The present invention is directed to the effective dispersion of carbon nanotubes (CNTs) into polymer matrices. The nanocomposites are prepared using polymer matrices and exhibit a unique combination of properties, most notably, high retention of optical transparency in the visible range (i.e., 400-800 μm), electrical conductivity, and high thermal stability. By appropriate selection of the matrix resin, additional properties such as vacuum ultraviolet radiation resistance, atomic oxygen resistance, high glass transition (T_g) temperatures, and excellent toughness can be attained. The resulting nanocomposites can be used to fabricate or formulate a variety of articles such as coatings on a variety of substrates, films, foams, fibers, threads, adhesives and fiber coated prepreg.

20 Claims, 10 Drawing Sheets
Young, "Surfactant-Assisted Processing of Carbon Nanotube/Poly-
Xiaoyi Gong, Jun Liu, Suresh Baskaran, Roger D. Voise, & James S.
Phys. Chem, American Chemical Society, p. 4318-4322, ( May 3,
3308-3310, ( Jun. 16, 1997).
Yong K. Kim, A.F. Lewis, S.B. Warner, P.K. Patra, & P. Calvert,
Fluorinated Single-Wall Carbon Nanotubes in Alcohol Solvents," J.
"Field Emission from Nanotube Bundle Emitters at Low Fields,
"Synthesis, Characterizations, and Physical Properties of Carbon
Cheol Park, Zoubeida Ounaies, Kent A. Watson, Kristin Pavlicki,
Sharon E. Lowther, John W. Connell, Emilie J. Siochi, Joycelys S.
Harrison, & Terry L. St. Clair, "Polymer-Single Wall Carbon
Nanotube Composite for Potential Spacecraft Applications," Nov.
Peter T. Lillehei, Cheol Park, Jason H. Rouse, & Emilie J. Siochi,
"Imaging Carbon Nanotubes in High Performance Polymer Compo-
Cheol Park, Zoubeida Ounaies, Kent A. Watson, Roy E. Crooks,
Joseph Smith, Jr., Sharon E. Lowther, John W. Connell, Emilie J.
Siochi, Joycelys S. Harrison & Terry L. St. Clair, “Dispersion of
Single Wall Carbon Nanotubes by in Situ Polymerization Under
Sumio Lijima, “Helical Micronanotubules of Graphitic Carbon,”Letters to
Andreas Thees, Roland Lee, Pavel Nikolaev, Hongjie Dai, Pierre
Petit, Jerome Robert, Chunhui Xu, Young Hee Lee, Seong Gon Kim,
Milo S.P. Shaffer & Alan H. Windle, “Fabrication and Characteriza-
J. Sandler, M.S.P. Shaffer, T. Prasse, W. Bauschofer, K. Schulte, & A.H.
Windle, “Development of a Dispersion Process for Carbon
Nanotubes in an Epoxy Matrix and the Resulting Electrical Proper-
ties,” Polymer Communication, Elsevier Science Ltd., p. 5967-5971,
(Oct. 31, 1999).
Winne, “Aligned Single-Wall Carbon Nanotubes in Composites by
Zhijie Jia, Zhengyuon Wang, Cailu Xu, Ji Liang, Bingqiu Wei,
Dehai Wu, Shaowen Zhu, “Study on Poly(methyl methacrylate)/
Carbon Nanotube Composites,", Materials Science & Engineering,
Jinhua Fan, Meixiang Wan, Daoben Zhu, Baohe Chang, Zhenwei
Pan, & Shishen Xie, "Synthesis, Characteristics, and Physical Prop-
Yong K. Kim, A.F. Lewis, S.B. Warner, P.K. Patra, & P. Calvert,
“Field Emission from Nanotube Bundle Emitters at Low Fields,”
3308-3310, (Jun. 16, 1997).
E.T. Mickelson, W.L. Chang, J.L. Zimmerman, P.J. Boul, J. L Ozano,
J. Liu, R.E. Smalley, R.H. Hauge, & J.J. Magrave, “Solvation of
Xiaoji Gong, Jun Liu, Suresh Baskaran, Roger D. Voise, & James S.
Young, “Surfactant-Assisted Processing of Carbon Nanotube Poly-
mer Composites,” Chem Master, 2nd ed., American Chemical Society,
J.N. Coleman, S. Curran, A.B. Dalton, A.P. Davey, B. McCarthy, W.
Blau, & R.C. Barklie, “Percolation-Dominated Conductivity in a
Conjugated-Polymer-Carbon Nanotube Composite,” Rapid Com-
unications, The American Physical Society, p. 7492-7495, (May
19, 1998).
A.B. Kaiser, G. Dusberg, & S. Roth, “Heterogeneous Model for
Seamus A. Curran, Pulicket M. Ajayan, Werner J. Blau, David L.
Carroll, Johnathan N. Coleman, Alan B. Dalton, Andrew P. Davey,
Anna Drury, Brendan McCarthy, Stephane Mairer, & Adam Stevens,
“A Composite from Poly(phenylenevinylene-co-2,5-dioctoxy-p-
phenylenevinylene) and Carbon Nanotubes: A Novel Material for
$$\text{H}_2\text{N-Ar-H}_2\text{N} + \text{OAr'COO} + \text{CNT}$$

$\text{23}^\circ\text{C, N}_2$

Polar Aprotic Solvent

$$\left[ \text{HArHNAr'COOH} \right] + \text{CNT}$$

$\text{HOOCCOO}$

$\text{H}_2\text{O}$

$$\left[ \text{OArNAr'N} \right] + \text{CNT}$$

FIG. 1

$$\text{HOAr''OH} + \text{XAr'''X} + \text{CNT}$$

$\text{H}_2\text{O}$

Alkali metal base

inert atmosphere

Polar aprotic solvent

Heat

$$\left[ \text{OAr''OAr'''} \right] + \text{CNT}$$

FIG. 2
\[
\begin{align*}
\text{H}_2\text{N-} & \text{O} - \text{O} - \text{NH}_2 \\
& + \text{F}_3\text{C, CF}_3 \\
& + \text{SWNT} \\
& \quad \downarrow 23 \degree \text{C, } \text{N}_2 \\
& \quad \text{Polar aprotic solvent} \\
\end{align*}
\]

\[
\begin{align*}
\text{O} & \text{N} - \text{H} - \text{O} - \text{F}_3\text{C, CF}_3 \\
& + \text{SWNT} \\
& \quad \downarrow -\text{H}_2\text{O} \\
\text{O} & \text{N} - \text{F}_3\text{C, CF}_3 \\
& + \text{SWNT} \\
\end{align*}
\]

FIG. 3
H₂N-\(\text{O}^{-}\)-O-\(\text{NH}_2\) + \(\text{O}^{-}\)-O-\(\text{NH}_2\) + SWNT

23 °C, \(\text{N}_2\)
Polar aprotic solvent

[Diagram showing chemical reactions]

FIG. 4
$\text{H}_2\text{N} \xrightarrow[23^\circ C, N_2]{\text{Polar aprotic solvent}} \text{+ Laser ablated carbon nanotubes}$

$\text{FIG. 5}$
FIG. 6
FIG. 7
+ Chemical vapor deposition carbon nanotubes

23 °C, N₂
Polar aprotic solvent

-H₂O

+ Chemical vapor deposition carbon nanotubes

FIG. 9
H₂N

+ Chemical vapor deposition carbon nanotubes

23 °C, N₂
Polar aprotic solvent

-H₂O

+ Chemical vapor deposition carbon nanotubes

FIG. 10


\[
\text{FIG. 11}
\]
ELECTRICALLY CONDUCTIVE, OPTICALLY TRANSPARENT POLYMER/CARBON NANOTUBE COMPOSITES AND PROCESS FOR PREPARATION THEREOF

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a continuation of commonly-owned patent application Ser. No. 12/546,724, filed Aug. 25, 2009, which is a divisional of patent application Ser. No. 10/288,797, filed Nov. 1, 2002, now U.S. Pat. No. 7,588,699, which, pursuant to 35 U.S.C. §119, claimed the benefit of priority from provisional patent application having U.S. Ser. No. 60/336,109, filed on Nov. 2, 2001, the contents of which are incorporated herein in their entirety.

ORIGIN OF INVENTION

The invention described herein was jointly made by employees of the U.S. Government, contract employees and employees of the National Research Council, and may be manufactured and used by or for the government for governmental purposes without the payment of royalties thereon or therefor.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention is directed to methods of preparation that effectively disperse carbon nanotubes into polymer matrices, and the novel nanocomposites that result therefrom.

2. Description of the Related Art

Since carbon nanotubes (CNTs) were discovered in 1991 (S. Iijima, Nature 354 56, 1991), significant interest has been generated due to their intrinsic mechanical, electrical, and thermal properties (P. M. Ajayan, Chem. Rev. 99 1787, 1999). Early studies focused on CNT synthesis and theoretical prediction of physical properties. Due to the recent development of efficient CNT synthesis (A. Thess et al., Science 273 483, 1996) and purification procedures (A. G. Rinzler et al., Appl. Phys. A 67 29, 1998), some applications have been realized. However, these applications have relied on the use of pure CNTs, not nanocomposites. Examples include a carbon nanotube in scanning probe microscopy (S. S. Wong et al., J. Am. Chem. Soc. 120 605, 1998), single wall carbon nanotube (SWNT) transistor (S. J. Tans et al., Nature 395 49, 1998), and field emission display (Q. H. Wang et al., Appl. Phys. Lett. 70 3308, 1997). There have been very few reports on the development of nanocomposites using CNTs as reinforcing inclusions in a polymer matrix primarily because of the difficulty in dispersing the nanotubes. This difficulty is partially due to the non-reactive surface of the CNT. A number of studies have concentrated on the dispersion of CNTs, but complete dispersion of the CNTs in a polymer matrix has been elusive due to the intrinsically strong van der Waals attraction between adjacent tubes. In practice, attempts to disperse CNTs into a polymer matrix leads to incorporation of agglomerates and/or compositions of matter produced therefrom. The resulting CNTs have been used as conductive fillers in a polymeric matrix to enhance conductivity, however the resulting nanocomposites exhibited little or no transparency in the visible range (400-800 nm). Coleman et al. (Physical Review B, 58, R7492, 1998) and Curran et al., (Advanced Materials, 10, 1091, 1998) reported conjugated polymer-CNT composites using multi-wall CNTs, which showed that the percolation concentration of the CNTs exceeded 5 wt %. The resulting nanocomposites were black with no transparency in the visible region. Shaffer and Windle (Advanced Materials, 11, 937, 1999) reported conductivity of a multi-wall CNT/poly(vinyl alcohol) composite, which also showed percolation above 5 wt % nanotube loading and produced a black nanocomposite. The same group (J. Sandler, M. S. P. Shaffer, T. Prasse, W. Banholzer, K. Schulte, and A. H. Windle, Polymer 40, 5967, 1999) reported another multi-wall CNT composite with an epoxy, which achieved percolation below 0.04 wt %. An optical micrograph of the CNT/epoxy composite was reported, which revealed that the CNT phase was separated from the epoxy resin, showing several millimeters of resin-rich domains. The dispersion of CNTs in this material was very poor. This agglomeration of CNTs in selected areas in the composite could explain the high conductivity observed since it provides the “shortest path” for the current to travel. Preliminary measurements of the conductivity of a CNT/poly(methyl methacrylate) (PMMA) composite were measured on a fiber (R. Haggenmueller, H. H. Gommans, A. G. Rinzler, J. E. Fischer, and K. I. Winey, Chemical Physics Letters, 330, 219, 2000). The level of conductivity was relatively high (1.8x10^-5 S/cm) at 1.3 wt % SWNT loading. However, the optical transparency in the visible range was not determined for the fiber sample. The mechanical properties of these fibers were much less than the predicted value, which implies that the CNTs were not fully dispersed.

The present invention is directed to methods of preparation that overcome the shortcomings previously experienced with the dispersion of CNTs in polymer matrices and the novel compositions of matter produced therefrom. The resulting nanocomposites exhibit electrical conductivity, improved mechanical properties, and thermal stability with high retention of optical transparency in the visible range.

SUMMARY OF THE INVENTION

Based on what has been stated above, it is an objective of the present invention to effectively disperse CNTs into poly-
mer matrices. It is a further objective to prepare novel polymer/CNT nanocomposites and articles derived therefrom. Methods of preparation that were evaluated include: (1) low shear mixing of a polymer solution with CNTs dispersed in an organic solvent; (2) high shear mixing (e.g., homogenizer or fluidizer) of a polymer solution with CNTs dispersed in an organic solvent; (3) ultrasonic mixing (e.g., sonic horn at 20-30 kHz for 1-10 minutes) of a polymer solution with CNTs dispersed in an organic solvent; (4) high shear mixing (e.g., homogenizer, fluidizer, or high speed mechanical stirrer) of a polymer solution with CNTs dispersed in an organic solvent with subsequent ultrasonic mixing (e.g., sonic horn at 20-30 kHz for 1-10 minutes); (5) synthesis of the polymer in the presence of pre-dispersed CNTs; and (6) synthesis of the polymer in the presence of pre-dispersed CNTs with simultaneous sonoation (e.g., 40-60 kHz in a water bath) throughout the entire synthesis process. Methods (4), (5) and (6) are applicable to a variety of polymers that can be synthesized in a solvent in the presence of the CNTs.

The resulting polymer/CNT materials exhibit a unique combination of properties that make them useful in a variety of aerospace and terrestrial applications, primarily because of their combination of improved mechanical properties, thermal stability, electrical conductivity, and high optical transmission. Examples of space applications include thin film membranes on antennas, second-surface mirrors, thermal optical coatings, and multi-layer thermal insulation (MLI) blanket materials. For these applications, materials that do not build-up electrical charge are preferred. In addition to exhibiting electrical conductivity, some of these space applications also require that the materials have low solar absorptivity and high thermal emissivity. Terrestrial applications include electrically conductive coatings on a variety of substrates, electrostatic dissipative coatings on electromagnetic displays, coatings for use in luminescent diodes, antistatic fabrics, foams, fibers, threads, clothing, carpeting and other broad goods.

BRIEF DESCRIPTION OF THE FIGURES

FIG. 1 illustrates preparation of an aromatic poly(amide acid)/CNT and polyimide/CNT nanocomposite.

FIG. 2 illustrates preparation of an aromatic poly(arylene ether)/CNT nanocomposite.

FIG. 3 illustrates preparation of a 0.1% wt/wt CNT/polyimide nanocomposite from 1,3-bis(3-aminophenoxy) benzene (APB) and 4,4'-perfluorocispropyldiene dianhydride (6FDA).

FIG. 4 illustrates preparation of a 0.1% wt % SWNT/polyimide nanocomposite from 2,6-bis(3-aminophenoxy) benzonitrile [(p-CN)APB] and 3,3',4,4'-oxydipthalic dianhydride (ODPA).

FIG. 5 illustrates preparation of a 0.1% wt/wt LA-NT/polyimide nanocomposite from [2,4-bis(3-aminophenoxy)phenyl]diphenylphosphate oxide (APB-PPO) and ODPA.

FIG. 6 illustrates preparation of a 0.2% wt/wt LA-NT/polyimide nanocomposite from APB-PPO and ODPA.

FIG. 7 illustrates preparation of a 0.1% wt/wt CVD-NT-1/polyimide nanocomposite from APB-PPO and ODPA.

FIG. 8 illustrates preparation of a 0.2% wt/wt CVD-NT-1/polyimide nanocomposite from APB-PPO and ODPA.

FIG. 9 illustrates preparation of a 0.1% wt/wt CVD-NT-2/polyimide nanocomposite from APB-PPO and ODPA.

FIG. 10 illustrates preparation of a 0.2% wt/wt CVD-NT-2/polyimide nanocomposite from APB-PPO and ODPA.

FIG. 11 illustrates preparation of a 0.1% wt/wt LA-NT/poly(arylene ether)/SWNT nanocomposite.

DETAILED DESCRIPTION OF THE INVENTION

The present invention involves the preparation of polymer/CNT composites with a unique combination of properties. The methods of preparation effectively disperse the CNTs into polymer matrices and overcome shortcomings of previous efforts to effectively disperse CNTs into polymers. The methods were successful using both single wall carbon nanotubes (SWNTs) and multi-wall carbon nanotubes (MWNTs). Within the scope of the present invention, the term CNT(s) designates both SWNTs and MWNTs. The resulting nanocomposites exhibit a unique combination of properties, such as high retention of optical transparency in the visible range, electrical conductivity, high mechanical properties, and high thermal stability. Appropriate selection of the polymer matrix produces additional desirable properties such as vacuum ultraviolet radiation resistance, atomic oxygen resistance, high Tg, excellent flexibility and high toughness. Of particular significance is the ability to fabricate freestanding films as well as coatings that exhibit an excellent and extremely useful combination of good optical transparency, electrical conductivity, high mechanical properties, and thermal stability.

Condensation polymers, such as polyimides, poly(arylene ether)s and poly(amide acids) and aromatic copolymers such as copolyimides, copoly(arylene ether)s and copoly(amide acids) can be used to prepare nanocomposites containing well dispersed CNTs. The methods discussed herein effectively disperse CNTs in polymer matrices on a nanoscale level such that significant improvements in electrical conductivity could be achieved without significant darkening or reduction in optical transmission in the visible region of the resultant nanocomposite. The following methods of preparation of polymer/CNT nanocomposites were evaluated: 1) low shear mixing of a polymer solution with CNTs dispersed in an organic solvent; 2) high shear mixing (e.g., homogenizer, fluidizer, or high-speed mechanical stirrer) of a polymer solution with CNTs dispersed in an organic solvent; 3) ultrasonic mixing (e.g., sonic horn at 20-30 kHz for approximately 1-10 minutes) of a polymer solution with CNTs dispersed in an organic solvent; 4) high shear mixing (e.g., homogenizer, fluidizer, or high-speed mechanical stirrer) of a polymer solution with CNTs dispersed in an organic solvent with subsequent ultrasonic mixing (e.g., sonic horn at 20-30 kHz for approximately 1-10 minutes); 5) synthesis of the polymer in the presence of pre-dispersed CNTs; and 6) synthesis of the polymer in the presence of pre-dispersed CNTs with simultaneous sonoation (e.g., water bath operating at 40 kHz) throughout the entire synthesis process. The effects of these different methods of preparation on electrical conductivity and optical transmission were investigated.

Preparation of Carbon Nanotube Dispersion

Two different types of CNTs were dispersed. The CNTs differed in their method of preparation (either laser ablation (LA) or chemical vapor deposition (CVD)), as well as the average lengths and diameters of the tubes. The LA CNTs were single wall carbon nanotubes (SWNTs) and were obtained from Tubes@Rice as purified dispersions in toluene. The CVD CNTs were multi-wall carbon nanotubes (MWNTs) and were obtained from Nanolab, Inc. CNT dispersions were prepared by placing the CNTs into an organic solvent, preferably at concentrations of less than 1 weight percent (wt %). Although concentrations of less than 1 wt % are preferred, concentrations of up to 5% may be used for thin films less than approximately 5 µm thick) while still
achieving retention of optical transparency. The liquid to

disperse the CNTs was chosen based on its compatibility and

solvating characteristics with the monomers and polymer of

interest. Preferably, polar aprotic solvents were selected that

were also compatible with the polymers to be synthesized.

The CNT dispersion was mixed mechanically, as appropriate,

with a high-speed, high-shear instrument (e.g., homogenizer,

fluidizer, or high-speed mechanical stirrer) and was subse-

quently placed in a glass vessel and immersed in an ultrasonic

water bath operating at 40-60 kHz for several 1-10 hours to

achieve initial dispersion.

Selection of Polymers

Predominately aromatic and conjugated polymers are gen-

erally preferred for use in the preparation of polymer/CNT

nanocomposites for long-term aerospace applications owing
to their high-temperature resistance and high durabilities.

Representative aromatic polymers and copolymers, repre-
senting the poly(amide acid), polyimide and poly(arylene

ether) families, were selected based upon their solubility in

several polar aprotic solvents of choice and their ability to

be synthesized in the presence of the CNTs without any dele-
terious effects on molecular weight build-up as evidenced by

a noticeable increase in solution viscosity. In some cases, target

polymers with polar groups such as carbonyl, cyano, phos-

phine oxide, sulfone and others or conjugated polymers were

selected to provide additional compatibility with CNTs. In

some cases, polymers with very high optical transmission

(i.e., greater than approximately 85%) at 500 nm were selected
to demonstrate this approach. Particularly good results, with respect to degree of dispersion, were obtained with aromatic polymers containing polar groups.

Methods of Preparation of Composites

Several methods of preparing polymer/CNT composites

were evaluated and are described in detail below.

Method (1) (Low Shear Mixing)

Low shear mixing of a pre-synthesized high molecular

weight aromatic polymer solution with CNTs dispersed in an

organic solvent was conducted by preparing a polymer solu-

tion in a solvent and subsequently adding the CNT dispersion

(prepared as previously described). A mechanical stirrer was

used to mix the two components. This approach typically

resulted in poor mixing and poor dispersion. The CNTs sep-

arated from solution upon removal of the mechanical agitation.
The resulting film and/or coating were black in color and

evolved poor retention of optical transmission (i.e., less than

approximately 35% retention of optical transmission) at 500

nm. Optical microscopic examination of the nanocomposite

film showed the presence of agglomerates of CNT bundles

indicating poor dispersion.

Method (2) (High Shear Mixing)

High shear mixing (e.g., using homogenizer, fluidizer, or

high-speed mechanical stirrer) of a pre-synthesized high

molecular weight aromatic polymer solution with CNTs dis-

persed in an organic solvent was conducted by preparing a

polymer solution in a solvent and subsequently adding the

CNT dispersion (prepared as previously described). A flat

bottom generator equipped with a homogenizer operating at

about 7500 revolutions per minute (rpm) was used for

approximately 20 minutes to mix the two components. Experiments were undertaken to study the effect of homog-

enization time on level of dispersion. Longer homogenization
times (>1 hour) did not provide significant improvement in

mixing and dispersion as compared to shorter times (<1 hour).

This approach typically resulted in better mixing and dis-

persion as compared to Method (1), but the resulting nano-

composite films and/or coatings were black and exhibited

poor retention of optical transmission (i.e., less than approxi-
mately 35% retention of optical transmission) at 500 nm. Optical microscopic examination of the nanocomposite film

showed the presence of agglomerates of CNT bundles indi-
cating poor dispersion.

Method (3) (Ultrasonic Mixing With Sonic Horn)

Ultrasonic mixing of a pre-synthesized high molecular

weight aromatic polymer solution with CNTs dispersed in an

organic solvent was conducted by preparing a polymer solu-
tion in a solvent and subsequently adding the CNT dispersion

(prepared as previously described). A high power sonic horn
equipped with a 13 mm probe operating at 20 kHz was used to

mix the two components. Experiments were undertaken to

study the effect of ultrasonic treatment time on level of dis-

persion. Longer ultrasonic treatment times (>10 min.) did not

provide significant improvement in mixing and dispersion as

compared to shorter ultrasonic treatment times (<10 min.).

This high power ultrasonic treatment appeared to cause sig-
nificant damage to the polymer as evidenced by a noticeable
decrease in solution viscosity. This observation suggests that

chemical bond cleavage is occurring that subsequently leads
to a reduction in molecular weight. The possibility also exists

that this high power ultrasonic treatment may cause damage

(i.e., introduction of defect sites through carbon-carbon bond
cleavage) to the CNTs. Modification of the chemical structure

of CNTs is known to cause bulk property changes, thus this

method was deemed undesirable. Nanocomposite films and/
or coatings prepared from solutions that received relatively

short exposures (<10 min.) to the high power sonic horn
treatment exhibited improvements in electrical conductivity

of 10-12 orders of magnitude; however the nanocomposite

films and/or coatings exhibited moderate retention of optical

transparency (i.e., 35-50% retention of optical transmission)
in the visible range. Optical microscopic examination of the

nanocomposite film showed the presence of agglomerates of

CNT bundles indicating poor dispersion. Based on a qualita-
tive assessment, the nanocomposite film prepared via this

method exhibited marginally improved dispersion relative to

the nanocomposite films prepared via Methods (1) and (2).

Method (4) (High Shear and Ultrasonic Mixing Using Sonic Horn)

A combination of high shear mixing and ultrasonic treat-

ment was conducted by initially preparing an aromatic poly-

mer solution in a solvent and subsequently adding the CNT

dispersion (prepared as previously described). A homog-

genizer was subsequently used to mix the dispersion, followed

by ultrasonic treatment with a high power sonic horn operated

at 20 kHz. The times of each treatment were varied, but no

significant differences in dispersion were apparent. This com-

bination treatment generally gave better dispersion than one

single component mixing. Nanocomposite films and/or coat-
ings with 0.1 wt % CNT exhibited improvements in electrical

conductivity of 10-12 orders of magnitude compared to a pristine polymer film. However, the nanocomposite films

and/or coatings exhibited moderate retention of optical trans-
parency (i.e., 35-50% retention of optical transmission) at

500 nm. Optical microscopic examination of the nanocom-

posite film showed the presence of agglomerates of CNT

bundless, indicating poor dispersion. Based on a qualitative

assessment, the nanocomposite film prepared via this method

exhibited marginally improved dispersion relative to the

nanocomposite films prepared via Methods (1) and (2).

Method (5) (Synthesis of the Polymer in the Presence of Pre-Dispersed CNTs)

Synthesis of an aromatic polymer in the presence of the

CNTs was conducted by pre-dispersing the CNTs in the sol-

vent of interest and subsequently adding the monomers. In the
case of the poly(amide acid) and polyimides, the diamine
component was added first to the predispersed CNTs and allowed to be stirred until dissolved. The dianhydride component was subsequently added as a solid and the progression of the polymerization was readily observable by a significant build-up in solution viscosity. The re-aggregation among the CNTs are inhibited and/or minimized due to the high viscosity of the solution, which preserves the state of CNT dispersion during further required processing. The polymerization was allowed to proceed under conditions analogous to those generally used for the particular polymer type using a mechanical stirrer (i.e., under low shear). Nanocomposite films and/or coatings with 0.1 wt % CNT exhibited improvements in electrical conductivity of 10-12 orders of magnitude compared to a pristine polymer film and a high retention of optical transparency (greater than 50%) at 500 nm. Optical microscopic examination of the nanocomposite film showed the presence of CNT bundles and agglomerates of bundles. However, the bundles were of a smaller size than those observed in nanocomposite films prepared by Methods (1)-(4). Based on a qualitative assessment, the nanocomposite film prepared via this method exhibited significantly improved dispersion relative to the nanocomposite films prepared via Methods (1)-(4). Optionally, the solution obtained by Method (5) may be filtered to remove extraneous particles or large agglomerates of CNT bundles. Method (6) (Synthesis of the Polymer in the Presence of Pre-dispersed CNTs with Simultaneous Ultrasonic Treatment)

A combination method of preparation involving synthesis of the polymer in the presence of the CNTs while simultaneously applying ultrasonic treatment using a low power water bath operating at 40 kHz throughout the entire synthesis process was investigated. This method involved synthesis of the polymer in the presence of pre-dispersed CNTs as described in Method (5), but the reaction vessel was immersed in an ultrasonic bath throughout the entire synthesis. It should be noted that in contrast to Methods (3) and (4), which used a high power sonic horn operating at 20 kHz (100-750 Watt/cm²), the ultrasonic bath operates at a much lower level of power (less than 10 Watt/cm²) and at a higher frequency (40 kHz). Based on the observed increase in solution viscosity (indicating high molecular weight polymer formation) and microscopic analysis of the nanocomposite films, the use of the ultrasonic bath operating at 40 kHz did not cause any observable degradation of the CNTs, nor did it affect the formation of high molecular weight polymer. Nanocomposite films and/or coatings with 0.1 wt % CNT exhibited improvements in electrical conductivity of 10-12 orders of magnitude compared to a pristine polymer film and a high retention of optical transparency (i.e., greater than about 50%) at 500 nm. Optical microscopic examination of the nanocomposite film showed the presence of CNT bundles and agglomerates of bundles. However, the bundles were of a smaller size than those observed in nanocomposite films prepared by methods (1)-(4). Based on a qualitative assessment, the nanocomposite film prepared via this method exhibited significantly improved dispersion relative to the nanocomposite films prepared via Methods (1)-(4). Optionally, the solution obtained by Method (6) may be filtered to remove extraneous particles or large agglomerates of CNT bundles. Performing synthesis of the polymers [i.e., Methods (5) and (6)] in the presence of the CNTs provided significant improvement in the dispersion of the CNTs, provided the smallest decrease in optical transmission, provided an equal or better electrical conductivity compared to a pristine polymer film and provided a stable solution. Attempts to mix a pre-synthesized high molecular weight aromatic polymer solution with a CNT dispersion was unsuccessful in achieving good dispersion and high retention of optical transmission. Methods (5) and (6) are applicable to various condensation polymers such as poly(amide acid), polyamide and poly(arylene ether)/CNT nanocomposites as shown in FIGS. 1 and 2. FIG. 1 illustrates the preparation of polyimide and poly(amide acid)/CNT nanocomposites, wherein Ar and Ar′ can be any aromatic moiety. FIG. 2 illustrates the preparation of poly(arylene ether)/CNT composites, wherein Ar′ represents any aromatic moiety, X represents a leaving group such as a halogen, nitro or other suitable group and Ar″ represents any electron withdrawing group or ring system.

EXAMPLES

The following specific examples are provided for illustrative purposes and do not serve to limit the scope of the invention.

Example 1A

Preparation of 0.1 wt % CNT/polyimide nanocomposite from 1,3-bis(3-aminophenoxy)benzene (APB) and 4,4'-perfluorosulfonyldiizy hydroxide (6FDA) by Method (6)

FIG. 3 illustrates preparation of 0.1 wt % LA-NT/polyimide nanocomposite from APB and 6 FDA by Method (6). Purified SWNTs obtained from Tubes@Rice as a dispersion in toluene were used as the conductive inclusions. A dilute SWNT solution, typically approximately 0.01% weight/volume (w/v) in N,N-dimethylformamide (DMF), was prepared by replacing the toluene with DMF by centrifuging and decanting several (typically three) times. Pure CNT powders could also be used, eliminating the previous step. The dilute SWNT solution was homogenized for 10 min. and sonicated for 1 hr in a ultrasonic bath operating at 40 kHz. If a higher power sonic bath is used, sonication time can be reduced depending on the power. Sonication time should be also adjusted depending on the quality of CNTs. The sonicated SWNT solution (2 mL, 0.01 g of the solid SWNT) was transferred into a 100 mL three neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube outlet filled with calcium sulfate. The flask was immersed in the ultrasonic bath throughout the entire synthesis procedure. APB (3.9569 g, 1.35 3×10⁻² mol) and pyridine (3.2273 g, 1.36 3×10⁻² mol) to effect imidization. The resulting solution was cast onto plate glass and placed in a dry air box for 24 hours to give a tack-free film. The film was removed from the glass and characterized.
Example 1B

Film was prepared in a manner identical to that described for EXAMPLE 1A, except that the SWNT concentration in the polyimide was 0.2% by weight.

Example 1C

Film was prepared in a manner identical to that described for EXAMPLE 1A, except that the SWNT concentration in the polyimide was 0.3% by weight.

Example 1D

Film was prepared in a manner identical to that described for EXAMPLE 1A, except that the SWNT concentration in the polyimide was 1.0% by weight.

Example 1E

Film was prepared in a manner to that described for EXAMPLE 1D, except that Method (1) was employed instead of Method (6).

Example 2

Preparation of 0.1 wt % LA-NT/polyimide nanocomposite from 2,6-bis(3-aminophenoxy)benzonitrile ([β-CN]APB) and 3,3',4,4'-oxydipthalic dianhydride (ODPA) by Method (6).

FIG. 4 illustrates the preparation of 0.1 wt % LA-NT/polyimide nanocomposite from 2,6-bis(3-aminophenoxy)benzonitrile ([β-CN]APB) and ODPA by Method (6).

Purified SWNTs obtained from Tubes@Rice as a dispersion in toluene were used as the conductive inclusions. A dilute SWNT solution, generally about 0.01% w/v in N,N-dimethylacetamide (DMAc), was prepared by replacing the toluene with DMAc by centrifuging and decanting several (typically three) times. The dilute SWNT solution was homogenized for 10 min. and sonicated for 1 hour in an ultrasonic bath operating at 40 kHz. The SWNT solution (2 mL...0.01 g of the solid SWNT was transferred into a 100 mL three neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube outlet filled with calcium sulfate. The flask was immersed in the ultrasonic bath during the entire reaction. ([β-CN]APB, (5.0776 g, 1.60x10^-2 mol) was subsequently added to the flask along with 20 mL of DMAc while stirring under sonication. After approximately 30 min., ODPA (4.9635 g, 1.60x10^-2 mol) was added along with an additional 30.5 mL of DMAc. The dark mixture was stirred under sonication overnight, approximately 12 hours, to give a 0.1 wt % SWNT/poly(amide acid) solution. During the course of the reaction, a noticeable increase in solution viscosity was observed.

The concentration of the solid SWNT/poly(amide acid) was 16% (w/w) in DMAc. The SWNT/poly(amide acid) solution was treated with acetic anhydride (4.1983 g, 4.080x10^-2 mol) and pyridine (3227 g, 1.360x10^-2 mol) to effect imidization. The resulting solution was cast onto plate glass and placed in a dry air box for 24 hours to give a tack-free film. This film was thermally treated (to remove solvent) for 1 hour each at 50, 150, 200 and 240° C. in a nitrogen oven. The film was removed from the glass and characterized.

Example 3

Preparation of 0.1% wt/wt LA-NT/polyimide nanocomposite from [2,4-bis(3-aminophenoxy)phenyl]diphenylphosphine oxide (APB-PPO) and ODPA by Method (5).

FIG. 5 illustrates preparation of a 0.1% wt/wt LA-NT/polyimide nanocomposite APB-PPO and ODPA by Method (5).

A glass vial containing 0.060 g of nanotubes and 10 mL DMF was placed in an ultrasonic bath operating at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/SWNT mixture was added and the resulting mixture was stirred for 20 mins. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.1% wt/wt. The mixture was stirred overnight at room temperature under a nitrogen atmosphere. During the course of the reaction a noticeable increase in solution viscosity was observed. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight under a nitrogen atmosphere. The polyimide/nanomaterial mixture was precipitated in a blender containing deionized water, filtered, washed with excess water and dried in a vacuum oven at 150° C. overnight to afford a light gray, fibrous material. A solution prepared from DMF or chloroform (20% solids w/w) was cast onto plate glass and allowed to dry to a tack-free state in a dust-free chamber. The film on the glass plate was placed in a forced air oven for 1 hour each at 100, 150, 175 and 225° C. to remove solvent. The film was subsequently removed from the glass and characterized.

Example 4

Preparation of 0.2% wt/wt LA-NT/polyimide nanocomposite from APB-PPO and ODPA via Method (5).

FIG. 6 illustrates preparation of a 0.2% wt/wt LA-NT/polyimide nanocomposite from APB-PPO and ODPA via method (5).

A glass vial containing 0.0120 g of LA-NT nanotubes and 10 mL of DMF was placed in an ultrasonic bath operating at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/SWNT mixture was added and the resulting mixture was stirred for 20 mins. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.2% wt/wt. The mixture was stirred overnight at room temperature under a nitrogen atmosphere. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight, approximately 12 hours, under a nitrogen atmosphere. During the course of the reaction a noticeable increase in solution viscosity was observed. The polyimide/SWNT mix-
Example 5

Preparation of a 0.1% wt/wt CVD-NT-1/polyimide nanocomposite from APB-PPO and ODPA by Method (5).

A glass vial containing 0.0060 g of CVD-NT-1 nanotubes and 10 mL of DMF was placed in an ultrasonic bath at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three-neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/CNT mixture was added and the resulting mixture was stirred for 20 min. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.1% wt/wt. The mixture was stirred overnight at room temperature under a nitrogen atmosphere. During the course of the reaction, a noticeable increase in solution viscosity was observed. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight under a nitrogen atmosphere. The polyimide/CNT mixture was precipitated in a blender containing deionized water, filtered, washed with excess water and dried in a vacuum oven at 150°C. to afford a light gray, fibrous material. A solution prepared from DMF or chloroform (20% solids w/w) was cast onto plate glass and allowed to dry to a tack-free state in a dust-free chamber. The film on the glass plate was placed in a forced air oven for 1 hour each at 100, 150, 175 and 225°C. to remove solvent. The film was subsequently removed from the glass and characterized.

Example 6

Preparation of a 0.2% wt/wt CVD-NT-1/polyimide nanocomposite from APB-PPO and ODPA by Method (5).

A glass vial containing 0.0120 g of CVD-NT-1 nanotubes and 10 mL of DMF was placed in an ultrasonic bath operating at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three-neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/CNT mixture was added and the resulting mixture was stirred for 20 min. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.2% wt/wt. The mixture was stirred overnight at room temperature under a nitrogen atmosphere. During the course of the reaction, a noticeable increase in solution viscosity was observed. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight, approximately 12 hours, under a nitrogen atmosphere. The polyimide/CNT solution was precipitated in a blender containing deionized water, filtered, washed with excess water and dried in a vacuum oven at 150°C. to afford a light gray, fibrous material. A solution prepared from DMF or chloroform (20% solids w/w) was cast onto plate glass and allowed to dry to a tack-free state in a dust-free chamber. The film on the glass plate was placed in a forced air oven for 1 hour each at 100, 150, 175 and 225°C. to remove solvent. The film was subsequently removed from the glass and characterized.

Example 7

Preparation of a 0.1% wt/wt CVD-NT-2/polyimide nanocomposite from APB-PPO and ODPA by Method (5).

A glass vial containing 0.0060 g of CVD-NT-2 nanotubes and 10 mL of DMF was placed in an ultrasonic bath operating at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three-neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/CNT mixture was added and the resulting mixture was stirred for 20 minutes. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.1% wt/wt. The mixture was stirred overnight, approximately 12 hours, at room temperature under a nitrogen atmosphere. During the course of the reaction, a noticeable increase in solution viscosity was observed. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight under a nitrogen atmosphere. The polyimide/CNT solution was precipitated in a blender containing deionized water, filtered, washed with excess water and dried in a vacuum oven at 150°C. to afford a light gray, fibrous material. A solution prepared from DMF or chloroform (20% solids w/w) was cast onto plate glass and allowed to dry to a tack-free state in a dust-free chamber. The film on the glass plate was placed in a forced air oven for one hour each at 100, 150, 175 and 225°C. to remove solvent. The film was subsequently removed from the glass and characterized.

Example 8

Preparation of a 0.2% wt/wt CVD-NT-2/polyimide nanocomposite from APB-PPO and ODPA by Method (5).

A glass vial containing 0.0120 g of CVD-NT-2 nanotubes and 10 mL of DMF was placed in an ultrasonic bath operating at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three-neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/CNT mixture was added and the resulting mixture was stirred for 20 minutes. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.2% wt/wt. The mixture was stirred overnight at room temperature under a nitrogen atmosphere. During the course of the reaction, a noticeable increase in solution viscosity was observed. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight, approximately 12 hours, at room temperature under a nitrogen atmosphere. During the course of the reaction, a noticeable increase in solution viscosity was observed. The poly(amide acid) was chemically imidized by the addition of 2.31 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight under a nitrogen atmosphere. The polyimide/CNT solution was precipitated in a blender containing deionized water, filtered, washed with excess water and dried in a vacuum oven at 150°C. to afford a light gray, fibrous material. A solution prepared from DMF or chloroform (20% solids w/w) was cast onto plate glass and allowed to dry to a tack-free state in a dust-free chamber. The film on the glass plate was placed in a forced air oven for one hour each at 100, 150, 175 and 225°C. to remove solvent. The film was subsequently removed from the glass and characterized.
A glass vial containing 0.0120 g of CVD-NT-2 nanotubes and 10 mL of DMF was placed in an ultrasonic bath operating at 40 kHz for periods ranging from 16 to 24 hours. A 100 mL three-neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube filled with calcium sulfate was charged with APB-PPO (3.6776 g, 7.467x10^-3 mole) and DMF (5.0 mL). Once the diamine dissolved, the DMF/nanomaterial mixture was added and the resulting mixture was stirred for 20 min. ODPA (2.3164 g, 7.467x10^-3 mole) was added along with additional DMF (8.2 mL) to give a solution with a concentration of 20% (w/w) solids and a nanotube concentration of 0.2% wt/wt. The mixture was stirred overnight, approximately 12 hours, at room temperature under a nitrogen atmosphere. During the course of the reaction, a noticeable increase in solution viscosity was observed. The poly(amide) acid was chemically imidized by the addition of 231 g of acetic anhydride and 1.77 g of pyridine. The reaction mixture was stirred at room temperature overnight, approximately 12 hours, under a nitrogen atmosphere. The polyimide/CNT solution was precipitated in a blender containing deionized water, filtered, washed with excess water and dried in a vacuum oven at 150° C. overnight to afford a light gray, fibrous material. A solution prepared from DMF or chloroform (20% solids w/w) was cast onto plate glass and allowed to dry to a tack-free state in a dust-free environment. Then a gravimetric analysis (TGA) was performed on the SWNT/PMMA solution (2 mL, 0.01 g of the solid SWNT) was transferred into a 100 mL three neck round bottom flask equipped with a mechanical stirrer, nitrogen gas inlet, and drying tube outlet filled with calcium sulfate. The flask was immersed in the 80° C. ultrasonic bath throughout the entire synthesis procedure. MMA (10 g, xmol) was added into the flask along with 40 mL of DMF while stirring under sonication at 80° C. After 30 min of stirring the SWNT and MMA mixture, AIBN (0.04188 g) and 1-dodecanethiol (20 ml) were added with stirring under sonication as an initiator and a chain extender, respectively. The dark mixture was stirred in the sonic bath six hours to give a 0.1% by weight SWNT/PMMA solution. During the course of the reaction, a noticeable increase in solution viscosity was observed. The concentration of the SWNT/PMMA was 20% solids (w/w) in DMF. The SWNT/PMMA solution was precipitated in methanol with a high-speed mixer. The precipitates were filtered with an aspirator thoroughly with distilled water. A gray powder was collected and dried in an vacuum oven at 60° C. The dried powder was re-dissolved in DMF and cast onto plate glass and placed in a dry air box for 24 hours to give a tack-free film. This film was thermally treated (to remove solvent) for six hours in a vacuum oven at 60° C. The film was removed from the glass and characterized. The nanocomposite films (SWNT/PMMA) exhibited high relative retention of optical transmission at 500 nm (>50% at 0.1 wt % SWNT loading) while exhibiting improvements in electrical conductivities of 10-12 orders of magnitude compared to the pristine polymer film.

The above examples are provided for illustrative purposes. In addition to the specific condensation and addition polymers described herein, other addition and condensation polymers may be used, including polyamides, polycarbonates, vinyl polymers, polyethylene, polyacrylonitrile, poly(vinyl chloride), polystyrene, poly(vinyl acetal), polytetrafluoroethylene, polyisoprene, polyurethane, and poly(methyl methacrylate)/polystyrene copolymer.

Characterization

Differential scanning calorimetry (DSC) was conducted on a Shimadzu DSC-50 thermal analyzer. The glass transition temperature (Tg) was taken as the inflection point of the AT versus temperature curve at a heating rate of 10° C/min on thin film samples. UV/VIS spectra were obtained on thin films using a Perkin-Elmer Lambda 900 UV/VIS/NIR spectrophotometer. Thin-film tensile properties were determined according to ASTM D882 using four specimens per test condition. Thermogravimetric analysis (TGA) was performed on a Seiko Model 200/220 instrument on film samples at a heating rate of 2.5° C. min^-1 in air and/or nitrogen at a flow rate of 15 cm^3 min^-1. Conductivity measurements were performed according to ASTM D257 using a Keithley 8009 Resistivity Test Fixture and a Keithley 6517 Electrometer. Homogenization was carried out using PowerGen Model 35 or a PowerGen Model 700 homogenizer at speeds ranging from 5,000 to 30,000 rpm. Optionally a fluidizer, such as a M-10Y High Pressure Microfluidizer from MFI Corp. (Newton, Mass.) could be used. Solar absorptivities were measured on a Sinton Model LPSR-300 spectrorrefectometer with measurements taken between 250 to 2800 nm with a vapor deposited aluminum on Kaption® as a reflective reference. An Aztek Temp 2000A Infrared reflectometer was used to measure the thermal emissivity. Ultrasonication was carried out using an Ultrasonic 57x ultrasonicator water bath operating at 40 kHz or with a ultrasonic horn, (VCX-750, Sonics and Materials, Inc.)
The nanocomposite films were characterized for optical, electrical and thermal properties. CNTs were subjected to elemental analysis prior to use. The results are summarized in Table 1. Characterization of the nanocomposite films described in EXAMPLES 1A-1E are presented in Tables 2 and 3. All of these samples were prepared using LA purified SWNTs obtained from Tubes@Rice.

**TABLE 1**

<table>
<thead>
<tr>
<th>CNT</th>
<th>Carbon, %</th>
<th>Hydrogen, %</th>
<th>Iron, %</th>
<th>Nickel, %</th>
<th>Cobalt, %</th>
</tr>
</thead>
<tbody>
<tr>
<td>LA-NT</td>
<td>78.2</td>
<td>0.94</td>
<td>0.06</td>
<td>1.45</td>
<td>1.54</td>
</tr>
<tr>
<td>CVD-NT-1</td>
<td>96.0</td>
<td>&lt;0.05</td>
<td>1.0</td>
<td>0.002</td>
<td>&lt;0.001</td>
</tr>
<tr>
<td>CVD-NT-2</td>
<td>97.0</td>
<td>&lt;0.05</td>
<td>1.5</td>
<td>0.002</td>
<td>&lt;0.001</td>
</tr>
</tbody>
</table>

The polymer matrix was prepared from APB and 6FDA. The control film was of comparable thickness or thinner than that of the nanocomposite films. The data in Table 2 indicates that at SWNT weight loadings of 0.1 to 1.0%, the transmission at 500 nm as determined by UV/VIS spectroscopy indicated a relative retention from less than 1% up to 80%. The nanocomposite film prepared via Method (1) exhibited by far the lowest retention of optical transmission (less than 1%). The nanocomposite films prepared via Method (6) exhibited significantly higher relative retention of optical transmission at 500 nm ranging from 38-80% while exhibiting improvements in electrical conductivities of 10-12 orders of magnitude compared to the pristine polymer film. Of particular note is the nanocomposite film designated as EXAMPLE 1A, which contained 0.1 wt % SWNT and exhibited high retention of optical transmission (80%) while exhibiting a volume conductivity of $10^{-6}$ S/cm. When the amount of SWNT was increased five-fold (EXAMPLE 1C), the nanocomposite still exhibited a high retention of optical transmission and an increase in volume conductivity of 11 orders of magnitude compared to the control. The temperature of 3% weight loss as determined by dynamic TGA increased with increasing SWNT concentration (Table 3) suggesting that the incorporation of SWNTs did not have a significant effect on thermal stability as measured by this technique.

Thermal emissivity ($\varepsilon$) and solar absorptivity ($\alpha$) measurements are also shown in Table 3. In general, the addition of CNTs to the polyimide material increased both $\varepsilon$ and $\alpha$. Dynamic mechanical data shown in Table 4 show that modulus increased with increasing nanotube concentration, with up to a 60% improvement at 1.0 vol % SWNT loading level. The tan$\delta$ peak decreased and shifted up 10°C with SWNT incorporation at 1.0 vol % as seen in Table 4, which suggests that CNT reinforcement made the nanocomposite more elastic and thermally more stable by increasing the glass transition temperature.

Another series of 0.1 and 0.2 wt % nanocomposite films were prepared from the polyimide derived from APB-PPO and ODPA and three different types of CNTs. Method (5) was used for the preparation of the nanocomposite films described in EXAMPLES 3-9. The nanotubes differed in their method of preparation (either LA or CVD) as well as the average lengths and diameters of the tubes. In addition, LA-NT are single wall carbon nanotubes (SWNTs) and CVD-NT-1 and CVD-NT-2 are multi-wall carbon nanotubes (MWNTs). Table 5 lists the types, sources and approximate dimensions of the nanotubes used in the preparation of nanocomposite films described in EXAMPLES 3-8.

Table 6 lists physical properties of the nanocomposite films, such as $T_g$ and thin film mechanical properties. The $T_g$ ranged from 187 to 212°C. The films exhibited room temperature tensile strengths and moduli from 77 to 99 MPa and 2.8 to 3.3 GPa, respectively. The elongations at break ranged from 3.1 to 4.9%. These values are comparable to other aromatic polyimides. The polyimide/CNT nanocomposite films exhibited reductions in $T_g$ of 5-25°C, comparable tensile strengths (except for EXAMPLE 6), increased tensile moduli and comparable or slightly lower elongations to break.

**TABLE 2**

<table>
<thead>
<tr>
<th>Sample Film</th>
<th>SWNT Loading, Weight %</th>
<th>UV/VIS Transmission %</th>
<th>Optical Transmission Retention, %</th>
<th>Conductivity $\sigma_s$, S/cm</th>
</tr>
</thead>
<tbody>
<tr>
<td>APB/6FDA</td>
<td>0</td>
<td>85</td>
<td>60</td>
<td>$6.3 \times 10^{-8}$</td>
</tr>
<tr>
<td>EXAMPLE 1A</td>
<td>0.1</td>
<td>68</td>
<td>80</td>
<td>$1 \times 10^{-7}$</td>
</tr>
<tr>
<td>EXAMPLE 1B</td>
<td>0.2</td>
<td>62</td>
<td>66</td>
<td>$1 \times 10^{-7}$</td>
</tr>
<tr>
<td>EXAMPLE 1C</td>
<td>0.5</td>
<td>54</td>
<td>64</td>
<td>$2 \times 10^{-7}$</td>
</tr>
<tr>
<td>EXAMPLE 1D</td>
<td>1.0</td>
<td>32</td>
<td>38</td>
<td>$&gt;10^{-4}$</td>
</tr>
<tr>
<td>EXAMPLE 1E</td>
<td>1.0</td>
<td>&lt;1</td>
<td>&lt;1</td>
<td>$&gt;10^{-4}$</td>
</tr>
</tbody>
</table>

The films were prepared by Method (6) except for EXAMPLE 1E, which was prepared by Method (1). All films were prepared using LA purified SWNTs (LA-NT) from Tubes@Rice. UV/VIS transmission was normalized at 54 µm.

Imidized thin film samples were measured for optical transparency using UV/VIS spectroscopy. The results are presented in Table 7. The retention of optical transparency at 500 nm ranged from 52 to 89%. It is well known that for these polyimide films, the optical transmission is dependent upon film thickness such that increasing film thickness results in a decrease in optical transmission. As shown in Table 7, the films thicknesses of the nanocomposite films were comparable or slightly greater than that of the control. Thus it is reasonable to compare the results directly without normalization. "High", "moderate", and "poor" retention of optical transparency are defined herein to mean greater than 50%, 35% to 50%, and less than 35%, respectively.

**TABLE 3**

<table>
<thead>
<tr>
<th>Sample Film</th>
<th>SWNT Loading, Weight %</th>
<th>Temp. of 5% Weight Loss, °C.</th>
<th>Solar absorptivity ($\alpha$)</th>
<th>Thermal emissivity ($\varepsilon$)</th>
</tr>
</thead>
<tbody>
<tr>
<td>APB/6FDA</td>
<td>0</td>
<td>444</td>
<td>0.068</td>
<td>0.525</td>
</tr>
<tr>
<td>EXAMPLE 1A</td>
<td>0.1</td>
<td>461</td>
<td>0.268</td>
<td>0.578</td>
</tr>
<tr>
<td>EXAMPLE 1B</td>
<td>0.2</td>
<td>474</td>
<td>0.398</td>
<td>0.614</td>
</tr>
<tr>
<td>EXAMPLE 1C</td>
<td>0.5</td>
<td>481</td>
<td>0.362</td>
<td>0.620</td>
</tr>
<tr>
<td>EXAMPLE 1D</td>
<td>1.0</td>
<td>479</td>
<td>0.478</td>
<td>0.652</td>
</tr>
</tbody>
</table>

1By dynamic TGA at a heating rate of 2.5°C/min. in air after holding 30 min. at 100°C.  
2UV/VIS transmission was normalized at 54 µm.  
$\varepsilon$ (S/cm) × $\alpha$ (S/m) = Volume conductivity, $\varepsilon$ (S/cm) × $\alpha$ (S/m) = Surface conductivity.
TABLE 4

<table>
<thead>
<tr>
<th>Sample Film</th>
<th>Tan δ Max, °C</th>
<th>Storage Modulus (GPa)</th>
</tr>
</thead>
<tbody>
<tr>
<td>APB/6FDA</td>
<td>214</td>
<td>8.5 × 10^9</td>
</tr>
<tr>
<td>EXAMPLE 1A</td>
<td>213</td>
<td>9.2 × 10^9</td>
</tr>
<tr>
<td>EXAMPLE 1C</td>
<td>214</td>
<td>1.2 × 10^9</td>
</tr>
<tr>
<td>EXAMPLE 1D</td>
<td>224</td>
<td>1.4 × 10^9</td>
</tr>
</tbody>
</table>

Dynamic Mechanical Data

Thermal emissivity (ε) and solar absorptivity (α) measurements are shown in Table 8. In general, the addition of CNTs to the polyimide material increased both ε and α. The solar absorptivity increased depending upon CNT type, for example the samples with the laser ablated nanotubes (SWNTs, EXAMPLES 3 and 4) exhibited the lowest increase while the chemical vapor deposited nanotubes (MWNTs, EXAMPLES 5 and 6) exhibited the largest increase.

TABLE 5

<table>
<thead>
<tr>
<th>Nanombe ID</th>
<th>Production Method</th>
<th>Average Diameter, nm</th>
<th>Average Length, µm</th>
</tr>
</thead>
<tbody>
<tr>
<td>LA-NT</td>
<td>Laser ablation</td>
<td>1.2-1.6</td>
<td>~3</td>
</tr>
<tr>
<td>CVD-NT-1</td>
<td>CVD</td>
<td>~20</td>
<td>~1</td>
</tr>
<tr>
<td>CVD-NT-2</td>
<td>CVD</td>
<td>10-20</td>
<td>~20</td>
</tr>
</tbody>
</table>

Nanombe Designations, Source and Approximate Dimensions

TABLE 6

<table>
<thead>
<tr>
<th>Sample Film, (CNT conc., wt %)</th>
<th>Tg, °C</th>
<th>Tensile Mod., MPa</th>
<th>Tensile Mod., GPa</th>
<th>Elong., @ Break, %</th>
</tr>
</thead>
<tbody>
<tr>
<td>APB-PPO/ODPA (0.0)</td>
<td>212</td>
<td>97</td>
<td>2.8</td>
<td>4.7</td>
</tr>
<tr>
<td>EXAMPLE 3 (0.1)</td>
<td>187</td>
<td>88</td>
<td>3.2</td>
<td>3.5</td>
</tr>
<tr>
<td>EXAMPLE 5 (0.1)</td>
<td>205</td>
<td>99</td>
<td>3.3</td>
<td>4.2</td>
</tr>
<tr>
<td>EXAMPLE 7 (0.1)</td>
<td>206</td>
<td>90</td>
<td>3.1</td>
<td>4.0</td>
</tr>
<tr>
<td>EXAMPLE 4 (0.2)</td>
<td>200</td>
<td>94</td>
<td>3.2</td>
<td>4.9</td>
</tr>
<tr>
<td>EXAMPLE 6 (0.2)</td>
<td>207</td>
<td>77</td>
<td>3.0</td>
<td>3.1</td>
</tr>
<tr>
<td>EXAMPLE 8 (0.2)</td>
<td>199</td>
<td>-</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

Thin Film Tensile Properties at Room Temperature

As mentioned above for optical transmission, α and ε are also dependent upon film thickness. As shown in Table 8, the nanocomposite film thicknesses were comparable or slightly greater than that of the control. Thus it is reasonable to compare the results directly without normalization. For some space applications, the increase in solar absorptivity exhibited by EXAMPLES 3 and 4 would not be detrimental. All samples exhibited increases in thermal emissivity which for many space applications is desirable. The term "optically transparent" is defined herein to mean the relative retention of greater than 50% of optical transparency (relative to a control film of comparable thickness) as measured by UV/Vis spectroscopy at a wavelength of 500 nm. The term "electrically conductive" is defined herein to mean exhibiting a surface conductivity ranging from less than 10^-5 S/cm to 10^-12 S/cm.

As mentioned above for optical transmission, α and ε are also dependent upon film thickness. As shown in Table 8, the nanocomposite film thicknesses were comparable or slightly greater than that of the control. Thus it is reasonable to compare the results directly without normalization. For some space applications, the increase in solar absorptivity exhibited by EXAMPLES 3 and 4 would not be detrimental. All samples exhibited increases in thermal emissivity which for many space applications is desirable. The term "optically transparent" is defined herein to mean the relative retention of greater than 50% of optical transparency (relative to a control film of comparable thickness) as measured by UV/Vis spectroscopy at a wavelength of 500 nm. The term "electrically conductive" is defined herein to mean exhibiting a surface conductivity ranging from less than 10^-5 S/cm to 10^-12 S/cm.

Although the present invention has been described in detail, it should be understood that various changes, substitutions, and alterations may be readily ascertained by those skilled in the art and may be made herein without departing from the spirit and scope of the present invention as defined by the following claims.

The invention claimed is:

1. A method for producing a polymer/carbon nanotube nanocomposite containing a dispersion of nanotubes in a continuous polymer matrix, comprising synthesis of a polymer in the presence of pre-dispersed non-functionalized nanotubes with simultaneous sonication throughout the synthesis.

2. The method of claim 1, wherein the nanocomposite is electrically conductive and optically transparent.

3. The method of claim 1, wherein the polymer is selected from the group consisting of polyimide, copolyimide, poly(arylene ether), copoly(arylene ether), poly(amide acid), copoly(amide acid), poly(vinyl polymer) and poly(methyl methacrylate).

4. A method for preparing a polymer/carbon nanotube nanocomposite, comprising:

(a) placing non-functionalized carbon nanotubes into an organic solvent at a concentration ranging from approximately 0.01% to approximately 1.0% weight per volume, forming a nanotube suspension;

(b) treating the nanotube suspension with an ultrasonic bath for a period of time sufficient to disperse the nanotubes in the solvent;

(c) placing at least one first monomer into a reaction vessel;

(d) adding the treated nanotube suspension to the reaction vessel;

(e) stirring sufficiently to form a first homogeneous suspension;

(f) adding at least one second monomer to the reaction vessel;
(g) stirring sufficiently to form a second homogeneous suspension;
(h) achieving condensation of the polymer; and
(i) isolating the nanocomposite by removal of the solvent;
wherein the nanocomposite is electrically conductive and optically transparent, and wherein steps (a) through (h) occur under simultaneous sonication.

5. The method of claim 4, wherein the polymer is a copolymer.

6. The method of claim 4, wherein the step (h) condensation is achieved thermally.

7. The method of claim 4, wherein the step (h) condensation is achieved chemically.

8. The method of claim 4, comprising the further step of heating between step (g) and step (h).

9. The method of claim 4, wherein step (b) further comprises treating with a homogenizer.

10. The method of claim 4, comprising the further step of filtering between step (b) and step (i).

11. The method of claim 4, wherein the polymer is selected from the group consisting of polyimide, copolyimide, poly(arylene ether), copoly(arylene ether), poly(amide acid), and copoly(amide acid).

12. A method for preparing a polymer/carbon nanotube nanocomposite, comprising:
(a) placing non-functionalized carbon nanotubes into an organic solvent at a concentration ranging from approximately 0.01% to approximately 1.0% weight per volume, forming a nanotube suspension;
(b) treating the nanotube suspension with an ultrasonic bath for a period of time sufficient to disperse the nanotubes in the solvent;
(c) placing at least one first monomer into a reaction vessel;
(d) adding the treated nanotube suspension to the reaction vessel;
(e) stirring sufficiently to form a first homogeneous suspension;
(f) adding at least one second monomer to the reaction vessel;
(g) stirring sufficiently to form a second homogeneous suspension;
(h) achieving condensation of the polymer; and
(i) isolating the nanocomposite by removal of the solvent;
wherein the nanocomposite is electrically conductive and optically transparent, and wherein steps (a) through (h) occur under simultaneous sonication.

13. The method of claim 12, wherein the polymer is a copolymer.

14. The method of claim 12, comprising the further step of filtering between step (h) and step (i).

15. The method of claim 12, comprising the further step of heating between step (g) and step (h).

16. The method of claim 12, wherein step (b) further comprises treating with a homogenizer.

17. The method of claim 12, comprising the further step of heating between step (g) and step (h).

18. The method of claim 12, wherein the polymer is selected from the group consisting of polyimide, copolyimide, poly(arylene ether), copoly(arylene ether), poly(amide acid), and copoly(amide acid).

19. A method for preparing a polymer/carbon nanotube nanocomposite, comprising:
(a) placing non-functionalized carbon nanotubes into an organic solvent at a concentration ranging from approximately 0.01% to approximately 1.0% weight per volume, forming a nanotube suspension;
(b) treating the nanotube suspension with an ultrasonic bath for a period of time sufficient to disperse the nanotubes in the solvent;
(c) placing at least one monomer into a reaction vessel;
(d) adding the treated nanotube suspension to the reaction vessel;
(e) stirring sufficiently to form a first homogeneous suspension;
(f) adding at least one second monomer to the reaction vessel;
(g) stirring sufficiently to form a second homogeneous suspension;
(h) achieving condensation of the polymer; and
(i) isolating the nanocomposite by removal of the solvent;
wherein the nanocomposite is electrically conductive and optically transparent, and wherein steps (a) through (h) occur under simultaneous sonication.

20. A method for preparing an electrically conductive and optically transparent a polymer/carbon nanotube nanocomposite, comprising:
(a) placing non-functionalized carbon nanotubes into an organic solvent at a concentration ranging from approximately 0.01% to approximately 1.0% weight per volume, forming a nanotube suspension;
(b) treating the nanotube suspension with an ultrasonic bath for a period of time sufficient to disperse the nanotubes in the solvent;
(c) placing at least one monomer into a reaction vessel;
(d) adding the treated nanotube suspension to the reaction vessel;
(e) stirring sufficiently to form a first homogeneous suspension;
(f) adding an initiator;
(g) stirring sufficiently to form a second homogeneous suspension; and
(h) achieving a polymer by addition polymerization; wherein steps (a) through (h) occur under simultaneous sonication.

* * * * *