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A novel hydrophobic carborane-hybrid microporous material for reversed C₂H₆ adsorption and efficient C₂H₄/C₂H₆ separation under humid conditions†

Lingyao Wang,^{‡a} Shuangshuang Wu,^{‡a} Jianbo Hu,^{‡b} Yunjia Jiang,^a Jiahao Li,^a Yongqi Hu,^a Yan Han,^a Teng Ben,^{©c} Banglin Chen^{©ad} and Yuanbin Zhang^{©*a}

Since ethylene (C₂H₄) is important feedstock in the chemical industry, developing economical and energy-efficient adsorption separation techniques based on ethane (C₂H₆)-selective adsorbents to replace the energy-intensive cryogenic distillation is highly demanded, which however remains a daunting challenge. While previous anionic boron cluster hybrid microporous materials display C₂H₄-selective features, we herein reported that the incorporation of a neutral *para*-carborane backbone and aliphatic 1,4-diazabicyclo[2.2.2]octane (DABCO) enables the reversed adsorption of C₂H₆ over C₂H₄. The generated carborane-hybrid microporous material ZNU-10 (ZNU = Zhejiang Normal University) is highly stable in humid air and maintains good C₂H₆/C₂H₄ separation performance under high humidity. Gas loaded single crystal structure and density-functional theory (DFT) calculations revealed that the weakly polarized carborane and DABCO within ZNU-10 induce more specific C–H^{δ+}...H^{δ-}–B dihydrogen bonds and other van der Waals interactions with C₂H₆, while the suitable pore space allows the high C₂H₆ uptake. Approximately 14.5 L kg⁻¹ of polymer grade C₂H₄ can be produced from simulated C₂H₆/C₂H₄ (v/v 10/90) mixtures under ambient conditions in a single step, comparable to those of many popular materials.

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Introduction

Polymer-grade ethylene (C₂H₄ > 99.9%) is significant feedstock to produce resins and plastics.¹ During the production, ethane (C₂H₆) is the major impurity and needs to be removed to improve the C₂H₄ quality. The current state-of-the-art technique to separate C₂H₄/C₂H₆ depends on cryogenic distillation at high pressure and low temperature.² The separation process is highly energy-intensive due to the similarity of the boiling points of C₂H₄ (–88.6 °C) and C₂H₆ (–103.7 °C) and requires very large distillation towers with 120 to 180 trays and high reflux ratios.³

Therefore, there is a need to develop novel technologies for efficient C₂H₄/C₂H₆ separation.⁴

Recently, physisorptive separation using porous solid adsorbents has attracted increasing attention due to its environmental friendliness and reduced energy consumption.⁵ Porous coordination polymers (PCPs) or metal-organic frameworks (MOFs), as a new class of crystalline porous materials with a high surface area, structural tailorability and controllable properties, have been developed for the separation of C₂H₄/C₂H₆ hydrocarbon mixtures.⁶ Among them, most MOF materials, especially those decorated with polar functional groups or unsaturated metal sites, exhibit the preferential adsorption order of C₂H₄ > C₂H₆ based on their difference in physico-chemical properties including molecular size, polarity and quadrupole moment (Table S2†).⁷ However, C₂H₄-selective MOFs are not the optimal selection for the adsorptive separation of C₂H₄/C₂H₆ mixtures. The concentration of C₂H₄ within the cracked gas mixtures is often over 10 times higher than that of C₂H₆, thus using C₂H₄-selective adsorbents for C₂H₄/C₂H₆ separation entails more adsorbent consumption and larger space occupation than using C₂H₆-selective adsorbents.⁸ Besides, the utilization of C₂H₄-selective adsorbents usually needs over four adsorption-desorption cycles to attain polymer-grade C₂H₄ due to the retention of C₂H₆ amidst adsorbent

^aKey Laboratory of the Ministry of Education for Advanced Catalysis Materials, College of Chemistry and Materials Science, Zhejiang Normal University, Jinhua, 321004, China. E-mail: ybzhang@zjnu.edu.cn

^bZhejiang Lab, Hangzhou, 311100, P. R. China

^cInstitute of Advanced Fluorine-Containing Materials, Zhejiang Normal University, Jinhua, 321004, China

^dFujian Provincial Key Laboratory of Polymer Materials, College of Chemistry & Materials Science, Fujian Normal University, Fuzhou, 350007, P. R. China

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‡ These authors contributed equally to this work.



particles.⁹ In sharp contrast, using C₂H₆-selective adsorbents facilitates the direct acquisition of high-purity C₂H₄ through a single adsorption step, streamlining the separation process and effecting approximately a 40% reduction in energy consumption.¹⁰ Hence, the development of C₂H₆-selective adsorbents is highly imperative for industrial refinement of C₂H₄. In previous reports, reducing the polarity of pore surfaces in porous materials is promising to afford reversed adsorption of C₂H₆ over C₂H₄.¹¹ This phenomenon can be regarded as “like adsorbs like” when compared to the “like dissolves like” principle. However, the construction of C₂H₆-selective MOFs is still a difficult problem at present.

With the above consideration in mind, we envision that three dimensional neutral *para*-carborane (*p*-C₂B₁₀H₁₂) as a derivative of the [B₁₂H₁₂]²⁻ anion (Scheme 1) can serve as a weakly polarized functional group in MOFs to selectively bind C₂H₆ over C₂H₄. Although a plenty of dodecaborate [B₁₂H₁₂]²⁻ anion pillared MOFs have been developed in our group for gas separation with efficient C₂H₂/CO₂ and C₂H₂/C₂H₄ splitting performance,¹² carborane-based MOFs have been rarely reported,¹³ and no records of light hydrocarbon separation with carborane hybrid MOFs can be traced. On the other hand, carborane hybrid MOFs seem to display higher water stability when compared to benzene-based MOF analogues, which is a benefit for real applications with moisture.^{13a,d}

Herein, we reported a novel microporous MOF termed ZNU-10 (ZNU = Zhejiang Normal University) with cluster *para*-carboranyl dicarboxylic acid (1,12-*p*-C₂B₁₀H₁₀-(COOH)₂) and 1,4-diazobicyclo[2.2.2]octane (DABCO) as the backbones. A pillar-layered framework with pcu topology and saturated metal sites is generated when assembled with classical paddle-wheel dicopper(II) SBUs. As a result, these pores with uniform electrostatic potential not only help to reverse the adsorption sequence of C₂H₆ over C₂H₄, but also contribute to improving the water stability of the framework due to the hydrophobic surface of the pore channel. Despite its higher affinity towards C₂H₆, the C₂H₆ adsorption heat (26.4 kJ mol⁻¹) in ZNU-10 is quite low, allowing its facile regeneration. *In situ* gas loaded single crystal structures and density-functional theory (DFT) calculations were applied to reveal the adsorption mechanism. In the poorly polarized channels, C₂H₆ molecules are stacked more closely and feature stronger van der Waals interactions

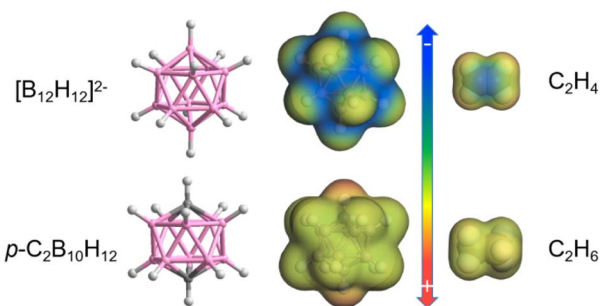
and C-H^{δ+}...H^{δ-}-B dihydrogen bonding to the framework due to the larger molecular size and polarizability. Experimental breakthrough studies confirmed that one-step acquisition of high-purity C₂H₄ from C₂H₄/C₂H₆ mixtures can be realized with a high production of *ca.* 14.5 L kg⁻¹.

Results and discussion

Greenish-blue single crystals of ZNU-10 {Cu(1,12-*p*-C₂B₁₀H₁₀-(COO)₂)(DABCO)_{0.5}} were produced by a solvothermal reaction of Cu(NO₃)₂·3H₂O, *p*-C₂B₁₀H₁₀-(COOH)₂ and DABCO in a mixed DMF/MeOH/H₂O (v/v/v = 2/2/1) solution (Fig. S1†). Single crystal X-ray diffraction (SCXRD) analysis showed that Cu₂(COO)₄ paddle wheel secondary building units (SBUs) are formed between two Cu²⁺ and four carboxylate ligands (Fig. 1A). Each SBU paddle wheel is connected by *p*-carborane ligands to form a two-dimensional (2D) square grid layer (Fig. 1B). The layers are further pillared by the organic DABCO ligands to generate a 3D framework with pcu topology and saturated metal sites (Fig. 1C). The analysis of the surface electrostatic potential of ZNU-10 indicates that ZNU-10 features a uniform and poorly polarized pore surface (Fig. 1D). This is because ZNU-10 consists of a neutral carborane backbone and aliphatic organic building blocks. When compared, ZNU-1 {CuB₁₂H₁₂(-dpe)₂}^{12a} constructed from -2 charged [B₁₂H₁₂]²⁻ backbones and aromatic ligands displays similar 1D channels but significantly different electrostatic potential on the pore surface. Notable charge separation can be observed on the isosurface of ZNU-1, namely the anionic boron cluster surface displays highly negative electrostatic potential while the organic linker surface displays very positive electrostatic potential (Fig. 1F). As we know, ZNU-1 is one of the best MOFs to selectively capture C₂H₂ from various mixtures.^{12a,b} Due to the completely different electrostatic potential distribution, ZNU-10 is yet supposed to be a C₂H₆ selective adsorbent for one-step C₂H₄ acquisition from C₂H₄/C₂H₆ mixtures.

Before gas adsorption experiments, we investigated the chemical and thermal stability of ZNU-10 to optimize the activation conditions. We find that ZNU-10 is highly stable in many organic solvents including DMA, EtOH, *n*-hexane, acetone, CH₂Cl₂, DMF, MeCN, MeOH and so on, identified by a microphotograph (Fig. 2A) and powder X-ray diffraction (PXRD) (Fig. 2B). Temperature varied PXRD and thermogravimetric analysis (TGA) indicated that ZNU-10 is stable below 320 °C (Fig. 2C and D). Such thermal stability is superior to that of all the boron cluster anion hybrid MOFs and most Cu(II) based MOFs (Fig. S10 and S11†).¹² According to the above results, the as-synthesized ZNU-10 was soaked in MeOH for solvent-exchange and activated under 120 °C to fully remove all the guest molecules. Besides, we find that ZNU-10 is highly stable in humid air. The as-synthesized single crystals retained the crystallinity and quality over 3 months under an ambient humid atmosphere or heating at 120 °C for 3 days under vacuum (Fig. 3D, inset), identified by single crystal X-ray analysis.

The permanent porosity of ZNU-10 was established by N₂ gas adsorption experiments at 77 K. The adsorption isotherm corresponds to the representative type I adsorption isotherm,



Scheme 1 Comparison of the surface electrostatic potential of boron clusters (dodecaborate dianion and *p*-carborane) and C₂ hydrocarbon gases (C₂H₆/C₂H₄).



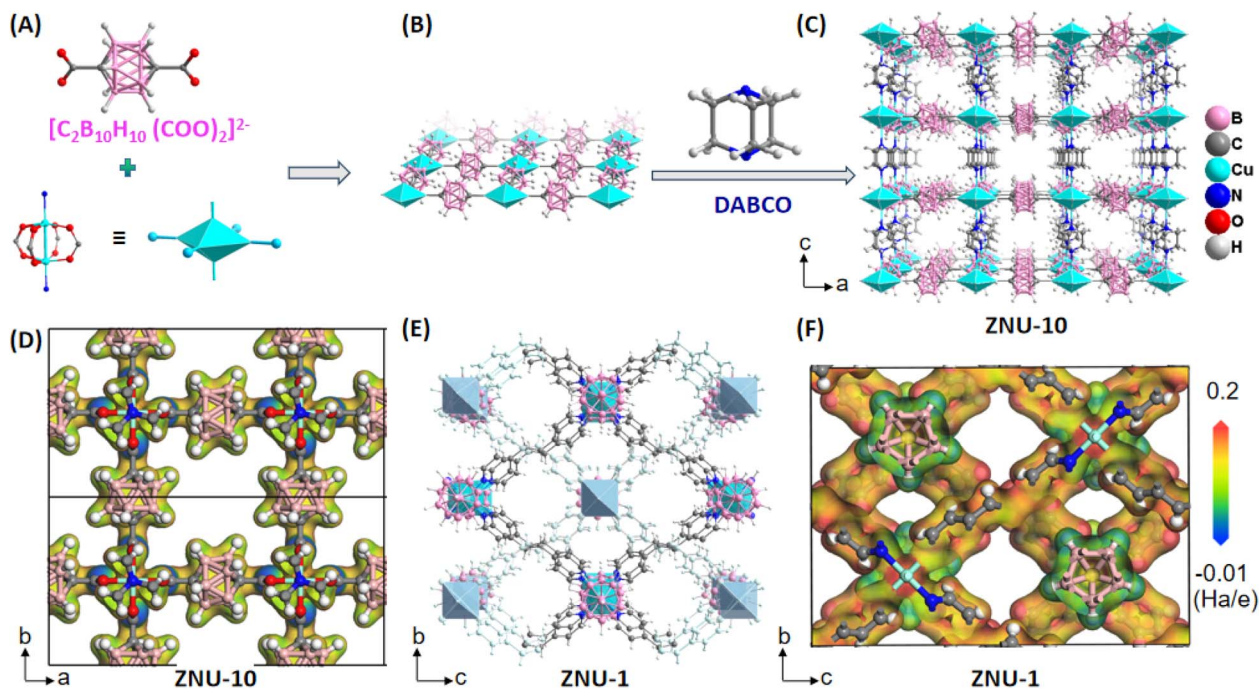


Fig. 1 (A and B) Single layer of ZNU-10 constructed from carborane dicarboxylic acid and Cu(II) paddle wheels. (C) 3D structure of ZNU-10 viewed along the *b* axis. (D) Isosurface of ZNU-10 viewed along the *c* axis. (E) Structure of ZNU-1 viewed along the *a* axis. (F) Isosurface of ZNU-1 viewed along the *a* axis.

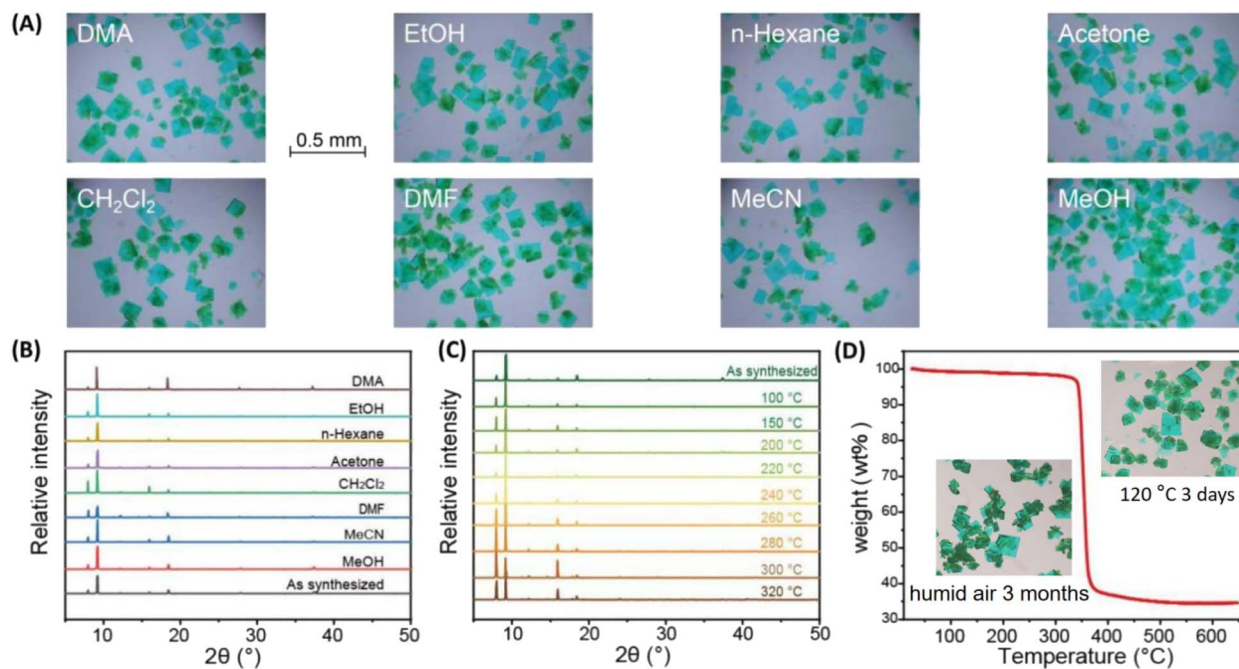


Fig. 2 (A) Microphotograph of single crystals and (B) PXRD of ZNU-10 after soaking in different solvents for 3 months. (C) Temperature varied PXRD of ZNU-10. (D) TGA curve of ZNU-10 (inset: microphotograph of single crystals of ZNU-10 after heating at 120 °C for 3 days or exposure to humid air for 3 months).

indicative of its inherent microporous characteristics (Fig. 3A). At $P/P_0 = 0.95$, the N_2 adsorption capacity of ZNU-10 was 293 STP $cm^3 g^{-1}$ (13.1 mmol g^{-1}), and the Brunauer–Emmett–Teller

(BET) surface area and micropore volume are calculated to be 1171 $m^2 g^{-1}$ and 0.45 $cm^3 g^{-1}$, respectively. The calculated pore size is centered at 8.59 Å (Fig. S13[†]), which is very close to the



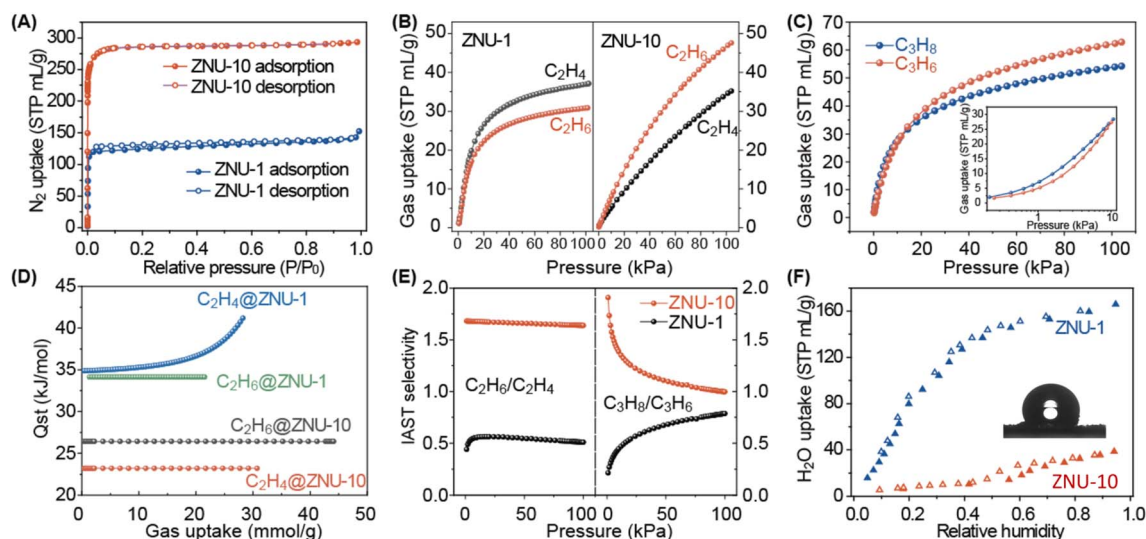


Fig. 3 (A) N_2 sorption isotherms for ZNU-1 and ZNU-10 at 77 K. (B) C_2H_4 and C_2H_6 adsorption isotherms for ZNU-10 at 298 K. (C) C_3H_8 and C_3H_6 adsorption isotherms for ZNU-10 at 298 K (inset: adsorption isotherms in the pressure region of 0–10 kPa). (D) The isothermic heat of adsorption (Q_{st}) of C_2H_4 and C_2H_6 for ZNU-10 and ZNU-1. (E) IAST selectivity of equimolar C_2H_6/C_2H_4 and C_3H_8/C_3H_6 at 298 K. (F) Water sorption isotherms for ZNU-10 and ZNU-1 at 298 K (inset: contact angle testing of ZNU-10).

pore size of 7.7–10 Å from the single crystal structure evaluation (Fig. S6 and S7†). When compared, ZNU-1 only displays a BET surface area of $532 \text{ m}^2 \text{ g}^{-1}$ and a pore volume of $0.20 \text{ cm}^3 \text{ g}^{-1}$ (Fig. S14†). Therefore, the porosity of ZNU-10 (Fig. S4 and S5†) is significantly increased when compared to that of ZNU-1.

Single component C_2H_6 and C_2H_4 adsorption measurements at 298 K were conducted for ZNU-10 and ZNU-1. At 1.0 bar, the C_2H_6 and C_2H_4 uptakes on ZNU-10 were 47.6 and $35.1 \text{ STP cm}^3 \text{ g}^{-1}$ (2.13 and 1.57 mmol g^{-1}), respectively (Fig. 3B, right). This uptake trend is opposite to that of ZNU-1 (30.9 and $37.1 \text{ STP cm}^3 \text{ g}^{-1}$ for C_2H_6 and C_2H_4) (Fig. 3B, left). With the temperature decreasing to 278 K, the C_2H_6 and C_2H_4 uptakes on ZNU-10 were improved to 67.9 and $55.1 \text{ cm}^3 \text{ g}^{-1}$ (Fig. S17 and S18†). The reversed adsorption of C_3H_8 and C_3H_6 is also observed in the low pressure region for ZNU-10 (Fig. 3C), which is quite rare in MOFs.¹⁴

In order to quantitatively compare the adsorption affinity between the framework and gas molecules, we calculated the adsorption heats (Q_{st}) of ZNU-10 and ZNU-1 using the Clausius–Clapeyron equation after fitting the isotherms to Langmuir equations with excellent accuracy (Tables S3 and S4†). The Q_{st} values of C_2H_6 and C_2H_4 for ZNU-10 were 26.4 and 23.2 kJ mol^{-1} , respectively; while those for ZNU-1 were 34.1 and 34.9 kJ mol^{-1} , respectively (Fig. 3D). These Q_{st} values are consistent with the slope of the adsorption isotherms in the low pressure region. Notably, the C_2H_6 adsorption heat on ZNU-10 is much lower than those in most C_2H_6 -selective materials such as $Fe_2(O_2)(\text{dobdc})$ (67 kJ mol^{-1}),¹⁵ MAF-49 (60 kJ mol^{-1}),¹⁶ UiO-NDC (58 kJ mol^{-1}),¹⁷ NKMOF-8-Br (40.8 kJ mol^{-1})¹⁸ and FJI-H11-Me (38.9 kJ mol^{-1}),¹⁹ and even lower than that of C_2H_6 -disfavored ZNU-1. This extremely low adsorption heat allows the facile regeneration of ZNU-10 for recyclable use.

The separation selectivity of C_2H_6/C_2H_4 is further calculated based on ideal adsorption solution theory (IAST). The $C_2H_6/$

C_2H_4 selectivity on ZNU-10 is $1.68\sim 1.64$ in the range of 1–100 kPa (Fig. 3E), which is approximately 3.2 times that of ZNU-1 ($S = 0.51$ at 100 kPa). This C_2H_6/C_2H_4 selectivity is also higher than those of many C_2H_6 selective MOFs such as UiO-NDC (1.35),¹⁷ UPC-612 (1.4),²⁰ TJT-100 (1.2),²¹ LIFM-63 (1.56),²² JNU-2 (1.6)²³ and Azole-Th-1 (1.46).²⁴ Besides, the C_2H_6/C_2H_4 selectivity on ZNU-10 remains consistent regardless of the C_2H_6/C_2H_4 ratio (Fig. S22†). The equimolar C_3H_8/C_3H_6 selectivity for ZNU-10 and ZNU-1 from 1 to 100 kPa is calculated to be $1.91\sim 1.00$ and $0.21\sim 0.78$, respectively, further indicating the opposite affinity of ZNU-10 and ZNU-1 towards olefins and paraffins.

To further explore the pore difference of ZNU-10 and ZNU-1, we performed a water vapor adsorption test. The results showed that at a relative humidity of 0.9, the water vapor adsorption capacity of ZNU-10 was only 35.6 mL g^{-1} , much lower than that of ZNU-1 (*ca.* 162 mL g^{-1}) under the same conditions (Fig. 3F). These results showed that ZNU-10 is more hydrophobic and has high potential to remove the C_2H_6 impurity from C_2H_4/C_2H_6 mixtures under humid environmental conditions. The water stability is also confirmed by soaking the ZNU-10 crystals in water. Initially, ZNU-10 floated on the surface of water due to its low density ($0.933 \text{ cm}^3 \text{ g}^{-1}$) and hydrophobicity. After some time, ZNU-10 crystals sunk to the bottom of water and became blue powders slowly. Nonetheless, the PXRD pattern of the water-soaked ZNU-10 is still consistent with that of the as-synthesized one (Fig. S25†). We also measured the water contact angle of ZNU-10, and the large water contact angle of $>114^\circ$ also indicated the hydrophobic nature of ZNU-10 (Fig. S26†).

Due to the high stability of ZNU-10 single crystals, the *in situ* single crystal structure of ZNU-10 with the loading of C_2H_6 or C_2H_4 was studied. We found that on average 0.7 C_2H_6 and 0.55 C_2H_4 molecules are adsorbed by a carborane unit (Fig. 4A and B), which corresponds to *ca.* 45 and $35 \text{ STP cm}^3 \text{ g}^{-1}$ of C_2H_6 and



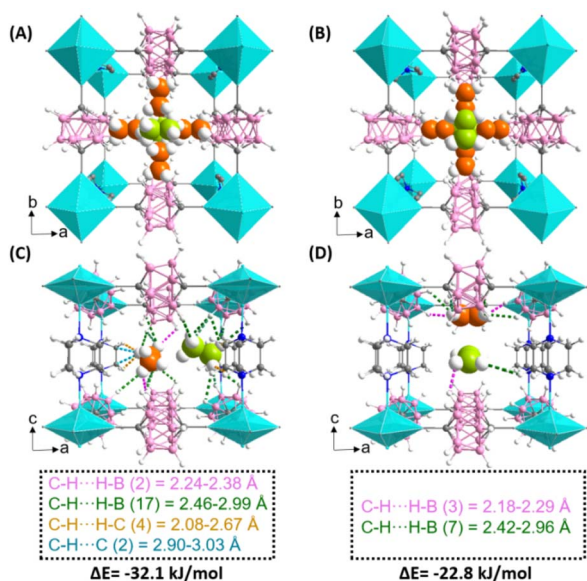


Fig. 4 (A and B) *In situ* single crystal structure of $C_2H_6@ZNU-10$ and $C_2H_4@ZNU-10$ viewed along the *c* axis. (C and D) DFT calculated C_2H_6 and C_2H_4 adsorption configuration in ZNU-10 viewed along the *b* axis and the corresponding binding energies.

C_2H_4 , respectively. These uptake values are close to the gas uptake from the adsorption isotherms at 1.0 bar. For both gases, two different binding sites are observed. The first site is located close to the window consisting of two carboranes and two DABCO (Fig. S9A and B[†]). There are four such sites in a single unit cell. The second site is located close to the window consisting of four carboranes (Fig. S9C and D[†]). There are two such sites in every unit cell. Therefore, six gas molecules can be adsorbed in a unit cell at maximum. However, the single crystal structure analysis indicated that the occupancy of gas molecules at each position is less than one. This could be explained by the low adsorption heats of C_2H_6 and C_2H_4 in ZNU-10 and the high symmetry of the framework. Due to the disorder, the contact distance between the gas molecules and the framework is not precise. Nonetheless, more close van der Waals interactions and C-H^{δ+}...H^{δ-}-B dihydrogen bonds are observed for C_2H_6 molecules. For example, the closest C-H^{δ+}...H^{δ-}-B distance between C_2H_6 and ZNU-10 is 2.10 Å, while that for C_2H_4 is 2.32 Å.

To gain more insights into the gas adsorption behavior, modeling studies using DFT calculations were further performed. The calculated average bonding energy between ZNU-10 and two gases located at different sites based on the *in situ* single crystal structures is -32.1 and -22.8 kJ mol⁻¹ for C_2H_6 and C_2H_4 , respectively (Fig. 4C and D), consistent with the experimental Q_{st} trend. In site I, C_2H_6 interacts with two carborane backbones by multiple C-H...H-B interactions. The contact between C_2H_6 and DABCO is also observed, with H...H distances of 2.08–2.67 Å and H...C distances of 2.90–3.03 Å. In site II, there only exist weak C-H...H-B interactions with a distance of >2.4 Å. When compared, C_2H_4 displays slightly shorter contact distances (2.18 and 2.21 Å in site I and 2.29 in site II) but decreased binding energy due to the fact that the

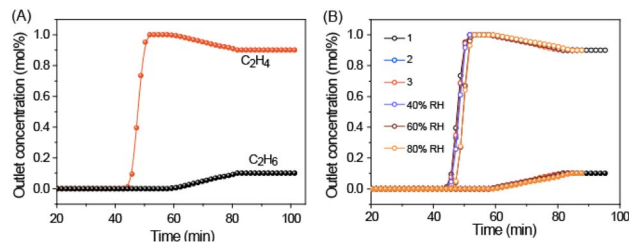


Fig. 5 (A) The column breakthrough curves of ZNU-10 for C_2H_4/C_2H_6 (90/10) mixtures at 298 K. (B) Repeated column breakthrough curves of ZNU-10 for C_2H_4/C_2H_6 (90/10) mixtures under dry and humid conditions.

overall interactions are fewer. This is consistent with the fact that C_2H_4 has small molecular size and thus the confinement in the nanospace of ZNU-10 will be weaker.

To evaluate the feasibility of ZNU-10 for practical C_2H_4 purification from binary C_2H_4/C_2H_6 mixtures, lab-scale breakthrough experiments were conducted for the C_2H_4/C_2H_6 (90/10) mixture to simulate the real separation conditions (Fig. S22[†]). Fig. 5A shows that high-purity C_2H_4 (>99.9%) was obtained between 44 and 58 min. The polymer grade C_2H_4 (>99.9%) productivity is estimated to be as high as 14.5 L kg⁻¹ (647 mmol kg⁻¹), superior to those of NKU-301 (9.5 L kg⁻¹),¹⁴ Zr-TCA (6.51 L kg⁻¹),²⁵ MOF-801 (5.73 L kg⁻¹),²⁶ UiO-66 (0.46 L kg⁻¹)²⁵ and many other popular materials under the same conditions.¹¹ Besides, ZNU-10 displays high recyclability and resistance to humidity. The breakthrough time is almost the same for multiple cycles or under highly humid conditions (Fig. 5B). Besides, ZNU-10 can be readily generated under Ar purge at room temperature within 1 h (Fig. S24[†]), which is consistent with the low adsorption heat of C_2H_6 and C_2H_4 in ZNU-10. The regeneration can also be achieved by desorption under vacuum for 1 h. In brief, the combination of high productivity of pure C_2H_4 , good recycling performance and facile regeneration conditions of the material makes ZNU-10 as a potential adsorbent for practical C_2H_4 purification.

Conclusions

In conclusion, we have reported a novel hydrophobic carborane hybrid metal-organic framework ZNU-10 with reversed C_2H_6 adsorption properties for efficient capture of C_2H_6 from C_2H_4/C_2H_6 mixtures to produce high-purity C_2H_4 in a single step. ZNU-10 displays distinct electrostatic potential distribution in the pore surface compared to the analogue cluster boron anion pillared ZNU-1. The difference leads to reversed C_2H_4/C_2H_6 hydrocarbon adsorption orders in ZNU-10 and ZNU-1. Notably, ZNU-10 exhibits good chemical/thermal stability with resistance towards water adsorption due to its hydrophobic pore surface. The excellent C_2H_4/C_2H_6 separation performance is fully illustrated by breakthrough experiments with good recyclability and capacity retention under high humidity. In general, our work demonstrates the versatility and importance of boron cluster functionalities, which can be tuned to achieve desirable gas adsorption properties. Considering the large library of boron



cluster compounds, this work will open a new avenue in boron cluster chemistry for light hydrocarbon separation applications.

Data availability

All the data supporting this article have been included in the main text and the ESI.†

Author contributions

L. W.: investigation, structural determination and analysis, funding, and supervision; S. W.: synthesis, characterization, and adsorption experiments; J. H.: DFT calculation; Y. J.: investigation and discussion; J. Li: adsorption experiments; Y. H.: breakthrough experiments; Y. H.: breakthrough experiments; T. B.: supervision; B. C.: supervision and funding; Y. Z.: concept, supervision, draft and funding.

Conflicts of interest

There are no conflicts to declare.

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