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(54) Title: FLUORIDE ION BATTERY COMPOSITIONS

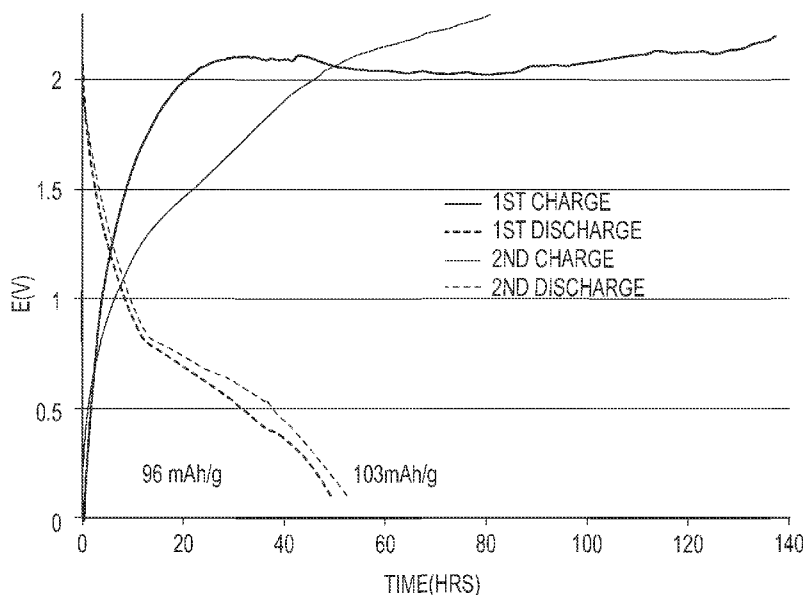


FIG.4

(57) Abstract: A lithium-free, anion based charge transport electrochemical system that uses fluoride ion transporting electrolytes, including ionic liquids, with and without various additives to improve performance, is described. The fluoride ion transporting electrolyte can be wholly or partly an ionic liquid that is typically liquid at temperatures less than 200 degrees Celsius. In other embodiments, electrolytes that remain liquid at less than 100 degrees Celsius are useful.



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**Title: FLUORIDE ION BATTERY COMPOSITIONS****Cross-Reference To Related Applications**

[0001] This application claims priority to and benefit of U.S. Provisional Application No. 61/426,456, filed December 22, 2010, and entitled "FLUORIDE ION BATTER  
5 ELECTROLYTE COMPOSITIONS", and is incorporated herein by reference.

**Field of the Invention**

[0002] Non-aqueous electrochemical cells based on fluoride ion transfer, ionic liquid and other electrolyte compositions containing fluoride ion salts, and their use in electrochemical cells, including batteries, capacitors, supercapacitors, and galvanic cells are described.

**10 Background**

[0003] A battery generally includes a positive electrode (cathode during discharge), a negative electrode (anode during discharge) and an electrolyte for ion transport. The electrolyte can contain one or more ionic species that that act as charge carriers. Many widely available battery systems are based on cation electrode reactions, with electrodes capturing or  
15 releasing a cation from an electrolyte and balancing the charge with an electron from the external circuit. Because of its very low electrochemical oxidation/reduction potential and lightweight, the element lithium is commonly used in cation based battery systems. Both lithium and lithium-ion batteries are commercially available and widely used.

[0004] However, the electrochemistry of lithium metal or lithium containing electrodes  
20 presents problems for commercial use. Lithium metal is highly reactive, and substantial extra processing may be needed to store lithium in safer intercalate, forms, increasing battery weight and reducing energy density. Li-ion batteries are not stable in many situations, and can be easily overheated or overcharged. In extreme cases, this can result in thermal runaway and battery cell rupture, or short circuiting between the electrodes. For safety and to allow for  
25 high cycle lifetime, lithium-ion battery packs often contain expensive voltage and thermal control circuitry to shut down the battery when voltage or temperature is outside a safe range.

[0005] Use of electrochemical cells supporting anion mediated electrode reactions offer one solution to the problems associated with lithium and lithium-ion batteries. In an anion based system, the electrode captures or releases an anion from electrolyte, with concomitant  
30 release or capture of an electron from the external circuit. Such anion systems have been used

in solid state battery systems, for example, by US 7,722,993 to Potanin, which describes an embodiment of a secondary electrochemical cell where fluoride ions are reversibly exchanged between anode and cathode during charge-discharge cycles, with these electrodes in contact with a solid-state fluoride-conducting electrolyte. Potanin describes solid state electrolytes containing fluorides of La, Ce or the compound fluorides based on them together with an alloying additives, such as fluoride/fluorides of alkaline-earth metals ( $\text{CaF}_2$ ,  $\text{SrF}_2$ ,  $\text{BaF}_2$ ) and/or fluorides of alkaline metals ( $\text{LiF}$ ,  $\text{KF}$ ,  $\text{NaF}$ ) and/or alkaline metal chlorides ( $\text{LiCl}$ ,  $\text{KCl}$ ,  $\text{NaCl}$ ), as well as a wide range of other compound fluorides.

[0006] Attempts have also been made to provide anion charge carrier based electrochemical systems capable of using liquid electrolytes. For example, US20100221603A1 "Lithium Ion Fluoride Battery" by Yazami, Darolles, and Weiss disclose a battery including a positive electrode comprising a carbon nanofiber or carbon nanotube material; a negative electrode comprising a graphite material; and an electrolyte provided between the positive electrode and the negative electrode. The electrolyte is selected to conduct charge carriers between the positive electrode and the negative electrode, and includes a solvent-borne fluoride salt is at least partially present in a dissolved state in the electrolyte. In operation, the positive electrode and negative electrode reversibly exchange fluoride ions with the electrolyte during charging and discharging of the battery. In one embodiment, during discharge of the battery fluoride ions are released from the positive electrode and accommodated by the negative electrode, and/or during charging of the battery fluoride ions are released from the negative electrode and accommodated by the positive electrode. However, for many applications the discussed electrolyte compositions do not provide sufficient ion charge transport capability to ensure reliable high discharge and/or high capacity operation.

## **Brief Description of the Drawings**

In the accompanying drawings:

[0007] Figure 1 shows the conductivity of a 0.1M TMAF solution in MPPTFSI as a function of temperature;

[0008] Figure 2 shows the electrochemical stability window for solutions of TMAF in various solvents;

[0009] Figure 3 shows the electrochemical stability windows for 0.1M TMAF-MPPTFSI and MPPTFSI compared to a typical liquid phase Li-ion electrolyte;

[0010] Figure 4 shows the first and second charge and discharge curves for a PbF<sub>2</sub>/TMAF-MPPTFSI/PANI cell assembled in the discharged state;

5 [0011] Figure 5 shows the first and second charge and discharge curves for a PbF<sub>2</sub>/NPTMAF-MPPTFSI/PANI cell assembled in the discharged state;

[0012] Figure 6 shows charge-discharge curves for PbF<sub>2</sub>/electrolyte/PANI cells (3rd cycle) containing TMAF-MPPTFSI electrolyte compared to 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC electrolyte;

10 [0013] Figure 7 shows characterizing data for the positive electrode in a symmetric carbon nanotube cell with 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC after charging to 5.3 Volts;

[0014] Figure 8 shows <sup>31</sup>P and <sup>19</sup>F solid-state NMR data for the carbon nanotube positive electrode after charging to 5.3 V and after discharging to 3.0 V;

[0015] Figure 9 shows internal resistance data measured for a PbF<sub>2</sub>/TMAF-MPPTFSI/PANI cell in the charged state from 20-100 °C, alongside comparative data for a solid-state FIB cell as reported in <http://www.sandia.gov/mission/stc/battery.pdf>;

[0016] Figure 10 shows OCV values for a PbF<sub>2</sub>/TMAF-MPPTFSI/PANI cell in the charged state measured from 20-100 °C;

[0017] Figure 11 shows a discharge profile of a Pb/0.1 M TMAF-MPPTFSI/PANI-F cell compared to a Pb/0.1M TMAF-MPPTFSI/PANI cell (containing no F<sup>-</sup> in the cathode);

[0018] Figure 12 shows cycling of a BiF<sub>3</sub>/0.1M TMAF-MPPTFSI/PANI cell;

[0019] Figure 13 shows a discharge profile of a La/0.2M TMAF-MPPTFSI/PbF<sub>2</sub> cell, with recharge capability indicated, compared to discharge of a La/0.2M TMAF-MPPTFSI with an additive of 0.2M boroxin/PbF<sub>2</sub> cell.; and

25 [0020] Figure 14 shows the charge-discharge profile of a PbF<sub>2</sub>/PANI system using the acidic ionic liquid fluoride electrolyte EMIF(HF)<sub>n</sub>.

### **Detailed Description**

[0021] A lithium-free, anion based charge transport electrochemical system that uses fluoride ion transporting electrolytes, including ionic liquids, with and without various additives to improve performance, is described. The fluoride ion transporting electrolyte can

be wholly or partly an ionic liquid that is typically liquid at temperatures less than 200 degrees Celsius. In other embodiments, electrolytes that remain liquid at less than 100 degrees Celsius are useful. In certain application, low temperature electrolytes that are liquid at temperatures greater than -40 degrees Celsius are preferred.

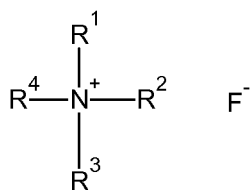
5 [0022] Such a room or low temperature fluoride ion battery (FIB) system utilizes fluoride anions carried in a liquid electrolyte as at least some of the charge carriers in an electrochemical cell. Typically, fluoride ions are majority charge carriers, but other charge carriers may also be present in certain embodiments. The FIB system has an anode and cathode physically separated from each other, but in common contact with a fluoride anion-  
10 conducting electrolyte. The anode is typically a low potential element or compound, and can be a metal, metal fluoride, or intercalating composition such as graphite or other carbon based material. Similarly, the cathode can be element or composition, and can be a metal, metal fluoride, or intercalating composition that has a higher potential than the anode. Fluoride anions (F<sup>-</sup>) in the fluoride-conducting electrolyte go from the cathode to the anode during  
15 discharge and from the anode to the cathode during the charge of the battery. As will be appreciated, operation of such a fluoride ion battery system requires a ready source of organic soluble free F<sup>-</sup> in an electrolyte solution for operation. However, common anhydrous metal fluorides such as alkali or alkaline earth fluorides (e.g. LiF, CsF, MgF<sub>2</sub>, BaF<sub>2</sub>), transition metal fluorides (e.g. VF<sub>4</sub>, FeF<sub>3</sub>, MoF<sub>6</sub>, PdF<sub>2</sub>, AgF), main-group metal fluorides (e.g. AlF<sub>3</sub>,  
20 PbF<sub>4</sub>, BiF<sub>3</sub>) and lanthanide or actinide fluorides (e.g. LaF<sub>3</sub>, YbF<sub>3</sub>, UF<sub>5</sub>) are essentially insoluble in organic solvents, so cannot be used as electrolyte components. In addition, many solid-state electrolyte compositions have poor ionic conductivity at temperatures below about 200 degrees Celsius, resulting in significant reduction in cell performance at these lower temperatures due to high cell internal resistance. Such solid-state FIB systems do not  
25 generally provide good performance at temperatures below 200 degrees Celsius.

[0023] In contrast, liquid electrolytes typically have higher conductivities at room temperatures compared to solid-state electrolytes. This permits FIB systems with liquid electrolytes, particularly ionic liquids, to operate with lower internal resistances than solid-state systems, improving performance. In addition, liquid electrolyte-based FIB systems will  
30 have applicability to areas of operation not possible for solid-state devices, such as reserve battery systems (that are activated by addition of liquid electrolyte to the system) and flexible devices (whereby a solid-state system would crack upon flexing and lose its function).

[0024] Primary and secondary electrochemical cells, such as batteries, utilizing fluoride ion charge carriers, active electrode materials, and suitable liquid electrolytes can provide an alternative to conventional state of the art lithium batteries and lithium ion batteries.

[0025] Liquid electrolyte salts suitable for FIB systems are those that contain complex cations in combination with the fluoride anion. The cation may feature organic groups, such as alkylammonium, alkylphosphonium or alkylsulfonium species, or may consist of metal-organic or metal-coordination complex motifs, such as metallocenium species. Simple inorganic fluorides such as KF and CsF do not have sufficient solubility in non-aqueous solvents to be useful and/or may be reduced to the metal on the electrode surface at low potentials.

[0026] In one embodiment the organic-soluble fluoride salt contains alkylammonium or substituted alkylammonium cations  $R^1R^2R^3R^4N^+ F^-$  where  $R^1$ ,  $R^2$ ,  $R^3$  and  $R^4$  may each be separately a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group.



[0027] In another embodiment, the organic-soluble fluoride salt is tetramethylammonium fluoride (TMAF) as described in Christe et al., J. Am. Chem. Soc., 1990, 112, 7619, incorporated here by reference.

[0028] In another embodiment, the organic-soluble fluoride salt is 2,2-dimethylpropyltrimethylammonium fluoride (NPTMAF) as described in Mahjoub et al., Chem. Eur. J., 1995, 1, 261, incorporated here by reference.

[0029] In another embodiment, the organic-soluble fluoride salt is 1-adamantyltrimethylammonium fluoride as described in Harmon et al., J. Org. Chem., 1993, 58, 7294, incorporated here by reference.

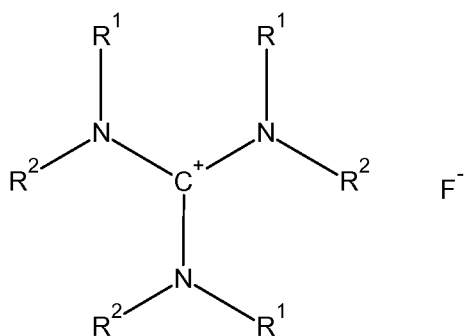
[0030] In another embodiment, the organic-soluble fluoride salt is phenyltrimethylammonium fluoride.

[0031] In another embodiment, the organic-soluble fluoride salt contains alkylammonium or substituted alkylammonium cations whereby one or more R-group is joined to two or more

alkylammonium cations to give a dimer, oligomer or polymer  $(R_1R_2R_3R_4N^+)_x (F^-)_x$  where  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  may each be separately a substituted or unsubstituted, linear or branched,  $C_1$  to  $C_{50}$  aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group, and  $x = 2$  to  $50$ .

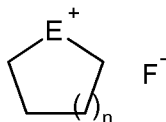
- 5 [0032] In another embodiment, the organic-soluble fluoride salt is 1,2-bis(dimethylamino)-1,2-bis(dimethylammonium)ethene difluoride as described in Chambers et al., J. Fluorine Chem., 1999, 94, 213, incorporated here by reference.

- [0033] In another embodiment, the organic-soluble fluoride salt contains alkylguanidinium and substituted alkylguanidinium cations  $(R_1R_2N)_3C^+ F^-$  where  $R_1$ ,  $R_2$ ,  
 10  $R_3$  and  $R_4$  may each be separately a substituted or unsubstituted, linear or branched,  $C_1$  to  $C_{50}$  aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group.



- [0034] In another embodiment, the organic-soluble fluoride salt is  
 15 hexamethylguanidinium fluoride as described in Kolomeitsev et al., J. Fluorine Chem., 2000, 103, 159, incorporated here by reference.

- [0035] In another embodiment, the organic-soluble fluoride salt is of the form  $X^+ F^-$  where  $X$  is a heterocyclic cation, whereby the heterocyclic ring has between 4 and 7 atoms, may be benzoannelated, may be polycyclic and/or may be substituted at one or more  
 20 positions with a substituted or unsubstituted, linear or branched,  $C_1$  to  $C_{50}$  aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl groups. Examples of such cations include imidazolium, thiazolium, oxazolium, isoxazolium, pyrazolium, pyridinium, piperidinium, pyrrolidinium, pyrilium, pyridazinium, pyrimidinium, pyrazinium, and triazolium, species.



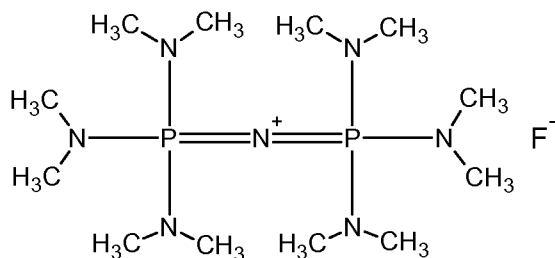
[0036] In another embodiment, the organic-soluble fluoride salt is 1-propyl,1-methylpiperidinium fluoride.

[0037] In another embodiment, the organic-soluble fluoride salt is 1,3,3,6,6,-

5 hexamethylpiperidinium fluoride as described in Mahjoub et al., Chem. Eur. J., 1995, 1, 261, incorporated here by reference.

[0038] In another embodiment, the organic-soluble fluoride salt is 1-methylhexamethylenetetramine fluoride (HMTF) as described in Gnann et al., J. Am. Chem. Soc., 1997, 119, 112, incorporated here by reference.

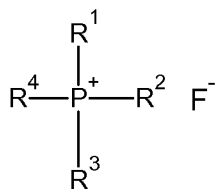
10 [0039] In another embodiment, the organic-soluble fluoride salt is a phosphazene or phosphazanium-containing material such as 1,1,1,3,3,3-hexakis(dimethylamino)diphosphazanium fluoride and tetrakis[tris(dimethylamino)-phosphoranylidenamino]phosphonium fluoride as described in Schwesinger et al., Chem. Eur. J., 2006, 12, 438, incorporated here by reference.



15

[0040] In another embodiment, the organic-soluble fluoride salt contains alkylphosphonium or substituted alkylphosphonium cations  $R^1R^2R^3R^4P^+ F^-$  where  $R^1$ ,  $R^2$ ,  $R^3$  and  $R^4$  may each be separately a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl

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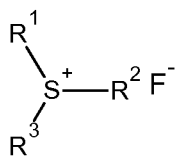


[0041] In another embodiment, the organic-soluble fluoride salt is tetramethylphosphonium fluoride, as described in Komath et al., Inorg. Chem., 2003, 42, 2894, incorporated here by reference.

[0042] In another embodiment, the organic-soluble fluoride salt is tetraphenylphosphonium fluoride, as described in Brown et al., J. Chem. Soc., Chem. Commun, 1983, 1256, incorporated here by reference.

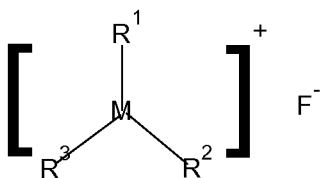
[0043] In another embodiment, the organic-soluble fluoride salt is phenyltrimethylphosphonium fluoride.

[0044] In another embodiment, the organic-soluble fluoride salt contains alkylsulfonium or substituted alkylsulfonium cations  $R^1R^2R^3S^+ F^-$  where  $R^1$ ,  $R^2$  and  $R^3$  may each be separately a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group.



[0045] In another embodiment, the organic-soluble fluoride salt is trimethylsulfonium fluoride.

[0046] In another embodiment, the organic-soluble fluoride salt contains metal-organic, substituted metal-organic or metal-coordination complex species  $[R^1, R^2, R^3 \dots M]^{n+} F^{n-}$  where  $R^1$ ,  $R^2$ ,  $R^3$  (and so on) may each be separately a particular ligand species. Suitable ligands include carbocyclic or heterocyclic organometallic ligands such as cyclopentadienyls, benzenes, cyclobutadienes, pyridines, phenanthrolines or phosphacyclopentadienyls and their isolobal analogues, which may be unsubstituted or substituted with a linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group. Other suitable ligand species include alkyls, alkenes, alkynes, alkynyls, carbonyls, amines, phosphines, halides, hydrides, nitriles, isonitriles and related ligands as described in "Dictionary of Organometallic Compounds," J. E. Macintyre and J. D. MacDonald eds., 2nd Edition, Chapman & Hall, London, 1995 and "Dictionary of Inorganic Compounds," J. E. Macintyre ed., Chapman & Hall, London, 1992. The metal species may be a main-group metal, transition metal or lanthanide metal accordingly, and the number of ligands ( $R^1 \dots$ ) may be from 1 to 8.



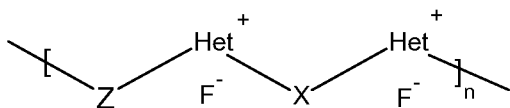
[0047] In another embodiment, the organic-soluble fluoride salt is cobaltocenium fluoride, as described in Bennett et al., J. Am. Chem. Soc., 1994, 116, 11165, incorporated here by reference.

- 5 [0048] In another embodiment, the fluoride-containing electrolyte is a molten salt (also known as a room-temperature ionic liquid (IL))  $X^+ F^-(HF)_n$ , where  $X^+$  is a cation corresponding to any of the classes described above and  $n$  is between 0 and 5.

[0049] In another embodiment, the electrolyte is acidic 1-ethyl-3-methylimidazolium fluoride (EMIF.(HF)<sub>2.3</sub>) as described in Hagiwara et al., J. Fluorine Chem, 1999, 99, 1 or  
10 related compound (whereby the amount of incorporated HF differs).

[0050] In another embodiment, the electrolyte is acidic 1-methyl-1-propylpiperidinium fluoride (MPPF.(HF)<sub>n</sub>) where  $n$  is around 2.3, or related compound (whereby the amount of incorporated HF differs).

[0051] In another embodiment, the organic-soluble fluoride salt contains a cation that is a  
15 polymer species such as  $-[Z-Het^+-X-Het^+-]_n$ , whereby Het is a heterocyclic cation whereby the heterocyclic ring has between 4 and 7 atoms, may be benzoannulated, may be polycyclic and/or may be substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl groups, and Z and X are spacer group such as CH<sub>2</sub>, CMe<sub>2</sub>, SiMe<sub>2</sub>, SO<sub>2</sub>,  
20 P=O, C2 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl groups, and may be the same or different from each other, and  $n$  is about 1 to 8.



[0052] In another embodiment, the organic-soluble fluoride salt is poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride, as described in Rios et al., J. Poly. Sci. B. Poly. Phys.,  
25 1990, 28, 505, incorporated here by reference.

## Solvents

[0053] Useful solvents include those that are non-aqueous (denoted here as “organic”) and are capable of dissolving the aforementioned fluoride salts to molar concentrations of 0.01 M and above, preferred concentrations being between 0.1 and 3 M. Examples of such solvents include acetone, acetonitrile, benzonitrile, 4-fluorobenzonitrile, pentafluorobenzonitrile, triethylamine (TEA), diisopropylethylamine, 1,2-dimethoxyethane, ethylene carbonate, propylene carbonate (PC),  $\gamma$ -butyrolactone, dimethyl carbonate, diethyl carbonate (DEC), methyl ethyl carbonate, propyl methyl carbonate, tetrahydrofuran, 2-methyltetrahydrofuran, nitromethane, benzene, toluene, chloroform, dichloromethane, 1,2-dichloroethane, dimethylsulfoxide, sulfolane, N,N-dimethylformamide (DMF), N,N-dimethylacetamide (DMA), carbon disulfide, ethyl acetate, methyl butyrate, n-propyl acetate, methyl propionate, methyl formate, 4-methyl-1,3-dioxolane, pyridine, methyl isobutyl ketone, methyl ethyl ketone, hexamethylphosphoramide, hexamethylphosphorus triamide, 1-methyl-2-pyrrolidinone, 2-methoxyethyl acetate, trimethyl borate, triethylborate and substituted derivatives thereof, as well as sulfones such as ethylmethylsulfone, trimethylene sulfone, 1-methyltrimethylene sulfone, ethyl-sec-butyl sulfone, ethyl isopropyl sulfone (EIPS), 3,3,3-trifluoropropylmethyl sulfone and 2,2,2-trifluoroethyl sulfone.

[0054] In certain embodiments, room temperature ionic liquid materials, or ionic liquids that remain liquid at temperatures below 200 degrees Celsius (such as those described in "Electrochemical Aspects of Ionic Liquids", E. Ohno ed., Wiley Interscience, New York, 2005), are preferred. These can include ionic liquids that remain liquid at temperatures below 100 degrees Celsius such as 1-methyl,1-propylpiperidinium bis(trifluoromethanesulfonyl)imide (MPPTFSI), butyltrimethylammonium bis(trifluoromethanesulfonyl)imide (BTMATFSI) 1-butyl,1-methylpyrrolidinium bis(trifluoromethanesulfonyl)imide (BMPTFSI) and their fluoroalkylphosphate (FAP) anion derivatives (e.g. MPPFAP, BMPFAP) where FAP is a hydrophobic anion such as tris(pentafluoroethyl)trifluorophosphate, all of which alone or in combination are useful solvents.

[0055] Preferred solvents include MPPTFSI, BMPFAP, benzonitrile, N,N-dimethylformamide (DMF), DMA and TEA.

[0056] In certain cases, electrolyte formulations may have a voltage stability window of 1V or less, or around 2V, or greater than 4V, depending on the salt and solvent combination.

## Electrolyte Additives

[0057] In certain embodiments, solubility of fluoride salts in liquid electrolytes may be enhanced through addition of electrolyte additives that can improve stability, viscosity, performance, or safety. One particular class of additives is fluoride ion complexing Lewis acid species (also known as "anion receptors"). While not wishing to be bound by any particular theory, anion receptor species are believed to reversibly bind to the fluoride ion in solution, increasing the amount of fluoride salt that is dissolved in that solution. In addition, as the complexation is reversible, these anion receptors may bind or release fluoride ion to or from a fluoride-accommodating electrode at a particular voltage. This reversible complexation, so that substantial "free" F<sup>-</sup> is not present in significant concentration in solution, may provide enhanced cycling stability to the electrochemical system. Suitable anion receptors include species capable of binding fluoride anion such as boron, aluminum, ammonium, H-bond donor or similar groups, including aza ethers and alkyl and aryl boron and boronate complexes such as those described in McBreen et al, J. Power Sources, 2000, 89, 163 and West et al., J. Electrochem. Soc., 154, A929 (2007), and boroxin species such as those described in Nair et al., J. Phys. Chem. A, 113, 5918 (2009), all of which are incorporated by reference herein. In particular tris(hexafluoroisopropyl)borate, tris(pentafluorophenyl)borane and all possible regioisomers of difluorophenyl boroxin (DFB), trifluorophenyl boroxin, bis(trifluoromethyl)phenyl boroxin, trifluoromethyl)phenyl boroxin and fluoro(trifluoromethyl)phenyl boroxin can be used.

[0058] In certain other cases, conductivity of a fluoride ion electrolyte solution may be enhanced through addition of additional solvents, by reduction of overall solution viscosity (amongst other factors). In particular, use of ionic liquid solvents such as MPPTFSI gives a somewhat viscous electrolyte mixture, for which the conductivity can be enhanced by addition of other compatible low viscosity solvents. These can include polar aprotic solvents such as diethyl carbonate (DEC) (~20%), ethyl isopropyl sulfone (EIPS) (~100%) or N,N-dimethylformamide (DMF) (~100%), or fluoralkyl species such as perfluoroethers and perfluoropolyethers.

## Electrodes

[0059] A wide range of electrode materials can be used in conjunction with the described liquid electrolytes. To improve safety, lithium-free electrodes, or substantially lithium-free, or electrodes with low weight percentage lithium (for example, less than 10 percent lithium) are

preferred. Electrodes can be anodes or cathodes. Here, the term "anode" shall be meant to refer to the electrode with more negative relative reduction potential when the cell is in the charged state, and "cathode" shall be meant to refer to the electrode with more positive relative reduction potential. Therefore, during discharge the general form of fluoride-ion

5 mediated processes occurring at the electrodes are:

[0060] Anode:  $\text{MF}_x + n\text{F}^- \rightarrow \text{MF}_{x+n} + n\text{e}^-$  (Fluoride ion accommodation, oxidation)

[0061] Cathode:  $\text{MF}_y + n\text{e}^- \rightarrow \text{MF}_{y-n} + n\text{F}^-$  (Fluoride ion release, reduction)

[0062] During charge, the reverse reactions occur.

**Anode materials:**

10 [0063] i) Any metal M of the periodic table in the charged state or corresponding metal fluoride  $\text{MF}_n$  in the discharged state having a standard potential  $E_0$  more negative than the standard potential of the cathode material (n being larger than zero).

[0064] ii) Any alloy of any metals  $\text{MM}_1\text{M}_2\ldots\text{M}_n$  in the charged state or corresponding alloy metal fluoride  $\text{MM}_1\text{M}_2\ldots\text{M}_n\text{F}_m$  in the discharged state having a  $E_0$  more negative than  
15 the  $E_0$  of the cathode material.

[0065] iii) Any metal fluoride  $\text{MF}_n$  in the charged state that can undergo a further fluorination to  $\text{MF}_{n+x}$ , or  $\text{MF}_{n+x}$  in the discharged state that has an intermediate oxidation state (metal oxidation state higher than zero) having a standard potential more negative than the cathode material.

20 [0066] iv) Any metal oxide  $\text{MO}_x$  in the charged state or corresponding metal oxide fluoride  $\text{MO}_x\text{F}_n$  in the discharged state having a standard potential  $E_0$  lower than the standard potential of the cathode material.

[0067] v) Any alloy  $\text{MM}_1\text{M}_2\ldots\text{M}_n\text{O}_x\text{F}_m$  with n larger or equal to 2 and m being larger or equal to zero.

25 [0068] vi) Any polymer that can accommodate fluoride anions in its structure having a standard potential  $E_0$  lower than the standard potential of the cathode material including (but not limited to) polyanilines, polypyrroles, polyacetylenes, polythiophenes, polypyrroles, polyethylenedioxythiophenes, polyphenylenes, polytriphenylenes, polyazulenes, polycarbazoles, polyfluorenes, polynaphthalenes, polyanthracenes, polyacenes. Such polymer

may contain associated anions or cations (corresponding to partially-oxidized or partially-reduced forms), or may be in the neutral state.

[0069]     vii) Any anion-intercalation host material such as a Layered Double Hydroxide (LDH), metal oxide or metal chalcogenide that can accommodate fluoride anions into its structure having a standard potential  $E_0$  more negative than the standard potential of the cathode material.

[0070]     viii) A carbon fluoride material  $CF_x$  that can accommodate fluoride anions into its structure having a standard potential  $E_0$  more negative than the standard potential of the cathode material. Here,  $x$  is between 0.05 and 2, with the region 0.05 to 0.6 particularly preferred. Such carbon materials may be graphite based, coke-based, or based on nanomaterials such as carbon nanotubes, graphene or assemblies of such nanomaterials similar to that described by Lee et al., Nature Nanotech., 5, 513 (2010), incorporated here by reference.

[0071]     Any mixture of one or more of the above mentioned type of materials can also be used.

**Cathode materials:**

[0072]     i) Any metal  $M$  of the periodic table in the discharged state or corresponding metal fluoride  $MF_n$  in the charged state having a standard potential  $E_0$  more positive than the standard potential of the anode material.  $n$  being larger than zero.

[0073]     ii) Any alloy of any metals  $MM_1M_2...M_n$  in the discharged state or corresponding alloy metal fluoride  $MM_1M_2...M_nF_m$  in the charged state having a  $E_0$  more positive than the  $E_0$  of the anode material.

[0074]     iii) Any metal fluoride  $MF_n$  in the discharged state that can accommodate more fluoride to  $MF_{n+x}$  or  $MF_{n+x}$  in the charged state that has an intermediate fluorination state (metal oxidation state higher than zero) having a standard potential more positive than the anode material.

[0075]     iv) Any metal oxide  $MO_x$  in the discharged state or corresponding metal oxide fluoride  $MO_xF_n$  in the charged state having a standard potential  $E_0$  more positive than the standard potential of the anode material.

[0076] v) Any metal oxide  $\text{MO}_x\text{Fn}$  in the discharged state or further fluorinated metal oxide fluoride  $\text{MO}_x\text{Fn}+\text{x}$  in the charged state having a standard potential  $E_0$  more positive than the standard potential of the anode material.

[0077] vi) Any alloy  $\text{MM}_1\text{M}_2\ldots\text{MnO}_x\text{F}_m$  with  $n$  larger or equal to 2 and  $m$  being larger or equal to zero.

[0078] vii) Any polymer that can accommodate fluoride anions in its structure having a standard potential  $E_0$  more positive than the standard potential of the anode material including (but not limited to) polyanilines, polypyrroles, polyacetylenes, polythiophenes, polypyrroles, polyethylenedioxythiophenes, polyphenylenes, polytriphenylenes, polyazulenes, polycarbazoles, polyfluorenes, polynaphthalenes, polyanthracenes, polyacenes. Such polymer may contain associated anions or cations (corresponding to partially-oxidized or partially-reduced forms), or may be in the neutral state.

[0079] viii) Any anion-intercalation host material such as an LDH, metal oxide or metal chalcogenide that can accommodate fluoride anions into its structure having a standard potential  $E_0$  more positive than the standard potential of the anode material.

[0080] ix) A carbon fluoride material  $\text{CF}_x$  that can accommodate fluoride anions into its structure having a standard potential  $E_0$  more positive than the standard potential of the anode material. Here,  $x$  is between 0 and 2, with the region 0 to 0.6 particularly preferred. Such carbon materials may be graphite based, coke-based, or based on nanomaterials such as carbon nanotubes, graphene or assemblies of such nanomaterials similar to that described by Lee et al., Nature Nanotech., 5, 513 (2010), incorporated here by reference.

[0081] Any mixture of one or more of the above mentioned type of materials is also contemplated. However, pure materials, substantially pure materials, or mixtures of materials that include electrode materials with solid state fluoride ion conductivity  $>10^{-12}$  S/cm are preferred. Solid-state fluoride ion conductivity values may be found, for example, in N.I. Sorokin and B.P. Sobolev, Crystallography Reports, 52, 842 (2007) incorporated herein by reference.

[0082] Using the described electrodes and electrolytes, along with separators, battery casing or packaging, current collectors, electrical contacts, electronic charge and discharge controllers, and other elements of battery construction known to those skilled in the art, one can create useful electrochemical cells operable at less than 200 degrees Celsius that do not require lithium for operation. Such electrochemical cells can have substantially irreversible

electrochemical reactions during discharge, making them suitable for forming galvanic cells or primary batteries. Alternatively, if the electrochemical reaction is at least partially reversible through application of electrical charge, secondary (rechargeable) batteries can be formed.

5 [0083] As will be appreciated, fluoride ion batteries are suitable for a wide range of primary or rechargeable applications, including but not limited to vehicle traction batteries (electric vehicles (EV), hybrid vehicles (HEV), and plug-in hybrid (PHEV)) or vehicle starter or ignition batteries. FIB systems can be useful stationary batteries for emergency power, local energy storage, starter or ignition, remote relay stations, communication base stations,  
10 uninterruptible power supplies (UPS), spinning reserve, peak shaving, or load leveling, or other electric grid electric storage or optimization applications. Small format or miniature battery applications including watch batteries, implanted medical device batteries, or sensing and monitoring system batteries (including gas or electric metering) are contemplated, as are other portable applications such as flashlights, toys, power tools, portable radio and  
15 television, mobile phones, camcorders, lap-top, tablet or hand-held computers, portable instruments, cordless devices, wireless peripherals, or emergency beacons. Military or extreme environment applications, including use in satellites, munitions, robots, unmanned aerial vehicles, or for military emergency power or communications are also possible.

[0084] The following specific examples are given to illustrate the practice of the  
20 invention, but are not to be considered as limiting in any way.

### **Examples**

#### **1) Conductivity of FIB Electrolytes**

[0085] Figure 1 shows the conductivity of 0.1M TMAF in 1-methyl-1-propylpiperidinium bis(trifluoromethanesulfonyl)imide (MPPTFSI) as a function of  
25 temperature, indicating conductivity increase as the solution viscosity decreases.

#### **2) Electrochemical Stability of FIB Electrolytes**

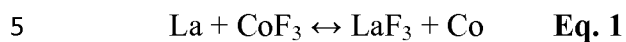
[0086] Figures 2 and 3 show linear sweep voltammetry experiments (2mV/sec) for several electrolyte formulations, indicating that a stable voltage window >4V can be obtained in certain cases for liquid phase FIB electrolytes, and that this stability window can be greater  
30 than for Li-ion electrolytes such as 0.1M LiPF<sub>6</sub> in EC/DMC.

#### **3) Examples of Theoretical Standard Potentials for Some FIB Electrode Materials:**

[0087] To better understand various aspects of the disclosure, consider the example system

La / F<sup>-</sup> electrolyte / CoF<sub>3</sub>

The extended cell reaction being:



[0088] From the following Table 1 and Eq. 1, one can calculate the voltage and the theoretical energy density of this example system as:

***Voltage = 3.5 V***

***Energy density = 1100 Wh/kg or 5400 Wh/L***

10

[0089] Similarly, using the following Table 1 and selected cell reactions, one can calculate the voltage and the energy density for other electrochemical systems.

| Cathode                | Anode | Voltage (V) | Specific energy (Wh/kg) | Energy density (Wh/L) |
|------------------------|-------|-------------|-------------------------|-----------------------|
| CoF <sub>3</sub>       | Ca    | ≈ 5         | 1005                    | 3190                  |
| PbF <sub>4</sub>       | Ca    | ≈ 4.6       | 780                     | 3700                  |
| SnF <sub>4</sub>       | Ca    | ≈ 3         | 685                     | 2415                  |
| FeF <sub>3</sub>       | Ca    | ≈ 3.6       | 725                     | 2295                  |
| BiF <sub>3</sub>       | Ca    | ≈ 3.2       | 790                     | 2905                  |
| CuF <sub>2</sub>       | Ca    | ≈ 3.2       | 1210                    | 3445                  |
| PANI-F                 | Ca    | ≈ 4         | 475                     | 580                   |
| CF <sub>x(x=0.8)</sub> | Ca    | ≈ 5         | 2465                    | 4685                  |
| CF <sub>x(x=0.8)</sub> | Mg    | ≈ 4.5       | 2615                    | 5375                  |
| CoF <sub>3</sub>       | Mg    | ≈ 4.4       | 920                     | 3185                  |

|                  |    |       |     |      |
|------------------|----|-------|-----|------|
| PbF <sub>4</sub> | Mg | ≈ 4.1 | 715 | 4505 |
| FeF <sub>3</sub> | Mg | ≈ 3.1 | 665 | 2300 |
| CoF <sub>3</sub> | Ti | ≈ 3.3 | 670 | 2650 |

**Table 1**

5

**4) Preparation of a PbF<sub>2</sub>/FIB Electrolyte/PANI FIB Coin Cell**

[0090] PbF<sub>2</sub> is milled along with carbon black. The resultant powder is then mixed with PVDF or PTFE and lightly graphitized conductive carbon black. A film is prepared and disk electrodes (14 mm diameter) are punched. Pellets can also be pressed from the same mixture (but dry and mixed with mortar and pestle) prior to overnight drying. Film electrodes and pellet electrodes are kept in a dry environment until being used in a cell.

[0091] PANI electrodes are prepared as follows: PANI powder is mixed with lightly graphitized conductive carbon black. Pellets or films can be 2016 coin cells can then be assembled. Pellets are soaked in the electrolyte to insure a good wetting. Film electrodes are soaked with a few drops of electrolyte. The cell can be assembled using the PbF<sub>2</sub> electrode on one side of the can, the PANI electrode on the other side with a polypropylene separator in between soaked with the electrolyte. Depending on the total thickness of the sandwich, stainless steel spacers and/or stainless steel spring can be included on one side of the can to ensure good stacking pressure inside the cell. The cell is then crimped and the excess electrolyte is washed away. The cell is then ready for testing in a cycler.

**5) Preparation of Pouch Cells:**

[0092] Lead fluoride is milled along with carbon black. The resultant powder is then mixed with PVDF and lightly graphitized conductive carbon black. The mixture is then

sprayed on a heated aluminum substrate layer by layer up to a thickness of several tens of microns. The film is then dried and kept in a dry environment until being used in a cell.

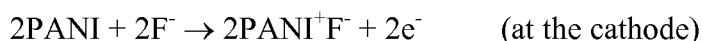
[0093] Polyaniline films are prepared by mixing polyaniline powder with lightly graphitized conductive carbon black and. The mixture is sprayed on a heated aluminum substrate layer by layer up to a thickness of several tens of microns. The film is then dried and kept in a dry environment until being used in a cell.

[0094] Small pouch cells can then be assembled by cutting rectangular shape electrodes from the previously prepared films and tabs are welded on the aluminum substrate for electrical contact. The cell can then be assembled using lead fluoride electrode as the anode, polyaniline electrode as the cathode with polypropylene separator (slightly bigger than the electrodes) in between. The sandwich is then put in a pouch material cut to the right dimensions and three sides of the pouch are heat sealed. The electrolyte is then injected inside the cell and vacuum soaked for a few minutes before testing in a cyclor.

#### 6) Charge-Discharge Characteristics of PbF<sub>2</sub>/FIB Electrolyte/PANI Cell

[0095] Figure 4 shows the first and second charge and discharge curves for a PbF<sub>2</sub>/TMAF-MPPTFSI/PANI cell assembled in the discharged state. Discharge capacity observed is around 100 mAh/g.

[0096] Without wishing to be bound by any particular theory, this process is consistent with electrode reactions:



#### 7) Use of Other Fluoride Salts in the Electrolyte

[0097] Figure 5 shows charge/discharge curves for a PbF<sub>2</sub>/NPTMAF-MPPTFSI/PANI cell assembled in the discharged state. NPTMAF (neopentyltrimethylammonium fluoride) is more soluble in common organic solvents and ionic liquids than TMAF, and a 0.4 M solution in MPPTFSI may be prepared with conductivity around 1 mS/cm.

#### 8) Characterizing Data for Charge of PbF<sub>2</sub>/electrolyte/PANI Cells to Distinguish Electrolyte Effects

[0098] Figure 6 shows charge-discharge curves for PbF<sub>2</sub>/electrolyte/PANI cells (3rd cycle) containing TMAF-MPPTFSI electrolyte (as taught here) alongside 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC electrolyte as taught in US 2009/0029237 A1. The TMAF-MPPTFSI system delivers significant capacity upon electrochemical cycling.

5

9) Characterizing Data for Carbon Electrodes Cycled with 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC Electrolyte

[0099] Providing a sufficient amount of charge carrying F<sup>-</sup> anions for FIB cells can be difficult to achieve, and can require careful selection of reactants and solvents for best results.

10 For examples, US Published Patent Application 2009/0029237 reports that cycling a carbon electrode using an electrolyte such as 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC will result in reversible incorporation of F<sup>-</sup> into the positive electrode upon charge, with the release of F<sup>-</sup> upon discharge. However, Seel and Dahn, J. Electrochem. Soc., 147, 892 (2000) and West *et al.*, J. Electrochem. Soc., 154, A929 (2007) indicate that under similar experimental

15 conditions the carbon structure does accommodate the additional anions in the electrolyte (PF<sub>6</sub><sup>-</sup> from the work of Seel and Dahn, and boron species from the work of West *et al.*). Further investigation has shown that charging of a symmetric carbon nanotube cell (both electrodes are carbon nanotube materials, with binder) with 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC to 5.3 V clearly results in accommodation of PF<sub>6</sub><sup>-</sup> into the positive electrode, as shown by

20 EDS mapping (Figure 7). Detailed <sup>31</sup>P and <sup>19</sup>F solid-state NMR studies of the carbon nanotube positive electrode after charging to 5.3 V and discharging to 3.0 V indicate the characteristic presence of PF<sub>6</sub><sup>-</sup> and hydrolysis products (as identified by their chemical shift and coupling patterns) in the carbon structure after charging and the significant reduction of the concentration of P-containing species after discharging (Figure 8). Therefore, these data

25 and those detailed in Example 8, indicate that electrolytes such as 0.5 M LiF/1M LiPF<sub>6</sub> in EC/DMC do not provide a source of F<sup>-</sup> for FIB cells that is useful for electrochemical reaction in the absence of participation of reactions of the counter ions (e.g. PF<sub>6</sub><sup>-</sup>).

30 10) Internal Resistance and Open-Circuit Voltage (OCV) for Typical Liquid Phase-Electrolyte FIB Cell

[00100] Figure 9 shows internal resistance data ( $\Omega$ ) measured for a PbF<sub>2</sub>/TMAF-MPPTFSI/PANI cell in the charged state from 20-100 oC, alongside comparative data for a solid-state FIB cell as reported in <http://www.sandia.gov/mission/st/battery.pdf>

[00101] The internal resistance values for the liquid-electrolyte FIB cell are at least one order of magnitude below that for the solid-state system, and do not vary significantly across the temperature range studied. Figure 10 shows OCV values for a PbF<sub>2</sub>/TMAF-

MPPTFSI/PANI cell in the charged state as measured from 20-100 °C, indicating a stable

5 OCV around 1 V across this temperature range.

11) Discharge of a Pb/0.1 M TMAF-MPPTFSI/PANI-F (charged state) cell:

10 [00102] Figure 11 shows the discharge profile of a Pb/0.1M TMAF-MPPTFSI/PANI-F (charged state) cell, with significant capacity. For comparison, the same cell with undoped PANI (containing no F<sup>-</sup> ions) has a negligible capacity, indicating the requirement for mobile F<sup>-</sup> to be present in the cathode for discharge to occur.

15 12) Charge-discharge of a BiF<sub>3</sub>/TMAF-MPPTFSI/PANI cell:

[00103] Figure 12 shows the charge-discharge profile of a BiF<sub>3</sub>/0.1M TMAF-MPPTFSI/PANI cell (assembled in the discharged state), with significant reversible capacity over three cycles.

20 13) Discharge of La/0.2M TMAF-MPPTFSI/PbF<sub>2</sub> cells:

[00104] Figure 13 shows the discharge profile of a La/0.2M TMAF-MPPTFSI/PbF<sub>2</sub> cell and the discharge profile of the same configuration cell using 0.2M TMAF-MPPTFSI with 0.2M boroxin in the electrolyte. This system displays some capability to be recharged, and displays a greater discharge capacity upon addition of boroxin additive to the electrolyte.

25

14) Charge-Discharge Characteristics of PbF<sub>2</sub>/EMIF(HF)<sub>n</sub>/PANI Cell

[00105] Figure 14 shows the charge-discharge profile of a PbF<sub>2</sub>/PANI system using the acidic ionic liquid fluoride electrolyte EMIF(HF)<sub>n</sub>, indicating significant reversible capacity in this system.

30

[00106] All references throughout this application, for example non-patent literature documents or other source material; are hereby incorporated by reference herein in their entireties, as though individually incorporated by reference, to the extent each reference is at least partially not inconsistent with the disclosure in this application. The terms and expressions which have been employed herein are used as terms of description and not of limitation, and there is no intention in the use of such terms and expressions of excluding any equivalents of the features shown and described or portions thereof, but it is recognized that various modifications are possible within the scope of the invention claimed. Thus, it should be understood that although the present invention has been specifically disclosed in various embodiments; optional features, modification and variation of the concepts herein disclosed may be resorted to by those skilled in the art, and such modifications and variations are considered to be within the scope of this invention as defined by the claims. As will be understood by one of skill in the art, methods and devices useful for the present methods can include a large number of optional composition and processing elements and steps. When a group of substituents is disclosed herein, it is understood that all individual members of that group and all subgroups, including any isomers, enantiomers, and diastereomers of the group members, are disclosed separately. When a Markush group or other grouping is used herein, all individual members of the group and all combinations and subcombinations possible of the group are intended to be individually included in the disclosure. When a compound is described herein such that a particular isomer, enantiomer or diastereomer of the compound is not specified, for example, in a formula or in a chemical name, that description is intended to include each isomers and enantiomer of the compound described individual or in any combination. Additionally, unless otherwise specified, all isotopic variants of compounds disclosed herein are intended to be encompassed by the disclosure. Many of the molecules disclosed herein contain one or more ionizable groups. All possible ionic forms of such molecules and salts thereof are intended to be included individually in the disclosure herein. With regard to salts of the compounds herein, one of ordinary skill in the art can select from among a wide variety of available counterions those that are appropriate for preparation of salts of this invention for a given application. In specific applications, the selection of a given anion or cation for preparation of a salt may result in increased or decreased solubility of that salt. Every formulation or combination of components described or exemplified herein can be used to practice the invention, unless otherwise stated. Whenever a range is given in the specification, for example, a temperature range, a time range, or a composition or concentration range, all intermediate ranges and subranges, as well as all individual values

included in the ranges given are intended to be included in the disclosure. It will be understood that any subranges or individual values in a range or subrange that are included in the description herein can be excluded from the claims herein. All art-known functional equivalents, of any such materials and methods are intended to be included in this invention.

- 5 The terms and expressions which have been employed are used as terms of description and not of limitation, and there is no intention that in the use of such terms and expressions of excluding any equivalents of the features shown and described or portions thereof, but it is recognized that various modifications are possible within the scope of the invention claimed. Thus, it should be understood that although the present invention has been specifically
- 10 disclosed by preferred embodiments and optional features, modification and variation of the concepts herein disclosed may be resorted to by those skilled in the art, and that such modifications and variations are considered to be within the scope of this invention as defined by the following claims.

**What is claimed is:**

1. A fluoride ion battery comprising  
an anode  
a cathode,  
5 an electrolyte comprising a dissolved fluoride salt at least partially dissolved in a  
solvent, and  
an additive comprising a fluoride ion complexing species.
2. The fluoride ion battery of claim 1, wherein the fluoride complexing species  
10 comprises at least one of boron, aluminum, ammonium, aza ether, or an H-bond donor.
3. The fluoride ion battery of any of the preceding claims, wherein the fluoride  
complexing species comprises at least one of tris(hexafluoroisopropyl)borate,  
tris(pentafluorophenyl)borane, regioisomers of difluorophenyl boroxin, trifluorophenyl  
15 boroxin, bis(trifluoromethyl)phenyl boroxin, trifluoromethyl)phenyl boroxin or  
fluoro(trifluoromethyl)phenyl boroxin.
4. The fluoride ion battery of any of the preceding claims, wherein the solvent comprises  
an organic liquid selected from one or more members of a group consisting of nitriles,  
20 amines, ethers, carbonates, nitro-containing compounds, aliphatic hydrocarbons, aromatic  
hydrocarbons, halogenated compounds, sulfoxides, sulfones, amides, esters, alcohols,  
heterocyclic compound, linear and cyclic alkyls optionally substituted with one or more of  
these functional groups.
- 25 5. The fluoride ion battery of one of the preceding claims, wherein the solvent comprises  
at least one of acetone, acetonitrile, benzonitrile, 4-fluorobenzonitrile,  
pentafluorobenzonitrile, triethylamine, diisopropylethylamine, 1,2-dimethoxyethane, ethylene  
carbonate, propylene carbonate,  $\gamma$ -butyrolactone, dimethyl carbonate, diethyl carbonate,  
methyl ethyl carbonate, propyl methyl carbonate, tetrahydrofuran, 2-methyltetrahydrofuran,  
30 nitromethane, benzene, toluene, chloroform, dichloromethane, 1,2-dichloroethane,  
dimethylsulfoxide, sulfolane, N,N-dimethylformamide, N,N-dimethylacetamide, carbon  
disulfide, ethyl acetate, methyl butyrate, n-propyl acetate, methyl propionate, methyl formate,  
4-methyl-1,3-dioxolane, pyridine, methyl isobutyl ketone, methyl ethyl ketone,

hexamethylphosphoramidate, hexamethylphosphorus triamide, 1-methyl-2-pyrrolidinone, 2-methoxyethyl acetate, trimethyl borate, triethylborate and substituted derivatives thereof, ethylmethylsulfone, trimethylene sulfone, 1-methyltrimethylene sulfone, ethyl-sec-butyl sulfone, ethyl isopropyl sulfone, 3,3,3-trifluoropropylmethyl sulfone, and 2,2,2-trifluoroethyl sulfone.

6. The fluoride ion battery of any one of the preceding claims, wherein the dissolved fluoride salt comprises an organic-soluble fluoride salt selected from at least one of:

1,2-bis(dimethylamino)-1,2-bis(dimethylammonium)ethene difluoride;

hexamethylguanidinium fluoride;

1-propyl,1-methyl-piperidinium fluoride;

1,3,3,6,6,-hexamethylpiperidinium fluoride;

1-methylhexamethylenetetramine fluoride;

tetramethylphosphonium fluoride;

tetraphenylphosphonium fluoride;

phenyltrimethylphosphonium fluoride;

trimethylsulfonium fluoride ;

tetramethylammonium fluoride;

neopentyltrimethylammonium fluoride;

cobaltocenium fluoride;

poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride;

dimethylpropyltrimethylammonium fluoride;

1-adamantyltrimethylammonium fluoride;

phenyltrimethylammonium fluoride;

cobaltocenium fluoride;

poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride;

an alkylammonium or substituted alkylammonium cation  $R_1R_2R_3S^+ F^-$ , wherein  $R_1$ ,  $R_2$  and  $R_3$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

an alkylammonium or substituted alkylammonium cation, wherein one or more R-groups is joined to two or more alkylammonium cations to provide a dimer, oligomer or polymer  $(R_1R_2R_3R_4N^+)_x (F^-)_x$ , wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic

aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group, and wherein x is 2 to 50;

an alkylguanidinium and substituted alkylguanidinium cation  $(R_1R_2N)_3C^+F^-$ , wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

a salt in the form of  $X^+F^-$  where X is a heterocyclic cation, wherein the heterocyclic ring comprises 4 to 7 atoms; optionally benzoannelated, polycyclic, and substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

a phosphazene or phosphazenium-containing compound, optionally selected from 1,1,1,3,3,3-hexakis(dimethylamino)diphosphazenium fluoride and tetrakis[tris(dimethylamino)-phosphoranylideneamino]phosphonium fluoride;

an alkylphosphonium or substituted alkylphosphonium cation  $R_1R_2R_3R_4P^+F^-$  wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  may each be separately a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

alkylsulfonium or substituted alkylsulfonium cation  $R_1R_2R_3S^+F^-$ , wherein  $R_1$ ,  $R_2$  and  $R_3$  are optionally and independently substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group; and

a cation polymer compound comprising  $-[Z-Het^+-X-Het^+-]_n$ , wherein Het is a heterocyclic cation comprising 4-7 atoms; optionally benzoannelated, polycyclic and substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl groups; wherein Z and X are spacer groups comprising at least one of  $CH_2$ ,  $CMe_2$ ,  $SiMe_2$ ,  $SO_2$ ,  $P=O$ , C2 to C50, aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group, and n is 1 to 8.

7. The fluoride ion battery of any one of claims 1 to 5, wherein the dissolved fluoride salt comprises an organic-soluble fluoride salt selected from at least one of a metal-organic, substituted metal-organic or metal-coordination complex species



wherein R1, R2, R3, RN comprises a ligand species selected from at least one of a carbocyclic or heterocyclic organometallic ligand, n is independently 1 to 8 for each occurrence, N is 1 to 8, and M is a metal-species.

- 5     8.     The fluoride ion battery of claim 7, wherein the carbocyclic or heterocyclic organometallic ligand comprises at least one of a cyclopentadienyl, benzene, cyclobutadiene, pyridine, phenanthroline or phosphacyclopentadienyl, isolobal analogues thereof, optionally substituted with a linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group, alkyl, alkene, alkyne, alkynyl, carbonyl, 10     amine, phosphine, halide, hydride, nitrile, or isonitrile.
9.     The fluoride ion battery of anyone of claims 7 or 8, wherein the metal species comprises a main-group metal, transition metal or lanthanide metal.
- 15    10.    The fluoride ion battery of any of the preceding claims, wherein the electrolyte is liquid at a temperature of less than 200 degrees Celsius.
11.    The fluoride ion battery of any of the preceding claims, wherein the electrolyte is liquid at a temperature of less than 100 degrees Celsius.
- 20    12.    The fluoride ion battery of any one of the preceding claims, wherein electrochemical reactions between the anode and the cathode are reversible to allow a rechargeable battery.
13.    The fluoride ion battery of any one of the preceding claims, wherein electrochemical 25    reactions between the anode and the cathode are substantially irreversible to form a primary battery.
14.    A fluoride ion battery comprising  
an anode  
30    a cathode, and  
an electrolyte comprising an ionic liquid solvent and a dissolved fluoride salt that is liquid at temperatures less than 200 degrees Celsius.

15. The fluoride ion battery of claim 14, wherein the electrolyte further comprises an additive that reduces viscosity of the ionic liquid solvent.

16. The fluoride ion battery of anyone claims 14 to 15, wherein the additive comprises a fluoride complexing species comprising at least one of boron, aluminum, ammonium, aza ether, or an H-bond donor.

17. The fluoride ion battery of claims 14 to 16, wherein the fluoride complexing species comprises at least one of: tris(hexafluoroisopropyl)borate; tris(pentafluorophenyl)borane; difluorophenyl boroxin, and regioisomers thereof; trifluorophenyl boroxin; bis(trifluoromethyl)phenyl boroxin; trifluoromethylphenyl boroxin; and, fluoro(trifluoromethyl)phenyl boroxin.

18. The fluoride ion battery of claims 14 to 17, wherein the ionic liquid solvent comprises at least one of 1-methyl-1-propylpiperidinium bis(trifluoromethanesulfonyl)imide; butyltrimethylammonium bis(trifluoromethanesulfonyl)imide; 1-butyl,1-methylpyrrolidinium bis(trifluoromethanesulfonyl)imide; or fluoroalkylphosphate anion derivatives thereof, optionally comprising a hydrophobic anion.

19. The fluoride ion battery of any one claims 14 to 18, wherein the dissolved fluoride salt comprises an organic-soluble fluoride salt selected from at least one of:

1,2-bis(dimethylamino)-1,2-bis(dimethylammonium)ethene difluoride;

hexamethylguanidinium fluoride;

1-propyl,1-methyl-piperidinium fluoride;

1,3,3,6,6,-hexamethylpiperidinium fluoride;

1-methylhexamethylenetetramine fluoride;

tetramethylphosphonium fluoride;

tetraphenylphosphonium fluoride;

phenyltrimethylphosphonium fluoride;

trimethylsulfonium fluoride ;

tetramethylammonium fluoride;

neopentyltrimethylammonium fluoride;

cobaltocenium fluoride;

poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride;

dimethylpropyltrimethylammonium fluoride;

1-adamantyltrimethylammonium fluoride;

phenyltrimethylammonium fluoride;

cobaltocenium fluoride;

5 poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride;

an alkylammonium or substituted alkylammonium cation  $R_1R_2R_3S^+ F^-$ , wherein  $R_1$ ,  $R_2$  and  $R_3$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

10 an alkylammonium or substituted alkylammonium cation, wherein one or more R-groups is joined to two or more alkylammonium cations to provide a dimer, oligomer or polymer  $(R_1R_2R_3R_4N^+)_x (F^-)_x$ , wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group, and wherein x is  
15 2 to 50;

an alkylguanidinium and substituted alkylguanidinium cation  $(R_1R_2N)_3C^+ F^-$ , wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

20 a salt in the form of  $X^+ F^-$  where X is a heterocyclic cation, wherein the heterocyclic ring comprises 4 to 7 atoms; optionally benzoannulated, polycyclic, and substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

a phosphazene or phosphazanium-containing compound, optionally selected from  
25 1,1,1,3,3,3-hexakis(dimethylamino)diphosphazanium fluoride and tetrakis[tris(dimethylamino)-phosphoranylideneamino]phosphonium fluoride;

an alkylphosphonium or substituted alkylphosphonium cation  $R_1R_2R_3R_4P^+ F^-$  wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  may each be separately a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a  
30 substituted aryl group;

alkylsulfonium or substituted alkylsulfonium cation  $R_1R_2R_3S^+ F^-$ , wherein  $R_1$ ,  $R_2$  and  $R_3$  are optionally and independently substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group; and

a cation polymer compound comprising  $-[Z\text{-Het}^+\text{-X-Het}^+\text{-}]_n$ , wherein Het is a heterocyclic cation comprising 4-7 atoms; optionally benzoannulated, polycyclic and substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl groups; wherein Z and X are spacer groups comprising at least one of CH<sub>2</sub>, CMe<sub>2</sub>, SiMe<sub>2</sub>, SO<sub>2</sub>, P=O, C2 to C50, aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group, and n is 1 to 8.

20. The fluoride ion battery of any one of claims 14 to 18, wherein the dissolved fluoride salt comprises an organic-soluble fluoride salt selected from at least one of a metal-organic, substituted metal-organic or metal-coordination complex species



wherein R<sub>1</sub>, R<sub>2</sub>, R<sub>3</sub>, R<sub>N</sub> comprises a ligand species selected from at least one of a carbocyclic or heterocyclic organometallic ligand, n is independently 1 to 8 for each occurrence, N is 1 to 8, and M is a metal-species.

21. The fluoride ion battery of claim 20, wherein the carbocyclic or heterocyclic organometallic ligand comprises at least one of a cyclopentadienyl, benzene, cyclobutadiene, pyridine, phenanthroline or phosphacyclopentadienyl, isolobal analogues thereof, optionally substituted with a linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group, alkyl, alkene, alkyne, alkynyl, carbonyl, amine, phosphine, halide, hydride, nitrile, or isonitrile.

22. The fluoride ion battery of anyone of claims 20 to 21, wherein the metal species comprises a main-group metal, transition metal or lanthanide metal.

23. The fluoride ion battery of any of claims 14 to 22, wherein the electrolyte is liquid at a temperature of less than 200 degrees Celsius.

24. The fluoride ion battery of any of claims 14 to 22, wherein the electrolyte is liquid at a temperature of less than 100 degrees Celsius.

25. The fluoride ion battery of any of claims 14 to 22, wherein electrochemical reactions between the anode and the cathode are reversible to allow a rechargeable battery.

26. The fluoride ion battery of any of claims 14 to 22, wherein electrochemical reactions between the anode and the cathode are substantially irreversible to form a primary battery.

27. A fluoride ion battery comprising

a substantially lithium-free anode and cathode, with at least one of the anode or cathode containing fluorine, and

a substantially lithium-free liquid electrolyte comprising an ionic liquid, wherein the electrolyte is liquid at some temperature less than 200 degrees Celsius.

28. The fluoride ion battery of claim 27, wherein the solvent comprises at least one of:

acetone, acetonitrile, benzonitrile, 4-fluorobenzonitrile, pentafluorobenzonitrile, triethylamine, diisopropylethylamine, 1,2-dimethoxyethane, ethylene carbonate, propylene carbonate (PC),  $\gamma$ -butyrolactone, dimethyl carbonate, diethyl carbonate, methyl ethyl carbonate, propyl methyl carbonate, tetrahydrofuran, 2-methyltetrahydrofuran, nitromethane, benzene, toluene, chloroform, dichloromethane, 1,2-dichloroethane, dimethylsulfoxide, sulfolane, N,N-dimethylformamide, N,N-dimethylacetamide, carbon disulfide, ethyl acetate, methyl butyrate, n-propyl acetate, methyl propionate, methyl formate, 4-methyl-1,3,-dioxolane, pyridine, methyl isobutyl ketone, methyl ethyl ketone, hexamethylphosphoramide, hexamethylphosphorus triamide, 1-methyl-2-pyrrolidinone, 2-methoxyethyl acetate, trimethyl borate, triethylborate and substituted derivatives thereof, as well as sulfones such as ethylmethylsulfone, trimethylene sulfone, 1-methyltrimethylene sulfone, ethyl-sec-butyl sulfone, ethyl isopropyl sulfone (EIPS), 3,3,3-trifluoropropylmethyl sulfone and 2,2,2-trifluoroethyl sulfone.

29. The fluoride ion battery of claim 27 to 28, wherein the organic-soluble fluoride salt comprises at least one of:

1,2-bis(dimethylamino)-1,2-bis(dimethylammonium)ethene difluoride;

hexamethylguanidinium fluoride;

1-propyl,1-methyl-piperidinium fluoride;

1,3,3,6,6,-hexamethylpiperidinium fluoride;

1-methylhexamethylenetetramine fluoride;

tetramethylphosphonium fluoride;

tetraphenylphosphonium fluoride;

phenyltrimethylphosphonium fluoride;

trimethylsulfonium fluoride ;

tetramethylammonium fluoride;

neopentyltrimethylammonium fluoride;

5 cobaltocenium fluoride;

poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride;

dimethylpropyltrimethylammonium fluoride;

1-adamantyltrimethylammonium fluoride;

phenyltrimethylammonium fluoride;

10 cobaltocenium fluoride,

poly(1,1-dimethyl-3,5-dimethylene piperidinium)fluoride an alkylammonium or substituted alkylammonium cation  $R_1R_2R_3S^+ F^-$ , wherein  $R_1$ ,  $R_2$  and  $R_3$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

15 an alkylammonium or substituted alkylammonium cation, wherein one or more R-groups is joined to two or more alkylammonium cations to provide a dimer, oligomer or polymer  $(R_1R_2R_3R_4N^+)_x (F^-)_x$ , wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group, and wherein x is  
20 2 to 50;

an alkylguanidinium and substituted alkylguanidinium cation  $(R_1R_2N)_3C^+ F^-$ , wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  are independently and optionally substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

25 a fluoride salt in the form of  $X^+ F^-$  where X is a heterocyclic cation, wherein the heterocyclic ring comprises 4 to 7 atoms; optionally benzoannelated, polycyclic, and substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

30 a phosphazene or phosphazenium-containing compound, optionally selected from 1,1,1,3,3,3-hexakis(dimethylamino)diphosphazenium fluoride and tetrakis[tris(dimethylamino)-phosphoranylideneamino]phosphonium fluoride;

an alkylphosphonium or substituted alkylphosphonium cation  $R_1R_2R_3R_4P^+ F^-$  wherein  $R_1$ ,  $R_2$ ,  $R_3$  and  $R_4$  may each be separately a substituted or unsubstituted, linear or

branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group;

alkylsulfonium or substituted alkylsulfonium cation  $R_1R_2R_3S^+ F^-$ , wherein  $R_1$ ,  $R_2$  and  $R_3$  are optionally and independently substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group; and

a cation polymer compound comprising  $-[Z-Het^+-X-Het^+-]_n$ , wherein Het is a heterocyclic cation comprising 4-7 atoms; optionally benzoannelated, polycyclic and substituted at one or more positions with a substituted or unsubstituted, linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl groups; wherein Z and X are spacer groups comprising at least one of  $CH_2$ ,  $CMe_2$ ,  $SiMe_2$ ,  $SO_2$ ,  $P=O$ , C2 to C50, aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or a substituted aryl group, and n is 1 to 8.

30. The fluoride ion battery of claim 27 to 28, wherein the organic-soluble fluoride salt comprises a metal-organic, substituted metal-organic or metal-coordination complex species



wherein  $R_1$ ,  $R_2$ ,  $R_3, R_N$  comprises a ligand species selected from at least one of a carbocyclic or heterocyclic organometallic ligand, n is independently 1 to 8 for each occurrence, N is 1 to 8, and M is metal species.

31. The fluoride ion battery of claim 30, wherein the carbocyclic or heterocyclic organometallic ligand comprises at least one of a cyclopentadienyl, benzene, cyclobutadiene, pyridine, phenanthroline or phosphacyclopentadienyl, isolobal analogues thereof, optionally substituted with a linear or branched, C1 to C50 aliphatic or cyclic aliphatic, fluoroalkyl, oligo(ethyleneglycol), aryl or substituted aryl group, alkyl, alkene, alkyne, alkynyl, carbonyl, amine, phosphine, halide, hydride, nitrile, or isonitrile.

32. The fluoride ion battery of claim 30 to 31, wherein metal species comprises a main-group metal, transition metal or lanthanide metal, and the number of ligands  $R_N$  is selected from  $N=1$  to 8.

33. The fluoride ion battery of any of claims 27 to 32, wherein the electrolyte is liquid at a temperature of less than 200 degrees Celsius.

34. The fluoride ion battery of any of claims 27 to 32, wherein the electrolyte is liquid at a temperature of less than 100 degrees Celsius.

5 35. The fluoride ion battery of any one of claims 27 to 32, wherein electrochemical reactions between the anode and the cathode are reversible to allow a rechargeable battery.

36. The fluoride ion battery of any one of the claims 27 to 32, wherein electrochemical reactions between the anode and the cathode are substantially irreversible to form a primary  
10 battery.

37. A fluoride ion battery comprising  
an anode  
a cathode, and  
15 an electrolyte comprising at least one of a room temperature ionic liquid fluoride or acidic ionic liquid fluoride.

38. The fluoride ion battery of claim 37, wherein the room temperature ionic liquid fluoride or acidic ionic liquid fluoride comprises:  
20  $X^+ F^-(HF)_n$ ,  
wherein  $X^+$  comprises at least one of an organic-soluble cation, wherein n is 0 to 5; acidic 1-ethyl-3-methylimidazolium fluoride (EMIF.(HF)<sub>2.3</sub>); or acidic 1-methyl-1-propylpiperidinium fluoride (MPPF.(HF)<sub>n</sub>) wherein n is about 2.3.

25 39. The fluoride ion battery of any of claims 1 to 3 or 27, wherein the solvent is an ionic liquid solvent comprising at least one of 1-methyl-1-propylpiperidinium bis(trifluoromethanesulfonyl)imide; butyltrimethylammonium bis(trifluoromethanesulfonyl)imide; 1-butyl,1-methylpyrrolidinium bis(trifluoromethanesulfonyl)imide; or fluoroalkylphosphate anion derivatives thereof.

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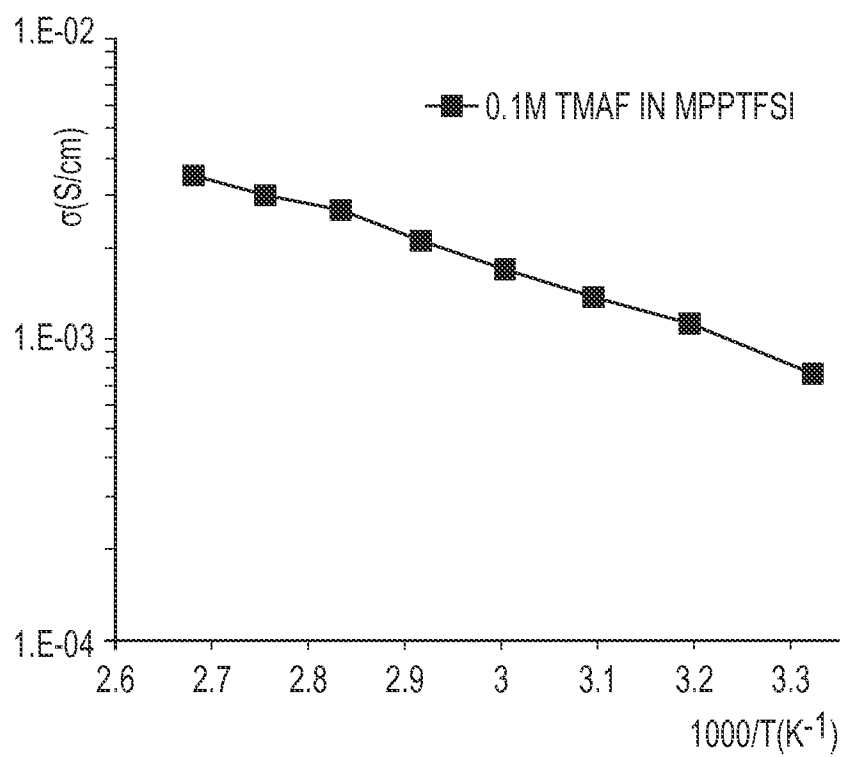


FIG.1

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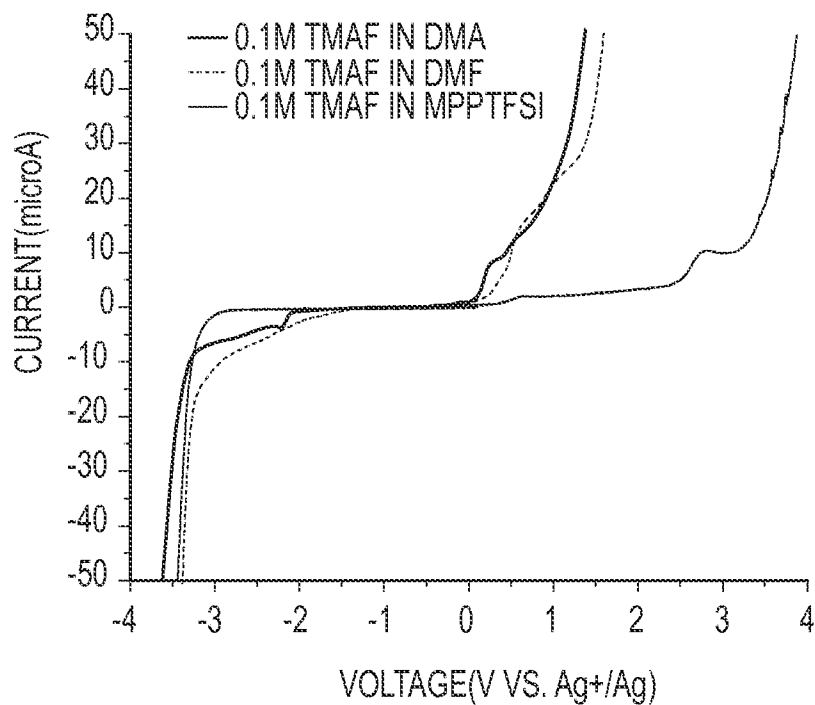


FIG.2

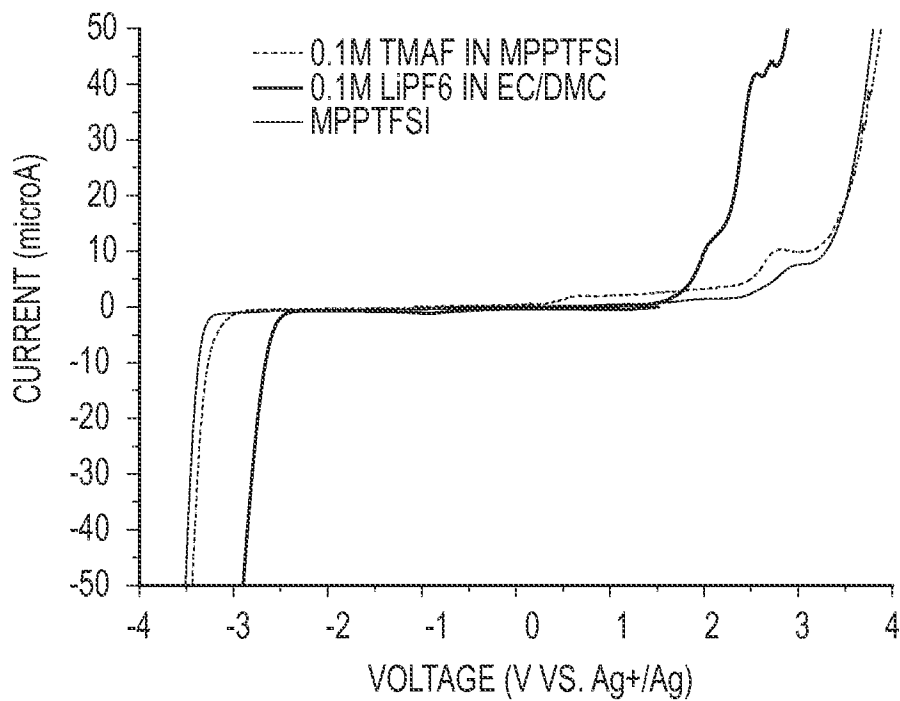


FIG.3

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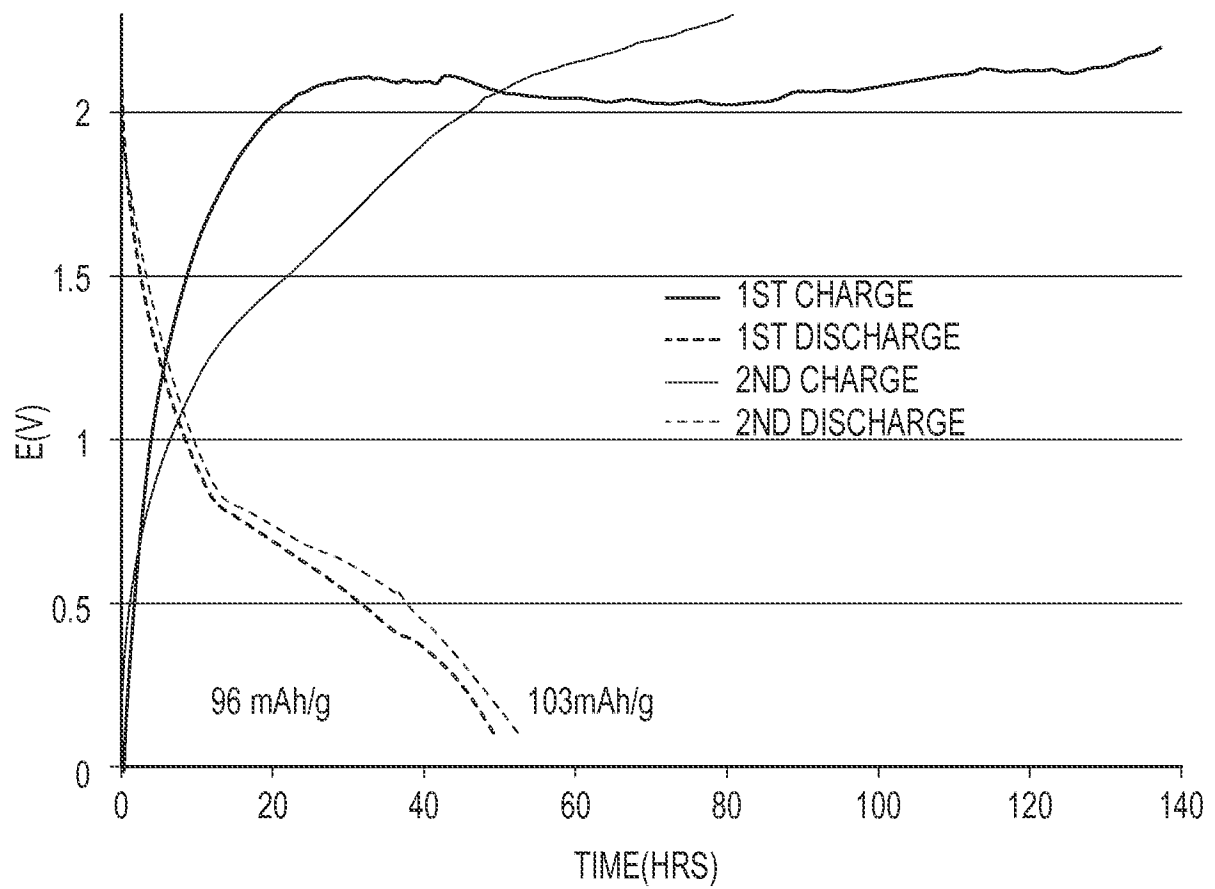


FIG.4

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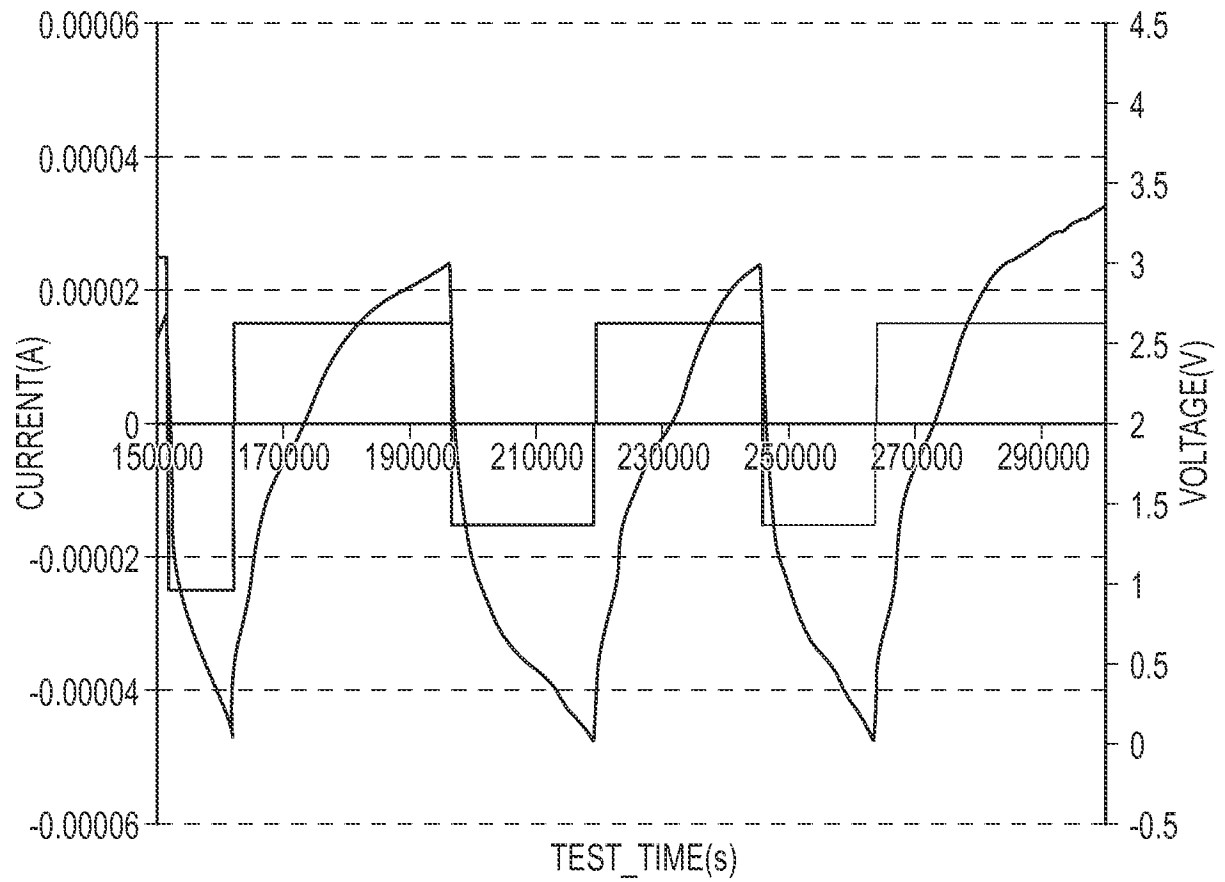


FIG.5

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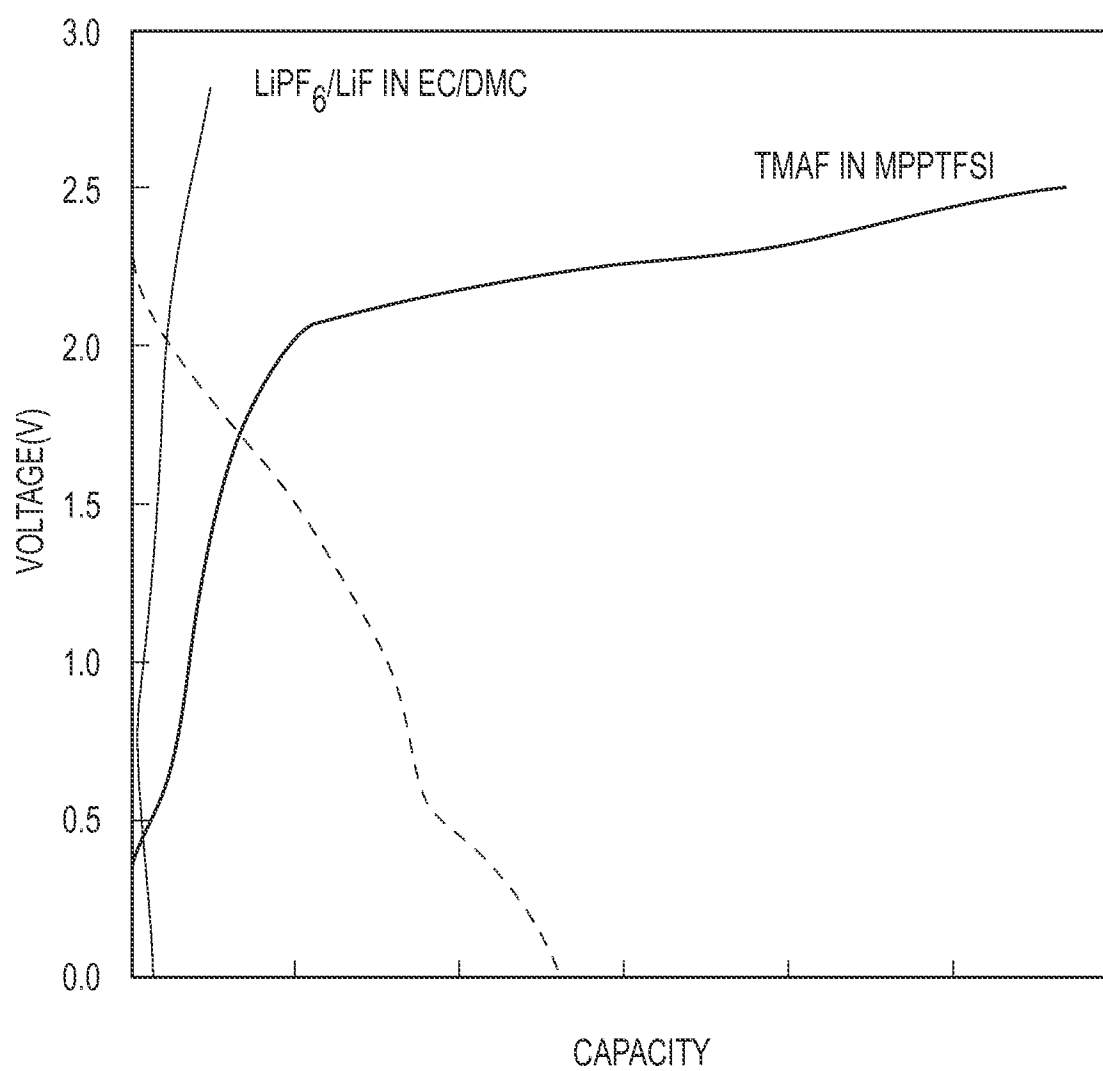
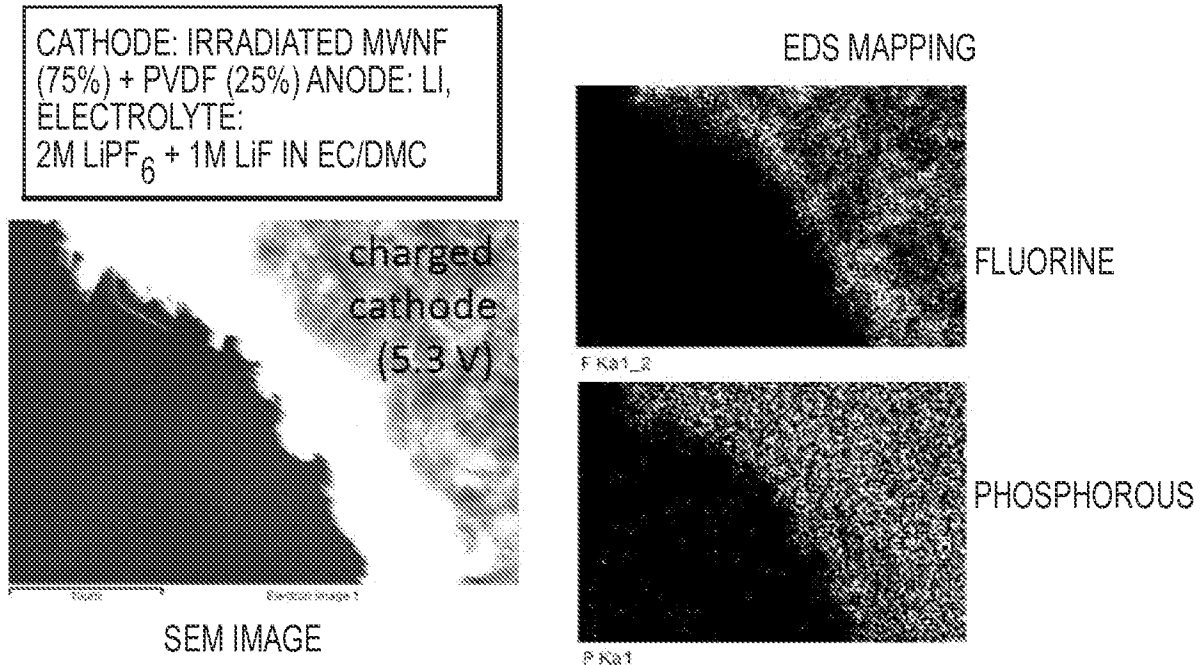


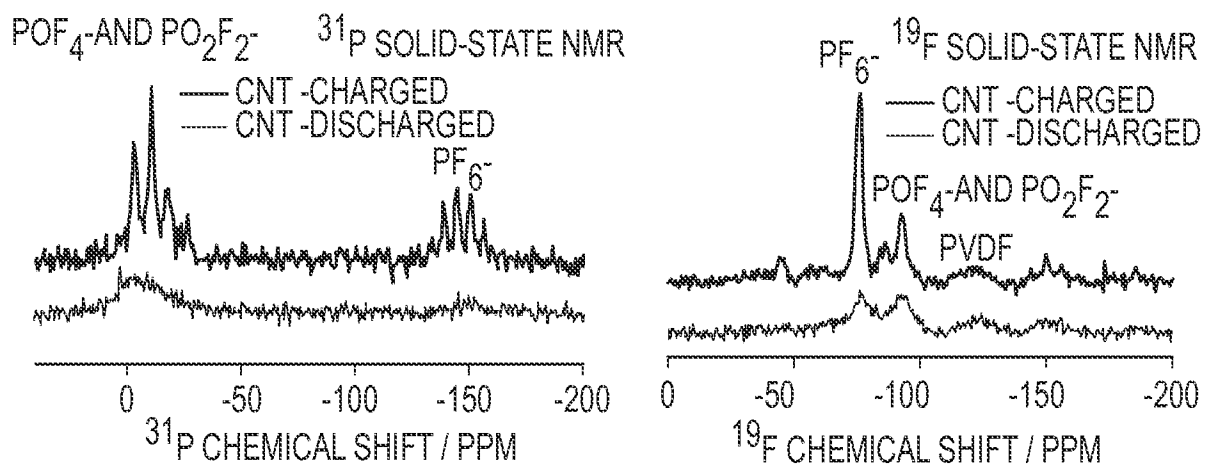
FIG.6

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EDS MAPPING INDICATES PRESENCE OF BOTH P AND F IN THE CHARGED CATHODE

FIG.7



CLEARLY SHOWS THE  $\text{PF}_6^-$  (AND HYDROLYSIS PRODUCTS) INTERCALATE INTO CNT ELECTRODE UPON CHARGE, DE-INTERCALATE UPON DISCHARGE

FIG.8

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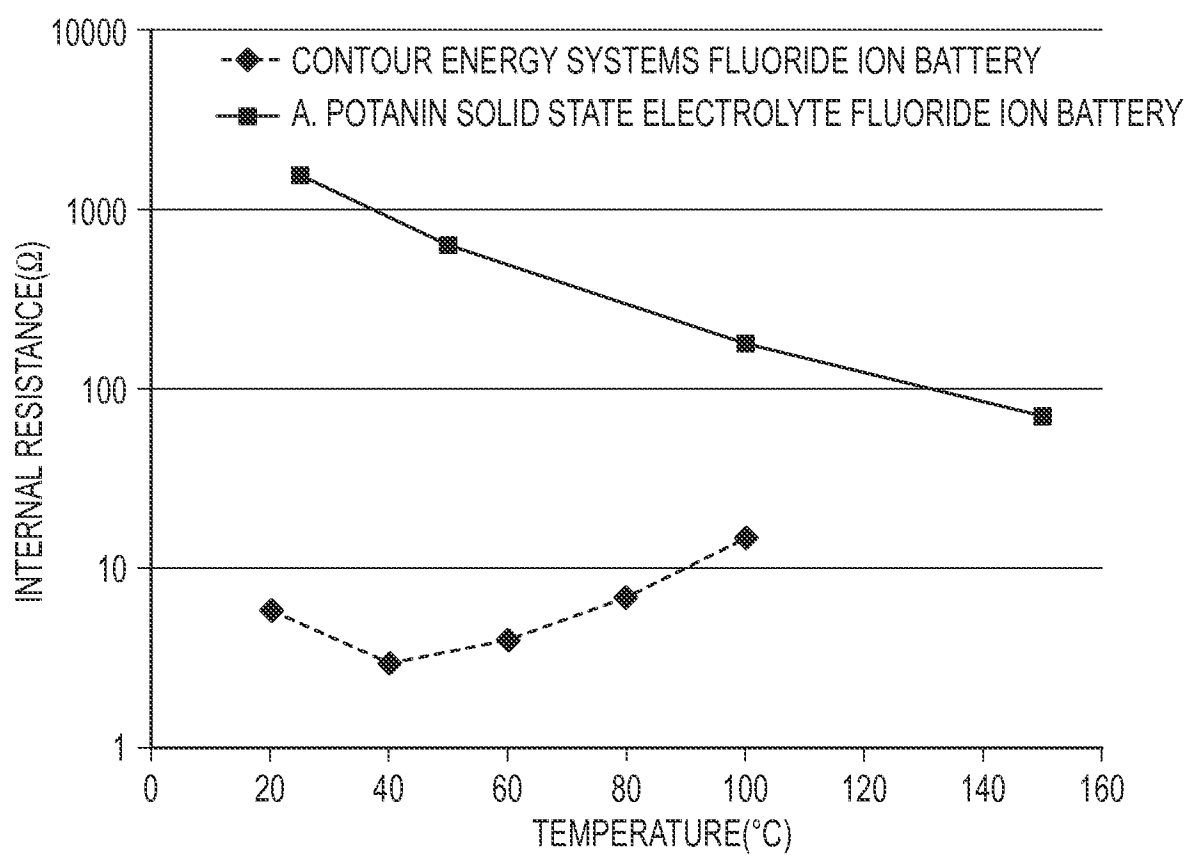


FIG.9

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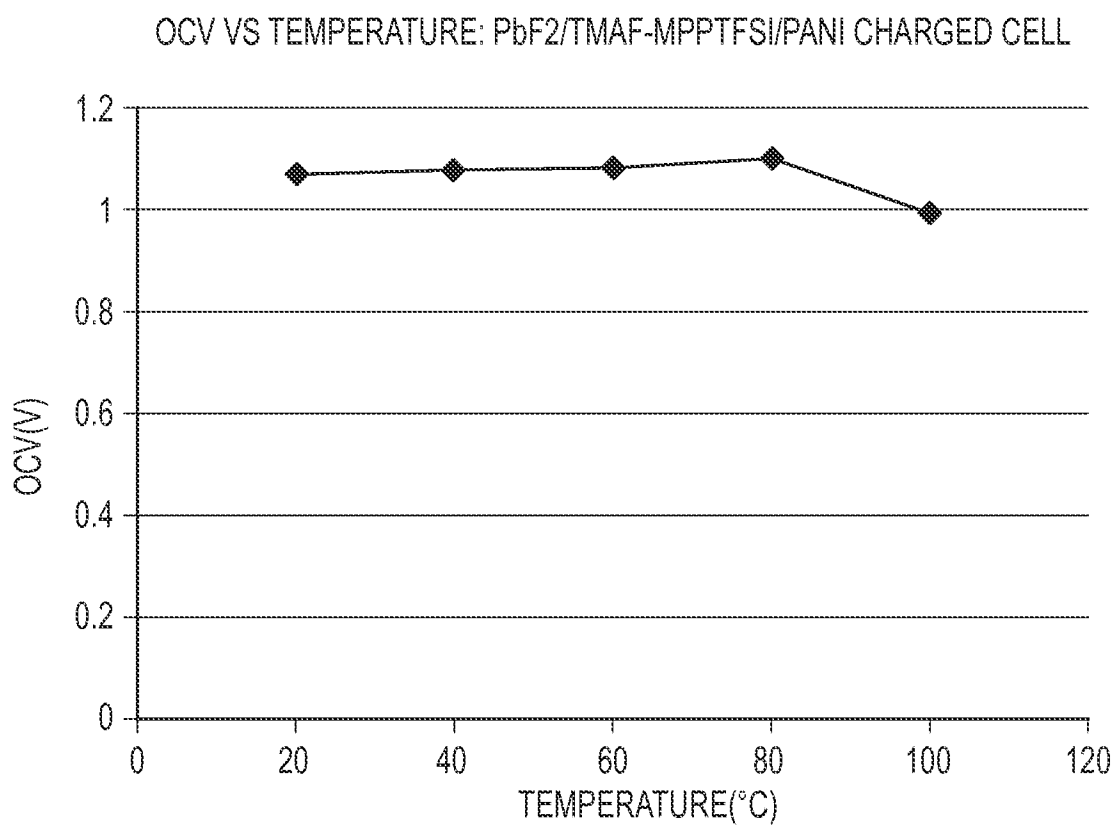


FIG.10

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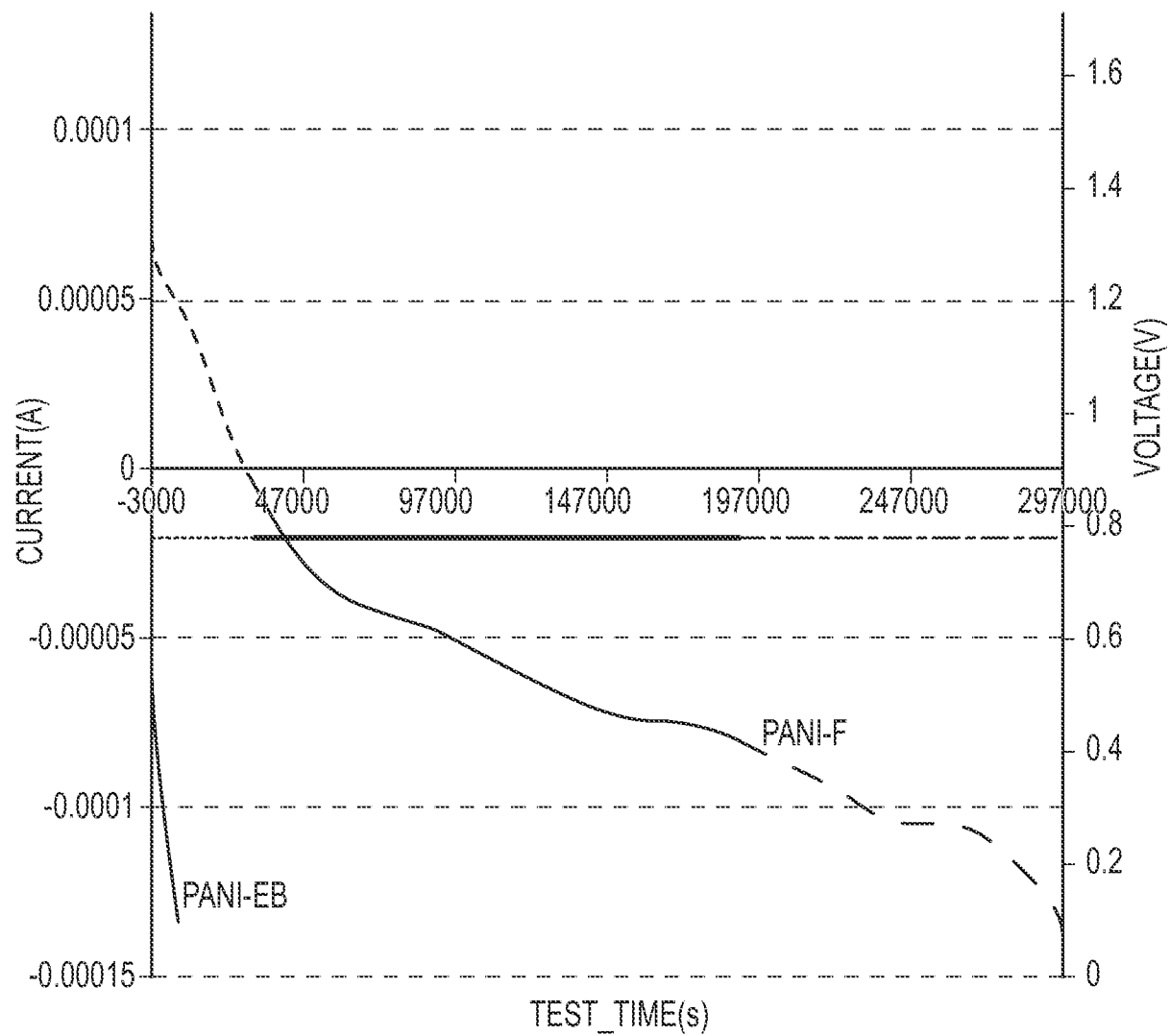


FIG.11

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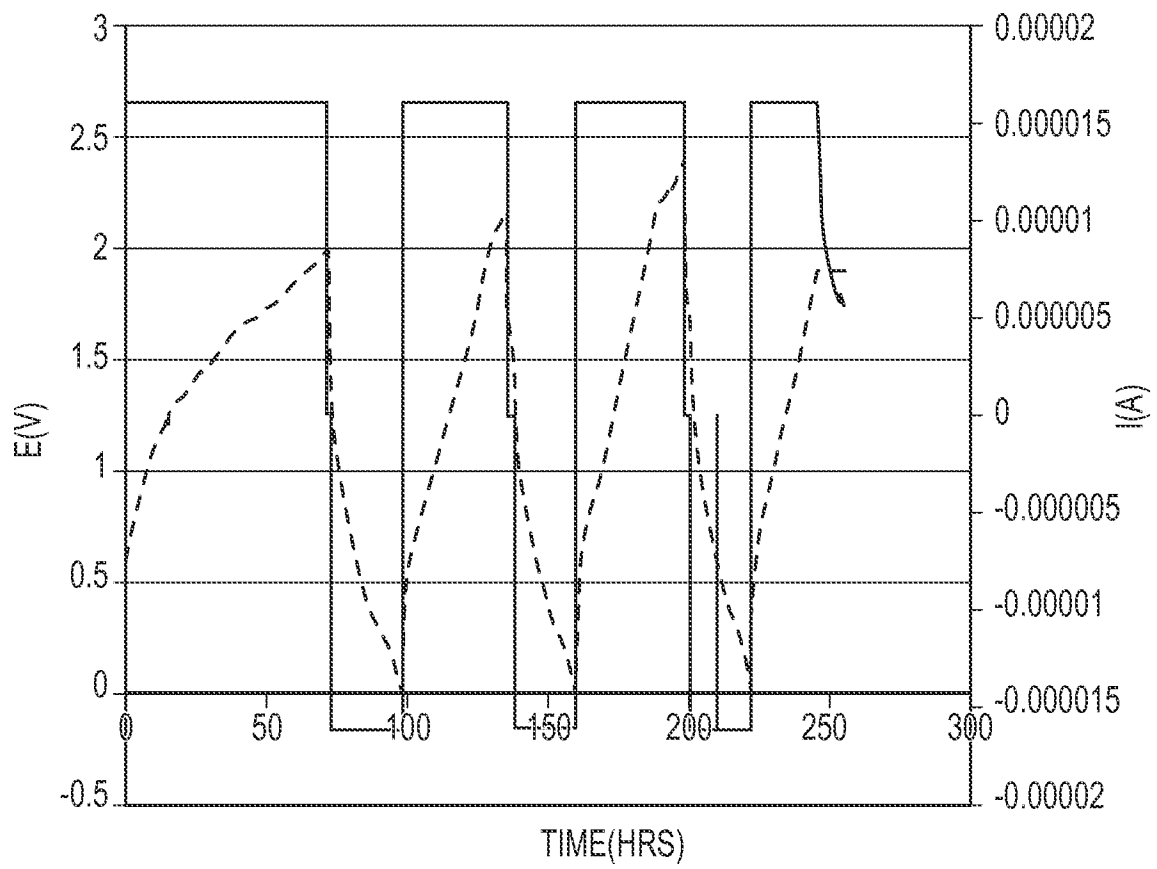


FIG.12

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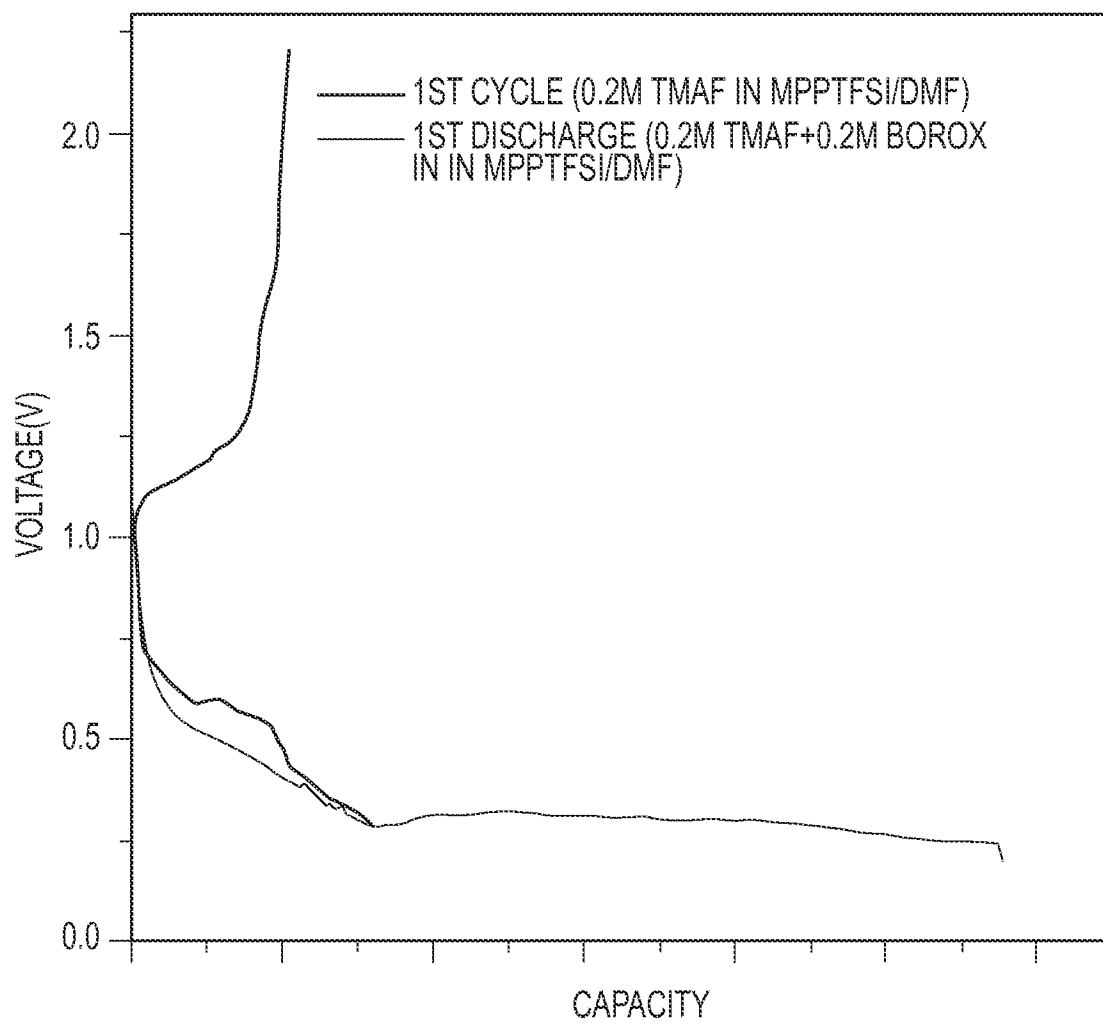


FIG.13

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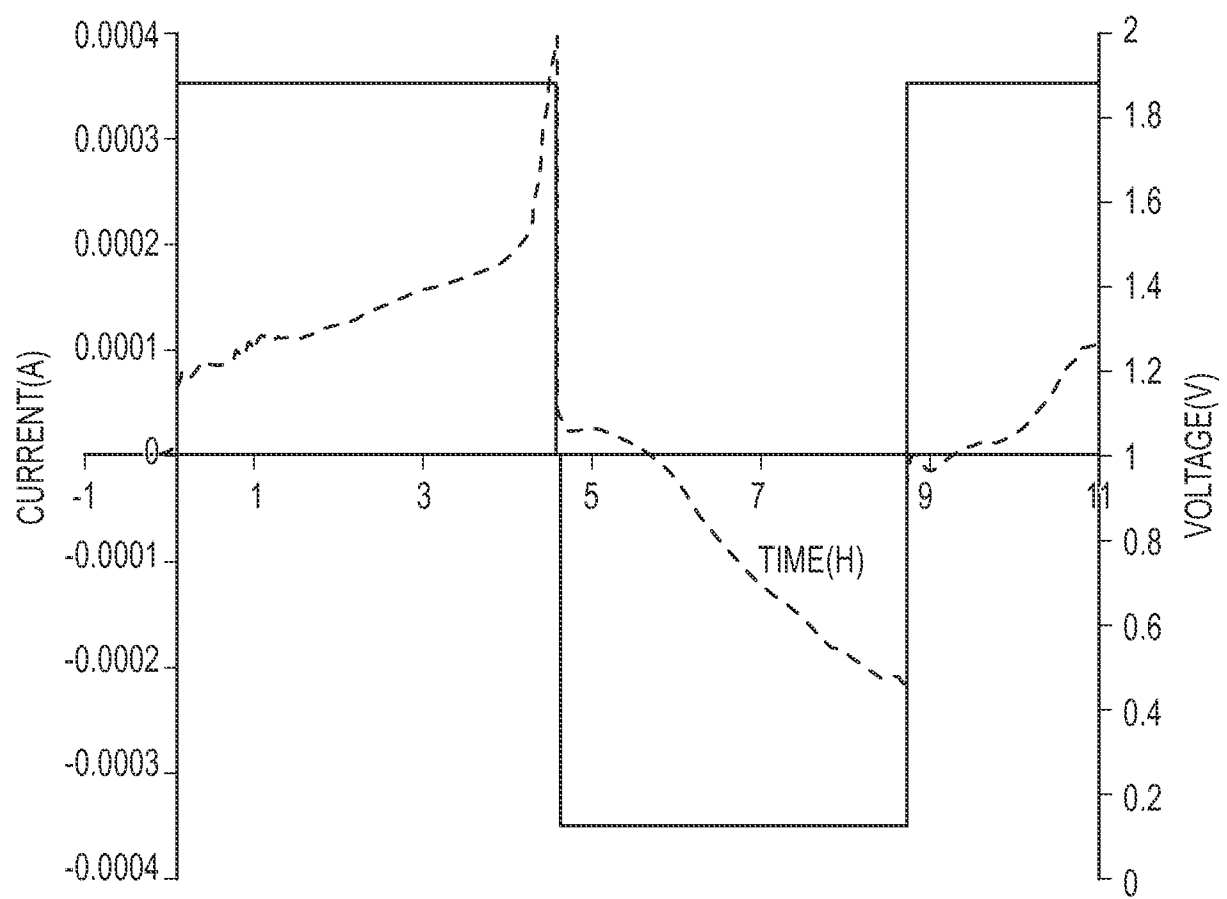


FIG.14