agent instead of mercaptopropyltrimethoxysilane. The XRD patterns and N₂ adsorption isotherm of the materials thus obtained were virtually identical to those of the mercaptopropyl (MP) 20 derivative described in Examples 1 and 2. ²⁹MAS-NMR and X-ray fluorescence measurements confirmed the presence of chloro groups in the samples in quantities similar to those of the sulfoxyl groups in the MP-derivatized analogs.

25 Another potential advantage of using poly(oxyalkylene) polymer based non-ionic structure-directing agents is their reported ability to form mesostructures of variable pore diameters by controlling the temperature of the assembly process (Prouzet E., et al., Angew. Chem. Int. Ed. Eng. 36, 516 (1997)). The 30 temperature and organosilane concentration on the incorporation of organic moieties into non-ionic surfactant assembled mesostructures represent another variable for control.

35 It is intended that the foregoing description be only illustrative and that the present invention be limited only by the hereinafter appended claims.

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WE CLAIM:

-1-

A synthetic, semi-crystalline inorganic oxide composition prepared by a method comprising reacting an inorganic oxide precursor and a hydrolyzable organic silane in the presence of water and a structure-directing template which comprises a poly(oxyalkylene) based surfactant having a hydrophobic and hydrophilic moiety, the composition having at least one resolved x-ray reflection corresponding to a lattice spacing of 3 to 40 nm, framework confined pores between about 1 and 35 nm, and a surface area between 100 and 1500 m²g⁻¹ and with the hydrolyzed organic silane moiety incorporated into the framework pore walls.

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The composition of Claim 1 wherein the structure-directing template is removed from the composition.

-3-

The method of Claim 1 wherein the surfactant has a terminal hydroxyl group or amino group.

-4-

The composition of Claim 1 wherein the surfactant is selected from the group consisting of nonionic alkyl polyethylene oxide molecules, alkyl and aryl polyethylene oxide molecules, polyethylene oxide-polypropylene oxide-polyethylene oxide block copolymer molecules, polypropylene oxide-polyethylene oxide-polypropylene oxide block copolymer and derivatives of ethylene diamine in which polyethylene oxide-polypropylene oxide block copolymers have replaced the amine protons of the ethylene diamine.

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The composition of any one of Claims 1, 2, 3 or 4 wherein inorganic oxide precursor is a M alkoxide thereof where M is Al, Cr, Fe, Ga, Ge, Mg, Mo, Nb, Sb, Sn, Ti, V, Si, W, Zr and mixtures thereof.

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A synthetic, semi-crystalline hybrid organic-inorganic silicon oxide composition prepared by a method comprising reacting a inorganic silicon oxide precursor and a hydrolyzable organic silane in the presence of water and structure-directing template which is a poly(oxyalkylene) based polymer surfactant having a hydrophobic and a hydrophilic moiety followed by removal of the surfactant having at least one x-ray diffraction reflection corresponding to a lattice spacing of 3 to 40 nm, framework confined pores between 1 and 35 nm in diameter, a specific surface area of between 100 and 1500 m²/g, and with the hydrolyzed organic silane moiety incorporated into the framework pore walls.

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A synthetic, semi-crystalline hybrid organic-inorganic silicon oxide composition prepared by a method comprising reacting a mixture of a inorganic silicon oxide precursor, a neutral poly(oxyalkylene) polymer based surfactant as a structure-directing template, and a hydrolyzable organic silane in the presence of an organic solvent containing water to provide the composition.

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The composition of any one of Claim 7 wherein the structure-directing template is selected from the group consisting of a poly(ethylene) oxide, poly(propylene) oxide polymers and mixtures thereof.

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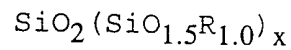
The composition of any one of Claims 7 or 8 wherein the surfactant is removed from the composition by solvent extraction.

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The composition of any one of Claims 7 or 8 having at least one x-ray diffraction reflection corresponding to a lattice spacing of 3 to 40 nm, framework confined pores between 1 and 35 nm and a specific surface area of between 100 and 1500 m²/g.

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The composition of Claim 1 represented by the anhydrous oxide formula:

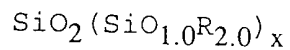


wherein $\text{SiO}_{1.5}\text{R}_{1.0}$ is the hydrolyzed organic silane moiety incorporated into the framework; Si is a silicon atom; O is oxygen and x is between 0.01 and 0.25.

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The composition of Claim 1 represented by the anhydrous oxide formula:



where $\text{SiO}_{1.0}\text{R}_{2.0}$ is the hydrolyzed organic silane moiety incorporated into the framework, Si is a silicon atom, O is oxygen and x is between 0.01 and 0.25.

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The composition of Claims 11 and 12 wherein R contains a $\text{C}_i\text{H}_{2i+1}$ alkyl group and wherein i is 1 to 25.

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The composition of Claims 11 and 12 wherein R contains an aryl group.

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The composition of Claim 5 wherein the ratio of hydrolyzed organic silane to M is between about 0.01 and 0.25.

-16-

The composition of Claims 11 and 12 in which R contains one or more functional groups selected from the groups consisting of a metal, vinyl, cyano, amino, epoxide, mercapto, a halogen selected from F, Br and Cl, a hydroxide, an aldehyde, a ketone, an acid and a base, and combinations thereof.

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The composition of Claim 12 wherein the R groups are of metal-complexing ligands.

-18-

The composition of Claim 1 wherein the reaction is at an acidic pH.

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The composition of Claim 1 wherein the ratio is at a basic pH.

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The composition of Claim 1 wherein the reaction is at a neutral pH.

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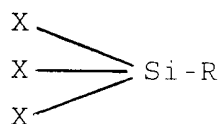
The composition of Claim 1 wherein mesitylene or other non-polar molecules are used as co-surfactants.

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The composition of Claims 11 and 12 wherein R contains a metal which is removable from the composition.

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The composition of Claim 1 wherein the organic silane has a formula:

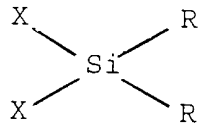


where X is a hydrolyzable chloride, bromide or an alkoxy group containing 1 to 4 carbon atoms and R is an organic group which is in the framework.

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The composition of Claim 1 wherein the organic silane has the formula:



where X is a hydrolyzable chloride, bromide or alkoxy group containing 1 to 4 carbon atoms and R is an organic group in the framework.

-25-

The composition of Claim 1 wherein the inorganic oxide precursor is selected from the group consisting of an alkoxide, halide, an acetylacetonate and a diketonate.

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The composition of Claim 24 wherein R is an alkyl containing 1 to 25 carbon atoms.

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The composition of Claim 25 wherein R is alkyl containing 1 to 25 carbon atoms.

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A method for the preparation of a synthetic, semi-crystalline hybrid organic-inorganic silicon oxide composition which comprises:

- (a) providing a mixture of (i) a silicon oxide precursor; (ii) a neutral polymeric surfactant which comprises poly(oxyalkylene) polymer as a template having a hydrophobic and a hydrophilic moiety; and (iii) a hydrolyzable organic silane;
- (b) mixing the solution to form a precipitated composition in the presence of a solvent comprising water; and
- (c) removing the surfactant from the precipitated composition by solvent extraction to form the organic-inorganic silicon oxide composition.

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A method for the preparation of a synthetic semi-crystalline hybrid organic-inorganic silicon oxide composition which comprises:

(a) providing a mixture of (i) a silicon oxide precursor; (ii) a non-ionic polymeric surfactant which comprises a poly(oxyalkylene) polymer as a template having a hydrophobic and a hydrophilic moiety; (iii) a hydrolyzable organic silane derivative; and (iv) a hydrolyzing agent;

(b) mixing the solution to form a precipitated composition in the presence of a solvent comprising water; and

(c) removing the surfactant from the precipitated composition by solvent extraction to form the organic-inorganic silicon oxide composition.

-30-

The method of any one of Claims 28 or 29 wherein the composition is prepared by a random order of addition of the surfactant, silicon oxide precursor, and the hydrolyzable organosilane.

-31-

The method of any one of Claims 28 or 29 wherein the silicon oxide precursor is selected from the group consisting of a silicon alkoxide, a silicic acid, a silicon complex, a colloidal silicon oxide solution, a silicon oxide sol, silicon halide, silicon acetylacetonate, silicon 1,3-diketonate, a silicate anion, and mixtures thereof.

-38-

-32-

The method of any one of Claims 28 or 29 wherein the solvent is a non-protic organic solvent.

-33-

The method of any one of Claims 28 or 29 wherein the surfactant is selected from the group consisting of primary, secondary and tertiary fatty alcohol poly(ethoxylates), alkyl phenol poly(ethoxylates), fatty acid ethoxylates, poly(ethylene oxide-propylene oxide) block copolymers, primary and secondary fatty primary amine poly(ethoxylates), fatty acid poly(ethylene oxide-propylene oxide) block co-polymers, fatty acid alkanolamides and ethoxylates, sorbitan esters, sorbitan ethoxylates, polyamine propoxylate ethoxylates and mixtures thereof.

-34-

The composition of Claim 11 wherein R is selected from the group consisting of a base, acid, dye chromophore, complexant for metal, metal complex and a cyclodextrin.

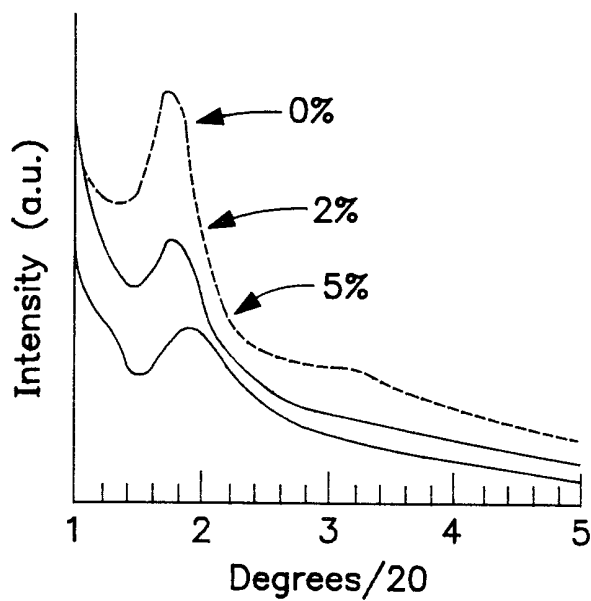


FIG. IA

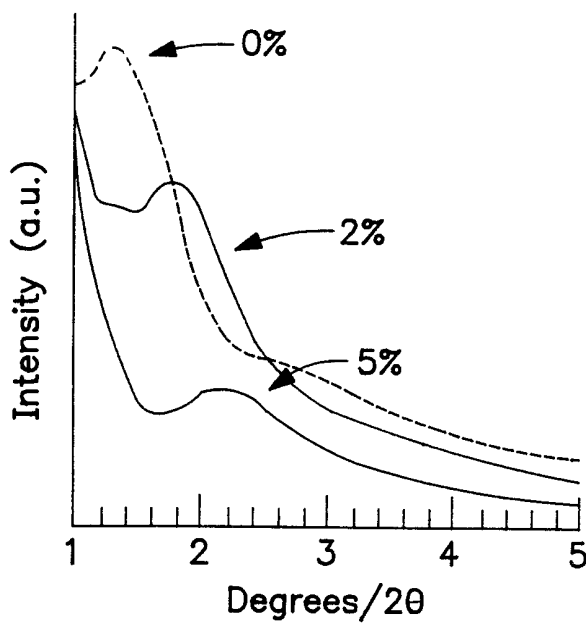


FIG. IB

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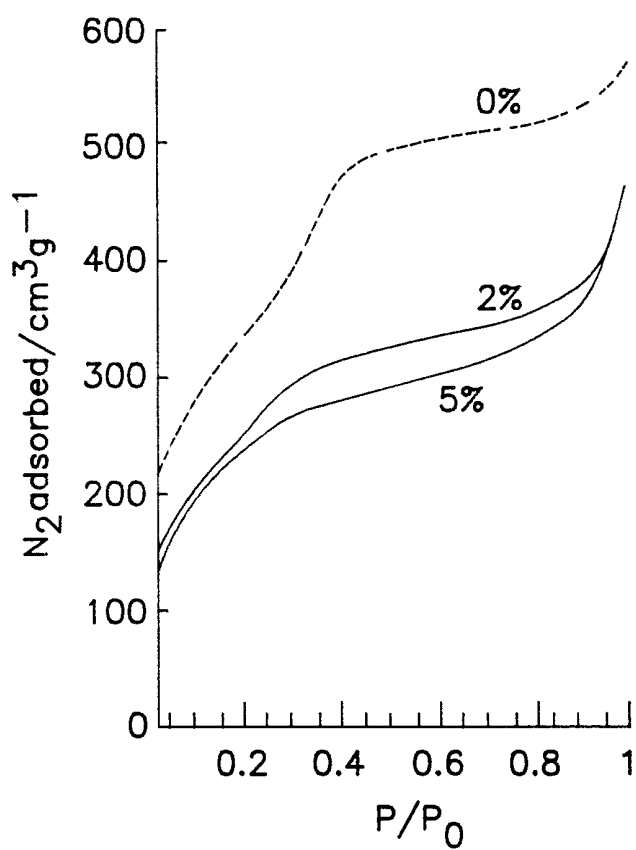


FIG. 2A

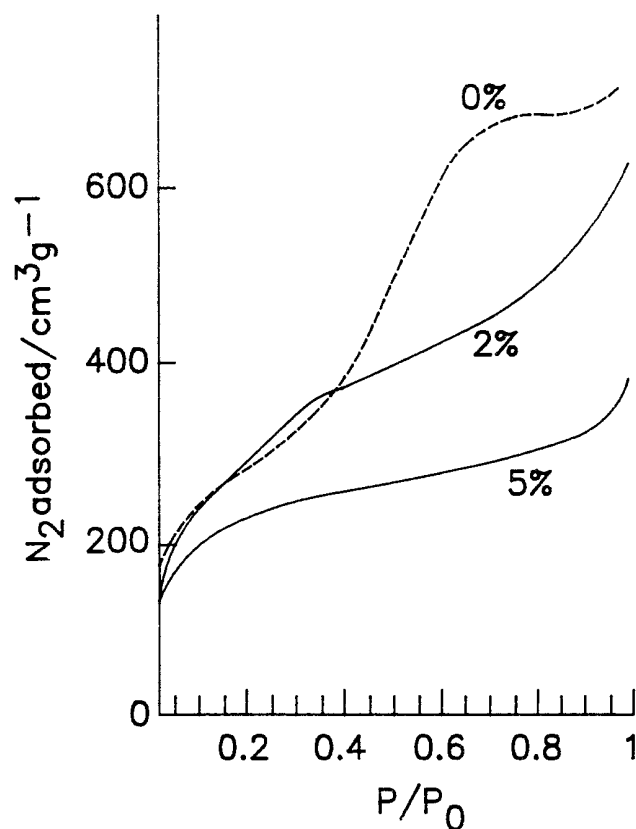


FIG. 2B

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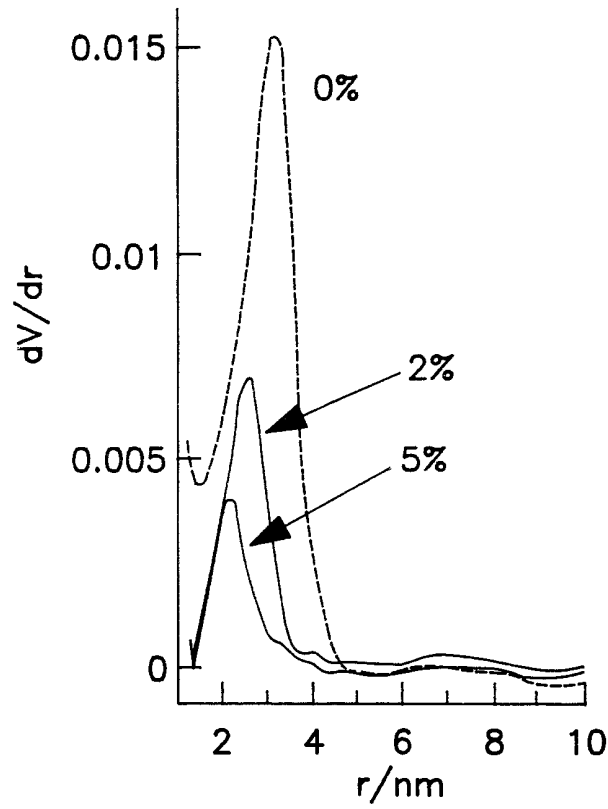


FIG. 2C

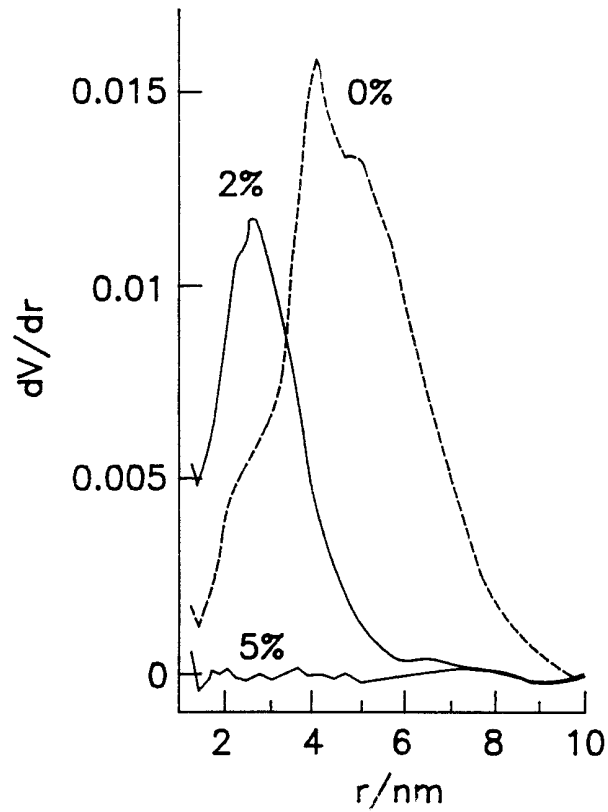


FIG. 2D

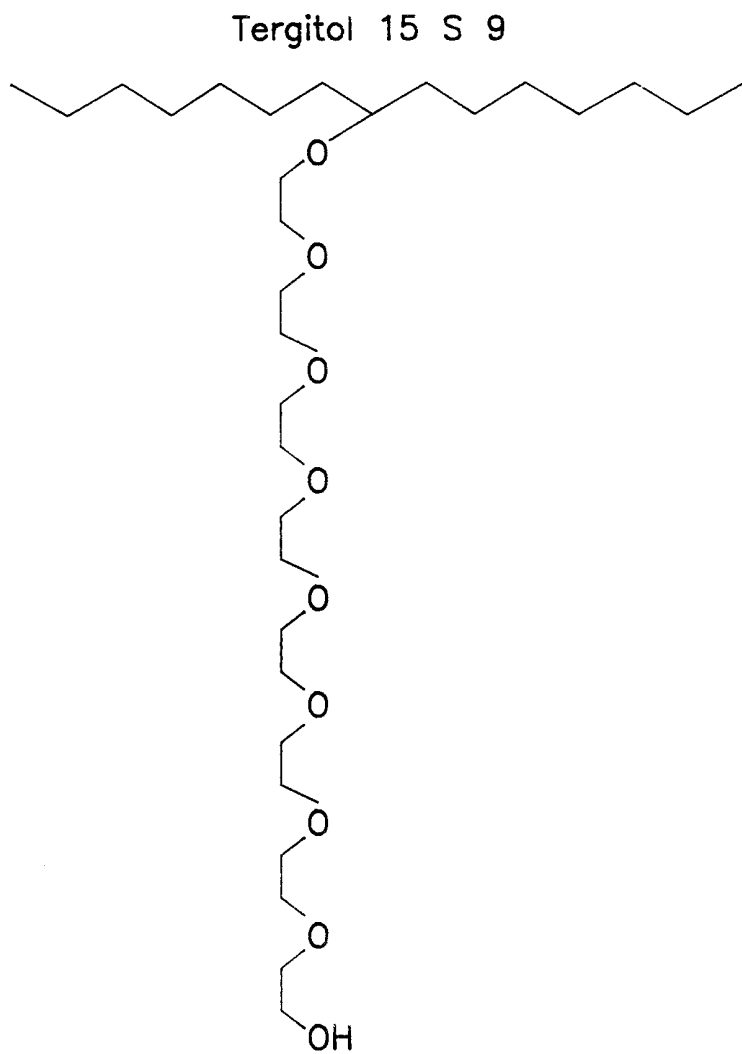


FIG. 3

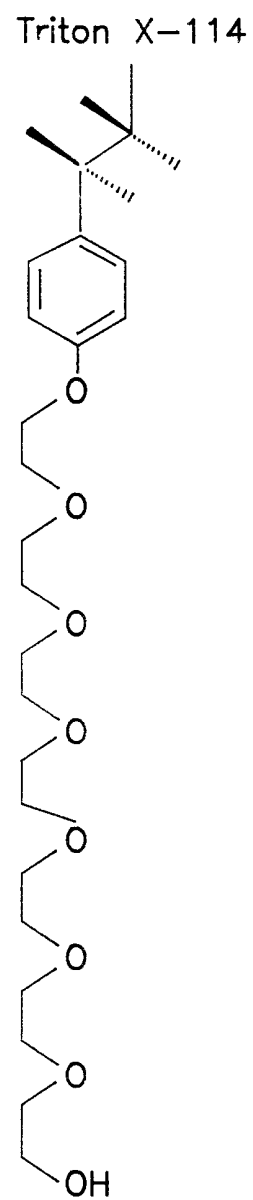
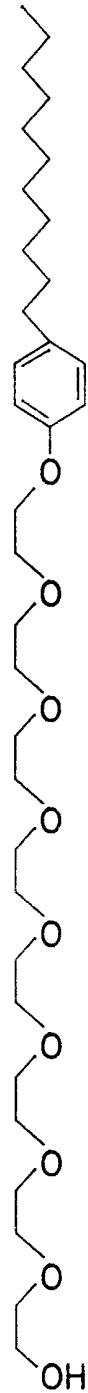


FIG. 4A

Igepal RC-760



PEO₁₈

FIG. 4B

Fatty Acid Ethoxylate

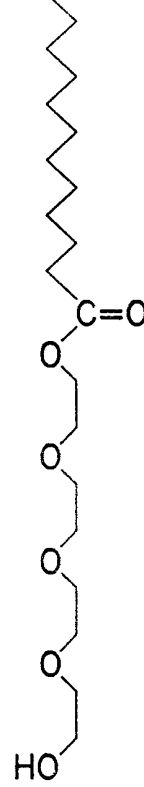
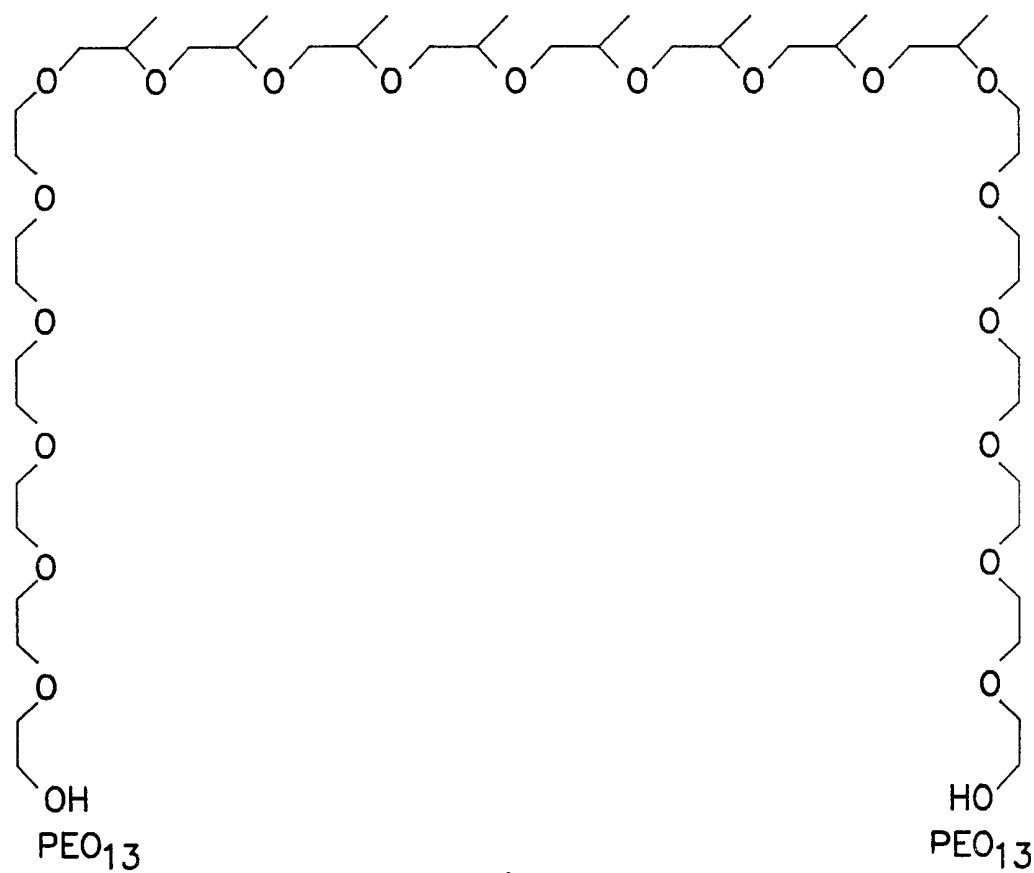


FIG. 5

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PPO₃₀



Pluronic 64 L

FIG. 6

Tetronic

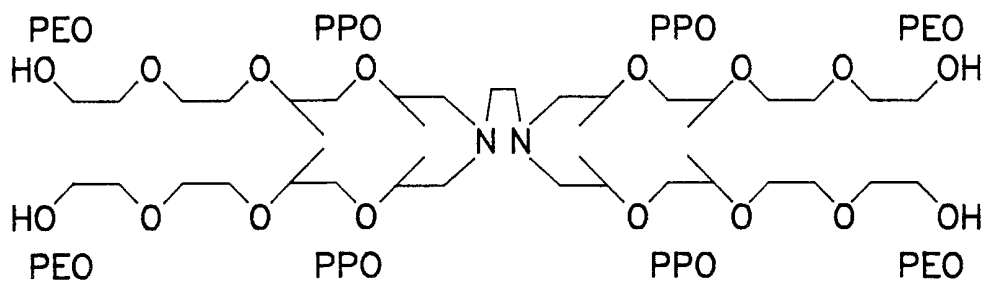


FIG. 7

Fatty Acid PPO/PEO block co-polymer

Fatty Amine Ethoxylate

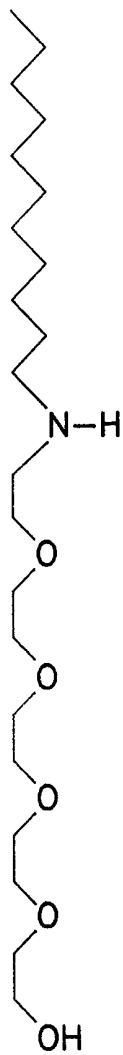


FIG. 8

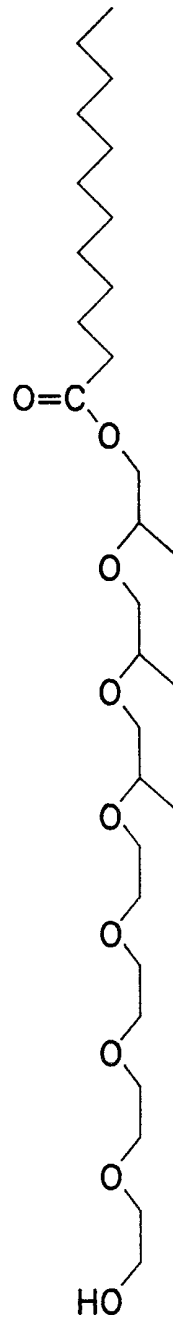


FIG. 9

Sorbitan Ester Ethoxylate
 $x+y+w+z=n$ (average number of EO units)

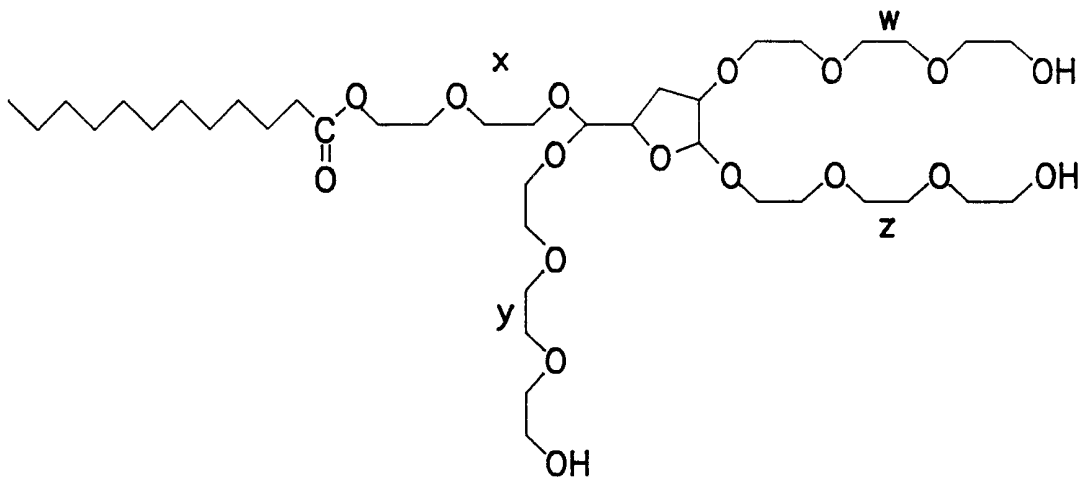


FIG. 10

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US00/40372

A. CLASSIFICATION OF SUBJECT MATTER

IPC(7) : C02F 5/02; C09K 3/32; B01J 20/00, 21/00, 23/16
US CL : 252/179; 516/100

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

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 252/179; 516/100

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

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

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	RICHER, R. and MERCIER, L., "Direct synthesis of functionalized mesoporous silica by non-ionic alkylpolyethyleneoxide surfactant assembly", Chemical Communications, 21, August 1998, Volume 16, pages 1775-1776.	1-12, 14-31 and 33-34
X --- Y	US 5,622,684 A (PINNAVAIA et al.) 22 April 1997 abstract, examples, claims; and column 12, lines 25-32.	1-12, 15, 20 and 23-25 ----- 13-14, 16-19, 21-22, 26-31 and 33-34

Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents:	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be of particular relevance	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E" earlier document published on or after the international filing date	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

10 OCTOBER 2000

Date of mailing of the international search report

03 NOV 2000

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INTERNATIONAL SEARCH REPORT

International application No.
PCT/US00/40372

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	MERCIER, L., et al., "Access in Mesoporous Materials: Advantages of a Uniform Pore Structure in the Design of a Heavy Metal Ion Absorbent for Environmental Remediation", <i>Advanced Materials</i> , 1997, volume 9, number 6, pages 500-503.	1-20, 22-31 and 33-34
A	BROWN, J., et al., "Selective adsorption of Hg ²⁺ by thiol-functionalized nanoporous silica", <i>Chemical Communications</i> , 07 January 1999, pages 69-70.	1-34