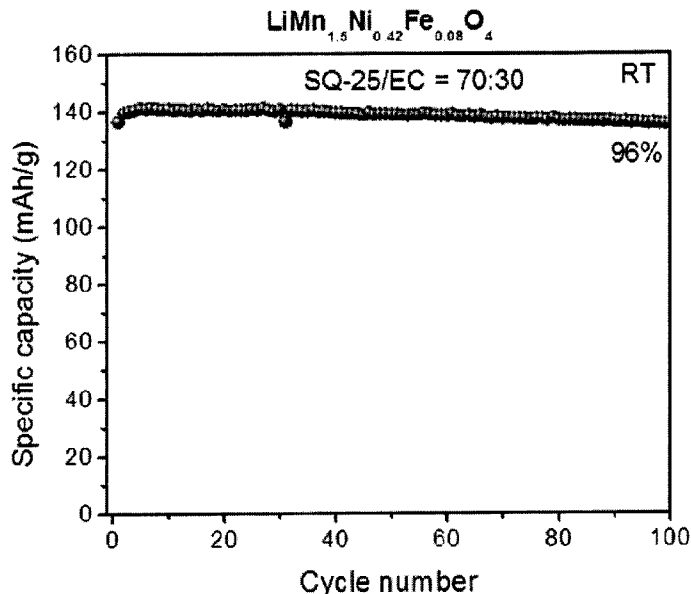




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(54) Titre : BATTERIE LITHIUM ION A ELECTROLYTE NON AQUEUX COMPRENANT UN ESTER D'ACIDE CARBOXYLIQUE CYCLIQUE FLUORE OU UN CARBONATE ACYCLIQUE FLUORE  
 (54) Title: LITHIUM ION BATTERY WITH NONAQUEOUS ELECTROLYTE COMPRISING FLUORINATED ACYCLIC CARBOXYLIC ACID ESTER AND/OR FLUORINATED ACYCLIC CARBONATE



(57) **Abrégé/Abstract:**

A lithium ion battery that has a spinel cathode and a nonaqueous electrolyte comprising a fluorinated acyclic carboxylic acid ester and/or a fluorinated acyclic carbonate solvent is described. The lithium ion battery operates at a high voltage (i.e. up to about 5 V) and has improved cycling performance at high temperature

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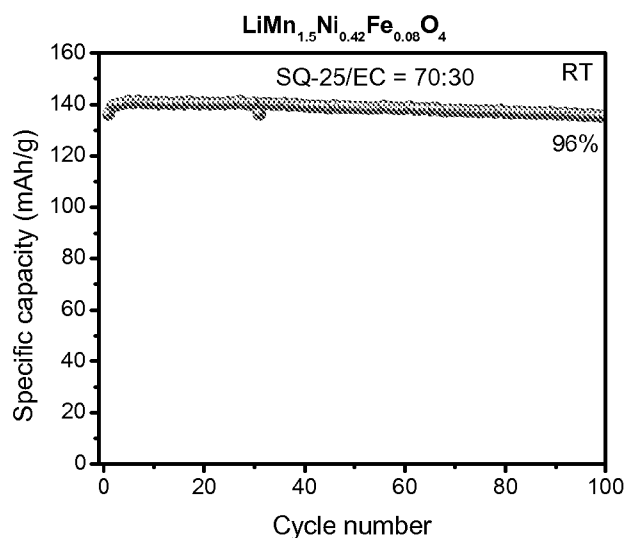
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(54) Title: LITHIUM ION BATTERY

Figure 1



(57) Abstract: A lithium ion battery that has a spinel cathode and a nonaqueous electrolyte comprising a fluorinated acyclic carboxylic acid ester and/or a fluorinated acyclic carbonate solvent is described. The lithium ion battery operates at a high voltage (i.e. up to about 5 V) and has improved cycling performance at high temperature.

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TITLE

LITHIUM ION BATTERY WITH NONAQUEOUS ELECTROLYTE  
COMPRISING FLUORINATED ACYCLIC CARBOXYLIC ACID ESTER  
AND/OR FLUORINATED ACYCLIC CARBONATE

5

10

Technical Field

15           This invention relates to the field of lithium ion  
batteries. More specifically, the invention relates to  
a lithium ion battery comprising a spinel cathode and a  
nonaqueous electrolyte.

20

Background

Lithium ion batteries are being intensively pursued  
for hybrid electric vehicle (HEV) and plug-in hybrid  
electric vehicle (PHEV) applications. Both the 4 V  
25 spinel  $\text{LiMn}_2\text{O}_4$  and 3.4 V olivine  $\text{LiFePO}_4$  cathodes have  
drawn much attention in this regard because Mn and Fe are  
inexpensive and environmentally benign. Additionally,  
these cathodes provide a higher rate capability and  
better safety compared to layered oxide cathodes.  
30 However, both  $\text{LiMn}_2\text{O}_4$  and  $\text{LiFePO}_4$  cathodes have limited

energy density due to their low capacity or operating voltage. One way to improve the energy and power density is to increase the operating voltage. In this regard, the 5 V spinel cathode  $\text{LiMn}_{1.5}\text{Ni}_{0.5}\text{O}_4$  has drawn much attention due to a nearly flat operating voltage close to 5 V and an acceptable capacity arising from operation of the  $\text{Ni}^{2+/3+}$  and  $\text{Ni}^{3+/4+}$  redox couples.

The  $\text{LiMn}_{1.5}\text{Ni}_{0.5}\text{O}_4$  cathode, however, can be characterized by suboptimal cycling performance in a conventional carbonate electrolyte, and this may be due to the large lattice strain during cycling, which involves the formation of three cubic phases with a large lattice parameter difference during the charge-discharge process. Other contributors to suboptimal cycling performance can include the  $\text{Li}_x\text{Ni}_{1-x}\text{O}$  impurity, and the corrosion reaction between the cathode surface and the carbonate electrolyte at the high operating voltage of approximately 5 V.

Partial substitution of Mn and Ni in  $\text{LiMn}_{1.5}\text{Ni}_{0.5}\text{O}_4$  by other elements such as Li, Al, Mg, Ti, Cr, Fe, Co, Cu, Zn and Mo has been pursued to improve the cyclability, as discussed in U.S. Patent No. 6,337,158 (Nakajima); and in Liu et al, *J. Phys. Chem. C* 13:15073-15079, 2009. Although improvement in cycling performance can be achieved in a conventional carbonate electrolyte at room temperature by partial cation substitution, high-temperature cycling performance still remains a problem due to the intrinsic instability of the traditional

carbonate electrolyte and the accelerated decomposition reaction at elevated temperature.

U.S. Patent Application Publication No. 2010/0035162  
5 (Chiga) described a nonaqueous electrolyte for use in a secondary battery that comprises a chain fluorinated carboxylic acid ester represented by the formula  $\text{CH}_3\text{COOCH}_2\text{CH}_{3-x}\text{F}_x$ , wherein  $x$  is 2 or 3, and a film-forming chemical that decomposes in the range of +1.0 to 3.0 V  
10 based on the equilibrium potential between metal lithium and lithium ion. This electrolyte was in various embodiments used in a secondary battery that was provided with a lithium-transition metal oxide cathode having a charge cut-off voltage of 4.2 V.

15

Despite the efforts in the art as described above, a need remains for a lithium ion battery that operates at high voltage (*i.e.* up to about 5 V) and has improved cycling performance at high temperature.

20

### Summary

In one embodiment, there is provided herein a lithium ion battery comprising:

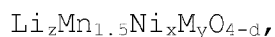
25

(a) a housing;

30

(b) an anode and a cathode disposed in the housing and in conductive contact with one another, wherein the cathode is a manganese cathode comprising a lithium-containing manganese composite oxide having a spinel structure as active material, the lithium-containing

manganese composite oxide being represented by the formula



5

wherein M is at least one metal selected from the group consisting of Al, Cr, Fe, Ga, Zn, Co, Nb, Mo, Ti, Zr, Mg, V and Cu, and  $0.38 \leq x < 0.5$ ,  $0 < y \leq 0.12$ ,  $0 \leq d \leq 0.3$ ,  $0.00 < z \leq 1.1$ , and z changes in accordance with release and uptake of lithium ions and electrons during charge and discharge;

(c) a nonaqueous electrolyte composition disposed in the housing and providing an ionically conductive pathway between the anode and the cathode, wherein the nonaqueous electrolyte composition comprises at least one electrolyte salt and at least one fluorinated acyclic carboxylic acid ester and/or at least one fluorinated acyclic carbonate; and

(d) a porous separator between the anode and the cathode.

In another embodiment, there is provided herein a lithium ion battery comprising:

(a) a housing;

(b) an anode and a cathode disposed in the housing and in conductive contact with one another, wherein the cathode is a manganese cathode comprising a lithium-containing manganese composite oxide having a spinel structure as active material, the lithium-containing manganese composite oxide being represented by the

30

formula



5

wherein z is 0.03 to 1.0; z changes in accordance with release and uptake of lithium ions and electrons during charge and discharge; x is 0.3 to 0.6; M comprises one or more of Cr, Fe, Co, Li, Al, Ga, Nb, Mo, Ti, Zr, Mg, Zn, V, and Cu; y is 0.01 to 0.18, and d is 0 to 0.3;

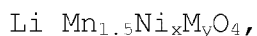
(c) a nonaqueous electrolyte composition disposed in the housing and providing an ionically conductive pathway between the anode and the cathode, wherein the nonaqueous electrolyte composition comprises at least one electrolyte salt and at least one fluorinated acyclic carboxylic acid ester and/or at least one fluorinated acyclic carbonate; and

(d) a porous separator between the anode and the cathode.

In a further alternative embodiment, there is provided herein a lithium ion battery comprising:

- (a) a housing;
- (b) an anode and a cathode disposed in the housing and in conductive contact with one another, wherein the cathode comprises a lithium-containing manganese composite oxide having a spinel structure as active material, the lithium-containing manganese composite oxide being represented by the formula





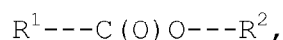
wherein M is at least one metal selected from the group  
 5 consisting of Al, Cr, Fe, Ga and Zn,  $0.4 \leq x < 0.5$ , and  
 $0 < y \leq 0.1$ ;

(c) a nonaqueous electrolyte composition disposed  
 in the housing and providing an ionically conductive  
 pathway between the anode and the cathode, wherein the  
 10 nonaqueous electrolyte composition comprises at least one  
 electrolyte salt and at least one fluorinated acyclic  
 carboxylic acid ester and/or at least one fluorinated  
 acyclic carbonate; and

(d) a porous separator between the anode and the  
 15 cathode.

In yet another alternative embodiment, a fluorinated  
 acyclic carboxylic acid ester can be represented by the  
 following structural formula:

20

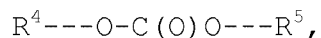


wherein  $\text{R}^1$  is selected from the group consisting of  
 $\text{CH}_3$ ,  $\text{CH}_2\text{CH}_3$ ,  $\text{CH}_2\text{CH}_2\text{CH}_3$ ,  $\text{CH}(\text{CH}_3)_2$ ,  $\text{CF}_3$ ,  $\text{CF}_2\text{H}$ ,  $\text{CFH}_2$ ,  $\text{CF}_2\text{R}^3$ ,  $\text{CFHR}^3$ ,  
 25 and  $\text{CH}_2\text{R}^f$ , wherein  $\text{R}^2$  is independently selected from the  
 group consisting of  $\text{CH}_3$ ,  $\text{CH}_2\text{CH}_3$ ,  $\text{CH}_2\text{CH}_2\text{CH}_3$ ,  $\text{CH}(\text{CH}_3)_2$ , and  
 $\text{CH}_2\text{R}^f$ , wherein  $\text{R}^3$  is a  $\text{C}_1$  to  $\text{C}_3$  alkyl group which is  
 optionally substituted with at least one fluorine,  
 wherein  $\text{R}^f$  is a  $\text{C}_1$  to  $\text{C}_3$  alkyl group substituted with at  
 30 least one fluorine, and further wherein at least one of  $\text{R}^1$

or R<sup>2</sup> contains at least one fluorine and when R<sup>1</sup> is CF<sub>2</sub>H,  
R<sup>2</sup> is not CH<sub>3</sub>, and/or

and a fluorinated acyclic carbonate can be  
represented by the following structural formula:

5



wherein R<sup>4</sup> and R<sup>5</sup> are independently selected from the  
group consisting of CH<sub>3</sub>, CH<sub>2</sub>CH<sub>3</sub>, CH<sub>2</sub>CH<sub>2</sub>CH<sub>3</sub>, CH(CH<sub>3</sub>)<sub>2</sub>, and  
10 CH<sub>2</sub>R<sup>f</sup> where R<sup>f</sup> is a C<sub>1</sub> to C<sub>3</sub> alkyl group substituted with  
at least one fluorine, and further wherein at least one  
of R<sup>4</sup> or R<sup>5</sup> contains at least one fluorine; and

In yet another embodiment hereof, there is disclosed  
15 an electronically powered or assisted device containing a  
lithium ion battery such as described above.

#### Brief Description of the Drawings

20 Figures 1-11 show in graphical form the results of  
the experiments run in Examples 1-11, respectively.

#### Detailed Description

25 Disclosed herein is a lithium ion battery, which is  
a type of rechargeable battery in which lithium ions move  
from the anode to the cathode during discharge, and from  
the cathode to the anode during charge. The lithium ion  
battery disclosed herein includes a housing; an anode  
30 and a cathode disposed in the housing and in conductive

contact with one another; a nonaqueous electrolyte composition providing an ionically conductive pathway between the anode and the cathode; and a porous separator between the anode and the cathode. The  
5 lithium ion battery disclosed herein can operate with the cathode at a high voltage (*i.e.* up to about 5 V relative to a Li|Li<sup>+</sup> reference electrode), and this type of battery can thus in some instances be referred to as a "high voltage" lithium ion battery. It has improved cycling  
10 performance at high temperature compared to other, conventional lithium ion batteries.

The lithium ion battery hereof includes a cathode, which is the electrode of an electrochemical cell at  
15 which reduction occurs during discharge. In a galvanic cell, such as a battery, the cathode is the more positively charged electrode. The cathode in the lithium ion battery hereof is a manganese cathode comprising a lithium-containing manganese composite oxide  
20 having a spinel structure as cathode active material. The lithium-containing manganese composite oxide in a cathode as used herein is represented by the formula



25 wherein M is at least one metal selected from the group consisting of Al, Cr, Fe, Ga, Zn, Co, Nb, Mo, Ti, Zr, Mg, V, and Cu, and  $0.38 \leq x < 0.5$ ,  $0 < y \leq 0.12$ ,  $0 \leq d \leq 0.3$ ,  $0.00 < z \leq 1.1$ , and z changes in  
30 accordance with release and uptake of lithium ions and

electrons during charge and discharge.

In one embodiment, M in the above formula is Fe; in another embodiment, M in the above formula is Ga; and in  
5 another embodiment, M in the above formula is Fe and Ga.

In the various embodiments hereof, the values of x and y can be selected from any one of the members of the group of couples consisting of: x=0.38/y=0.12,  
10 x=0.39/y=0.11, x=0.40/y=0.1, x=0.41/y=0.09,  
x=0.42/y=0.08, x=0.43/y=0.07, x=0.44/y=0.06,  
x=0.45/y=0.05, x=0.46/y=0.04, x=0.47/y=0.03,  
x=0.48/y=0.02, x=0.49/y=0.01.

15 In one embodiment, z has a value given by  $0.03 \leq z \leq 1.1$ . In another embodiment, z has a value given by  $0.03 \leq z \leq 1.0$ .

In one embodiment, M in the above formula is at  
20 least one metal selected from the group consisting of Al, Cr, Fe, Ga and Zn, and  $0.4 \leq x < 0.5$ , and  $0 < y \leq 0.1$ ,  $z = 1$  and  $d = 0$ .

The lithium cathode material described above is  
25 believed to be stabilized by the presence of the M component in the compound. Manganese cathodes stabilized by other systems may also comprise spinel-layered composites which contain a manganese-containing spinel component and a lithium rich layered structure, as  
30 described in U.S. Patent No. 7,303,840.

In an alternative embodiment, the lithium-containing manganese composite oxide in a cathode as used herein comprises oxides of the formula

5



wherein z is 0.03 to 1.0; z changes in accordance with release and uptake of lithium ions and electrons during charge and discharge; x is 0.3 to 0.6; M comprises one or more of Cr, Fe, Co, Li, Al, Ga, Nb, Mo, Ti, Zr, Mg, Zn, V, and Cu; y is 0.01 to 0.18, and d is 0 to 0.3. In one embodiment, in the above formula, x is 0.38 to 0.48, y is 0.03 to 0.12, and d is 0 to 0.1. In one embodiment, in the above formal, M is one or more of Li, Cr, Fe, Co, and Ga.

The cathode active material as described and used herein can be prepared using methods such as the hydroxide precursor method described by Liu *et al* (*J. Phys. Chem. C* 13:15073-15079, 2009). In that method, hydroxide precursors are precipitated from a solution containing desired amounts of manganese, nickel and other desired metal(s) acetates by the addition of KOH. The resulting precipitate is oven-dried and then fired with a desired amount of LiOH·H<sub>2</sub>O at about 800 to about 950°C in oxygen for 3 to 24 hours, as described in detail in the examples herein. Alternatively, the cathode active material can be prepared using a solid phase reaction process or a sol-gel process as described in U.S. Patent

30

No. 5,738,957 (Amine).

The cathode, in which the cathode active material is contained, may be prepared by methods such as mixing an effective amount of the cathode active material (e.g. about 70 wt% to about 97 wt%), a polymer binder, such as polyvinylidene difluoride, and conductive carbon in a suitable solvent, such as N-methylpyrrolidone, to generate a paste, which is then coated onto a current collector such as aluminum foil, and dried to form the cathode.

The lithium ion battery hereof further contains an anode, which is the electrode of an electrochemical cell at which oxidation occurs during discharge. In a galvanic cell, such as a battery, the anode is the more negatively charged electrode. The anode contains anode active material, which can be any material capable of storing and releasing lithium ions. Examples of suitable anode active materials include without limitation lithium alloys such as lithium-aluminum alloy, lithium-lead alloy, lithium-silicon alloy, lithium-tin alloy and the like; carbon materials such as graphite and mesocarbon microbeads (MCMB); phosphorus-containing materials such as black phosphorus,  $\text{MnP}_4$  and  $\text{CoP}_3$ ; metal oxides such as  $\text{SnO}_2$ ,  $\text{SnO}$  and  $\text{TiO}_2$ ; and lithium titanates such as  $\text{Li}_4\text{Ti}_5\text{O}_{12}$  and  $\text{LiTi}_2\text{O}_4$ . In one embodiment, the anode active material is lithium titanate or graphite.

30

An anode can be made by a method similar to that described above for a cathode wherein, for example, a binder such as a vinyl fluoride-based copolymer is dissolved or dispersed in an organic solvent or water, which is then mixed with the active, conductive material to obtain a paste. The paste is coated onto a metal foil, preferably aluminum or copper foil, to be used as the current collector. The paste is dried, preferably with heat, so that the active mass is bonded to the current collector. Suitable anode active materials and anodes are available commercially from companies such as NEI Inc. (Somerset NJ) and Farasis Energy Inc. (Hayward CA).

The lithium ion battery hereof further contains a nonaqueous electrolyte composition, which is a chemical composition suitable for use as an electrolyte in a lithium ion battery. The electrolyte composition typically contains at least one nonaqueous solvent and at least one electrolyte salt. The electrolyte salt is an ionic salt that is at least partially soluble in the solvent of the nonaqueous electrolyte composition and that at least partially dissociates into ions in the solvent of the nonaqueous electrolyte composition to form a conductive electrolyte composition. The conductive electrolyte composition puts the cathode and anode in ionically conductive contact with one another such that ions, in particular lithium ions, are free to move between the anode and the cathode and thereby conduct charge through the electrolyte composition between the

anode and the cathode.

The solvent in the nonaqueous electrolyte composition of the lithium ion battery hereof can contain  
 5 at least one fluorinated acyclic carboxylic acid ester and/or at least one fluorinated acyclic carbonate. A fluorinated acyclic carboxylic acid ester suitable for use herein as a solvent can be described by structural formula as follows:

10



wherein  $R^1$  is selected from the group consisting of  $CH_3$ ,  $CH_2CH_3$ ,  $CH_2CH_2CH_3$ ,  $CH(CH_3)_2$ ,  $CF_3$ ,  $CF_2H$ ,  $CFH_2$ ,  $CF_2R^3$ ,  
 15  $CFHR^3$ , and  $CH_2R^f$ , and  $R^2$  is independently selected from the group consisting of  $CH_3$ ,  $CH_2CH_3$ ,  $CH_2CH_2CH_3$ ,  $CH(CH_3)_2$ , and  $CH_2R^f$ , where  $R^3$  is a  $C_1$  to  $C_3$  alkyl group which is optionally substituted with at least one fluorine, and  $R^f$  is a  $C_1$  to  $C_3$  alkyl group substituted with at least one  
 20 fluorine, and further wherein at least one of  $R^1$  or  $R^2$  contains at least one fluorine and when  $R^1$  is  $CF_2H$ ,  $R^2$  is not  $CH_3$ .

In some embodiments,  $R^1$  is selected from the group  
 25 consisting of  $CH_3$ ,  $CH_2CH_3$ ,  $CH_2CH_2CH_3$ ,  $CH(CH_3)_2$ ,  $CF_3$ ,  $CFHR^3$ , and  $CH_2R^f$ , and  $R^2$  is independently selected from the group consisting of  $CH_3$ ,  $CH_2CH_3$ ,  $CH_2CH_2CH_3$ ,  $CH(CH_3)_2$ , and  $CH_2R^f$ , where  $R^3$  is a  $C_1$  to  $C_3$  alkyl group which is optionally substituted with at least one fluorine, and  $R^f$  is a  $C_1$  to  
 30  $C_3$  alkyl group substituted with at least one fluorine, and



further wherein at least one of R<sup>1</sup> or R<sup>2</sup> contains at least one fluorine.

In some embodiments, R<sup>1</sup> is selected from the group consisting of CH<sub>3</sub>, CH<sub>2</sub>CH<sub>3</sub>, CH<sub>2</sub>CH<sub>2</sub>CH<sub>3</sub>, CH(CH<sub>3</sub>)<sub>2</sub>, and CH<sub>2</sub>R<sup>f</sup>, and R<sup>2</sup> is independently selected from the group consisting of CH<sub>3</sub>, CH<sub>2</sub>CH<sub>3</sub>, CH<sub>2</sub>CH<sub>2</sub>CH<sub>3</sub>, CH(CH<sub>3</sub>)<sub>2</sub>, CH<sub>2</sub>R<sup>f</sup>, where R<sup>f</sup> is a C<sub>1</sub> to C<sub>3</sub> alkyl group substituted with at least one fluorine, and further wherein at least one of R<sup>1</sup> or R<sup>2</sup> contains at least one fluorine.

In other alternative embodiments a fluorine-containing carboxylic acid ester suitable for use herein can be represented by the formula:

15



where R<sup>8</sup> and R<sup>9</sup> independently represent an alkyl group, the sum of carbon atoms in R<sup>8</sup> and R<sup>9</sup> is 2 to 7, at least two hydrogens in R<sup>8</sup> and/or R<sup>9</sup> are replaced by fluorines and neither R<sup>8</sup> nor R<sup>9</sup> contains a FCH<sub>2</sub> or FCH group.

In some embodiments the fluorinated acyclic carboxylic acid ester is selected from one or more members of the group consisting of:

CH<sub>3</sub>C(O)OCH<sub>2</sub>CF<sub>2</sub>H (2,2,-difluoroethyl acetate, CAS No. 1550-44-3),  
 CH<sub>3</sub>C(O)OCH<sub>2</sub>CF<sub>3</sub> (2,2,2-trifluoroethyl acetate, CAS No. 406-95-1), and  
 CH<sub>3</sub>C(O)OCH<sub>2</sub>CF<sub>2</sub>CF<sub>2</sub>H (2,2,3,3-tetrafluoropropyl

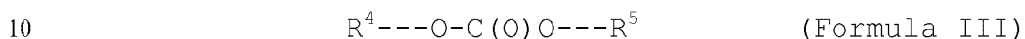
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acetate, CAS No. 681-58-3).

In one particular embodiment, the fluorinated acyclic carboxylic ester solvent is  $\text{CH}_3\text{C}(\text{O})\text{OCH}_2\text{CF}_2\text{H}$ .

5

A fluorinated acyclic carbonate suitable for use herein as a solvent can be described by structural formula as follows:



wherein  $\text{R}^4$  and  $\text{R}^5$  are independently selected from the group consisting of  $\text{CH}_3$ ,  $\text{CH}_2\text{CH}_3$ ,  $\text{CH}_2\text{CH}_2\text{CH}_3$ ,  $\text{CH}(\text{CH}_3)_2$ , and  $\text{CH}_2\text{R}^f$  where  $\text{R}^f$  is a  $\text{C}_1$  to  $\text{C}_3$  alkyl group substituted with at least one fluorine, and further wherein at least one of  $\text{R}^4$  or  $\text{R}^5$  contains at least one fluorine.

15

In some embodiments, the fluorinated acyclic carbonate solvent is selected from one or more members of the group consisting of:

20

$\text{CH}_3\text{OC}(\text{O})\text{OCH}_2\text{CF}_2\text{H}$  (methyl 2,2-difluoroethyl carbonate, CAS No. 916678-13-2),

$\text{CH}_3\text{OC}(\text{O})\text{OCH}_2\text{CF}_3$  (methyl 2,2,2-trifluoroethyl carbonate, CAS No. 156783-95-8), and

25

$\text{CH}_3\text{OC}(\text{O})\text{OCH}_2\text{CF}_2\text{CF}_2\text{H}$  (methyl 2,2,3,3-tetrafluoropropyl carbonate, CAS No. 156783-98-1).

In one particular embodiment, the fluorinated acyclic carbonate solvent is  $\text{CH}_3\text{OC}(\text{O})\text{OCH}_2\text{CF}_3$ .

30

A mixture of two or more of these fluorinated acyclic carboxylic acid ester and/or fluorinated acyclic carbonate solvents may also be used.

5 Fluorinated acyclic carboxylic acid esters and fluorinated acyclic carbonates suitable for use herein may be prepared using known methods. For example, acetyl chloride may be reacted with 2,2-difluoroethanol (with or without a basic catalyst) to form 2,2-  
10 difluoroethyl acetate. Additionally, 2,2-difluoroethyl acetate and 2,2-difluoroethyl propionate may be prepared using the method described by Wiesenhofer *et al* (WO 2009/040367 A1, Example 5). Similarly, methyl chloroformate may be reacted with 2,2-difluoroethanol to  
15 form methyl 2,2-difluoroethyl carbonate. Alternatively, some of these fluorinated solvents may be purchased from companies such as Matrix Scientific (Columbia SC). For best results, it is desirable to purify the fluorinated acyclic carboxylic esters and fluorinated acyclic  
20 carbonates to a purity level of at least about 99.9%, more particularly at least about 99.99%. These fluorinated solvents may be purified using distillation methods such as vacuum distillation or spinning band distillation.

25

The nonaqueous electrolyte composition in a lithium ion battery hereof can also contain a solvent mixture that includes at least one fluorinated acyclic carboxylic acid ester and/or a fluorinated acyclic carbonate, as  
30 described above, and at least one co-solvent. Examples

of suitable co-solvents include without limitation ethylene carbonate (EC), propylene carbonate, fluoroethylene carbonate (FEC), tetramethylene sulfone and ethyl methyl sulfone. For best results, it is desirable to use a co-

5 solvent that is battery grade or has a purity level of at least about 99.9%, and more particularly at least about 99.99%. In one embodiment, the co-solvent is ethylene carbonate. In another embodiment, the fluorinated acyclic carboxylic acid ester is  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  and the co-

10 solvent is ethylene carbonate or fluorinated ethylene carbonate.

A fluorinated acyclic carboxylic acid ester and/or a fluorinated acyclic carbonate, as described above, and

15 the co-solvent may be combined in various ratios to form a solvent mixture as used in an electrolyte composition, depending on the desired properties of the electrolyte composition. In one embodiment, the fluorinated acyclic carboxylic acid ester and/or fluorinated acyclic

20 carbonate comprises about 40% to about 90% by weight of the solvent mixture. In another embodiment, the fluorinated acyclic carboxylic acid ester and/or fluorinated acyclic carbonate comprises about 50% to about 80% by weight of the solvent mixture. In another

25 embodiment, the fluorinated acyclic carboxylic acid ester and/or fluorinated acyclic carbonate comprises about 60% to about 80% by weight of the solvent mixture. In another embodiment, the fluorinated acyclic carboxylic acid ester and/or fluorinated acyclic carbonate comprises

30 about 65% to about 75% by weight of the solvent mixture.

In another embodiment, the fluorinated acyclic carboxylic acid ester and/or fluorinated acyclic carbonate comprises about 70% by weight of the solvent mixture.

5           In another embodiment, the nonaqueous electrolyte composition comprises a solvent mixture containing the fluorinated acyclic carboxylic acid ester  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  and ethylene carbonate, wherein  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  comprises about 50% to about 80% by weight of the solvent mixture. In  
10 another embodiment, the nonaqueous electrolyte composition contains a solvent mixture of the fluorinated acyclic carboxylic ester  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  and ethylene carbonate, wherein  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  comprises about 65% to about 75% by weight of the solvent mixture.

15

A nonaqueous electrolyte composition in a lithium ion battery herein also contains at least one electrolyte salt. Suitable electrolyte salts include without limitation

20           lithium hexafluorophosphate,  $\text{Li PF}_3(\text{CF}_2\text{CF}_3)_3$ ,  
            lithium bis(trifluoromethanesulfonyl)imide,  
            lithium bis(perfluoroethanesulfonyl)imide,  
            lithium (fluorosulfonyl)  
            (nonafluorobutanesulfonyl)imide,  
25           lithium bis(fluorosulfonyl)imide,  
            lithium tetrafluoroborate,  
            lithium perchlorate,  
            lithium hexafluoroarsenate,  
            lithium trifluoromethanesulfonate,  
30           lithium tris(trifluoromethanesulfonyl)methide,

lithium bis(oxalato)borate,  
lithium difluoro(oxalato)borate,  
 $\text{Li}_2\text{B}_{12}\text{F}_{12-x}\text{H}_x$  where x is equal to 0 to 8, and  
mixtures of lithium fluoride and anion receptors  
5 such as  $\text{B}(\text{OC}_6\text{F}_5)_3$ .

Mixtures of two or more of these or comparable  
electrolyte salts may also be used. In one embodiment,  
the electrolyte salt is lithium hexafluorophosphate.  
The electrolyte salt can be present in the nonaqueous  
10 electrolyte composition in an amount of about 0.2 to  
about 2.0 M, more particularly about 0.3 to about 1.5 M,  
and more particularly about 0.5 to about 1.2 M.

A nonaqueous electrolyte composition in a lithium  
15 ion battery hereof may also contain at least one additive  
that are believed to contribute to film forming on one or  
both of the electrodes. Suitable such additives include  
without limitation

fluoroethylene carbonate (also referred to  
20 herein as 4-fluoro-1,3-dioxolan-2-one, CAS No.  
114435-02-8) and its halogenated,  $\text{C}_1\sim\text{C}_3$  and  
halogenated  $\text{C}_1\sim\text{C}_3$  derivatives,  
ethylene sulfate and its halogenated,  $\text{C}_1\sim\text{C}_3$  and  
halogenated  $\text{C}_1\sim\text{C}_3$  derivatives,  
25 vinyl ethylene carbonate and its halogenated,  
 $\text{C}_1\sim\text{C}_3$  and halogenated  $\text{C}_1\sim\text{C}_3$  derivatives,  
vinylene carbonate and its halogenated,  $\text{C}_1\sim\text{C}_3$   
and halogenated  $\text{C}_1\sim\text{C}_3$  derivatives,  
maleic anhydride and its halogenated,  $\text{C}_1\sim\text{C}_3$  and  
30 halogenated  $\text{C}_1\sim\text{C}_3$  derivatives, and

vinyl acetate.

In one embodiment, the preferred additive is fluoroethylene carbonate.

5           These additives are generally available commercially; fluoroethylene carbonate, for example, is available from companies such as China LangChem INC. (Shanghai, China) and MTI Corp. (Richmond, CA). It is desirable to purify these additives to a purity level of  
10 at least about 99.0%, more particularly at least about 99.9%. Purification may be done using known methods, as described above. This type of additive, if used, is generally present in an amount of about 0.01% to about 5%, more particularly about 0.1% to about 2%, and more  
15 particularly about 0.5% to about 1.5% by weight of the total electrolyte composition.

The lithium ion battery hereof also contains a porous separator between the anode and cathode. The  
20 porous separator serves to prevent short circuiting between the anode and the cathode. The porous separator typically consists of a single-ply or multi-ply sheet of a microporous polymer such as polyethylene, polypropylene, polyamide or polyimide, or a combination  
25 thereof. The pore size of the porous separator is sufficiently large to permit transport of ions to provide ionically conductive contact between the anode and cathode, but small enough to prevent contact of the anode and cathode either directly or from particle penetration  
30 or dendrites which can form on the anode and cathode.

Examples of porous separators suitable for use herein are disclosed in U.S. Application SN 12/963,927 (filed 09 Dec 2010), published as U.S. Patent Application Publication No. 2012/0149852 A1.

5

The housing of the lithium ion battery hereof may be any suitable container to house the lithium ion battery components described above. Such a container may be  
10 fabricated in the shape of small or large cylinder, a prismatic case or a pouch.

A lithium ion battery hereof may be used for grid  
15 storage or as a power source in various electronically powered or assisted devices such as a transportation device (including a motor vehicle, automobile, truck, bus or airplane), a computer, a telecommunications device, a camera, a radio, or a power tool.

20



### Examples

The operation and effects of certain embodiments  
5 of the inventions hereof may be more fully appreciated  
from a series of examples, as described below. The  
embodiments on which these examples are based are  
representative only, and the selection of those  
embodiments to illustrate the inventions hereof does not  
10 indicate that materials, components, reactants,  
conditions, techniques, configurations or designs not  
described in the examples are not suitable for use  
herein, or that subject matter not described in the  
examples is excluded from the scope of the appended  
15 claims and equivalents thereof. The significance of the  
examples is better understood by comparing the results  
obtained therefrom with the results obtained from certain  
trial runs that are designed to serve as controlled  
experiments and provide a basis for such comparison since  
20 a different type of solvent was used in those trial runs.

The meaning of abbreviations used in the examples is  
as follows: "g" means gram(s), "mg" means milligram(s),  
25 "µg" means microgram(s), "L" means liter(s), "mL" means  
milliliter(s), "mol" means mole(s), "mmol" means  
millimole(s), "M" means molar concentration, "wt%" means  
percent by weight, "Hz" means hertz, "mS" means  
millisiemen(s), "mA" mean milliamp(s), "mAh/g" means  
30 milliamp hour(s) per gram, "V" means volt(s),

"x C" refers to a constant current that can fully charge/discharge the cathode in 1/x hours, "SOC" means state of charge, "SEI" means solid electrolyte interface formed on the surface of the electrode material, "kPa" means kilopascal(s), "rpm" means revolutions per minute, "psi" means pounds per square inch.

#### Preparation of $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$ Cathode Active Material

10 Iron-doped  $\text{LiMn}_{1.5}\text{Ni}_{0.5}\text{O}_4$  was synthesized by the hydroxide precursor method described by Liu *et al* (*J. Phys. Chem. C* 113, 15073-15079, 2009). In this method, hydroxide precursors were precipitated from a 100 mL solution containing 7.352 g of  $\text{Mn}(\text{CH}_3\text{COO})_2 \cdot 4\text{H}_2\text{O}$ , 2.090 g  
15 of  $\text{Ni}(\text{CH}_3\text{COO})_2 \cdot 4\text{H}_2\text{O}$ , and 0.278 g of  $\text{Fe}(\text{CH}_3\text{COO})_2$  by adding this solution to 200 mL of 3.0 M KOH solution dropwise. The resulting precipitate was collected by filtration, washed extensively with deionized water, and then dried in an oven, yielding 3.591 g of the transition metal  
20 hydroxides.

The precipitate containing the transition metal hydroxides was then mixed with 0.804 g of  $\text{LiOH} \cdot \text{H}_2\text{O}$  at 900°C in air for 12 h with a heating/cooling rate of  
25 1°C /min. The resulting  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  showed the same cubic spinel structure as  $\text{LiMn}_{1.5}\text{Ni}_{0.5}\text{O}_4$  without impurities, as determined by X-ray powder diffraction.

30

Preparation of  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  Cathode

The  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  (2.08 g) cathode active material, prepared as described above, 0.26 g of Denka black (acetylene black, obtained from DENKA Corp., Japan), 2.16 g of polyvinylidene difluoride (PVDF) solution (12 wt% in N-methylpyrrolidone (NMP), Kureha America Inc., New York, NY, KFL#1120), and an additional 2.93 g of NMP were mixed first using a planetary centrifugal mixer (THINKY ARE-310, THINKY Corp., Japan) at 2,000 rpm and then using a shear mixer (IKA® Works, Wilmington, NC) to form a uniform slurry. The slurry was coated on aluminum foil using a doctor blade gate, and dried in a convection oven at 100°C for 10 to 15 min. The resulting electrode was calendared at ambient temperature between 102 mm diameter steel rolls at a nip force of 370 kg. The electrode was further dried in a vacuum oven at 90°C at -25 inches of Hg (-85 kPa) for 6 h.

20

Preparation of Nonaqueous Electrolyte Composition  
Comprising 2,2-Difluoroethyl Acetate

2,2-Difluoroethyl acetate, obtained from Matrix Scientific (Columbia, SC), was purified by spinning band distillation twice to 99.99% purity, as determined by gas chromatography using a flame ionization detector. The purified 2,2-difluoroethyl acetate (7.32 g) and 3.10 g of ethylene carbonate (99%, anhydrous, Sigma-Aldrich, Milwaukee, WI) were mixed together. To 9.0 mL of the resulting solution was added 1.35 g of lithium

30

hexafluorophosphate (99.99% battery grade, Sigma-Aldrich) and the mixture was shaken for a few minutes until all the solid was dissolved. In the Figures, this electrolyte composition is referred to as "SQ-25/EC" or "TE-5".

5

Preparation of Nonaqueous Electrolyte Composition  
Comprising 2,2-Difluoroethyl Acetate and Fluoroethylene  
Carbonate Additive

4-Fluoro-1,3-dioxolan-2-one, obtained from China  
10 LangChem INC, (Shanghai, China), was purified by vacuum  
distillation. The purified 4-fluoro-1,3-dioxolan-2-one  
(0.053 g) was added to 5.30 g of the nonaqueous  
electrolyte composition described above and the mixture  
was shaken for several minutes.

15

Synthesis of Methyl 2,2,2-Trifluoroethyl Carbonate  
(CH<sub>3</sub>OC(O)OCH<sub>2</sub>CF<sub>3</sub>)

In a dry-box, chloroformate (232.0 g, Sigma-Aldrich)  
20 was added to a solution of 2,2,2-trifluoroethanol (202.0  
g, Sigma-Aldrich), pyridine (194.0 g, anhydrous, Sigma-  
Aldrich), and dichloromethane (1.5 L, anhydrous, EMD  
Chemicals, Gibbstown, NJ, at 0 to 15°C. The mixture was  
stirred at room temperature over the weekend. A sample  
25 was taken for NMR analysis, which indicated that the  
conversion of 2,2,2-trifluoroethanol was 100%. The  
mixture was filtered. The collected solid was washed  
with dichloromethane, and the combined organic liquid  
filtrate was washed five times with 50 mL portions of 5%  
30 HCl. A sample was taken for NMR analysis, and pyridine

was detected. The organic liquid filtrate was then washed four more times with 25 mL portions of 5% HCl, after which no pyridine was detected by NMR. The organic liquid filtrate was washed with brine (50 mL).  
5 Dichloromethane was removed from the organic liquid filtrate by rotoevaporation. The crude product (273 g) obtained was dried over molecular sieves, and then twice purified by spinning-band column distillation. Pure material (101.6 g) was obtained and used for the  
10 electrolyte composition.

Preparation of Nonaqueous Electrolyte Composition  
Comprising Methyl 2,2,2-Trifluoroethyl Carbonate,

15 Ethylene Carbonate and Fluoroethylene Carbonate Additive

Methyl 2,2,2-trifluoroethyl carbonate (10.0 g) was dried over 4A molecular sieves (1.0 g) over the weekend, and then further dried over 4A molecular sieves (1.0 g) overnight. The dried methyl 2,2,2-trifluoroethyl  
20 carbonate was then filtered with a PTFE (polytetrafluoroethylene) filter plate with syringe. The dried, filtered methyl 2,2,2-trifluoroethyl carbonate (2.80 g) was mixed with ethylene carbonate (Novolyte, 1.20 g) and the resulting solvent mixture was shaken  
25 until all solid was dissolved. To a 2-mL GC vial (oven dried), was added  $\text{LiPF}_6$  (0.076 g, Novolyte, Cleveland OH), followed by the addition of 1.0 mL of the solvent mixture. The net weight of the resulting mixture was 1.36 g. The mixture was shaken until all solid was  
30 dissolved. To the above mixture, 4-fluoro-1,3-dioxolan-

2-one (14 mg, LongChem, Shanghai, China, purified by vacuum distillation) was added. The resulting nonaqueous electrolyte composition was shaken and stored in a dry-box.

5

Preparation of Nonaqueous Electrolyte Composition  
Comprising 2,2,2-Trifluoroethyl Acetate, Ethylene  
Carbonate and Fluoroethylene Carbonate Additive

10 2,2,2-Trifluoroethyl acetate ( $\text{CH}_3\text{C}(\text{O})\text{OCH}_2\text{CF}_3$ ), obtained from SynQuest Laboratories (Alachua FL), was purified by spinning-band column distillation twice to 99.9% purity, as determined by gas chromatography using a flame ionization detector. The purified 2,2,2-  
15 trifluoroethyl acetate (10.0 g) was dried over 4A molecular sieves (1.0 g) over the weekend, and further dried over 4A molecular sieves (1.0 g) overnight. The dried, purified 2,2,2-trifluoroethyl acetate was then filtered with a PTFE filter plate with syringe. The  
20 filtered material (2.80 g) was mixed with ethylene carbonate (Novolyte, 1.20 g) and the resulting solvent mixture was shaken until all solid was dissolved. To a 2 mL GC vial (oven dried), was added  $\text{LiPF}_6$  (0.076 g, Novolyte, Cleveland OH), followed by the addition of 1.0  
25 mL of the solvent mixture. The net weight of the resulting mixture was 1.38 g. The mixture was shaken until all solid was dissolved. To this mixture, 4-fluoro-1,3-dioxolan-2-one (14 mg, LongChem, Shanghai, China, purified by vacuum distillation) was added. The  
30 resulting nonaqueous electrolyte composition was shaken

and stored in a dry-box.

Synthesis of Methyl 2,2-Difluoroethyl Carbonate

5 (CH<sub>3</sub>OC(O)OCH<sub>2</sub>CF<sub>2</sub>H)

Under nitrogen protection, chloroformate (136.1 g, Sigma-Aldrich) was added slowly via syringe pump, over a period of 3 h, to a solution of 2,2-difluoroethanol (113.9.0 g, Matrix Scientific, Columbia SC, purified by spinning-band column distillation), pyridine (113.9 g, anhydrous, Sigma-Aldrich), and dichloromethane (0.80 L, anhydrous, EMD Chemicals, Gibbstown NJ) in a 2-L oven-dried, three-neck flask, which was equipped with overhead stirring, and cooled with a water bath. The resulting mixture was stirred at room temperature overnight. A sample was taken for NMR analysis, which revealed that no 2,2-difluoroethanol was detected. The mixture was filtered and the filtrate was washed with 100 mL of 10% HCl, followed by two more washes with 50 mL portions of 10% HCl. A sample was taken for NMR analysis, which revealed that no pyridine was detected. The filtrate was then washed with 50 mL of 5% Na<sub>2</sub>CO<sub>3</sub> solution, then with 100 mL of brine. The organic layer was dried over anhydrous MgSO<sub>4</sub> (50 g) for 2 h, then dried over molecular sieves (4A, 50 g) overnight. The dried solution was rotoevaporated to remove dichloromethane. The crude product obtained (208 g) was purified by spinning-band column distillation. Pure product (101.7 g) was obtained and used for the electrolyte composition.

30

Preparation of Nonaqueous Electrolyte Composition  
Comprising Methyl 2,2-Difluoroethyl Carbonate, Ethylene  
Carbonate and Fluoroethylene Carbonate Additive

5 Methyl 2,2-difluoroethyl carbonate (10.0 g) was dried  
over 4A molecular sieves (1.0 g) overnight, then further  
dried over 4A molecular sieves (1.0 g) overnight. The  
dried methyl 2,2-difluoroethyl carbonate was then  
filtered with a PTFE filter plate with syringe. The  
10 filtered material (2.80 g) was mixed with ethylene  
carbonate (Novolyte, 1.20 g) and the resulting solvent  
mixture was shaken until all solid was dissolved. To a  
2-mL GC vial (oven dried), was added  $\text{LiPF}_6$  (0.228 g,  
Novolyte), followed by the addition of 1.5 mL of the  
15 solvent mixture. The net weight of the resulting  
mixture was 2.19 g. The mixture was shaken until all  
solid was dissolved. To 1.0 g of this mixture, 4-  
fluoro-1,3-dioxolan-2-one (10 mg, LongChem, Shanghai,  
China, purified by vacuum distillation) was added. The  
20 resulting nonaqueous electrolyte composition was shaken  
and stored in a dry-box.

Preparation of Nonaqueous Electrolyte Composition  
25 Comprising Methyl 2,2-Difluoroacetate, Ethylene  
Carbonate and Fluoroethylene Carbonate Additive

Methyl 2,2-difluoroacetate ( $\text{HCF}_2\text{C}(\text{O})\text{OCH}_3$ ), obtained  
from SynQuest, was purified by spinning-band column  
distillation twice to 99.9% purity, as determined by gas  
30 chromatography using a flame ionization detector. The



purified methyl 2,2-difluoroacetate (10.0 g) was dried over 4A molecular sieves (1.0 g) overnight, then further dried over 4A molecular sieves (1.0 g) overnight. The dried, purified methyl 2,2-difluoroacetate was then  
5 filtered with a PTFE filter plate with syringe. The filtered material (2.80 g) was mixed with ethylene carbonate (Novolyte, 1.20 g) and the resulting solvent mixture was shaken until all solid was dissolved. To a 2-mL GC vial (oven dried), was added  $\text{LiPF}_6$  (0.228 g,  
10 Novolyte), followed by the addition of 1.5 mL of the solvent mixture. The net weight of the resulting mixture was 2.15 g. The mixture was shaken until all solid was dissolved. To 1.0 g of the mixture, 4-fluoro-1,3-dioxolan-2-one (10 mg, LongChem, Shanghai, China,  
15 purified by vacuum distillation) was added. The resulting nonaqueous electrolyte composition was shaken and stored in a dry-box.

20 Synthesis of 2,2,3,3-Tetrafluoropropyl Acetate  
( $\text{CH}_3\text{C}(\text{O})\text{OCH}_2\text{CF}_2\text{CF}_2\text{H}$ )

Under nitrogen protection, acetyl chloride (94.2 g, Sigma-Aldrich) was added slowly via syringe pump, over a period of 3 h, to 2,2,3,3-tetrafluoropropanol (132.0 g,  
25 97%, SynQuest) in an oven-dried 0.5-L round-bottom flask, which was equipped with magnetic stirring and cooled with an ice/water bath. The flask was connected via tubing to a 10% NaOH solution trap to trap HCl gas generated (a funnel was used to avoid suction of NaOH solution back  
30 into the system). The mixture was stirred at room

temperature overnight. A sample was taken for NMR analysis and 2,2,3,3-tetrafluoropropanol was detected. Acetyl chloride (0.6 g) was added to the mixture, and the mixture was stirred at room temperature for 2 h. NMR  
5 analysis showed that no 2,2,3,3-tetrafluoropropanol was present. The mixture was washed 5 times with 25 mL portions of 10% Na<sub>2</sub>CO<sub>3</sub>, then with 25 mL of water, followed by 25 mL of brine. The resulting mixture was dried over anhydrous MgSO<sub>4</sub> (20 g) overnight, then further dried twice  
10 over 5 g of 4A molecular sieves. The resulting crude product was purified by spinning-band column distillation. Pure material (82.7 g) was obtained and used for the electrolyte composition.

15

Preparation of Nonaqueous Electrolyte Composition  
Comprising 2,2,3,3-Tetrafluoropropyl Acetate, and  
Ethylene Carbonate

2,2,3,3-Tetrafluoropropyl acetate (10.0 g) was dried  
20 over 4A molecular sieves (1.0 g) overnight and then filtered with a PTFE filter plate with syringe. The dried, filtered material (2.80 g) was mixed with ethylene carbonate (Novolyte, 1.20 g) and the resulting solvent mixture was shaken until all solid was dissolved. To a  
25 2-mL GC vial (oven dried), was added LiPF<sub>6</sub> (0.076 g, Novolyte, Cleveland OH), followed by the addition of 1.0 mL of the solvent mixture. The net weight of the resulting mixture was 1.42 g. The mixture was shaken until all solid was dissolved. The resulting nonaqueous  
30 electrolyte composition was filtered with a PTFE filter

plate with syringe and then stored in a dry-box.

Synthesis of Methyl 2,2,3,3-Tetrafluoropropyl Carbonate  
5 (CH<sub>3</sub>OC(O)OCH<sub>2</sub>CF<sub>2</sub>CF<sub>2</sub>H)

Under nitrogen protection, chloroformate (113.4 g, Sigma-Aldrich) was added slowly via syringe pump, over a period of 3 h, to a solution of 2,2,3,3-tetrafluoropropanol (132.0 g, 97%, SynQuest), pyridine  
10 (94.9 g, anhydrous, Sigma-Aldrich), and dichloromethane (0.80 L, anhydrous, EMD Chemicals) in an oven-dried, 2-L three-neck flask, which was equipped with overhead stirring and cooled with a water bath. The resulting mixture was stirred at room temperature overnight. A  
15 sample was taken for NMR analysis, which revealed that no 2,2,3,3-tetrafluoropropanol was detected. The mixture was filtered and the resulting filtrate was washed with 100 mL of 10% HCl, followed by 2 washes with 50 mL portions of 10% HCl. An NMR analysis revealed  
20 that pyridine was detected. The mixture was washed again with 50 mL of 10% HCl and an NMR analysis revealed that no pyridine was detected. The mixture was washed with 50 mL of 5% Na<sub>2</sub>CO<sub>3</sub>, then with 100 mL of brine. The organic layer was dried over anhydrous MgSO<sub>4</sub> (50 g) for 2  
25 h, then molecular sieves (4A, 50 g) overnight. The dried organic layer was rotoevaporated to remove dichloromethane. The resulting crude product was purified by spinning-band column distillation. Pure material (96.0 g) was obtained and used for the  
30 electrolyte composition.

Preparation of Nonaqueous Electrolyte Composition  
Comprising Methyl 2,2,3,3-Tetrafluoropropyl Carbonate,  
and Ethylene Carbonate

5 Methyl 2,2,3,3-tetrafluoropropyl carbonate (10.0 g) was dried over 4A molecular sieves (1.0 g) overnight. The dried methyl 2,2,3,3-tetrafluoropropyl carbonate was then filtered with a PTFE filter plate with syringe.

10 The dried, filtered material (2.80 g) was mixed with ethylene carbonate (Novolyte, 1.20 g) and the resulting solvent mixture was shaken until all solid was dissolved. To a 2-mL GC vial (oven-dried), was added  $\text{LiPF}_6$  (0.076 g, Novolyte, Cleveland OH), followed by the addition of 1.0

15 mL of the solvent mixture. The net weight of the resulting mixture was 1.43 g. The mixture was shaken until all solid was dissolved. The resulting nonaqueous electrolyte composition was filtered with a PTFE filter plate with syringe and then stored in a dry-box.

20

Fabrication of  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}$  Half Cells

A  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  cathode, prepared as described above, a Celgard® separator 2325 (Celgard, LLC,

25 Charlotte, NC), a lithium foil anode (0.75 mm in thickness) and a few drops of the nonaqueous electrolyte composition of interest were sandwiched in 2032 stainless steel coin cell cans (Hohsen Corp., Japan) to form the  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}$  half cells.

30

Fabrication of  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$  Full Cells

A  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  cathode, prepared as described above, a Celgard® separator 2325 (Celgard, LLC.

5 Charlotte, NC), a  $\text{Li}_4\text{Ti}_5\text{O}_{12}$  anode (Farasis Energy Inc., Hayward, California), and a few drops of the nonaqueous electrolyte composition of interest, were sandwiched in 2032 stainless steel coin cell cans to form the  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$  full cells.

10

EXAMPLE 1Room Temperature Cycling Performance of $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}$  Half Cell with Nonaqueous

15 Electrolyte Composition Comprising 2,2-Difluoroethyl Acetate

A  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell was prepared as described above with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate,

20 prepared as described above. This  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}$  half cell was cycled between 3.5 and 4.95 V at 0.2C rate and 25°C. The cycling performance data is shown in Figure 1. As can be seen from the figure, the  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell with the nonaqueous  
25 electrolyte composition comprising 2,2-difluoroethyl acetate had a capacity retention of 96% in 100 cycles at room temperature.

30

EXAMPLE 2

Room Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li Half Cell with Nonaqueous  
5 Electrolyte Composition Comprising 2,2-Difluoroethyl  
Acetate and Fluoroethylene Carbonate

A LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was prepared as described above with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate and the  
10 fluoroethylene carbonate additive, prepared as described above. This LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was cycled between 3.5 and 4.95 V at 0.2C rate and 25°C.

The cycling performance data is shown in Figure 2.  
15 As can be see from the figure, the LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate and the fluoroethylene carbonate additive had a capacity retention of 98% in 80 cycles at room temperature.

20

EXAMPLE 3, COMPARATIVE

Room Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li Half Cell with Standard EC/EMC  
25 Electrolyte

A LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was prepared as described above using a standard electrolyte containing ethyl carbonate (EC)/ethyl methyl carbonate (EMC) in a volume ratio of 30:70 and 1 M LiPF<sub>6</sub> (Novolyte, Cleveland,  
30 OH). This half cell was cycled between 3.5 and 4.95 V

at 0.2C rate and 25°C.

The cycling performance data is shown in Figure 3. As can be seen from the figure, the  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell with the standard EC/EMC electrolyte had a capacity retention of 98% in 100 cycles at room temperature.

10

#### EXAMPLE 4

#### High Temperature Cycling Performance of $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$ /Li Half Cell with Nonaqueous Electrolyte Composition Comprising 2,2-Difluoroethyl Acetate

15

A  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell was prepared as described above with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate. This  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell was cycled between 3.5 and 4.95 V at 0.5C rate and 55°C.

20

The cycling performance data is shown in Figure 4. As can be seen from the figure, the  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate had a capacity retention of 97% in 100 cycles at 55°C.

25

EXAMPLE 5

High Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li Half Cell with Nonaqueous  
5 Electrolyte Composition Comprising 2,2-Difluoroethyl  
Acetate and Fluoroethylene Carbonate

A LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was prepared as described above with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate and the  
10 fluoroethylene carbonate additive. This LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was cycled between 3.5 and 4.95 V at 0.5C rate and 55°C.

The cycling performance data is shown in Figure 5.  
15 As can be seen from the figure, the LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate and the fluoroethylene carbonate additive had a capacity retention of 99% in 100 cycles at 55°C.

20

EXAMPLE 6, COMPARATIVE

High Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li Half Cell with Standard EC/EMC  
25 electrolyte

A LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was prepared as described above with standard EC/EMC electrolyte. This  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> /Li half cell was cycled between 3.5 and 4.95 V at 0.5C rate and 55°C.

30



The cycling performance data is shown in Figure 6. As can be seen from the figure, the  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cell with the standard EC/EMC electrolyte had a capacity retention of only 39% in 100 cycles at 55°C.

5

#### EXAMPLE 7

##### Electrochemical Impedance Spectroscopy of

##### $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$ /Li Half Cells with Various Electrolytes

10 Electrochemical impedance spectroscopy (EIS) studies of  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  /Li half cells with different electrolytes (see Table 1) were done at 100% SOC (*i.e.* fully charged) after 100 cycles at 55°C. The frequency ranged from  $10^5$  Hz to  $10^{-3}$  Hz. The AC voltage amplitude  
15 was 10 mV.

The resulting EIS spectra are shown in Figure 7a (Example 4 half cell), 7b (Example 5 half cell), and 7c (Example 6, Comparative half cell), and the results are summarized in  
20 Table 1. As can be seen from the data in the table, the SEI resistances ( $R_s$ ) and the charge transfer resistances ( $R_{ct}$ ) were significantly lower for the half cells with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate (Example 4 half cell) and with the  
25 nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate and the fluoroethylene carbonate additive (Example 5 half cell) than with the half cell with the standard EC/EMC electrolyte (Example 6, Comparative, half cell). These results indicate that  
30 the nonaqueous electrolyte compositions containing the

fluorinated components suppressed SEI development and significantly improved surface charge transfer kinetics at elevated temperature (55°C).

5

Table 1.

Results of EIS Of  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}$  Half Cells

| $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4 / \text{Li}$<br>Half Cell | $R_s$<br>(ohm g) | $R_{ct}$<br>(ohm g) |
|----------------------------------------------------------------------------------------|------------------|---------------------|
| Example 4                                                                              | 0.45             | 2.4                 |
| Example 5                                                                              | 0.30             | 0.9                 |
| Example 6,<br>Comparative                                                              | 1.0              | 7.3                 |

10

EXAMPLE 8

High Temperature Cycling Performance of

$\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$  Full Cell with Nonaqueous

Electrolyte Composition Comprising

15 2,2-Difluoroethyl Acetate and Fluoroethylene Carbonate

A  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$  full cell was prepared as described above with the nonaqueous electrolyte composition comprising 2,2-difluoroethyl acetate and the fluoroethylene carbonate additive. This

20  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$  full cell was cycled between 1.95 and 3.4 V at 0.5C rate and 55°C.

The cycling performance is shown in Figure 8. As can be seen in the figure, this  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$

full cell had a capacity retention of 94.8% in 100 cycles at 55°C.

5

EXAMPLE 9, COMPARATIVE

High Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.5</sub>O<sub>4</sub>/Li<sub>4</sub>Ti<sub>5</sub>O<sub>12</sub> Full Cell with Nonaqueous Electrolyte Composition  
Comprising 2,2-Difluoroethyl Acetate and Fluoroethylene Carbonate

A LiMn<sub>1.5</sub>Ni<sub>0.5</sub>O<sub>4</sub>/Li<sub>4</sub>Ti<sub>5</sub>O<sub>12</sub> full cell was prepared as  
10 described above with the nonaqueous electrolyte composition  
comprising 2,2-difluoroethyl acetate and the fluoroethylene carbonate additive. This  
LiMn<sub>1.5</sub>Ni<sub>0.5</sub>O<sub>4</sub>/Li<sub>4</sub>Ti<sub>5</sub>O<sub>12</sub> full cell was cycled between 1.95  
and 3.4 V at 0.5C rate and 55°C.

15 The cycling performance is shown in Figure 9. As  
can be seen in the figure, only 61.9% capacity retention  
was observed in 100 cycles for the LiMn<sub>1.5</sub>Ni<sub>0.5</sub>O<sub>4</sub>/Li<sub>4</sub>Ti<sub>5</sub>O<sub>12</sub>  
full cell with this electrolyte at 55°C.

20

EXAMPLE 10

High Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li Half Cell with Nonaqueous  
Electrolyte Composition Comprising CH<sub>3</sub>OCO<sub>2</sub>CH<sub>2</sub>CF<sub>2</sub>H:EC  
25 (70:30) and Fluoroethylene Carbonate

A LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> / Li half cell was prepared as  
described above using the nonaqueous electrolyte  
composition comprising CH<sub>3</sub>OCO<sub>2</sub>CH<sub>2</sub>CF<sub>2</sub>H:EC (70:30) and the  
fluoroethylene carbonate additive (1%). This  
30 LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> / Li half cell was cycled at 60 mA/g at

55 °C between 3.5 V and 4.95 V.

The cycling performance data is shown in Figure 10. The capacity retention was as high as 98% in 100 cycles at 55°C, indicating that the cathode/fluorinated electrolyte combination has a very good high temperature cycling performance.

10

EXAMPLE 11, COMPARATIVE

High Temperature Cycling Performance of

LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li Half Cell with Nonaqueous Electrolyte

Composition Comprising CF<sub>2</sub>HCO<sub>2</sub>CH<sub>3</sub>:EC (70:30)

and Fluoroethylene Carbonate

15

A LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> / Li half cell was prepared as described above using the nonaqueous electrolyte composition comprising CF<sub>2</sub>HCO<sub>2</sub>CH<sub>3</sub>:EC (70:30) and the fluoroethylene carbonate additive (1%). This LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> / Li half cell was cycled at 60 mA/g at 20 55 °C between 3.5 V and 4.95 V.

25

The cycling performance data is shown in Figure 11. The capacity retention was only 23% in 100 cycles at 55°C, indicating that this cathode/fluorinated electrolyte combination has a very poor high temperature cycling performance.

EXAMPLES 12-22

High Temperature Cycling Performance of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li<sub>4</sub>Ti<sub>5</sub>O<sub>12</sub> Full Cells with Nonaqueous  
5 Electrolyte Compositions Comprising Various Fluorinated  
Solvents

The following descriptions of preparations are typical of those used in the following Examples.

10

Preparation of LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub> Cathode Active Material

Iron-doped LiMn<sub>1.5</sub>Ni<sub>0.5</sub>O<sub>4</sub> was synthesized by the hydroxide precursor method described by Liu et al (*J. Phys. Chem. C* 113, 15073-15079, 2009). For this  
15 preparation, 401 g of manganese (II) acetate tetrahydrate (Sigma-Aldrich), 115 g of nickel (II) acetate tetrahydrate (Sigma-Aldrich) and 15.2 g of iron (II) acetate anhydrous (Alfa Aesar, Ward Hill, MA) were weighed on a balance then dissolved in 5 L of deionized  
20 water to prepare the acetate solution. KOH pellets were dissolved in 10 L of deionized water in a 30-L reactor to produce a 3.0 M solution. The acetate solution was transferred to an addition funnel and dripped rapidly into the stirred reactor to precipitate the mixed  
25 hydroxide material. Once all 5 L of the acetate solution was added to the reactor, stirring was continued for 1 h. Then, stirring was stopped and the hydroxide precipitate was allowed to settle overnight. After settling, the liquid was removed from the reactor and 15  
30 L of fresh deionized water was added. The contents of

the reactor were stirred, allowed to settle again, and the liquid was removed. This rinse process was repeated. Then, the precipitate was transferred to two (split evenly) coarse glass frit filtration funnels covered with Dacron® paper. The solids collected were rinsed with deionized water until the filtrate pH reached 6.0 (pH of deionized rinse water), and a further 20 L of deionized water was added to each filter cake. Finally, the cakes were dried in a vacuum oven at 120°C overnight. The yield at this point was typically 80-90%.

The hydroxide precipitate filter cake was then ground and mixed with lithium carbonate. This step was done in 60 g batches using a Fritsch Pulverisette automated mortar and pestle (Fritsch USA, Goshen, NY). For each batch, the hydroxide precipitate was weighed, then ground alone for 5 min in the Pulverisette. Then, a stoichiometric amount plus a small excess of lithium carbonate was added to the system. For 53 g of hydroxide, 11.2 g of lithium carbonate was added. Grinding was continued for a total of 60 min with stops every 10-15 min to scrape the material off the surfaces of the mortar and pestle with a sharp metal spatula. If humidity caused the material to form clumps, it was sieved through a 40 mesh screen once during grinding, then again following grinding.

The ground material was fired in an air box furnace inside shallow rectangular alumina trays. The trays were 158 mm by 69 mm in size, and each held about 60 g of

material. The firing procedure consisted of ramping from room temperature to 900°C in 15 h, holding at 900°C for 12 h, then cooling to room temperature in 15 h.

5

#### Preparation of $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$ Cathode

$\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4$  spinel cathode material, prepared as described above, was used to prepare the cathode. The binder was obtained as a 12% solution of polyvinylidene fluoride in NMP (KFL #1120, Kureha America Corp, New York, NY). Carbon black (0.260 g, acetylene black, Denka Corp. New York, NY, uncompressed), 3.88 g of NMP, and the PVDF solution (2.16 g) were combined in a 15 mL vial with a fluoropolymer cap and centrifugally mixed 3 times for 1 min each at 2,000 rpm using a THINKY ARE-310 centrifuge (THINKY Corp., Japan). The cathode material (2.08 g) was ground using a mortar and pestle for approximately one hour. The cathode material and 0.70 g of NMP were then added to the vial and the mixture was again centrifugally mixed 3 times for 1 min each at 2000 rpm to form a cathode paste. The total weight of the paste was 9.08 g (28.6% solids). The vial was mounted in an ice bath and homogenized twice using a rotor-stator (Model PT 10-35 GT, 7.5 mm dia. stator, Kinematicia, Bohemia NY) for 15 min each at 6500 rpm and then twice more for 15 min each at 9500 rpm. Between each of the four homogenization periods, the homogenizer was moved to another position in the paste vial. The paste was cast onto untreated aluminum foil using a doctor blade with a 0.25 mm gate height and dried in a vacuum oven at 100°C

for 15 min. The resulting 50-mm wide cathode was placed on a 125  $\mu\text{m}$  thick brass sheet and two 38 mm wide brass shim strips of 37  $\mu\text{m}$  thickness were placed on either side of the cathode to help control the gap thickness in the calender. The cathode and shims were covered with a second 125  $\mu\text{m}$  thick brass sheet, and the assembly was passed through a calender twice using 100 mm diameter steel rolls at ambient temperature with nip forces of 560 and then 680 kg, respectively. The average cathode thickness was reduced from 67  $\mu\text{m}$  before calendaring to 45  $\mu\text{m}$ . Additional cathodes were prepared in a similar manner, except the gate height of the doctor blade was increased to 0.29 mm and the cathodes were dried.

15

#### Preparation of Lithium Titanate Anode

Carbon black (0.39 g, acetylene black, Denka Corp., New York NY, uncompressed), PVDF solution (3.00 g, 13% in NMP, KFL #9130, Kureha America Corp, New York NY), and 6.03 g of NMP were combined and centrifugally mixed three times for 60 s each time at 2000 rpm.  $\text{Li}_4\text{Ti}_5\text{O}_{12}$  powder (3.12 g, Nanomyte BE-10, NEI Corporation, Somerset, NJ) and an additional 1.10 g of NMP were added to the carbon black and PVDF mixture, and the resulting paste was centrifugally mixed three times for 60 s each at 2000 rpm. The vial was mounted in an ice bath and homogenized twice using a rotor-stator for 15 min each at 6500 rpm and then twice more for 15 min each at 9500 rpm. The paste was placed in a mortar and manually ground briefly with a pestel to further remove aggregates.

30



Then, the paste was cast using a doctor blade with a 0.29 mm gate height onto untreated 25  $\mu\text{m}$  thick aluminum foil. The paste was dried in a convection oven (model FDL-115, Binder Inc., Great River, NY) at 100°C for 15 min. The thickness of the anode was 71  $\mu\text{m}$ . The resulting 50-mm wide anode was calendered in a manner similar to the cathode described above. The average anode thickness was reduced from 71  $\mu\text{m}$  before calendering to 53  $\mu\text{m}$  after calendering.

10

#### Fabrication of $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$ Full Cells

Nonaqueous electrolyte lithium-ion CR2032 coin cells were prepared for electrochemical evaluation. Circular anodes and cathodes were punched out, placed in a heater in the antechamber of a glove box, further dried under vacuum overnight at 100°C, and brought into an argon glove box (Vacuum Atmospheres, Hawthorne CA, with HE-493 purifier). The electrode diameters were a 14.1 mm cathode used with a 16.0 mm anode, or a 10.1 mm cathode used with a 12.3 mm anode. All the cells were cathode limited, with a ratio of the lithium titanate weight to the Fe-LNMO weight greater than 1.0 for all the cells. The coin cell parts (case, spacers, wave spring, gasket, and lid) and coin cell crimper were obtained from Hohsen Corp (Osaka, Japan). The separator used was a 25  $\mu\text{m}$  thick microporous polyolefin separator (CG2325, Celgard, Charlotte, NC). The electrolyte used in each of the Examples is given in Table 2.

30

High Temperature Cycling of  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$   
Full Cells

The  $\text{LiMn}_{1.5}\text{Ni}_{0.42}\text{Fe}_{0.08}\text{O}_4/\text{Li}_4\text{Ti}_5\text{O}_{12}$  full cells were cycled  
5 using a commercial battery tester (Series 4000, Maccor,  
Tulsa, OK) at 55°C using voltage limits of 1.9 and 3.4 V.  
The first 29 cycles were performed using constant current  
charging and discharging at a rate of 60 mA per gram of  
Fe-LNMO. In the 30<sup>th</sup> cycle, the rate was reduced to 24  
10 mA/g. This set of 30 cycles (29+1) was repeated 10  
times for a total of 300 cycles. The number of cycles  
before the discharge capacity was reduced to 80% of the  
initial discharge capacity in the first cycle is shown in  
Table 2. The average of the specific discharge capacity  
15 remaining in cycles 297-299 is also shown in Table 2.

Table 2  
Results of High Temperature Cycling of  
LiMn<sub>1.5</sub>Ni<sub>0.42</sub>Fe<sub>0.08</sub>O<sub>4</sub>/Li<sub>4</sub>Ti<sub>5</sub>O<sub>12</sub> Full Cells

| Example            | Electrolyte                                                                                        | Cycle Life 80% Retention | Specific Capacity after 298 cycles mAh/g of cathode active |
|--------------------|----------------------------------------------------------------------------------------------------|--------------------------|------------------------------------------------------------|
| 12                 | CH <sub>3</sub> OC(O)OCH <sub>2</sub> CF <sub>3</sub> :EC:FEC                                      | 102                      | 80                                                         |
| 13                 | 69:30:1, 0.5 M LiPF <sub>6</sub>                                                                   | 111                      | 84                                                         |
| 14                 | CH <sub>3</sub> C(O)OCH <sub>2</sub> CF <sub>3</sub> :EC:FEC                                       | 101                      | 25                                                         |
| 15                 | 69:30:1, 0.5 M LiPF <sub>6</sub>                                                                   | 182                      | 89                                                         |
| 16                 | CH <sub>3</sub> OC(O)OCH <sub>2</sub> CF <sub>2</sub> H:EC:FEC<br>69:30:1, 1.0 M LiPF <sub>6</sub> | 96                       | 40                                                         |
| 17,<br>Comparative | HCF <sub>2</sub> C(O)OCH <sub>3</sub> :EC:FEC                                                      | 2                        | 3                                                          |
| 18,<br>Comparative | 69:30:1, 1.0 M LiPF <sub>6</sub>                                                                   | 2                        | 7                                                          |
| 19                 | CH <sub>3</sub> C(O)OCH <sub>2</sub> CF <sub>2</sub> CF <sub>2</sub> H:EC                          | 178                      | 84                                                         |
| 20                 | 70:30, 0.5 M LiPF <sub>6</sub>                                                                     | 69                       | 38                                                         |
| 21                 | CH <sub>3</sub> OC(O)OCH <sub>2</sub> CF <sub>2</sub> CF <sub>2</sub> H:EC                         | 16                       | 28                                                         |
| 22                 | 70:30, 0.5 M LiPF <sub>6</sub>                                                                     | 24                       | 11                                                         |

5

In various embodiments of the lithium ion battery hereof, pairs of dopant metals and fluorinated solvents may be formed from (i) any one or more of all of the members of the total group of dopant metals disclosed herein (Al, Cr, Fe, Ga, Zn, Co, Nb, Mo, Ti, Zr, Mg, V and Cu), selected as described above as a single member or any subgroup of any size taken from the total group of doping metals in all the various different combinations of individual members of that total group, together with (ii) any one or more of all of the members of the total group of Formula IIA, IIB or Formula III fluorinated solvents disclosed herein, selected as described above as a single member or any subgroup of any size taken from the total group of those fluorinated solvents in all the various different combinations of individual members of that total group. Subgroups of the members of the groups of dopant metals or fluorinated solvents may be formed by omitting any one or more members from the respective whole groups as set forth above. As a result, the dopant metal or fluorinated solvent (or pair thereof) may not only be the members of any subgroup of any size that may be formed from the whole group from all the various different combinations of individual members of the groups as set forth in the list above, but may also be made in the absence of the members that have been omitted from the whole group to form the subgroup. The subgroup formed by omitting various members from the whole group in the lists above may, moreover, be an individual member of the whole group such that the dopant

metal or fluorinated solvent (or pair thereof) may be selected in the absence of all other members of the whole group except the selected individual member.

5           Formulae IIA, IIB and III shown herein describes each and all of the separate, individual fluorinated solvent compounds that can be assembled in each of the formulae by (1) selection from within the prescribed range for one of the variable radicals, substituents or  
10 numerical coefficients while all of the other variable radicals, substituents or numerical coefficients are held constant, and (2) performing in turn the same selection from within the prescribed range for each of the other variable radicals, substituents or numerical coefficients  
15 with the others being held constant. In addition to a selection made within the prescribed range for any of the variable radicals, substituents or numerical coefficients of only one of the members of the group described by the range, a plurality of compounds may be described by  
20 selecting more than one but less than all of the members of the whole group of radicals, substituents or numerical coefficients. When the selection made within the prescribed range for any of the variable radicals, substituents or numerical coefficients is a subgroup  
25 containing (i) only one of the members of the whole group described by the range, or (ii) more than one but less than all of the members of the whole group, the selected member(s) are selected by omitting those member(s) of the whole group that are not selected to form the subgroup.  
30 The compound, or plurality of compounds, may in such

event be characterized by a definition of one or more of the variable radicals, substituents or numerical coefficients that refers to the whole group of the prescribed range for that variable but where the member(s) omitted to form the subgroup are absent from the whole group.

In this specification, unless explicitly stated otherwise or indicated to the contrary by the context of usage, where an embodiment of the subject matter hereof is stated or described as comprising, including, containing, having, being composed of or being constituted by or of certain features or elements, one or more features or elements in addition to those explicitly stated or described may be present in the embodiment. An alternative embodiment of the subject matter hereof, however, may be stated or described as consisting essentially of certain features or elements, in which embodiment features or elements that would materially alter the principle of operation or the distinguishing characteristics of the embodiment are not present therein. A further alternative embodiment of the subject matter hereof may be stated or described as consisting of certain features or elements, in which embodiment, or in insubstantial variations thereof, only the features or elements specifically stated or described are present.

Where a range of numerical values is recited or established herein, the range includes the endpoints

thereof and all the individual integers and fractions within the range, and also includes each of the narrower ranges therein formed by all the various possible combinations of those endpoints and internal integers and fractions to form subgroups of the larger group of values within the stated range to the same extent as if each of those narrower ranges was explicitly recited. Where a range of numerical values is stated herein as being greater than a stated value, the range is nevertheless finite and is bounded on its upper end by a value that is operable within the context of the invention as described herein. Where a range of numerical values is stated herein as being less than a stated value, the range is nevertheless bounded on its lower end by a non-zero value.

In this specification, unless explicitly stated otherwise or indicated to the contrary by the context of usage,

- (a) lists of compounds, monomers, oligomers, polymers and/or other chemical materials include derivatives of the members of the list in addition to mixtures of two or more of any of the members and/or any of their respective derivatives; and
- (b) amounts, sizes, ranges, formulations, parameters, and other quantities and characteristics recited herein, particularly when modified by the term "about", may but need not be exact, and may also be approximate and/or larger or smaller (as desired) than stated, reflecting tolerances,

conversion factors, rounding off, measurement error  
and the like, as well as the inclusion within a  
stated value of those values outside it that have,  
within the context of this invention, functional  
5 and/or operable equivalence to the stated value.



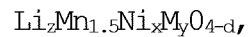
CLAIMS

What is claimed is:

1. A lithium ion battery comprising:

(a) a housing;

(b) an anode and a cathode disposed in the housing and in conductive contact with one another, wherein the cathode is a manganese cathode comprising a lithium-containing manganese composite oxide having a spinel structure as active material, the lithium-containing manganese composite oxide being represented by the formula



wherein

M is at least one metal selected from the group consisting of Al, Cr, Fe, Ga, and Zn,

$$0.38 \leq x < 0.5,$$

$$0 < y \leq 0.12,$$

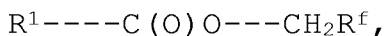
$$0 \leq d \leq 0.3,$$

$0.00 < z \leq 1.1$ , and z changes in accordance with release and uptake of lithium ions and electrons during charge and discharge;

(c) a nonaqueous electrolyte composition disposed in the housing and providing an ionically conductive pathway between

the anode and the cathode, wherein the nonaqueous electrolyte composition comprises (i) at least one electrolyte salt and (ii) at least one fluorinated acyclic carboxylic acid ester,

wherein the fluorinated acyclic carboxylic acid ester is represented by the following structural formula:



wherein  $R^1$  is selected from the group consisting of  $\text{CH}_3$ ,  $\text{CH}_2\text{CH}_3$ ,  $\text{CH}_2\text{CH}_2\text{CH}_3$ , and  $\text{CH}(\text{CH}_3)_2$ , and wherein  $R^f$  is a  $\text{C}_1$  to  $\text{C}_3$  alkyl group substituted with at least one fluorine; and

(d) a porous separator between the anode and the cathode.

2. The lithium ion battery of Claim 1 wherein:

$$0.4 \leq x < 0.5,$$

$$0 < y < 0.1,$$

$$z = 1 \text{ and}$$

$$d = 0.$$

3. The lithium ion battery of Claim 1 wherein the fluorinated acyclic carboxylic acid ester is selected from one or more members of the group consisting of  $\text{CH}_3\text{C(O)OCH}_2\text{CF}_2\text{H}$ ,  $\text{CH}_3\text{C(O)OCH}_2\text{CF}_3$ , and  $\text{CH}_3\text{C(O)OCH}_2\text{CF}_2\text{CF}_2\text{H}$ .

4. The lithium ion battery of Claim 1 wherein M in the formula of (b) comprises Fe.

5. The lithium ion battery of Claim 3 wherein the fluorinated acyclic carboxylic acid ester comprises  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$ .

6. The lithium ion battery of Claim 1 wherein the nonaqueous electrolyte composition (c) comprises a solvent mixture comprising the fluorinated acyclic carboxylic acid ester, and at least one co-solvent.

7. The lithium ion battery of Claim 6 wherein the solvent mixture comprises the fluorinated acyclic carboxylic acid ester at about 50% to about 80% by weight of the solvent mixture.

8. The lithium ion battery of Claim 6 wherein the solvent mixture comprises the fluorinated acyclic carboxylic acid ester at about 65% to about 75% by weight of the solvent mixture.

9. The lithium ion battery of Claim 6 wherein the co-solvent comprises ethylene carbonate.

10. The lithium ion battery of Claim 6 wherein the solvent mixture comprises  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  and ethylene carbonate.

11. The lithium ion battery of Claim 10 wherein  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  comprises about 50% to about 80% by weight of the solvent mixture.

12. The lithium ion battery of Claim 10 wherein  $\text{CH}_3\text{CO}_2\text{CH}_2\text{CF}_2\text{H}$  comprises about 65% to about 75% by weight of the solvent mixture.

13. The lithium ion battery of Claim 1 wherein the nonaqueous electrolyte composition (c) further comprises an additive selected from the group consisting of fluoroethylene carbonate and its derivatives, ethylene sulfate and its derivatives, vinyl ethylene carbonate and its derivatives, vinylene carbonate and

its derivatives, maleic anhydride and its derivatives, and vinyl acetate.

14. The lithium ion battery of Claim 1 wherein the nonaqueous electrolyte composition (c) further comprises fluoroethylene carbonate.

15. The lithium ion battery of Claim 1 wherein the electrolyte salt in the nonaqueous electrolyte composition (c) is selected from one or more members of the group consisting of:

lithium hexafluorophosphate,

$\text{Li PF}_3 (\text{CF}_2\text{CF}_3)_3$ ,

lithium bis(trifluoromethanesulfonyl)imide,

lithium bis(perfluoroethanesulfonyl)imide,

lithium (fluorosulfonyl)

(nonafluorobutanesulfonyl)imide,

lithium bis(fluorosulfonyl)imide,

lithium tetrafluoroborate,

lithium perchlorate,

lithium hexafluoroarsenate,

lithium trifluoromethanesulfonate,

lithium tris(trifluoromethanesulfonyl)methide,

lithium bis(oxalato)borate,

lithium difluoro(oxalato)borate,

$\text{Li}_2\text{B}_{12}\text{F}_{12-x}\text{H}_x$  where x is equal to 0 to 8, and

a mixture of lithium fluoride and an anion receptor.

16. The lithium ion battery of Claim 15 wherein the electrolyte salt comprises lithium hexafluorophosphate.

17. The lithium ion battery of Claim 1 wherein the anode comprises lithium titanate or graphite as active material.

18. An electronically powered or assisted device comprising a lithium ion battery according to Claim 1.

19. A device according to Claim 18 that is fabricated as a transportation device, a computer, a telecommunications device, a camera, a radio, or a power tool.

Replacement Sheet

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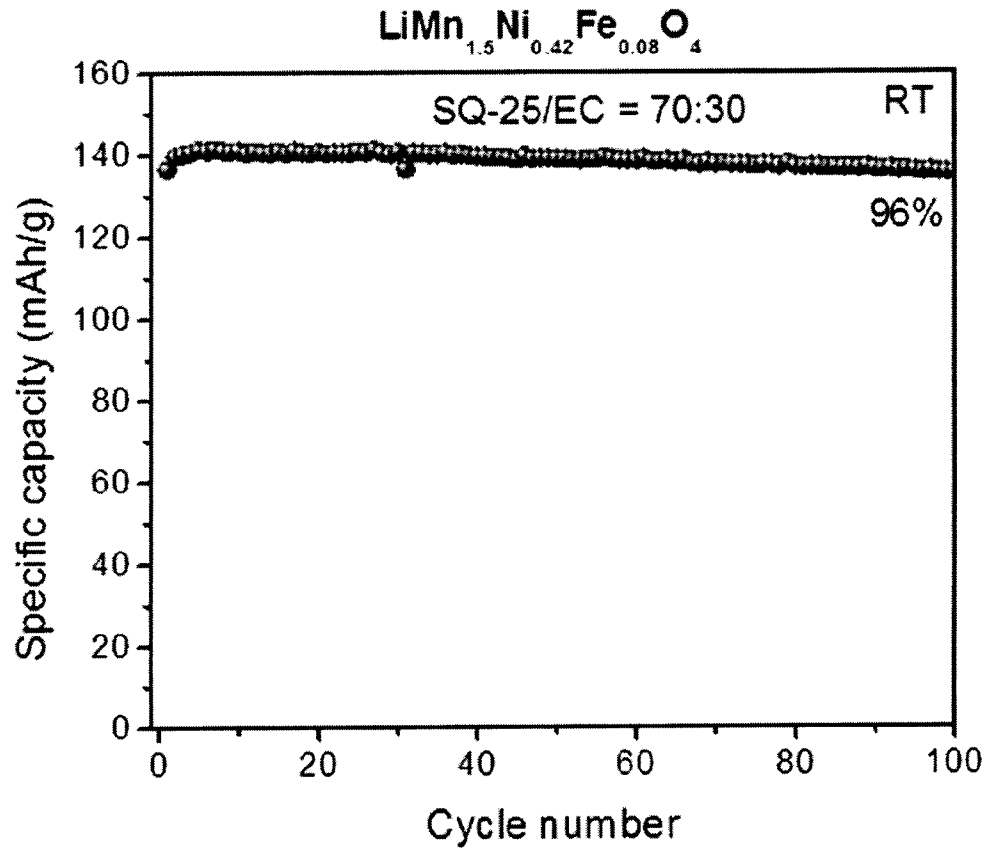
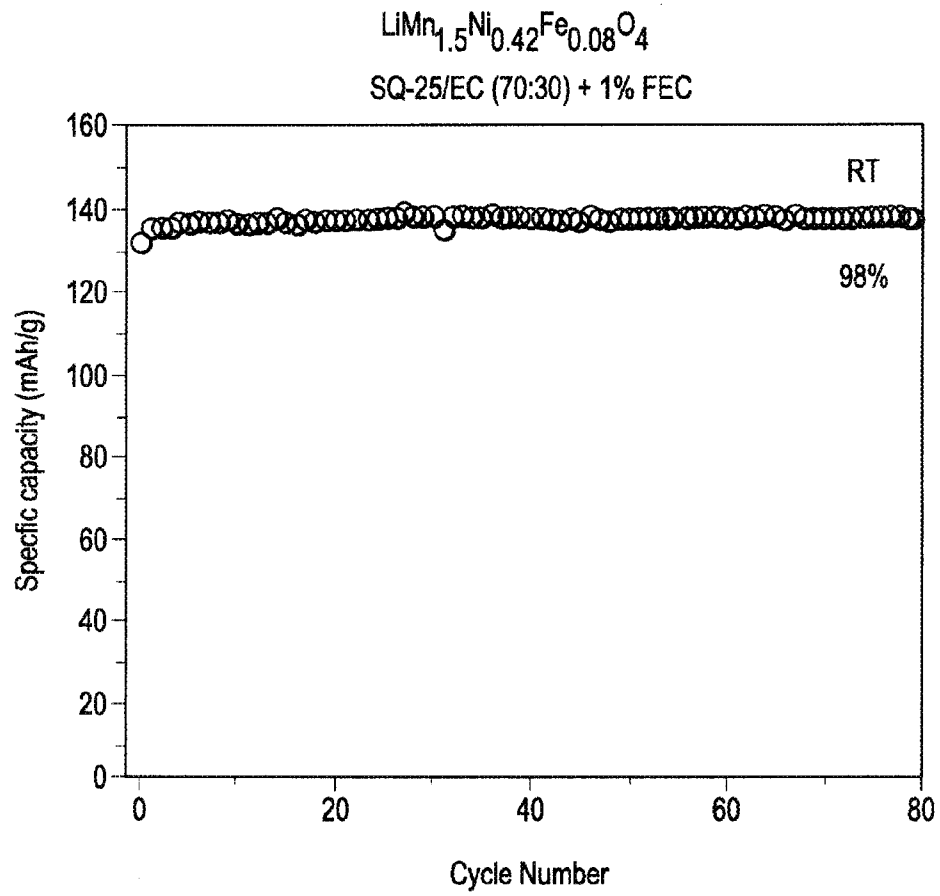


FIG. 1



*FIG. 2*

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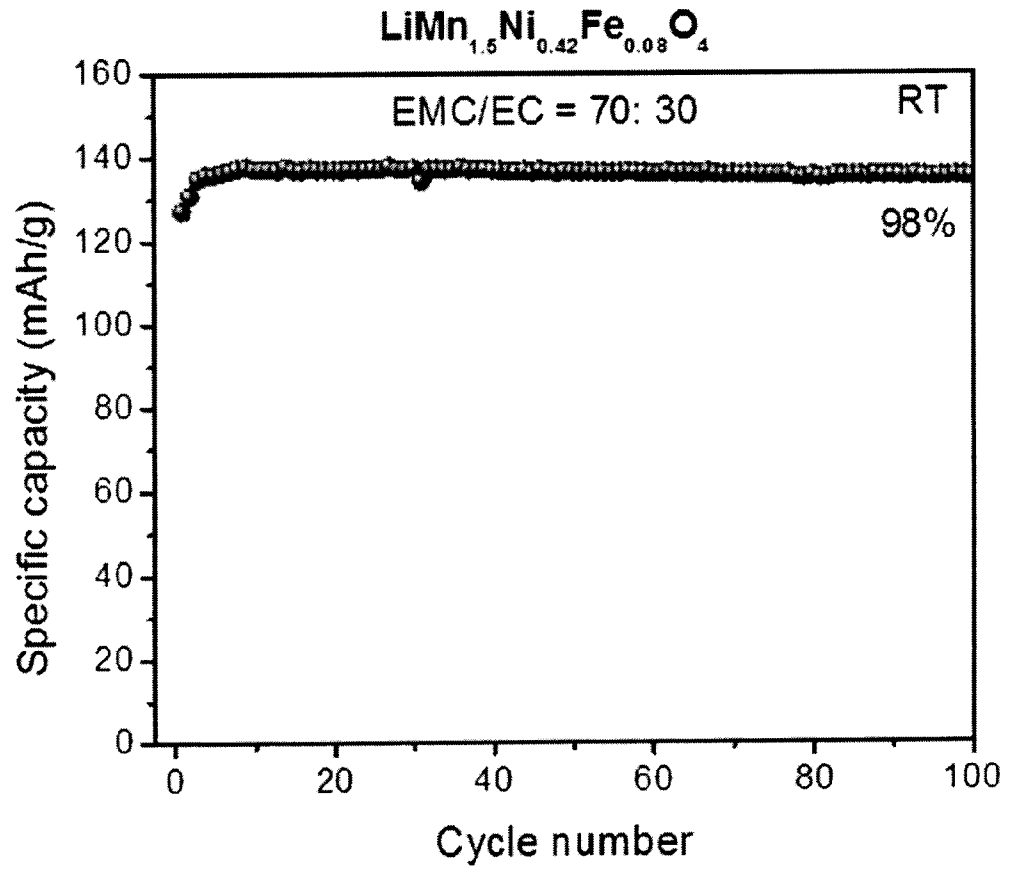


FIG. 3



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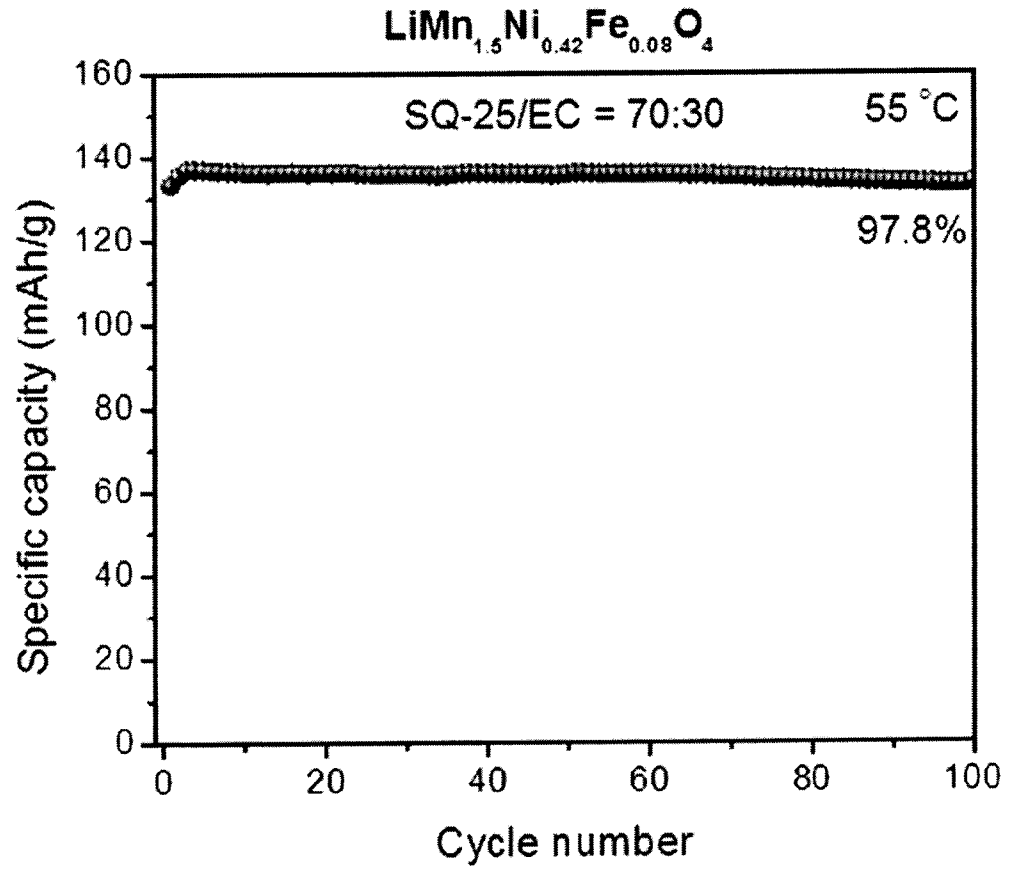
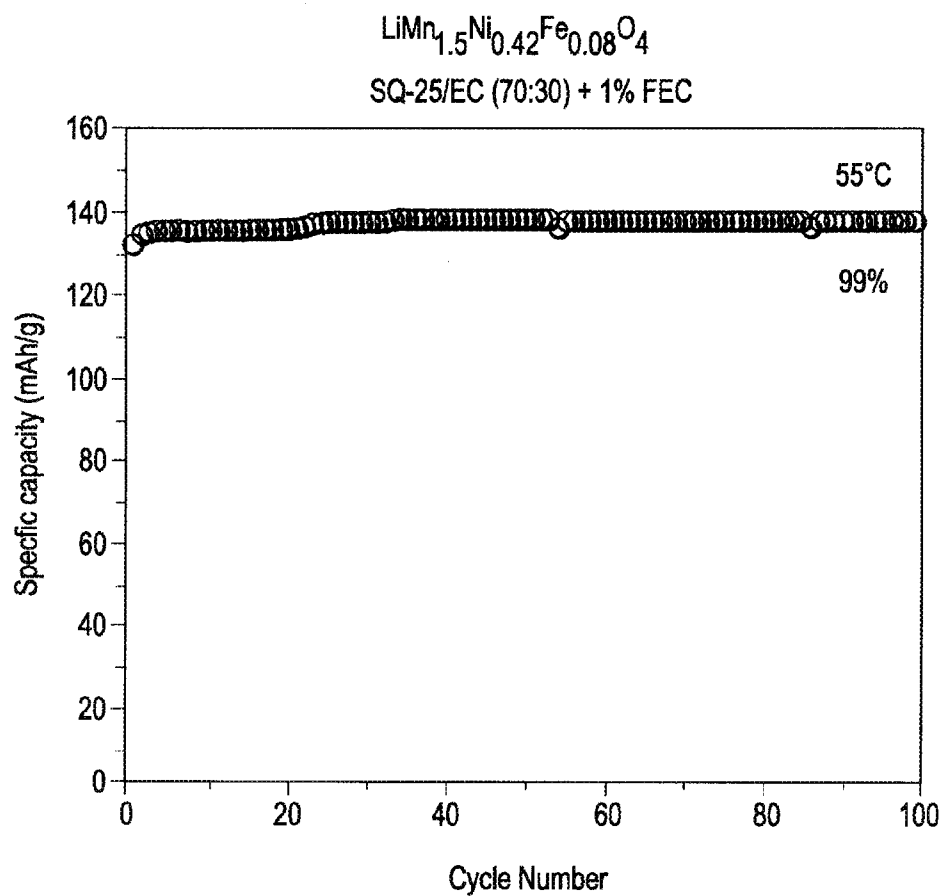


FIG. 4



*FIG. 5*

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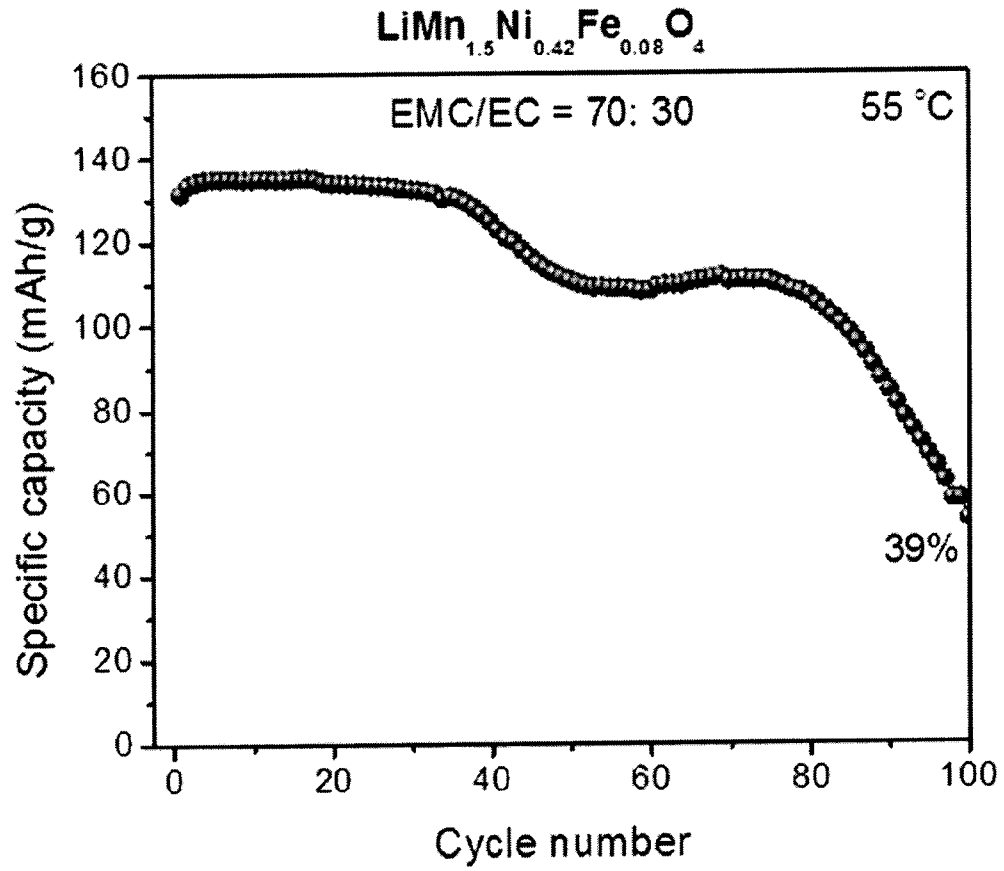


FIG. 6

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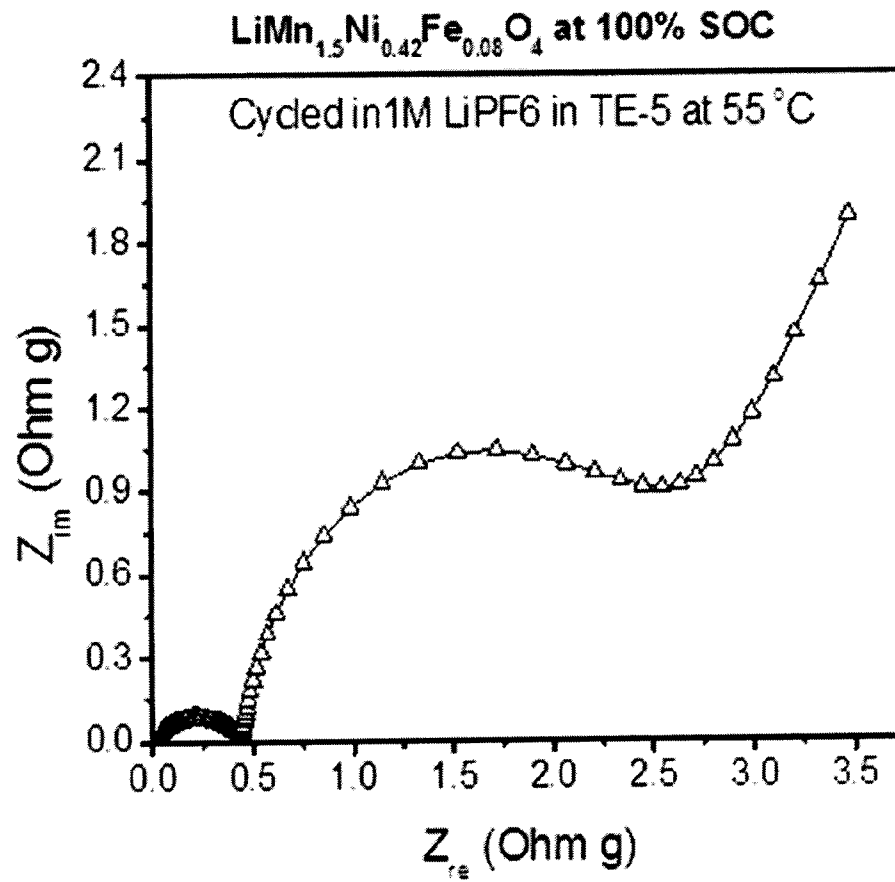
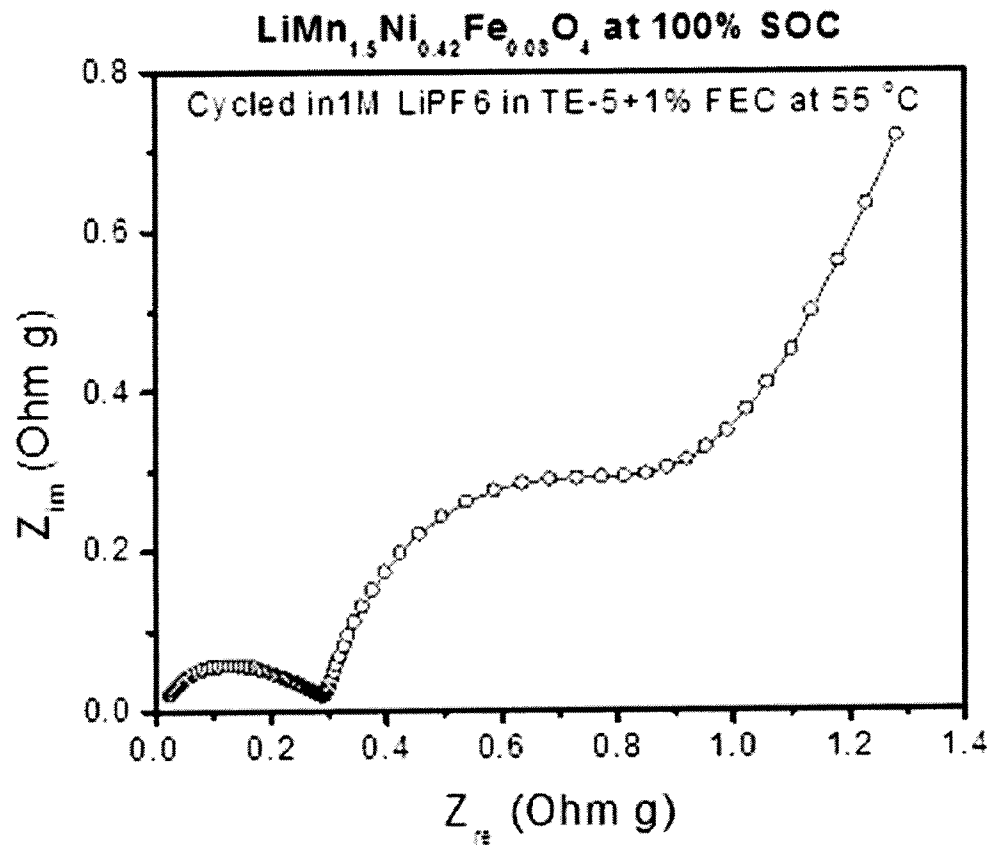


FIG. 7a

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**FIG. 7b**

## Replacement Sheet

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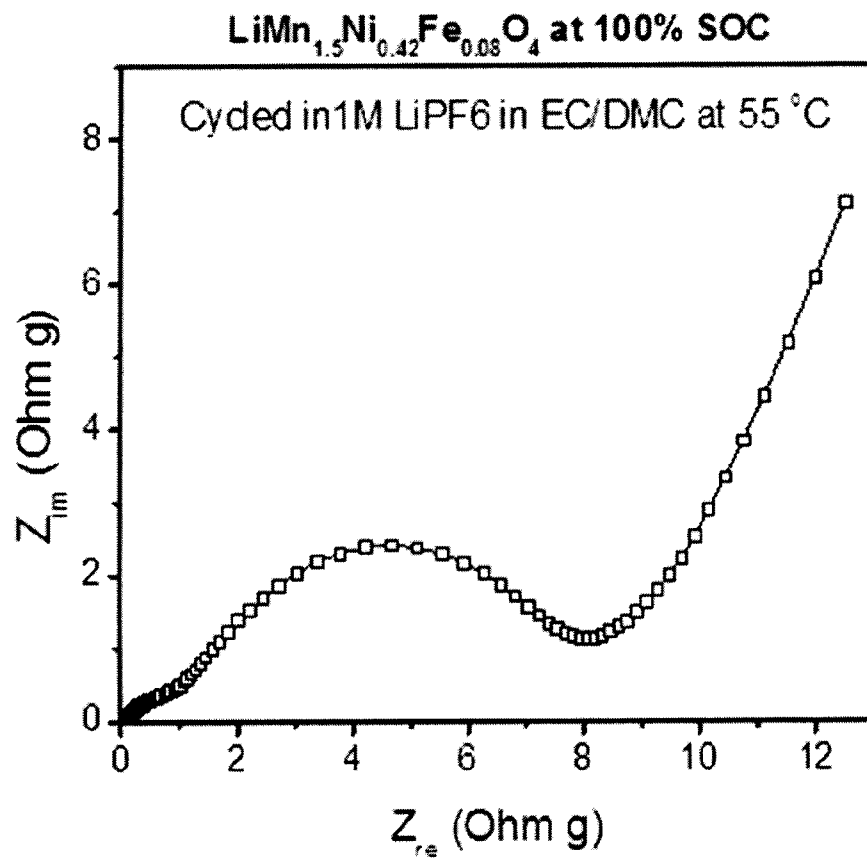


FIG. 7c

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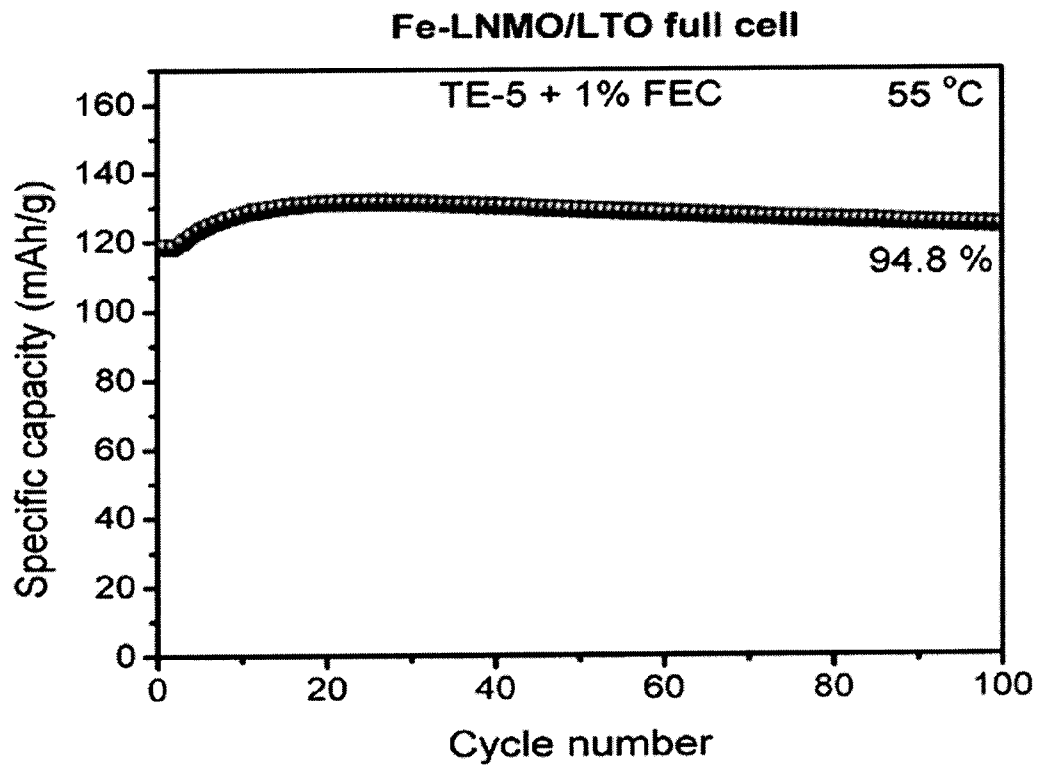


FIG. 8

Replacement Sheet  
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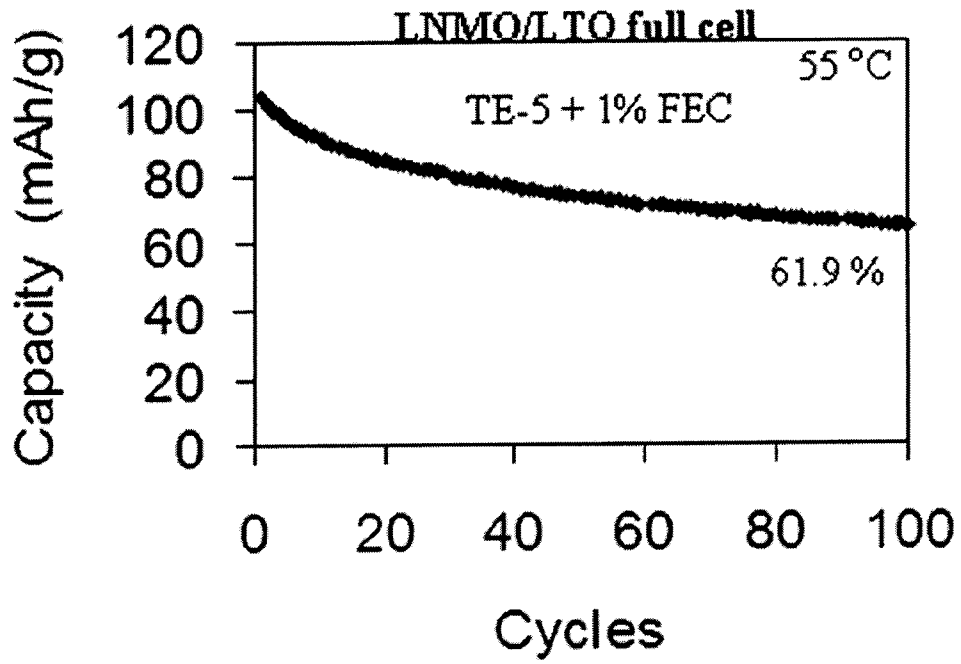
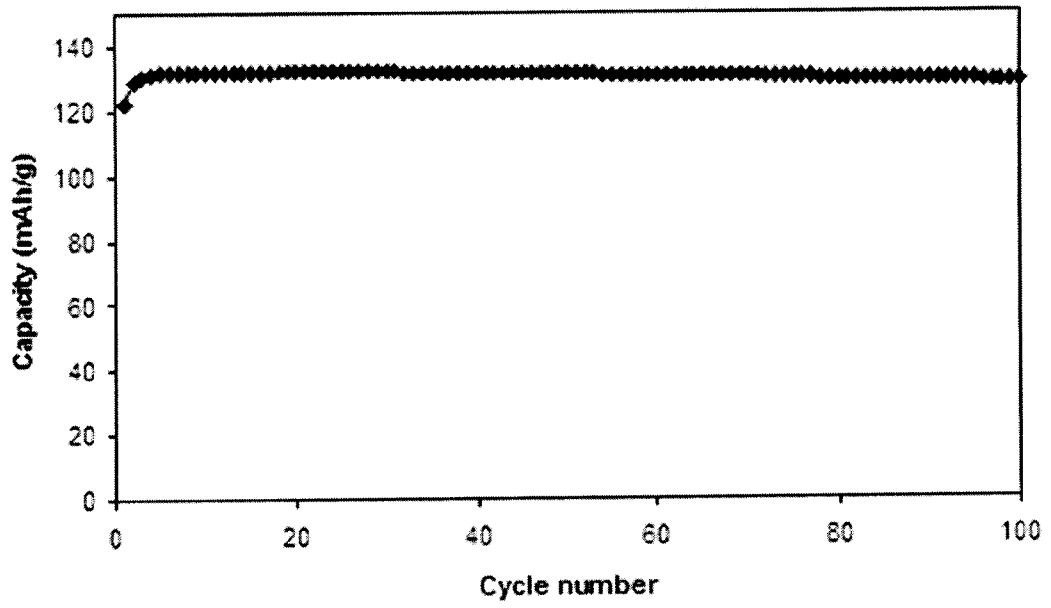


FIG. 9

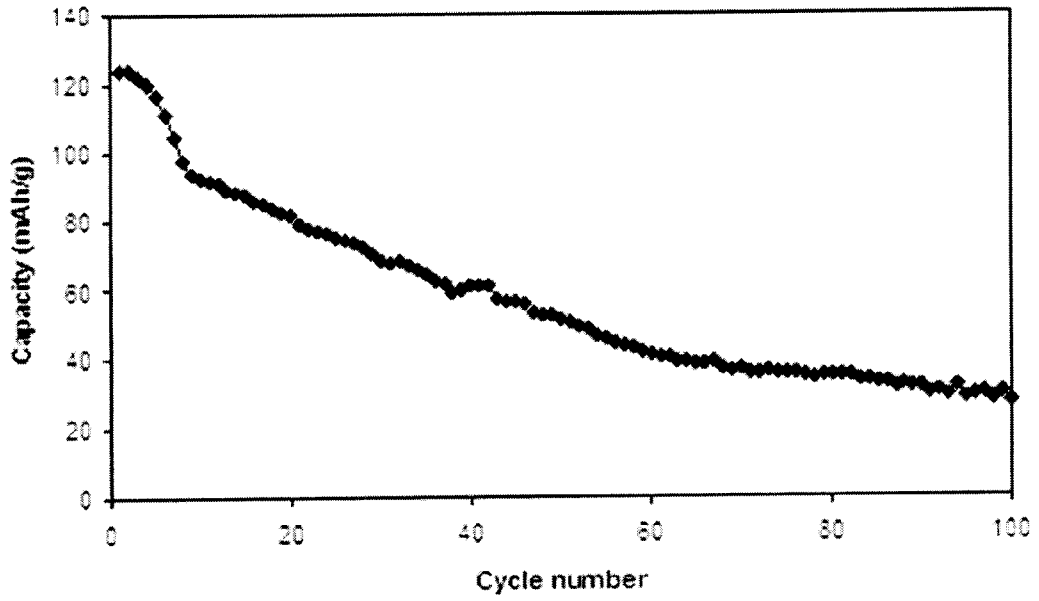


**Replacement Sheet**  
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**FIG. 10**

**Replacement Sheet**  
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**FIG. 11**

