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Reversible addition–fragmentation chain transfer depolymerization of poly(methyl methacrylate) in toluene

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Controlled depolymerizations of poly(methyl methacrylate) (PMMA) *via* reversible addition fragmentation chain transfer (RAFT) reach higher yields in some solvents rather than others, and the exact reasons are not fully understood. PMMA was synthesized with trithiocarbonate (TTC) and dithiobenzoate (DTB) end groups to study depolymerization in toluene, which has been reported to have a lower monomer yield than other solvents. In toluene, the depolymerization kinetics were found to have two regions: one assisted by solvent-derived impurities and another being primarily self-initiation. Using a rate order analysis, we found evidence that initiation can lead to simultaneous homolysis of the RAFT end group and the depropagation of one monomer. Additionally, DTB end groups had a greater tendency than TTC end groups to undergo elimination, terminating the active depropagating center and limiting depolymerization extent. Radical thermal initiators were added into PMMA depolymerizations in toluene, demonstrating that di-*tert*-butyl peroxide can increase the conversion of polymer to monomer for TTC end groups.

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Introduction

Scientists continue to combat the ongoing crisis of plastic waste by developing new materials and techniques that will reduce pollution. A common technique is mechanical recycling, where mixed waste is physically separated, melted, and formed into flakes and pellets for future use.¹ Unfortunately, this technique cannot be applied to plastics that degrade significantly when reprocessed. In such cases, the heat-sensitive plastic must be recycled chemically. Chemical recycling converts solid plastic waste into valuable commodities, often in the form of monomers or fuels, recapturing much of the energy to produce the original molecules.²

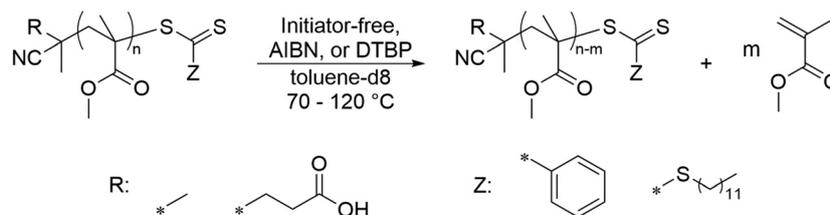
Polymers with ester groups in their backbone (*e.g.*, poly(lactic acid) and poly(ethylene terephthalate)) are susceptible to chemical recycling techniques, due to their susceptibility towards solvolysis.² Conversely, vinyl polymers, with backbones that consist entirely of carbon–carbon bonds, often require high-temperature pyrolysis to decompose into smaller molecules, generating a mixture including monomers. Some

methacrylate polymers can primarily decompose into their respective monomer along with some impurities. For example, the pyrolysis of stabilized poly(methyl methacrylate) (PMMA) at 400 °C yields a mixture of methyl methacrylate (MMA), ethyl acrylate, and other chemicals due to degradation at these elevated temperatures.³ The impure crude product must be purified, increasing the cost and decreasing the yield of the chemical recycling process. To avoid the challenges with purification, reactions must occur at temperatures high enough to facilitate depolymerization, but low enough to avoid the formation of impurities.

Controlled depolymerizations, defined as the reverse of controlled polymerizations that utilize the same methods to reduce irreversible termination,⁴ can overcome these challenges by functionalizing a polymer with an end group⁴ or comonomer⁵ that, when activated by external stimuli, generates active centers. After initiation, the active center concentration is controlled by a reversible deactivation equilibrium to minimize termination while allowing depropagation to occur. For PMMA, two classes of controlled depolymerization have been studied: atom transfer radical polymerization (ATRP)^{6,7} and reversible addition fragmentation chain transfer (RAFT) polymerization.

RAFT polymerizations of PMMA often generate a polymer with a trithiocarbonate (TTC) or dithiobenzoate (DTB) end group due to their controlled MMA RAFT polymerizations.⁸ The controlled depolymerization of RAFT methacrylates in the

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Scheme 1 Depolymerization of PMMA-RAFT with and without the radical initiators azobis(2-methylpropionitrile) (AIBN) and di-*tert*-butyl peroxide (DTBP).

absence of an initiator was first witnessed using oligo-dimethylsiloxane and oligo-ethylene glycol terminated with methyl methacrylate in dioxane at 70 °C with repeat unit concentrations of 0.1 M.⁹ Both poly(methacrylates) depolymerized to approximately 30 mM monomer concentration and reached equilibrium in 48 hours. Size exclusion chromatography indicated controlled depolymerizations because the molecular weight decreased due to the chain transfer mechanisms allowing all polymers to depolymerize evenly. The radical inhibitor, butylated hydroxy toluene, inhibited depolymerization, suggesting that the depolymerization proceeded *via* a radical mechanism.

Since then, others have continued to explore and refine RAFT poly(methacrylate) depolymerizations. For example, the Anastasaki group conducted depolymerizations at 120 °C at 5 mM repeat unit concentration on various methacrylate repeat units, reaching >90% depolymerization of repeat units to monomer.¹⁰ Later, this reaction was optimized using a flow reactor and in-line dialysis at 160 °C and 1 M repeat unit concentration, reaching 68% depolymerization.¹¹ Controlled depolymerizations of MMA have also been investigated with various end-groups and solvents. They found that dithiobenzoate terminated PMMA (PMMA-DTB) liberated more monomer than trithiocarbonate terminated PMMA (PMMA-TTC) and that depolymerizations should be performed in a dioxane solvent for greater yields under their conditions.¹² Furthermore, they functionalized the dithiobenzoate end group with electron donating groups and achieved depolymerization yields of 75% at 90 °C within 8 hours.¹³ However, most research efforts did not explore the practicality of RAFT depolymerizations in chemical recycling, specifically whether the end groups are preserved at the end of the service life of the polymer. Despite the recent research in PMMA-RAFT depolymerizations, why some solvent and RAFT end group systems depolymerize better than others is unclear.

Furthermore, questions still exist regarding the exact mechanisms of initiating PMMA-RAFT depolymerizations without the addition of external initiators in different solvents. The Anastasaki group has investigated the fate of the RAFT end group for PMMA-RAFT depolymerizations using dioxane and *p*-xylene as solvents, and DTB and TTC as RAFT end groups.¹⁴ Regardless of the conditions employed, unimers and solvent-derived RAFT products were observed. The solvent-derived RAFT products suggested that one of the potential

initiation mechanisms originates from solvent-derived radicals. However, currently reported results have not confirmed the common hypothesis for PMMA-RAFT depolymerizations that it initiates *via* the thermal homolysis of the C–S linkage between the polymer and RAFT end group.

This current investigation aims to understand how solvents with lower monomer yields, like toluene, facilitate PMMA-RAFT depolymerizations by studying their kinetics to yield a mechanistic understanding and discover opportunities for improvement and optimization. To this end, we prepared PMMA-TTC and PMMA-DTB, dissolved them in toluene-*d*8, and depolymerized them under various end group concentrations, temperatures, and radical initiators (Scheme 1). With these variations, we monitored monomer evolution and end group degradation, discovering that PMMA-TTC depolymerized to a higher extent than PMMA-DTB in toluene which is different than depolymerizations in 1,4-dioxane. The kinetics data were then used to support hypothesized mechanisms and compare the two RAFT end groups in toluene. In doing so, we found that initiation by C–S homolysis of the end group fails to completely describe the system properly and that the RAFT end groups explored have similar degradation rates. The analysis of the mechanisms of RAFT depolymerizations and the different behavior between RAFT end groups in toluene provides valuable information to improve and optimize depolymerizations for chemical recycling.

Materials and methods

Anhydrous 1,4-dioxane (Sigma-Aldrich), toluene-*d*8 (Thermoscientific), and di-*tert*-butyl peroxide (DTBP) (TCI) were used as received. Stabilized methyl methacrylate (Thermoscientific) was purified by passing through a basic alumina column. 2,2'-Azobis(2-methylpropionitrile) (Sigma-Aldrich) was purified by recrystallization in methanol. Chain transfer agents (CTA) 4-cyano-4-(dodecylsulfanylthiocarbonyl) sulfanyl pentanoic acid¹⁵ (TTC) and 2-cyano-2-propyl benzo-dithioate¹⁶ (DTB) were synthesized according to literature.

RAFT polymerization of poly(methyl methacrylate)

RAFT polymerizations were performed with a molar ratio of [MMA]:[CTA]:[AIBN] = 50:1:0.2 in anhydrous 1,4-dioxane with an MMA concentration of 0.2 g mL⁻¹. The reaction



mixture was degassed by three freeze–pump–thaw cycles, and then heated at 70 °C for 7 hours (TTC) or 8 hours (DTB), to achieve approximately 80% monomer conversion. The polymerization was then quenched by cooling in a water ice bath. After quenching, the volatiles were removed *in vacuo*, and the crude PMMA-TTC and PMMA-DTB were precipitated in 10-fold excess methanol 3 times. The purified product was then analyzed by ^1H NMR spectroscopy and size exclusion chromatography (SEC). ^1H NMR spectroscopy was used to determine the number of average molecular weights of the polymer through end group analysis (Fig. S5 and S6). SEC indicated a low relative dispersity to confirm a successful controlled RAFT polymerization (Fig. S7 and S8).

Monomer equilibrium determination

Additional polymerizations were performed at 90 °C and 120 °C to approximate the monomer equilibrium concentration (Table S1). All polymerizations were degassed by three freeze–pump–thaw cycles in a Schlenk flask. Polymerizations were first performed at monomer concentrations of 200 mM at 120 °C and 100 mM at 90 °C for 24 hours with molar ratios $[\text{MMA}] : [\text{TTC}] : [\text{I}] = 36 : 1 : 0.2$, where $[\text{I}]$ is AIBN for 90 °C and DTBP for 120 °C. The solutions were then cooled in ice and removed of volatiles. The number average molecular weight of the polymer was determined by ^1H NMR spectroscopy using end group analysis to determine the final monomer concentration in the reaction mixture after quenching. Additional polymerizations were performed to determine if the final monomer concentration was a result of exhausting initiating species or an equilibrium between propagation and depropagation. In general, subsequent polymerizations were performed with a monomer concentration 10–15 mM higher than the previous final monomer concentration. This process was repeated until a polymerization yielded a monomer concentration that was equivalent to the previous trial or equivalent to the greatest monomer concentration yielded from any depolymerization (Table S1).

Controlled depolymerization of PMMA-CTA

Solutions of PMMA-RAFT in toluene-d8 were prepared in 5 mm diameter, precision Wilmad® NMR tubes. For depolymerizations with initiators, the AIBN or DTBP were dissolved in toluene-d8 and included. The NMR tube was then degassed by three freeze–pump–thaw cycles and flame sealed under reduced pressure. An ^1H NMR spectrum was collected to determine the initial monomer concentration. The NMR tube was then heated in an oil bath for a predetermined time and temperature to facilitate depolymerization. For each time point, depolymerization was then quenched by immersing the NMR tube in ice, an NMR spectrum was collected, and then heated once again. This heat–quench–cool cycle was repeated until all desired NMR spectra were acquired. A selection of the depolymerization trials was then analyzed by SEC. The heat–quench–cool cycles were not performed for experiments that required less than 15 minutes of heating per cycle. Rather, a single

sample in an NMR tube was heated for a predetermined time for each point in the depolymerization curve.

^1H NMR spectroscopy

Purified polymers and RAFT agents were dissolved in 0.6 mL of deuterated chloroform (CDCl_3) and analyzed on a Bruker Ascend 500 MHz NMR spectrometer. Data was obtained and processed with MestReNova14 ^1H NMR software. Spectra were referenced to residual CHCl_3 (7.265 ppm). All depolymerizations were performed in toluene-d8 which was referenced to residual toluene methyl protons (2.08 ppm).

Quantification of PMMA end groups and monomers was achieved by using the methyl ester protons of MMA monomer and repeat units (3.23–3.65 ppm)¹⁷ as internal standards. This assumed that no monomers escaped the flame sealed NMR tube or degraded. Monomer concentration was determined by using a vinyl peak at 6.03 ppm.⁹ The TTC end group concentration was determined by using the methylene proton adjacent to the thiol of the dodecyl group peak at 3.03 ppm.¹⁵ The DTB end group concentration was determined by using the phenyl group meta protons peak at 7.90 ppm.¹⁶ Unsaturated end group concentration was determined by using a vinyl peak at 6.14 ppm.¹⁷

Size exclusion chromatography

Size exclusion chromatography was performed with a 5 mg mL^{-1} concentration of polymer in solvent. Solutions were passed through a 0.2 μm PTFE syringe filter prior to injection on an Agilent 1260 Infinity Size Exclusion Chromatograph equipped with a temperature-controlled refractive index detector. For all samples, HPLC grade THF was used as the eluent at a 1 mL min^{-1} flow rate and operating temperature of 35 °C. The SEC was equipped with three Phenogel columns with different pore sizes (Phenomenex Organic columns, 50 Å, 10³ Å, and 10⁶ Å) and calibrated with polystyrene standards.

Inductively coupled plasma mass spectrometry

The impurities of toluene-d8 were collected by evaporating 3 mL of toluene-d8 and 1 mL Milli-Q water in glass vials followed by rinsing the vials with 3 mL Milli-Q water. Samples were then acidified using Optima double distilled nitric acid to 1% acid. Samples were run using a Thermo Element 2 inductively coupled plasma-sector field mass spectrometer (ICP-MS). The sample introduction system consisted of an Elemental Scientific (ESI) DX-4 autosampler with a PFA nebulizer self-aspirated at 100 $\mu\text{L min}^{-1}$. The instrument was tuned each day to optimize the signal and minimize oxides. The samples were analyzed for ^{56}Fe , ^{60}Ni , ^{63}Cu , and ^{32}S , all measured in medium resolution. The instrument was calibrated before each run and a reference sample, SLRS-6 from National Research Council Canada, was run as a quality control sample.

Computational methods

All the structures of the polymer chains used in the simulation were fully optimized at the M06-2X/def2TZVP level of



theory^{18,19} without any constraints using the Gaussian 16 program.²⁰ Each polymeric system was modeled as two monomeric chain units attached to the RAFT end groups TTC, DTB, *O*-ethyl dithiocarbonate (DTO), 1-pyrrolicarbo-dithioate (DTP), and *N*-pyridine carbonodithiaote (PCDT). To identify the best possible depolymerization pathway, the structures were optimized first to potential global minimum (GM) structures by performing a conformational search and explicitly sampled low-lying local minima in the predicted GM neighborhood. A systematic conformational search on TTC and DTB were performed using the ABCluster Program.^{21,22} These conformational searches were carried out at the GFN2-xTB level of theory with thorough and explicit dihedral sampling, resulting in the generation of 1500 different conformers for each TTC and DTB. Transition-state searches were initiated from each refined conformer to capture possible kinetic advantages arising from conformational diversity. While the predicted global-minimum (GM) conformer is the thermodynamically most stable, a local-minimum conformer 4.07 kcal mol⁻¹ above the GM for TTC and 6.77 kcal mol⁻¹ above the GM for DTB delivered a lower activation barrier. Accordingly, the lowest ΔG^\ddagger (kinetically controlled barrier) is presented in support of our experimental results, while the GM-based analysis wherein the six lowest-energy conformers for both TTC and DTB were subsequently optimized at the M06-2X/def2-TZVP level of theory without constraints using the Gaussian 16 program is provided in the Supplementary Information (SI).

The free energy landscapes for the decomposition reactions were explored using the DFT-based metadynamics. To attain the desired reactions, the breaking of bonds in the depolymerization reactions was biased using three collective variables (CVs): the distances between Carbon-Sulfur (CV₁), Carbon-Carbon (CV₂), and Carbon-Hydrogen (CV₃). The bond distances were monitored and confined with quadratic walls at 8.0 Å and a force constant of 100.0 kcal mol⁻¹ Å⁻². The dimensions of the model system in the non-periodic box defined to perform the metadynamics were 30 × 30 × 30 Å³. The Gaussian bias potential, characterized by a height of 0.25 kcal mol⁻¹ and a width of 0.15, was introduced at intervals of every 25-time step throughout the simulation. The simulations were performed using the CP2K program.^{23,24} A double zeta valence polarized basis set, optimized for the Goedecker, Teter, and Hutter (GTH) pseudopotential²⁵⁻²⁷ was employed in the calculations. These simulations used the PBE functional²⁸ in conjunction with Grimme's DFT-D3 dispersion correction, which was applied with zero damping.²⁹ The NVT ensemble was utilized, and temperature control at 393.15 K was achieved using a thermostat based on canonical sampling through velocity rescaling (CSVR).³⁰ Further, a cutoff parameter of 360 Ry and a relative cutoff of 60 Ry were used for the basis set defined for the simulation. The graph.psm program incorporated in the CP2k software package²³ was employed to explore the free energy surface (FES)³¹⁻³³ and minimum energy path.

Results and discussion

Initial rates of depolymerization

Previous reports have demonstrated that in a solution of dioxane PMMA-DTB depolymerizes faster and with a greater yield than PMMA-TTC.^{12,34} However, in toluene, which has not been reported as a solvent for PMMA-TTC depolymerization, PMMA-TTC depolymerized faster and to higher monomer concentrations than PMMA-DTB regardless of the end group concentration and temperature used (Fig. 1a and b). This faster and higher yield with PMMA-TTC in toluene *versus* PMMA-DTB in dioxane suggests that the solvent type can affect the effectiveness of a particular end group for depolymerization. An equilibrium kinetics model was used to linearize the depolymerization progress curves in Fig. 1a and b (eqn (1), see SI for derivation):

$$\ln\left(\frac{[M]_{\text{eq}} - [M]_0}{[M]_{\text{eq}} - [M]_t}\right) = k_p[P^*]t \quad (1)$$

where k_p is the rate constant for propagation, $[P^*]$ is the active center concentration, $[M]_{\text{eq}}$ is the equilibrium monomer concentration, $[M]_t$ is monomer concentration at time t , and $[M]_0$ is the initial monomer concentration. Eqn (1) indicates that a linearized depolymerization curve with a constant $[P^*]$ will yield a straight line. Linearized depolymerization curves at 90 °C matched the model well, as a clear linear slope was observed with a y-intercept near 0 mM, indicating that controlled depolymerization followed the equilibrium model (Fig. 1c). However, linearized depolymerization kinetics at 120 °C were only linear after 15 minutes and failed to intersect with the origin (Fig. 1d), suggesting a difference in active center concentration before and after 15 minutes. After 15 minutes, the depolymerizations at 120 °C appeared to follow controlled depolymerization.

The apparent activation energy of these depolymerizations can be used to compare the lability of the end groups to different linkages within PMMA. PMMA-TTC and PMMA-DTB had apparent activation energies of 13 ± 3 and 24 ± 3 kcal mol⁻¹, respectively, which is significantly lower than potential other linkages in PMMA (see SI). Computational analysis of the depolymerization mechanism in the gas phase yielded activation energies of 17 and 25 kcal mol⁻¹ for PMMA-DTB and PMMA-TTC, respectively (see SI for more details). This relative agreement between experimental and gas phase computations suggests that the apparent activation energies experimentally observed in toluene are due to the fragmentation of the RAFT end group initiating the depolymerization and not due to toluene. These results are consistent with literature reported bulk depolymerizations where PMMA-TTC depolymerized at lower temperatures than PMMA-DTB which was attributed to a stronger C-S bond for PMMA-DTB than PMMA-TTC.^{35,36} Since solvent-free gas phase computations and bulk depolymerizations have similar reactivities to depolymerizations in toluene, toluene does not appear to significantly affect the initiation step of polymerization. Since this behavior is the opposite of



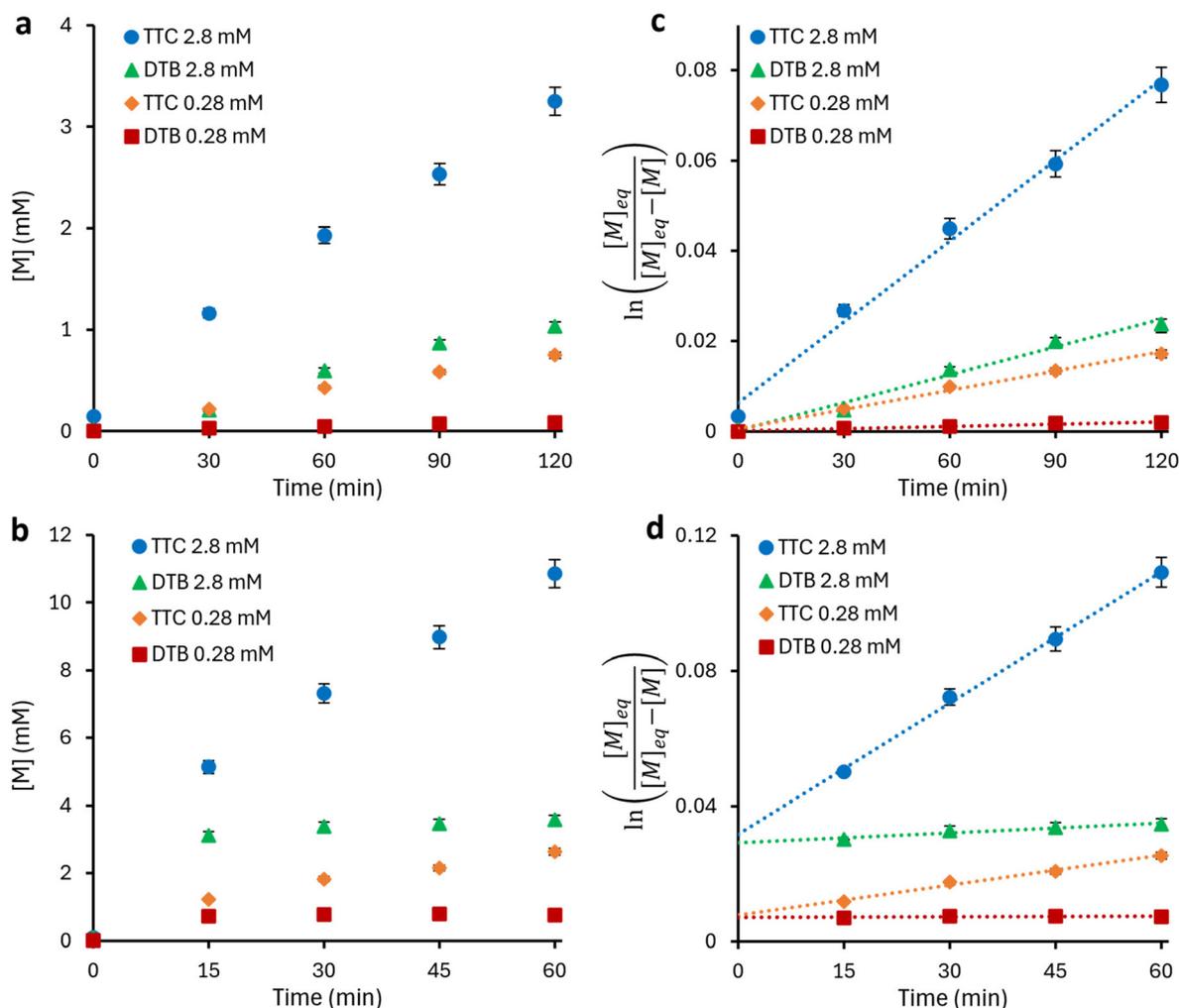


Fig. 1 The concentration of monomer in solution, [M], for depolymerizations of PMMA-TTC and PMMA-DTB at end group concentrations of 0.28 mM and 2.8 mM, or repeat unit concentrations of 10 mM and 100 mM respectively, at (a) 90 °C and (b) 120 °C. Depolymerization curves linearized using eqn (1), with $[M]_0$ equal to zero, for (c) 90 °C and (d) 120 °C. Error bars are one standard error with $n = 2$ replications. The linear fits of graph d are extrapolated to the ordinate.

1,4-dioxane, the results suggest that 1,4-dioxane does affect the reactivity of the end group.

The relative reactivity of the two RAFT end groups is different than that previously reported in different solvents. The Anastasaki group¹² found that PMMA-DTB depolymerized faster than PMMA-TTC at 67 μ M end group concentration in 1,4-dioxane at 120 °C. In their work, they attributed the difference in depolymerization rates to the difference in the strength of the C–S bond between the RAFT end group and the polymer. However, if this difference in depolymerization rates was only due to the C–S bond strength, we would expect the same relative rates regardless of the reaction concentration and solvent at 120 °C. Additionally, deviations in PMMA-DTB rate trends could also be due to a competing reaction where elimination by the Chugaev elimination is preferred over homolysis of the C–S bond.³⁷ Furthermore, solvent molecules can stabilize transition states, allowing C–S bonds to break

more easily in different solvents, potentially explaining the different behavior in 1,4-dioxane.³⁸ Finally, 1,4-dioxane has been shown to react with RAFT end group fragments during depolymerization, which could also explain the relative reactivity discrepancy between depolymerizations in different solvents.¹⁴

Evidence of impurity assisted depolymerization

Depolymerizations at 120 °C failed to follow the equilibrium model early in the reaction because the fit (Fig. 1d) did not intersect at the origin. This behavior appears to be due to a greater active center concentration within the first 15 minutes. A separate study was performed within 15 minutes to analyze the depolymerization of PMMA-DTB at short intervals (Fig. 2a). The curve shows a sharp increase in monomer evolution and thus, depolymerization rate within the first 5 minutes. After 5 minutes, the rate of depolymerization drasti-



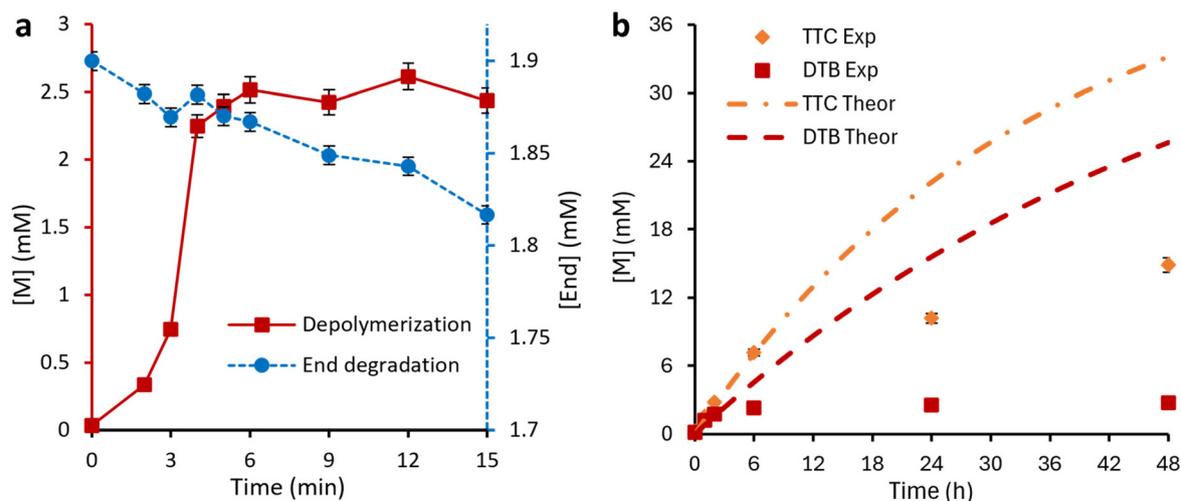


Fig. 2 (a) Depolymerization of PMMA-DTB at 120 °C and 1.9 mM end group concentration (left axis, solid red line, squares) and the concentration of remaining DTB end group (right axis, dashed blue line, circles) with respect to time. (b) Depolymerization of PMMA-DTB and PMMA-TTC at 90 °C for 48 hours with an end group concentration of 5.56 mM, or a repeat unit concentration of 200 mM (Exp). The expected result of the depolymerization curve using the initial rate and eqn (1) (Theor). Error bars are one standard error with $n = 2$ replications.

cally decreases, and monomer concentration nearly plateaus, yielding a discontinuous trend in monomer evolution. For depolymerizations at 90 °C, a discontinuity was not as visually clear (Fig. 2b). To determine whether these depolymerization curves exhibit any discontinuities and determine the origin of the discontinuity, further analysis was needed.

Literature has suggested that some initiation in a controlled RAFT depolymerization occurs at the RAFT end group *via* thermal homolysis of the C–S bond present at the terminal repeat unit.^{10,34,36} Since this initiation mechanism creates a thiol-centered radical as well, it can result in some fraction of RAFT end groups degrading as a side reaction and consequently decrease the end group concentration. Thus, the trends in end group concentration should follow those in monomer concentration over time if the initially higher active center concentration is due to end groups undergoing homolysis. Depolymerization of PMMA-DTB (Fig. 2a) had a steady decrease of $4.9 \pm 0.4 \mu\text{M s}^{-1}$ in end group concentration within a 15-minute depolymerization, indicating no change in the end group degradation rate, while having a significant change and discontinuity in monomer generation rate. Since no discontinuity exists for the degradation of the end group, the change in active center concentration, and thus change in the rate of monomer generation, observed is partially independent of the end group concentration. This behavior suggests that another species exists in the toluene that can generate radicals that can react with RAFT chain ends to form active centers. These impurities are consumed within 5 minutes at 120 °C, leading to a slower depolymerization rate.

The PMMA-DTB and PMMA-TTC linearized depolymerization curves in Fig. 1d are also consistent with initial rates of depolymerization being faster due to impurities assisting initiation. The linear fit of the 15–60 minutes region extrapolated to the ordinate yields monomer concentrations of $3.2 \pm$

0.2 and 0.78 ± 0.06 mM for end group concentrations of 2.8 and 0.28 mM, respectively. This monomer concentration appears to correlate to the monomers generated by impurities initially assisting the depolymerization. For PMMA-DTB and PMMA-TTC depolymerizations with identical end group concentrations, the monomer concentrations generated by impurities are nearly equivalent to one another, as suggested by the extrapolations' intersection near the ordinate. Interestingly, even though PMMA-TTC depolymerized faster than PMMA-DTB, the extrapolations' intersection at the ordinate suggests that the monomer generated by impurities is independent of the RAFT end group used.

For experiments at 90 °C, no noticeable discontinuities existed within the first two hours (Fig. 1a). However, around 2 and 6 hours the rate law appears to change for PMMA-DTB and PMMA-TTC, respectively (Fig. 2b). Eqn (1) was used to model the expected RAFT depolymerization by fitting the first 2 hours of the depolymerization curves in Fig. 2b and predicting theoretical future monomer concentrations, assuming a steady state active center concentration. This theoretical curve predicts a significantly higher concentration at 24 and 48 hours than observed. This suggested that the active center concentration does not remain constant throughout the 48-hour depolymerization. This behavior suggests that like at 120 °C, early in the depolymerization at 90 °C a greater active center concentration exists from radical generating impurities that initiate depolymerization. At 90 °C, the impurity assisted region lasts longer because the half-life of the radical generating impurities is significantly greater at reduced temperatures as expected by an Arrhenius relationship. Once the impurities are mostly consumed at around 2–6 h, the depolymerization likely is primarily initiated by RAFT end group homolysis.

The presence of initiating impurities in solvents is supported by Wang *et al.*'s investigation on the solvent effects of



RAFT depolymerizations.¹² Their analysis showed that the depolymerization conversions for xylene, toluene, and benzene were significantly different under the same conditions which was attributed to polarity differences.³⁸ However, the dielectric constants of xylenes, toluene, and benzene are 2.4, 2.38, and 2.28, respectively, which are not large differences.³⁹ Rather, the results of Wang *et al.* suggest that the different behavior for these three solvents could be due to varying concentrations of impurities that can initiate depolymerizations. This behavior would also explain why depolymerizations in 1,4-dioxane have faster rates than toluene, since 1,4-dioxane generates peroxides that can generate radicals.¹² Evidence of impurity assisted initiation was reported by Häfliger *et al.* who found solvent-derived moieties covalently bonded to the RAFT group for xylene,¹⁴ which may have been due to trace metals, sulfur-containing compounds, or other impurities in toluene.

In our current study, we performed ICP-MS on toluene-d8 and found that iron, copper, and nickel were present at approximately 1 ppb, while sulfur atoms were present at 300 ppb. These metals have been shown to initiate RAFT polymerizations.⁴⁰ Additionally, some sulfur oxyanions are reducing agents that can initiate.⁴¹ We performed a depolymerization of PMMA-DTB at 120 °C using distilled toluene-d8 (Fig. S9) to see if this would affect the concentration of monomer evolved due to impurities. The monomer concentration evolved *via* impurity assistance for non-distilled toluene-d8 was 4.2 mM ($n = 3$ replications, 95% CI [3.4, 5.0]). Using distilled toluene-d8, the monomer concentration evolved dropped to 3.7 mM, remaining within the 95% confidence interval of the non-distilled toluene-d8 trials. This suggests that the impurities assisting depolymerization were not the metals in the solvent found by ICP-MS. The impurities assisting the depolymerization may have been unsuccessfully removed by distillation or originated from contact with glassware and needles during solvent trans-

fer to the reaction vessel. The impurities also may have originated from the purified polymer, such as trace AIBN that was not fully removed by precipitation after synthesis or trace metals, or from auto-oxidized toluene from trace oxygen remaining in the system.⁴² Future more detailed studies are required to confirm the identity of these impurities.

End group order analysis

To understand the depolymerization initiation mechanism, the reactant order of the end group for depolymerization was determined with eqn (2) (see SI for derivation):

$$\ln R_d = \ln k_{app} + a(\ln[\text{End}]) \quad (2)$$

where R_d is the initial rate of depolymerization, k_{app} is the apparent rate constant, $[\text{End}]$ is the concentration of end groups, and a is the end group order with respect to the evolution of monomer. The initial rates were measured for PMMA-TTC and PMMA-DTB depolymerizations at 90 and 120 °C (see Fig. 1) and used to analyze the end group order (Fig. 3). Since two different kinetic regions for depolymerizations existed, these were analyzed separately. The results (Fig. 3) indicate that end group orders vary between 0.57 and 1.05, depending on the end group, temperature, and region analyzed. To connect the observed empirical end group orders to the depolymerization mechanisms, we considered three initiation mechanisms and the other expected mechanistic steps: RAFT equilibrium, propagation, depropagation, and termination (Scheme 2).

The first mechanism to consider is an impurity assisted initiation, where an unknown species reacts with the terminal RAFT end group to form an adduct that can decompose to form an active center. If the most dominant initiation mechanism is the initiation by radicals originating from impurities

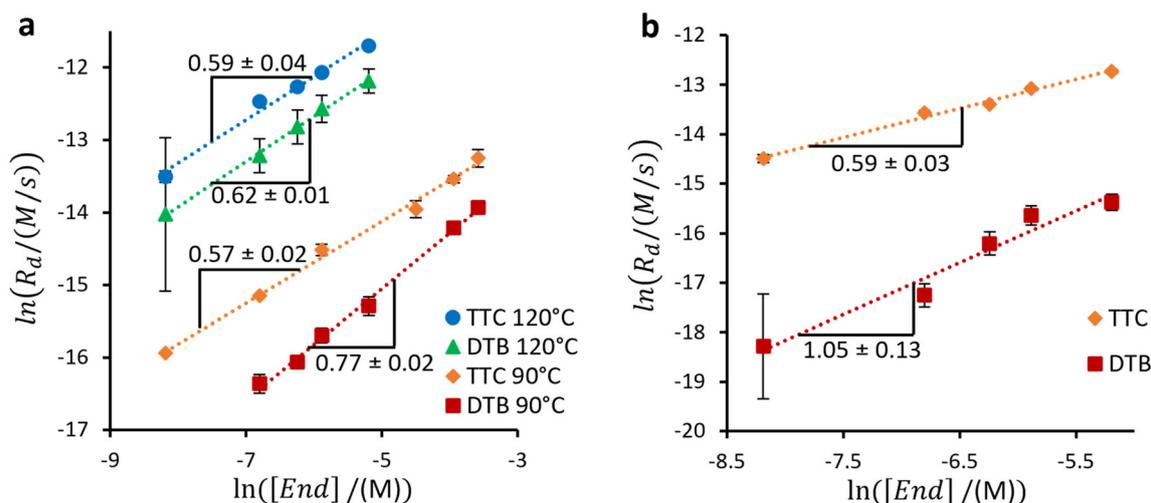
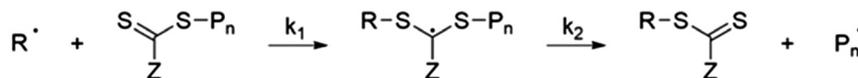


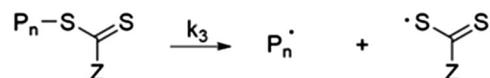
Fig. 3 Polymer end group order plots for PMMA-TTC and PMMA-DTB at 90 and 120 °C using (a) rates expected to include initiation from impurities and the end group (120 °C, 0–15 min; 90 °C, 0–120 min) and (b) rates from regions suspected to have initiation from only the end group (120 °C, 15–60 min). Both end group order plots contain the slopes of each line which indicate the end group order. Errors bars of data points are the standard error of the initial rate. Errors bars of the end group order are the standard error of the linear fit slopes.



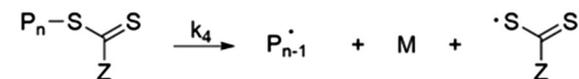
(1) Impurity Assisted Initiation



(2) Initiation by Homolysis



(3) Initiation by Homolysis Accompanied by Monomer Evolution

**Scheme 2** Proposed initiation mechanisms involved in RAFT depolymerization.

(Scheme 2, reaction (1)) then the rate of monomer evolution can be expressed as eqn (3) (see SI for derivation):

$$R_d = k_{\text{app1}}[\text{End}]^{\frac{1}{2}}[\text{R}^\cdot]^{\frac{1}{2}} \quad (3)$$

where k_{app1} is the apparent rate constant for impurity assisted initiation, $[\text{End}]$ is the end group concentration, and $[\text{R}^\cdot]$ is the concentration of radicals generated by impurities. Thus, if only impurities independent of the polymer initiate depolymerization, then the end group order should be 0.5.

The second mechanism is initiation by homolysis, where the C–S bond between the polymer and end group homolyzes to form an active center. If the dominant initiation mechanism is homolysis (Scheme 2, reaction (2)), then the rate of monomer evolution can be expressed as eqn (4) (see SI for derivation):

$$R_d = k_{\text{app2}}[\text{End}]^{\frac{1}{2}} \quad (4)$$

where k_{app2} is the apparent rate constant for initiation by homolysis. If the only source of radicals is from homolysis between the RAFT end group and polymer, then the end group order should be 0.5 with respect to the monomer generation for the depolymerization. An order-based analysis cannot differentiate between initiation by C–S homolysis and initiation by solvent derived impurities since they have the same end group order.

The third mechanism is initiation by homolysis accompanied by monomer evolution (Scheme 2, reaction (3)). This mechanism has not been proposed yet for controlled depolymerizations of PMMA, but computational studies on the molecular dynamics of PMMA decomposition suggest it is possible.⁴³ Stoliarov's simulations suggest that neither random chain scission nor side group scission are dominating initiating steps for PMMA decomposition. Rather, random chain scission accompanied by the evolution of a monomer is the most dominant initiating mechanism. We attempted to observe this homolysis accompanied by monomer evolution using a metadynamic simulation, but under the conditions performed, homolysis was favored. We believe this could be

due to the short (two repeat units) length of the PMMA-RAFT analogue used (see SI for more details).

For this reaction, monomers evolve during initiation as well as depropagation of active centers, resulting in eqn (5) (see SI for derivation):

$$R_d = k_{\text{act}}[\text{End}]^{\frac{1}{2}} + k_4[\text{End}] \quad (5)$$

where k_{act} is an apparent rate constant associated with monomers evolved from active center concentration, and k_4 is the rate constant for initiation. The first term describes monomers generated by active centers, where k_{act} encompasses k_d and all rate constants that directly affect the active center concentration: initiation by homolysis accompanied by monomer evolution (k_4), RAFT equilibrium (k_{add} , $k_{-\text{add}}$), termination (k_t), and potentially impurity assisted initiation (k_1 , k_2). Of the two end groups tested, PMMA-DTB has a RAFT equilibrium that favors the formation of RAFT adducts more than PMMA-TTC,⁴⁴ which should reduce the rate of monomer evolution by decreasing the active center concentration. The second term describes monomers generated during initiation. To determine the end group order under various parameters and compare them to experimental data (Fig. 3), the rate at which $\ln(R_d)$ changes with \ln can be used to find the order (eqn (6), see SI for derivation):

$$\frac{d \ln(R_d)}{d \ln[\text{End}]} = a = \frac{[\text{End}]^{\frac{1}{2}} + 2m[\text{End}]}{2[\text{End}]^{\frac{1}{2}} + 2m[\text{End}]} \quad (6)$$

where a is the apparent end group order and m is the ratio k_4/k_{act} , which describes a relative propensity of both reactions to generate monomer. As m approaches 0, meaning that monomer evolution is predominantly through depropagating active centers, then a approaches 0.5. If m is large enough that $[\text{End}]^{\frac{1}{2}} \ll m$, then a approaches 1 (Fig. S10). For this model and the end group concentration range of 0.28 to 5.56 mM, different values of m yield apparent end group orders between 0.5 and 1 (Fig. S10). The ratio m would be affected by the RAFT end group, temperature, and solvent since it is composed of rate constants.



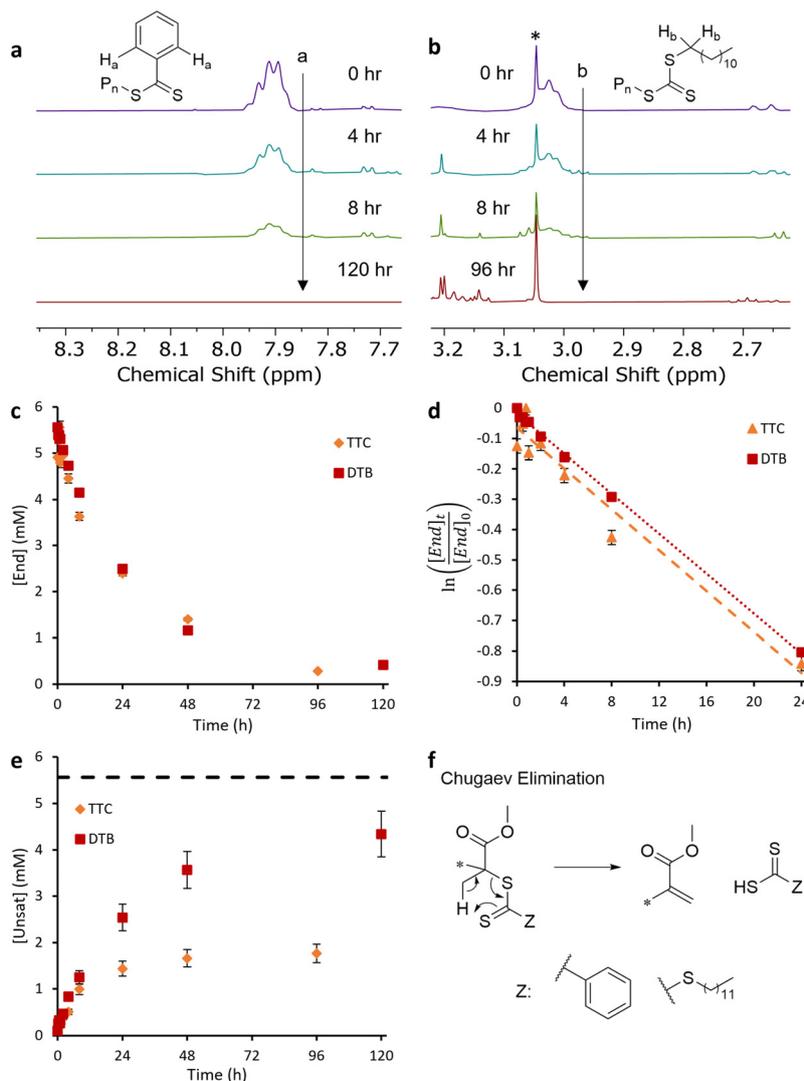


Fig. 4 ^1H NMR spectra of (a) PMMA-DTB and (b) PMMA-TTC end group protons over time. The end group concentration was 5.56 mM in toluene- d_8 , with the temperature held at 120 $^\circ\text{C}$. PMMA-TTC had a methanol peak interfering with the alpha methylene protons of TTC that remained after 96 h (marked by an asterisk). (c) End group concentration ([End]) as a function of time for PMMA-TTC and PMMA-DTB depolymerizations (120 $^\circ\text{C}$ and $[\text{End}]_0 = 5.56$ mM). (d) Linearized degradation kinetics assuming a first-order kinetics model. (e) Concentration of unsaturated ends ([Unsat]) of PMMA-TTC and PMMA-DTB depolymerizations over time (120 $^\circ\text{C}$ and $[\text{End}]_0 = 5.56$ mM). The dashed black line at 5.56 mM indicates the maximum possible [Unsat] assuming all polymers undergo elimination. (f) Mechanism of the Chugaev elimination. Error bars are one standard error with $n = 2$ replications.

energy is significantly higher than depolymerization, which further suggests that elimination does not occur through a Chugaev elimination. Likely an elimination pathway exists for PMMA-DTB that is neither a Chugaev elimination nor disproportionation that is tied to the degradation of DTB end group. The greater tendency of PMMA-DTB to irreversibly terminate through elimination in toluene suggests that the propensity for an end group to eliminate is another factor to optimize for PMMA-RAFT depolymerizations under different conditions. Successful reduction of the elimination rate by synthesizing novel RAFT agents will result in depolymerizations with fewer dead polymers generated and higher monomer yields.

Computational analysis of mechanism

The empirical data above enables the opportunity to explore further the mechanisms described. We performed metadynamics simulations to model the initiation and elimination mechanisms, compare experiments to theory, and predict the reactivity of untested RAFT end groups (see SI for more details). Throughout the initiation simulation, the C-S bond broke in a homolytic manner leaving behind radicals on carbon and sulfur (Fig. 5a and b). Based on preliminary DFT simulations, achieving a simultaneous C-C homolytic cleavage was challenging (Scheme 2, reaction (3)), because of the high thermal stability of the C-C bond. The absence



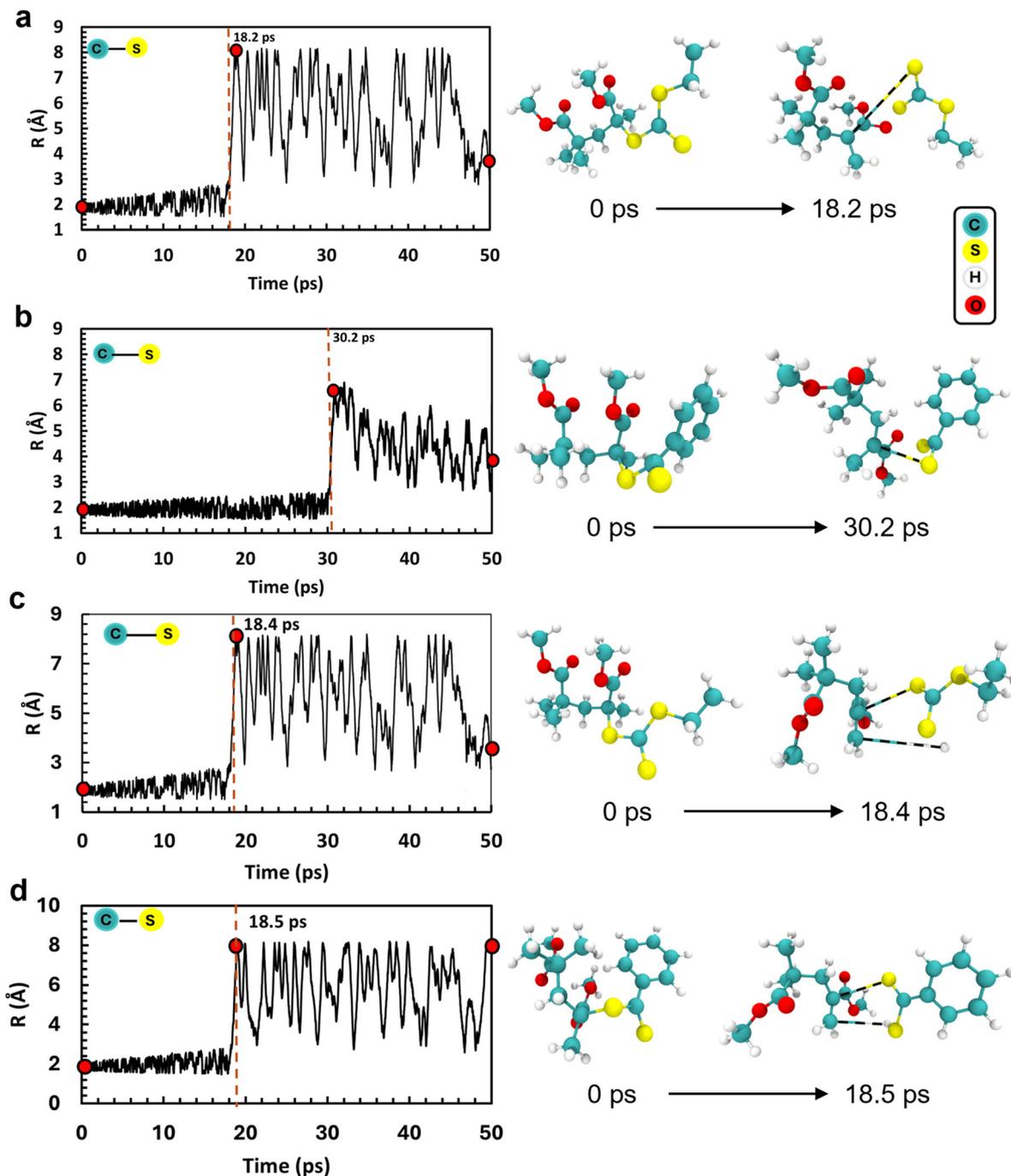


Fig. 5 Variation of C–S bond distances throughout initiation for (a) PMMA-TTC and (b) PMMA-DTB, and over time. The C–S bond is cleaved after 18.2 ps and 30.2 ps for PMMA-TTC and PMMA-DTB, respectively. Variation of C–S bond distances throughout elimination for (c) PMMA-TTC and (d) PMMA-DTB, and over time. The C–S bond is cleaved after 18.4 ps and 18.5 ps for PMMA-TTC and PMMA-DTB, respectively. Snapshots are provided of PMMA-TTC and PMMA-DTB before and after bond cleavage.

of the simultaneous C–C and C–S bond stretching associated with simultaneous initiation and monomer evolution may be attributed to the molecule consisting of only two monomers. Simulation of larger polymers would be more representative of the conformational and entropic effects on the depolymerization thermodynamics potentially

demonstrating simultaneous initiation and monomer release.

Throughout the elimination simulation, the C–S and C–H bonds broke concertedly. For simulations of TTC, DTB, 1-pyrrolicarboxodithioate (DTP), and *N*-pyridine carbonodithioate (PCDT) (Fig. 5c, d, S17, and S18, respectively) the elimination



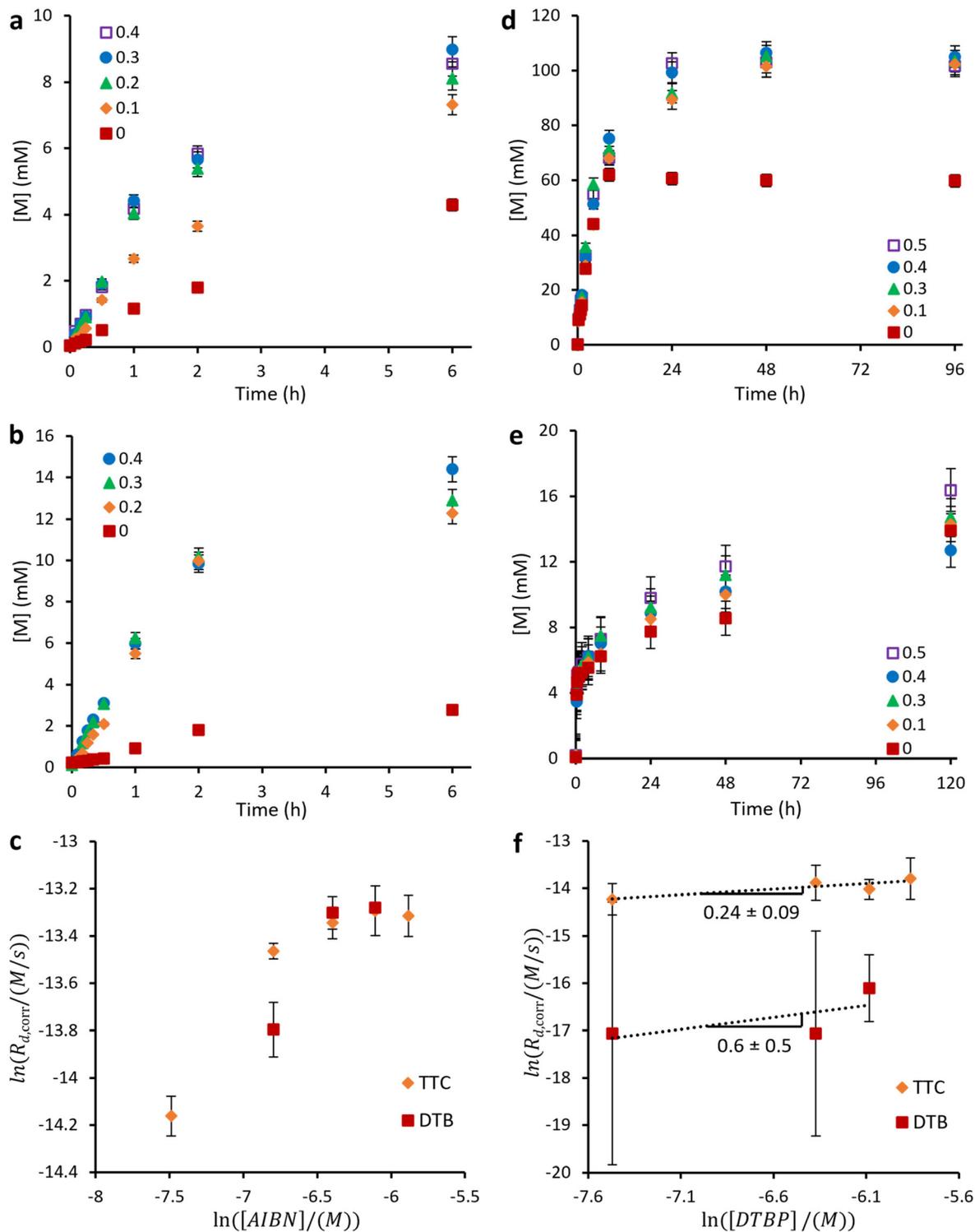


Fig. 6 Depolymerization curves of (a) PMMA-TTC and (b) PMMA-DTB at 90 °C with varying [AIBN] : [End] as indicated by legends. Order analysis of added (c) AIBN at 90 °C. Depolymerization curves of (d) PMMA-TTC and (e) PMMA-DTB at 120 °C with varying [DTBP] : [End] as indicated by legends. Order analysis of added (f) DTBP at 120 °C. All reactions were performed with an end group concentration of 5.56 mM, or 200 mM repeat unit concentration, in toluene-d₈. Error bars of graphs (a), (b), (d) and (e) are one standard error with $n = 2$ replications. Error bars of graphs (c) and (f) are from the standard error of the initial rate.



difference suggests that the RAFT agent and solvent pair could be optimized to lower the rate of elimination for more effective depolymerizations. Furthermore, adding exogenous radical initiators can enhance the rate of depolymerization and yield of monomers when paired with PMMA-TTC through the generation of additional active centers. These findings show that controlled depolymerizations of PMMA *via* RAFT have multiple factors to be optimized.

Author contributions

Empirical: All synthetic and analytical methods were performed by Don Bones under the supervision of Dr William Gramlich. The write-up of the empirical results was done by Don Bones under the supervision of Dr William Gramlich.

Computational: An initial quantum mechanics-based survey of potential RAFT agents was carried out by Emily Nelson and Bryanna Fofie (both undergraduates) under the supervision of Dr Erik P. Hoy to provide insights into the expected activation energies of RAFT agents and provide insights into potential decomposition mechanisms. This informed the design of the final mechanism and dynamics studies that were designed and carried out by Adarsh Kumar (graduate student) under the supervision of Dr Erik P. Hoy. The write-up of the computational results was done by Mr Kumar under the supervision of Dr Hoy.

Conflicts of interest

There are no conflicts to declare.

Data availability

The data supporting this article have been included as part of the supplementary information (SI). Supplementary information is available, which includes derivations of kinetics equations, computational analysis descriptions, additional NMR spectra, and additional kinetics results. See DOI: <https://doi.org/10.1039/d5py00576k>.

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