Semi-Aromatic Polyesters Based on a Carbohydrate-Derived Rigid Diol for Engineering Plastics

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New carbohydrate-based polyesters were prepared from isoidide-2,5-dimethanol (extended isoidide, XII) through melt polymerization with dimethyl esters of terephthalic acid (TA) and furan-2,5-dicarboxylic acid (FDCA), yielding semi-crystalline pre-polymers. Subsequent solid-state post-condensation (SSPC) gave high molecular weight ($M_n = 30$ kg mol$^{-1}$ for FDCA) materials, the first examples of high $M_n$ semi-aromatic homopolymers containing isohexide derivatives obtained via industrially relevant procedures. NMR spectroscopy showed that the stereo-configuration of XII was preserved under the applied conditions. The polyesters are thermally stable up to 380 °C. The TA- and FDCA-based polyesters have high $T_g$ (105 °C and 94 °C, resp.) and $T_m$ (284 °C and 250 °C, resp.) values. Its reactivity, stability, and ability to afford high $T_g$ and $T_m$ polyesters make XII a promising diol for the synthesis of engineering polymers.

Synthetic semi-aromatic polyesters such as poly(ethylene terephthalate) (PET) and poly(butylene terephthalate) (PBT) are widely applied engineering thermoplastics that have high heat distortion temperatures, good mechanical properties, and excellent chemical resistance and electrical insulation properties.[1] In particular, the combination of a relatively high glass transition temperature ($T_g$) and a high melting temperature ($T_m$) facilitates that these engineering plastics maintain their shape and strength at elevated temperatures, which renders them useful in a wide range of automotive, electronics, and packaging applications.

In recent years, concerns regarding fossil feedstock availability and related price increases have sparked research efforts into alternatives for petrochemicals.

Carbohydrates are increasingly investigated as a renewable source of raw materials for the production of chemicals, adding value to agricultural products and residues. However, most currently available biobased monomers are aliphatic, flexible molecules. In addition, the synthesis of high-molecular-weight polymers through step-growth polymerization requires monomers with high purity and is typically performed at high temperatures, while many biobased monomers lack the required thermal stability. As a result, the preparation of high-molecular-weight, semi-crystalline polymers with both high $T_g$ and high $T_m$ from renewable resources remains challenging. Still, some biobased monomers seem suitable to replace conventional monomers while obtaining comparable polymer properties. For example, carbohydrate-derived furan-2,5-dicarboxylic acid (FDCA) is a rigid monomer that is advocated as an alternative for the petrochemical-based terephthalic acid (TA).[2] Potentially, new polymers based on FDCA, such as poly(ethylene furanoate) (PEF), could provide the desired performance.[3] Alternatively, biobased monomers can be introduced into existing petrochemical-derived polyesters to improve their properties. For such an approach, isohexides or 1,4,3,6-dianhydrohexitols are of interest. Isohexides are a group of rigid secondary diols derived from C$_6$-sugar alcohols, and are found in three major isomeric forms: isosorbide (1,4,3,6-dianhydro-d-

![Figure 1. Three isomeric isohexides.](image)

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ondary hydroxyl groups is a major drawback, resulting in relatively low molecular weights ($M_n = 2000–5000 \, \text{g mol}^{-1}$) and discolored products after melt polycondensation at high temperatures (> 230 °C). In addition, the asymmetrical isosorbide is known to significantly reduce the crystallinity and melting temperatures of terephthalate-based polyesters due to stereo-irregularity. Hence, there is a need for a more reactive, and more thermally stable, rigid biobased symmetrical primary diol, which allows for milder melt polymerization conditions and which would yield semi-crystalline polymers, facilitating the subsequent application of solid-state post-condensation (SSPC, a synthetic method in which a semi-crystalline polymer is allowed to polymerize at a temperature just below its $T_m$ but well above its $T_g$, leading to condensation reactions taking place exclusively in the mobile amorphous phase). Recently, bicyclic acetalized C$_8$ alditols and methyl aldarates were studied as rigid, biobased monomers for polyester synthesis. Although most of these (co-)polymers are semi-crystalline materials, their melting temperatures are typically lower than those of for example, PET and PBT.

Previously, we reported the development of a new family of 1-carbon-extended isohexides, and their application in the synthesis of various aliphatic polyesters, which would yield semi-crystalline polymers with higher molecular weights and semi-crystalline properties. This prompted us to investigate the potential of XII as rigid biobased diol in industrially-relevant semi-aromatic polyesters. The focus of this study is to evaluate the effect of XII incorporation on polyester synthesis (reactivity, molecular weight build-up, color formation, polydispersity) and polymer properties ($T_g$, crystallinity, $T_m$, thermal stability). The development of more efficient, environmentally benign and industrially viable methods to produce XII are beyond the scope of the present study.

Hence, herein we describe the synthesis and molecular characterization of new XII-based, semi-aromatic polyesters. The thermal properties of these polyesters are discussed and compared to those of relevant reference polyesters.

Due to the relatively low reactivity of the isohexides, the few reported high-molecular-weight isohexide-based, semi-aromatic polyesters are almost exclusively prepared by solution polymerization with acid chlorides. Our aim was to investigate the feasibility of synthesizing XII-based, semi-aromatic polyesters by more industrially relevant methods, that is, melt polymerization and SSPC. The aromatic monomers included in this study are the dimethyl esters of terephthalic acid (TPA) and furan-2,5-dicarboxylic acid (FDCA).

Poly(isosorbide-2,5-bismethylene terephthalate) (PXIIT) and poly(isosorbide-2,5-bismethylene furan-2,5-dicarboxylate) (PXIIF) pre-polymers were synthesized by melt polymerization (MP). The prepolymers were synthesized by melt polymerization at 180 °C for about 1 h. The PXIIT and PXIIF prepolymers were white solids with moderate number-average molecular weights ($M_n = 2300 \, \text{g mol}^{-1}$ and 6900 g mol$^{-1}$, respectively). Still, compared to similar polymerizations of isosorbide with TPA and FDCA, the molecular weight values of XII-based polyesters after the rather short melt polymerization time of 1 h are remarkable and indicate that XII is significantly more reactive than the parent isohexides. Furthermore, the PXIIT and PXIIF prepolymers showed rather high melting temperatures (approx. 278–282 °C and 246–250 °C respectively, as determined by melting point testing), which confirms the crystallizability of these polyesters, allowing for post-condensation in the solid state between $T_g$ and $T_m$. The case of PXIIF, increasing the polymerization temperature to 260 °C to maintain a polymer melt causes discoloration and thermal degradation of the prepolymers, evidenced by an increase of the polydispersity ($M_w = 13 \, 400 \, \text{g mol}^{-1}$, PDI = 2.9). Therefore, to obtain PXIIT and PXIIF with high molecular weights, narrow molecular weight distributions, and limited discoloration, SSPC was applied to the prepolymers.

SSPC of PXIIT was performed at two temperatures: 200 and 240 °C. As shown in Figure 2 A, the polymerization temperature strongly influences the SSPC reaction rate: after 23 h at 200 °C a product with an $M_n$ of 4700 g mol$^{-1}$ is obtained. When SSPC
was performed at 240 °C, a comparable molecular weight ($M_n = -5000 \text{ g mol}^{-1}$) was obtained after only 0.5 h. After 5 h at 240 °C, PXIIIF was obtained as a white to slightly greyish material with $M_n = 7700 \text{ g mol}^{-1}$ (HFIP-SEC). Higher SSPC temperatures (>250 °C) or prolonged reaction times (>5 h) resulted in the formation of insoluble products, indicative of cross-linking.

The melting point of the PXIIIF prepolymer was observed at 15 °C, PXIIT was obtained as a white to slightly greyish material with a PDI value of 2.0. When the SSPC reaction was performed at 200 °C, more than 24 h (1440 min) was required to attain an $M_n$ of over 21 000 g mol$^{-1}$. Color formation was limited during SSPC, affording slightly greyish, high-molecular-weight polyesters.

The molecular structures of the polyesters were analyzed by 1D and 2D nuclear magnetic resonance (NMR) spectroscopy, as representatives shown in Figure 3 by the 2D $^1$H–$^1$H COSY spectrum of PXIIIF. The bridge proton $a$ appears as a singlet at 4.8 ppm. The absence of dihedral coupling with the neighboring proton $b$ is indicative of an exo–exo configuration of the incorporated XII units, as is also the case in the XII monomer prior to polymerization. Apparently, the isoidide structure is retained under the applied reaction conditions. More details concerning the NMR spectra of these polyesters can be found in the Supporting Information.

Table 1. Molecular and thermal properties of XII-based polyesters.

<table>
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<tr>
<th>Sample</th>
<th>Molecular weight distributions$^a$</th>
<th>Thermal properties$^b$</th>
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<tbody>
<tr>
<td></td>
<td>$M_n$ ($\text{g mol}^{-1}$)</td>
<td>$M_w$ ($\text{g mol}^{-1}$)</td>
</tr>
<tr>
<td>PKIXII</td>
<td>2300</td>
<td>3900</td>
</tr>
<tr>
<td>PXIIIF</td>
<td>6900</td>
<td>15 200</td>
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</tbody>
</table>

[a] $M_n$: number-average molecular weight, $M_w$: weight-average molecular weight, PDI: polydispersity index. Determined by HFIP-SEC against PMMA standards. [b] Measured for samples as prepared after SSPC. $T_m$: temperature at 5% weight loss, $T_g$: temperature at maximum rate of decomposition, $T_d$: glass transition temperature, $T_k$: melting temperature, $T_x$: crystallization temperature, $\Delta H$: enthalpy of transition. DSC data derived from the second heating and cooling runs performed at a heating/cooling rate of 10 °C min$^{-1}$. [c] Measured after dissolution/precipitation from TFA + CHCl$_3$/MeOH. [d] Measured for samples as prepared after SSPC. [e] $T_g$ obtained by rapid quenching of the polymer melt at a cooling rate of 100 °C min$^{-1}$.

Figure 2. Plots of the $M_n$ and PDI values vs. SSPC time: a) SSPC of PXIIIT at 200 and 240 °C; b) SSPC of PXIIIF at 200 and 230 °C. Note: trend lines are drawn to guide the eye only.

The thermal stability of the polyesters was investigated by thermogravimetric analysis (TGA) under N$_2$ atmosphere. The 5% weight loss temperatures were observed at approximately 380 °C for the two XII-based polyesters (Table 1 and Figure S2 in the Supporting Information), which are comparable to those of PET (degradation temperature $T_d = 407$ °C), PBT ($T_d = 384$ °C) and PEF ($T_d = 389$ °C).[13] Differential scanning calorimetry (DSC) performed on materials obtained by SSPC confirms that PXIIIT and PXIIIF are semicrystalline materials, with melting endotherms at 284 and 250 °C, respectively (Supporting Information, Figures S3 and S4). Wide-angle X-ray diffractograms (Figure 4) of these samples corroborate the DSC data, showing sharp crystalline diffraction signals for both XII-based polyesters (samples obtained after SSPC without further work-up). The estimated degrees of crystallinity of PXIIIT and PXIIIF, determined through peak deconvolution of the WAXD diffractograms (Figure 5), are 66 and 42%, respectively.

The $T_g$ values of PXIIIT and PXIIIF are 105 and 94 °C, respectively. Given the relatively low molecular weight ($M_n = 7700 \text{ g mol}^{-1}$) of PXIIIT, it is probable that the ultimate value of the $T_g$ of this polymer is even higher for high-molecular-weight samples. In addition to the observed melting transitions, PXIIIT and PXIIIF show pronounced crystallization exotherms during the DSC cooling runs (Figure S4). The crystallization tempera-
The melting and glass transition temperatures of PXIIT and PXIIF are plotted together with those of high-molecular-weight terephthalate- and furanoate-based reference polyesters PET, PEF, PBT, poly(butylene furanoate) (PBF), poly(1,6-hexene terephthalate) (PHT), poly(1,6-hexene furanoate) (PHF), poly(1,4-cyclohexylene dimethylene terephthalate) (PCT, commercial grade of 70% trans- and 30% cis-1,4-cyclohexylene units), and poly(2,4,3,5-di-O-methylene-α-glucitol terephthalate) (PGT). The XII-based polyesters show higher Tm and Tg values than all the reference polymers, except PGT. The Tm of PXIIT (292 °C) even exceeds that of PCT (287 °C), while the Tm of PXIIF is similar to that of PET. The Tg values of both XII-based polyesters are higher than those of PET and PBT, and are comparable to that of PCT. Compared to the terephthalate (PHT) and furanoate (PHF) polyesters based on 1,6-hexanediol, their XII-based counterparts show significantly higher Tm and Tg values although the distance between the ester linkages in the diol residues is six carbon atoms in all cases, demonstrating the rigidity of the bicyclic XII structure. Polyterephthalates based on the parent isohexides IS and II have Tg values that exceed 150 °C.

Poly(isosorbide terephthalate) and poly(isoidide terephthalate) do crystallize from solution (Tm = 260 °C) but not from the melt. As mentioned previously, increasing the molecular weights of such polymers to high values is difficult due to the limited reactivity of these secondary diols. The aforementioned alditol-based terephthalates generally also have higher Tg values than the XII-based polyesters, but are mostly amorphous, with one notable exception: poly(2,4,3,5-di-O-methylene-α-glucitol terephthalate) (PGT, included in Figure 6) was reported to have a Tg of 154 °C in combination with a high Tm of 272 °C, although this polymer did not crystallize from the melt.
To conclude, we have shown that 1-carbon extension of the biobased rigid diol isoxide results in higher reactivity during polymerization (resulting in higher molecular weights) and higher selectivity (better color, low PDI values). As a result, XII can be directly incorporated into high-molecular-weight semi-aromatic polyesters via melt polymerization. The resulting homopolyesters have excellent color, display semi-crystalline behavior, and crystallization from the melt. This feature was subsequently used to further increase the molecular weights of the new polyesters by means of solid-state post-condensation (SSPC). This is the first successful application of this common industrial procedure for isohexide-based semi-aromatic polyesters. The \( T_g \) values of the polymers obtained after SSPC are in line with those of commercial benchmarks such as PET, PEF and PCT. Hence, XII can be considered as a biobased alternative to the petrochemical cyclohexanedinemethanol (CHDM). Additionally, the novel and fully biobased polyester PXIIIF shows highly interesting properties, and can be prepared in high molecular weight by common industrial methods.

**Experimental Section**

**Melt polymerization:** This procedure is representative for poly(isoide-dide-2,5-dimethylene terephthalate) and poly(isoide-2,5-dimethy- lene furan-2,5-dicarboxylate) (PXIIIT and PXIIIF): XII (0.26 g, 1.5 mmol), which was prepared from isomannide (Sigma–Aldrich, 95%, purified by recrystallization from ethanol to achieve a final purity of 99.5 ± %), and dimethyl-2,5-furandicarboxylate (0.18 g, 1.0 mmol) were charged into a 10 mL round bottom flask located inside a Kugelrohr oven. The apparatus was flushed with nitrogen to remove oxygen, and then internally heated to 150 °C and rotated at a speed of 20 rpm until a clear, homogeneous melt was obtained after 5–10 min. Next, 0.01 mmol of dibutyltin(IV) oxide was added into the flask and the pre-polymerization was continued at a rotation speed of 20 rpm under \( N_2 \) atmosphere. The polymerization temperature was then increased in a stepwise fashion from 150 to 180 °C in 30 min. After about 1 h polymerization at 180 °C, the formed polyester started to crystallize as a white solid. After cooling down to room temperature, the resulting polymer was dissolved in TFA/CHCl\(_3\) (v/v = 1:4) and precipitated into methanol giving a white suspension. The precipitate was collected by filtration and further dried in vacuo. The product was ground to a powder and subsequently subjected to solid-state post-condensation between its \( T_g \) and \( T_m \) (vide infra) to further increase the molecular weight.

**Solid-state post-condensation (SSPC):** SSPC of the PXIIIT and PXIIIF prepolymers was carried out in a glass tube reactor (2.5 cm diameter) equipped with a sintered glass plate at the bottom on which the polyester powder was deposited. Below this glass plate the SSPC reactor was fitted with an inert gas inlet through which preheated \( N_2 \) gas was introduced. The SSPC reactor was immersed into a salt bath preheated to the desired temperature (200–240 °C, see Supporting Information, Table S1). The reactor was heated using a salt mixture of KNO\(_3\) (53 wt%), NaNO\(_2\) (40 wt%), NaNO\(_3\) (7 wt%). SSPC was carried out in \( N_2 \) atmosphere at a gas flow rate of 2.5 L min\(^{-1}\). More extensive experimental information, including materials, monomer synthesis, and characterization, is provided in the Supporting Information.

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