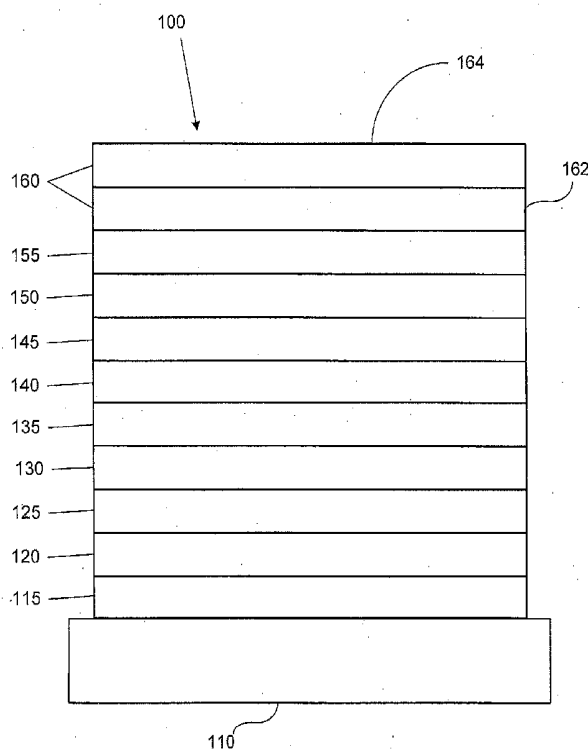




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XIA et al.(10) **Pub. No.: US 2017/0194577 A1**(43) **Pub. Date: Jul. 6, 2017**(54) **ORGANIC ELECTROLUMINESCENT
MATERIALS AND DEVICES**continuation-in-part of application No. PCT/US2009/
052045, filed on Jul. 29, 2009.(71) Applicant: **Universal Display Corporation,**
Ewing, NJ (US)(60) Provisional application No. 61/093,967, filed on Sep.
3, 2008, provisional application No. 61/140,459, filed
on Dec. 23, 2008, provisional application No. 61/229,
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Ewing, NJ (US)(21) Appl. No.: **15/467,724**(22) Filed: **Mar. 23, 2017****Related U.S. Application Data**(60) Division of application No. 14/791,741, filed on Jul.
6, 2015, now Pat. No. 9,630,983, which is a contin-
uation of application No. 13/968,551, filed on Aug.
16, 2013, now Pat. No. 9,076,973, which is a contin-
uation of application No. 13/062,141, filed on May
20, 2011, now Pat. No. 8,519,384, filed as application
No. PCT/US2009/055890 on Sep. 3, 2009, which is a**Publication Classification**(51) **Int. Cl.****H01L 51/00** (2006.01)**C07F 15/00** (2006.01)**C09K 11/06** (2006.01)(52) **U.S. Cl.**CPC **H01L 51/0085** (2013.01); **C09K 11/06**
(2013.01); **C07F 15/0033** (2013.01); **C09K**
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2211/1074 (2013.01); **C09K 2211/1066**
(2013.01)

(57)

ABSTRACTMethods of making novel organic compounds containing a
twisted aryl group are provided. In particular, the com-
pounds provided contain a 2-phenylpyridine ligand having a
twisted aryl group on the pyridine portion of the ligand. The
compounds may be used in organic light emitting devices,
particularly as emitting dopants. Devices comprising the
compounds containing twisted aryl may demonstrate
improved color, efficiency, stability and manufacturing.

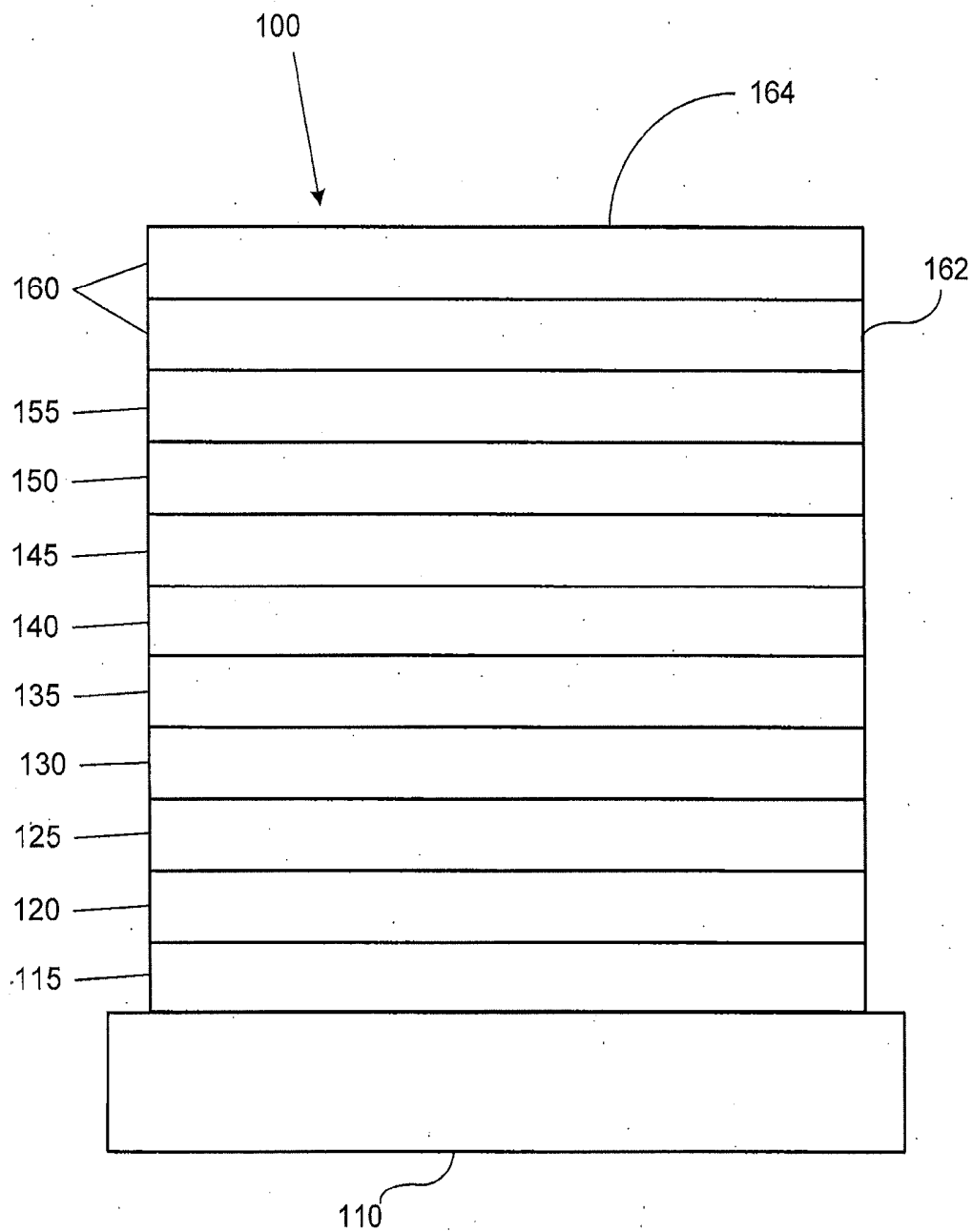


FIGURE 1

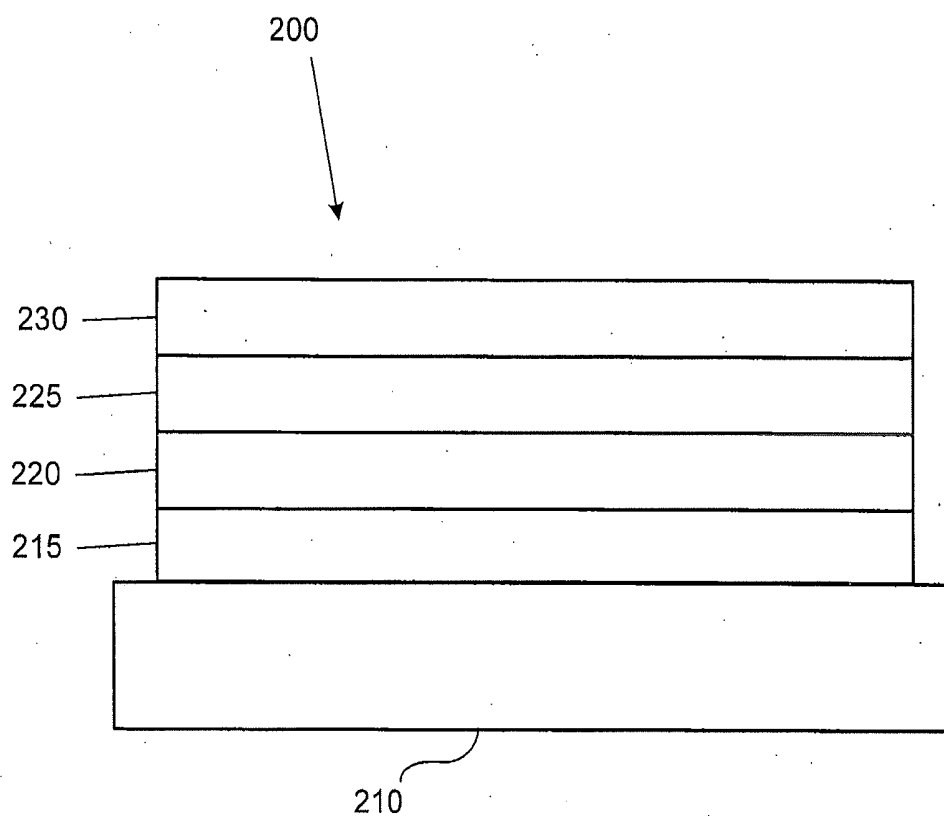


FIGURE 2

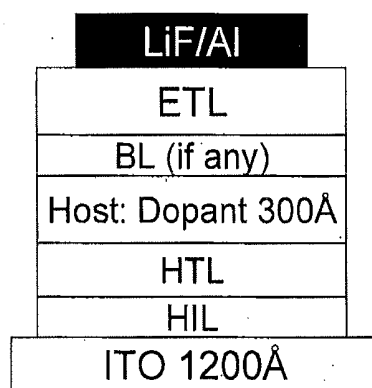


FIGURE 3

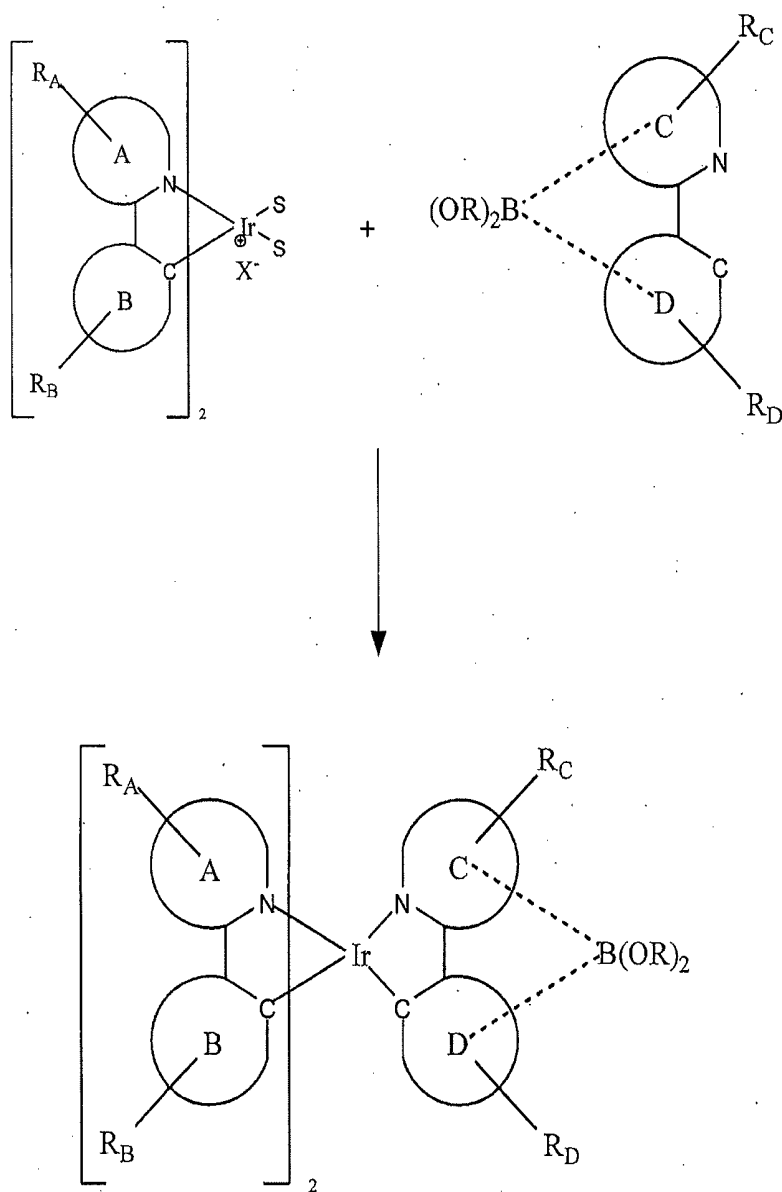
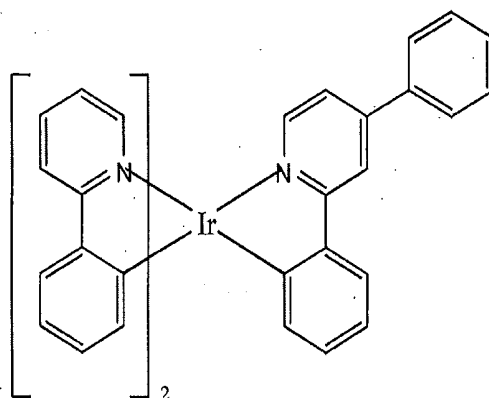
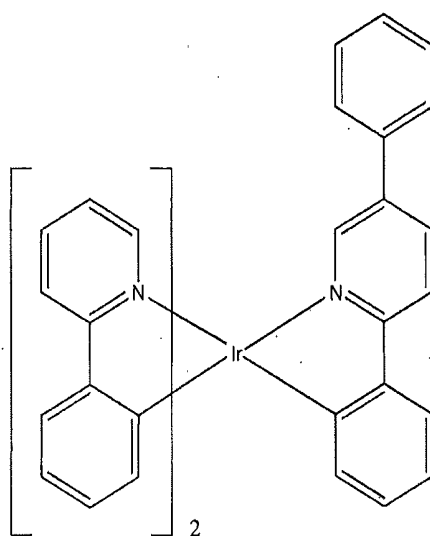


FIGURE 4



Compound 1



Compound 2

FIGURE 5

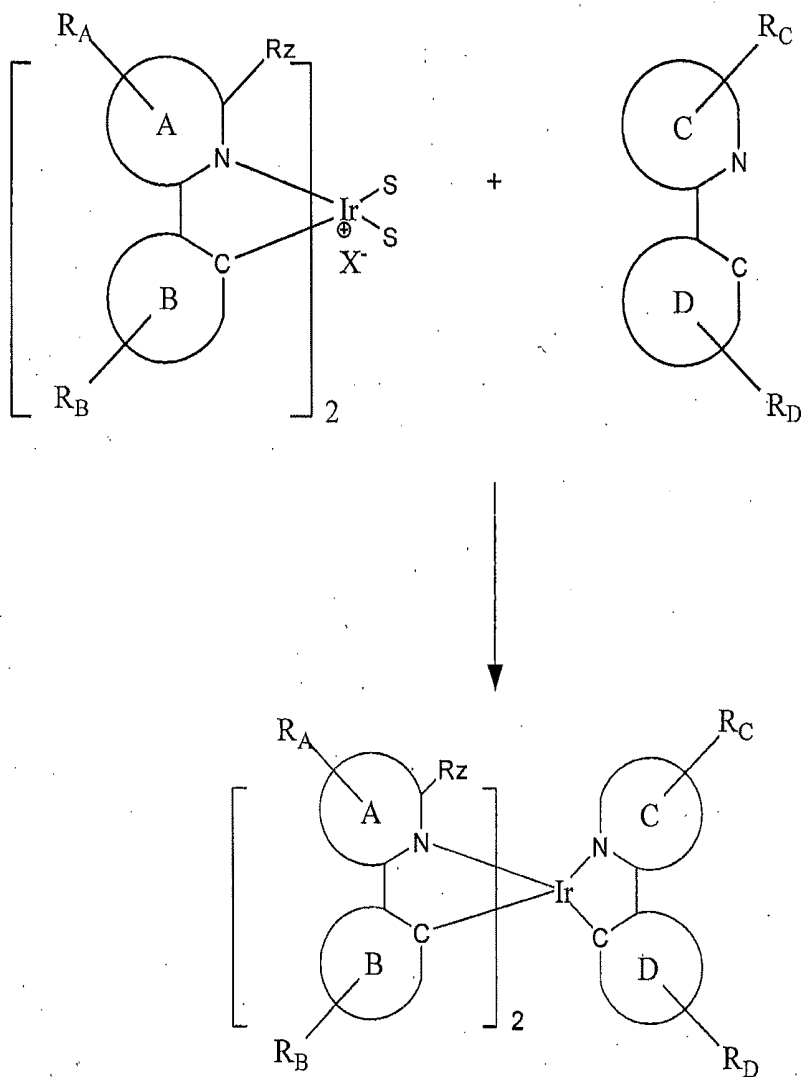
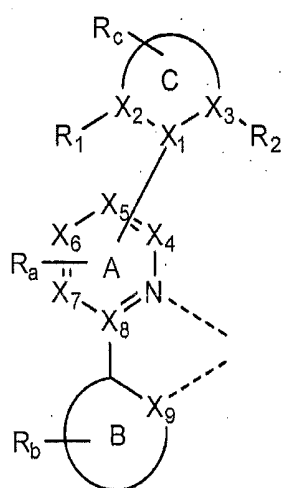
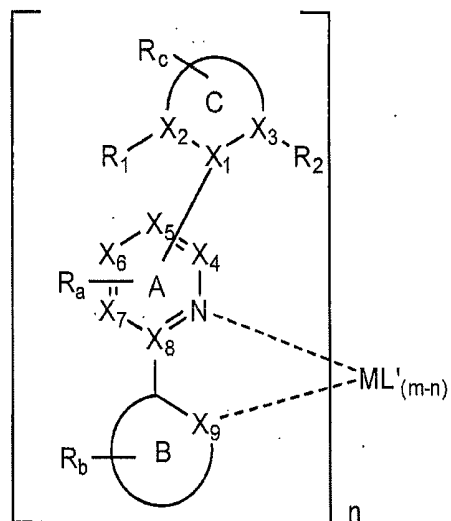


FIGURE 6

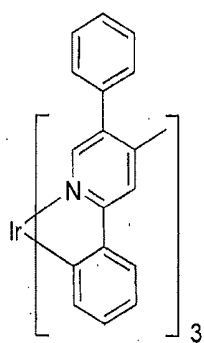


Formula I

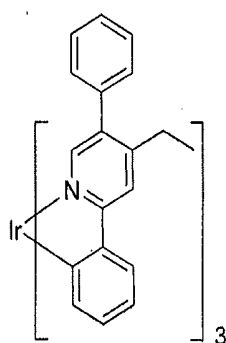


Formula II

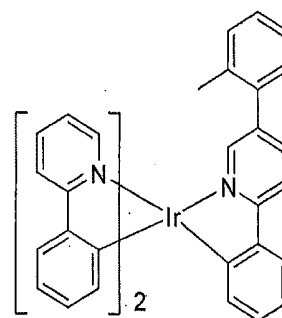
FIGURE 7



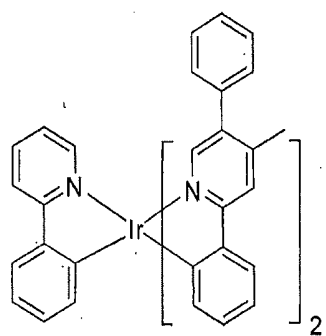
Compound 21



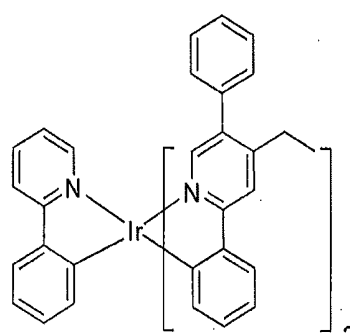
Compound 22



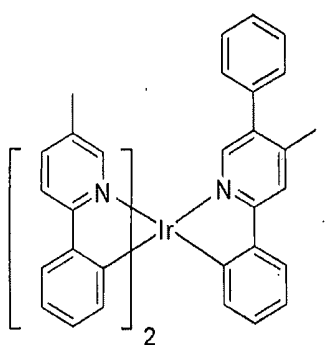
Compound 25



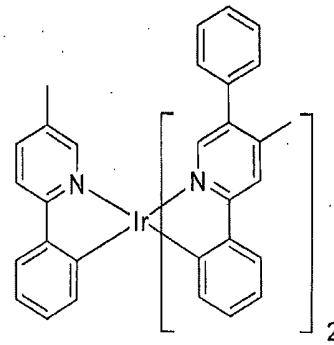
Compound 29



Compound 30



Compound 31



Compound 34

FIGURE 8

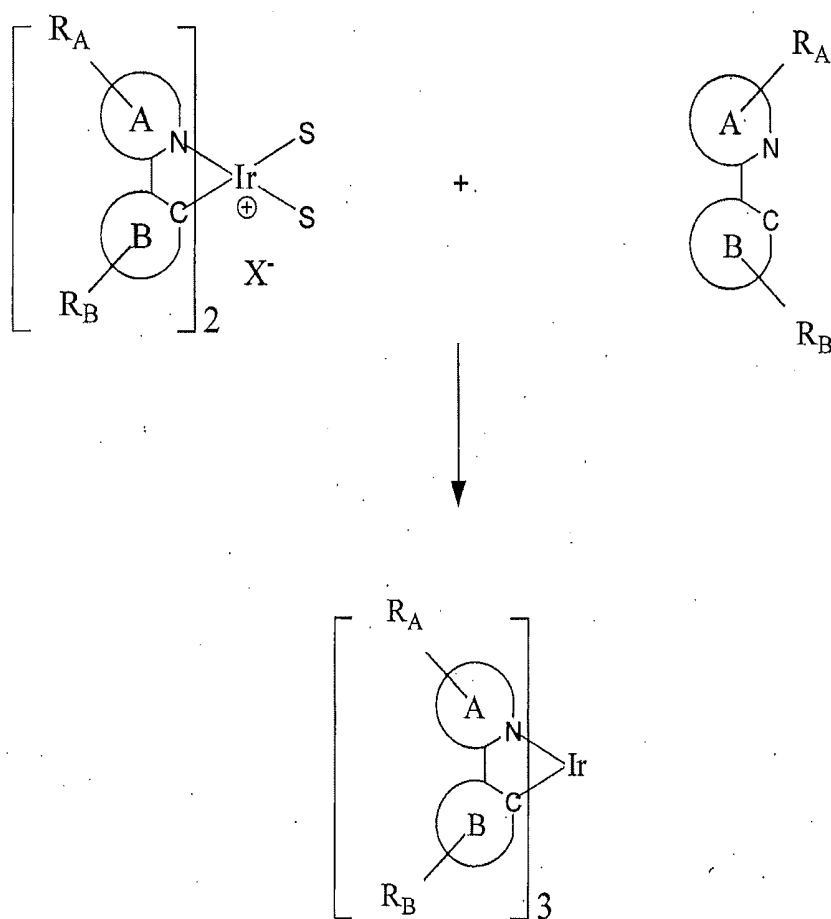


FIGURE 9

ORGANIC ELECTROLUMINESCENT MATERIALS AND DEVICES

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application is a divisional application of co-pending U.S. patent application Ser. No. 14/791,741, filed Jul. 6, 2015, which is a continuation application of U.S. patent application Ser. No. 13/968,551, filed Aug. 16, 2013, now U.S. Pat. No. 9,076,973 issued on Jul. 7, 2015, which is a continuation application of U.S. patent application Ser. No. 13/062,141, filed May 20, 2011, now U.S. Pat. No. 8,519,384 issued on Aug. 27, 2013, which is a U.S. national phase application filed under 35 U.S.C. §371 of International Application No. PCT/US2009/55890, filed Sep. 3, 2009, which is a continuation-in-part of application No. PCT/US2009/052045, filed on Jul. 29, 2009, and claims priority to provisional application No. 61/093,967, filed on Sep. 3, 2008, provisional application No. 61/140,459, filed on Dec. 23, 2008, and provisional application No. 61/229,088, filed on Jul. 28, 2009.

FIELD OF THE INVENTION

[0002] The present invention relates to organic materials that may be advantageously used in organic light emitting devices. More particularly, the present invention relates to a method of making organic materials for such devices, as well as novel organic materials.

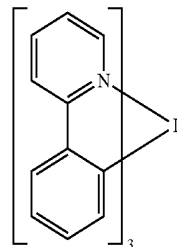
BACKGROUND

[0003] Opto-electronic devices that make use of organic materials are becoming increasingly desirable for a number of reasons. Many of the materials used to make such devices are relatively inexpensive, so organic opto-electronic devices have the potential for cost advantages over inorganic devices. In addition, the inherent properties of organic materials, such as their flexibility, may make them well suited for particular applications such as fabrication on a flexible substrate. Examples of organic opto-electronic devices include organic light emitting devices (OLEDs), organic phototransistors, organic photovoltaic cells, and organic photodetectors. For OLEDs, the organic materials may have performance advantages over conventional materials. For example, the wavelength at which an organic emissive layer emits light may generally be readily tuned with appropriate dopants.

[0004] OLEDs make use of thin organic films that emit light when voltage is applied across the device. OLEDs are becoming an increasingly interesting technology for use in applications such as flat panel displays, illumination, and backlighting. Several OLED materials and configurations are described in U.S. Pat. Nos. 5,844,363, 6,303,238, and 5,707,745, which are incorporated herein by reference in their entirety.

[0005] One application for phosphorescent emissive molecules is a full color display. Industry standards for such a display call for pixels adapted to emit particular colors, referred to as “saturated” colors. In particular, these standards call for saturated red, green, and blue pixels. Color may be measured using CIE coordinates, which are well known to the art.

[0006] One example of a green emissive molecule is tris(2-phenylpyridine) iridium, denoted Ir(ppy)₃, which has the structure:



[0007] In this, and later figures herein, we depict the dative bond from nitrogen to metal (here, Ir) as a straight line.

[0008] As used herein, the term “organic” includes polymeric materials as well as small molecule organic materials that may be used to fabricate organic opto-electronic devices. “Small molecule” refers to any organic material that is not a polymer, and “small molecules” may actually be quite large. Small molecules may include repeat units in some circumstances. For example, using a long chain alkyl group as a substituent does not remove a molecule from the “small molecule” class. Small molecules may also be incorporated into polymers, for example as a pendent group on a polymer backbone or as a part of the backbone. Small molecules may also serve as the core moiety of a dendrimer, which consists of a series of chemical shells built on the core moiety. The core moiety of a dendrimer may be a fluorescent or phosphorescent small molecule emitter. A dendrimer may be a “small molecule,” and it is believed that all dendrimers currently used in the field of OLEDs are small molecules.

[0009] As used herein, “top” means furthest away from the substrate, while “bottom” means closest to the substrate. Where a first layer is described as “disposed over” a second layer, the first layer is disposed further away from substrate. There may be other layers between the first and second layer, unless it is specified that the first layer is “in contact with” the second layer. For example, a cathode may be described as “disposed over” an anode, even though there are various organic layers in between.

[0010] As used herein, “solution processible” means capable of being dissolved, dispersed, or transported in and/or deposited from a liquid medium, either in solution or suspension form.

[0011] A ligand may be referred to as “photoactive” when it is believed that the ligand directly contributes to the photoactive properties of an emissive material. A ligand may be referred to as “ancillary” when it is believed that the ligand does not contribute to the photoactive properties of an emissive material, although an ancillary ligand may alter the properties of a photoactive ligand.

[0012] As used herein, and as would be generally understood by one skilled in the art, a first “Highest Occupied Molecular Orbital” (HOMO) or “Lowest Unoccupied Molecular Orbital” (LUMO) energy level is “greater than” or “higher than” a second HOMO or LUMO energy level if the first energy level is closer to the vacuum energy level. Since ionization potentials (IP) are measured as a negative energy relative to a vacuum level, a higher HOMO energy level corresponds to an IP having a smaller absolute value (an IP that is less negative). Similarly, a higher LUMO

energy level corresponds to an electron affinity (EA) having a smaller absolute value (an EA that is less negative). On a conventional energy level diagram, with the vacuum level at the top, the LUMO energy level of a material is higher than the HOMO energy level of the same material. A “higher” HOMO or LUMO energy level appears closer to the top of such a diagram than a “lower” HOMO or LUMO energy level.

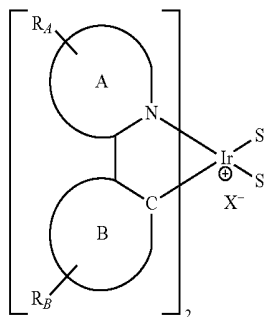
[0013] As used herein, and as would be generally understood by one skilled in the art, a first work function is “greater than” or “higher than” a second work function if the first work function has a higher absolute value. Because work functions are generally measured as negative numbers relative to vacuum level, this means that a “higher” work function is more negative. On a conventional energy level diagram, with the vacuum level at the top, a “higher” work function is illustrated as further away from the vacuum level in the downward direction. Thus, the definitions of HOMO and LUMO energy levels follow a different convention than work functions.

[0014] More details on OLEDs, and the definitions described above, can be found in U.S. Pat. No. 7,279,704, which is incorporated herein by reference in its entirety.

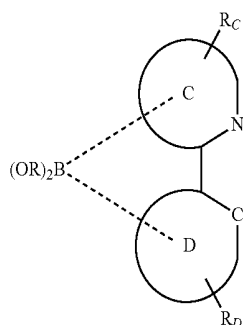
SUMMARY OF THE INVENTION

[0015] A method is provided for making heteroleptic Ir(III) complexes having extended conjugation. The method, comprising:

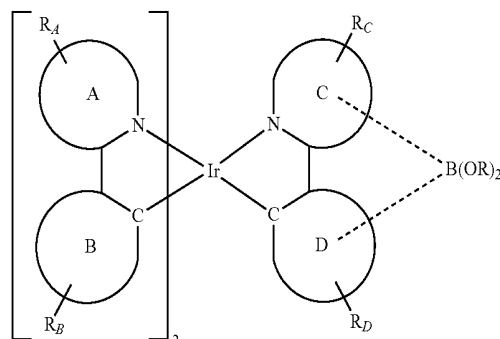
[0016] reacting



with

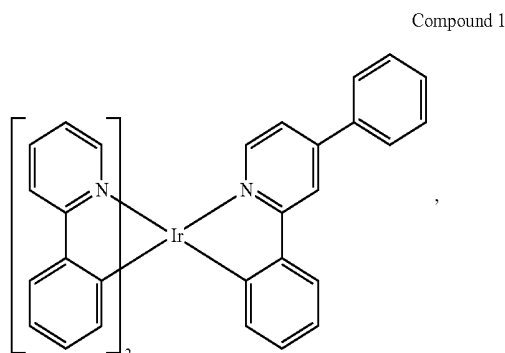


[0017] to form



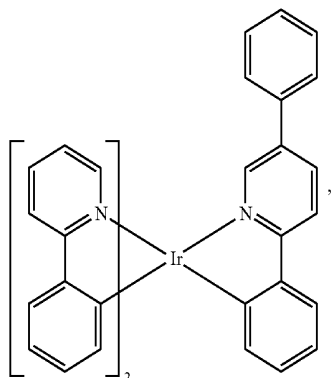
S is a neutral ligand. X is a counterion. Preferably, S is selected from the group consisting of triflate, tosylate, trifluoroacetate, tetrafluoroborate, and hexafluorophosphate. A and B are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and A-B represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. C and D are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and C-D represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen ring atom on ring C and an sp^2 hybridized carbon atom on ring D. R_A , R_B , R_C , and R_D are each independently selected from the group consisting of no substitution, alkyl, heteroalkyl, aryl, or heteroaryl groups. Each of R_A , R_B , R_C , and R_D represent one or more substituents. Preferably, R_A , R_B , R_C , and R_D are selected from the group consisting of benzene, pyrimidine, pyridine, thiophene, thianaphene, fluorine, carbazole, and dibenzothiophene. R is an alkyl, heteroalkyl, or perfluoroalkyl group and the two R_S are optionally joined to form a cycle.

[0018] Additionally, phosphorescent emissive materials are provided. The materials are heteroleptic complexes with extended conjugation on the heterocyclic ring. The materials may be advantageously used in organic light emitting devices. In particular, the materials may be useful as the emissive dopant of such devices. The materials are selected from the group consisting of:



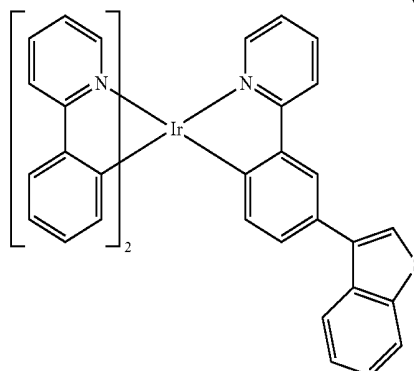
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Compound 2

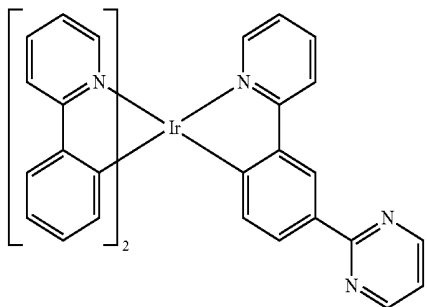


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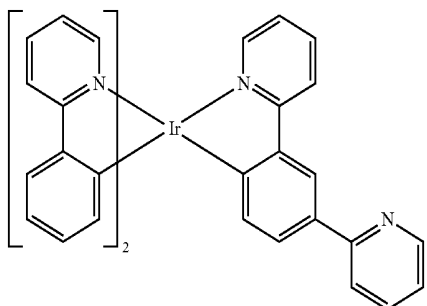
Compound 6



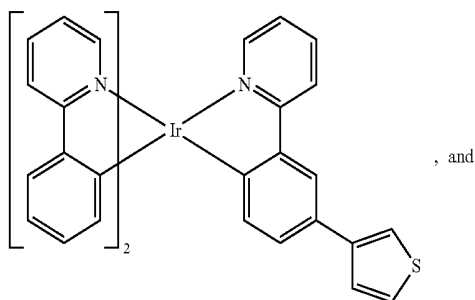
Compound 3



Compound 4

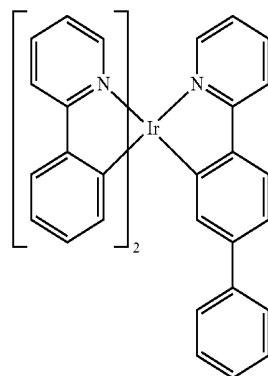


Compound 5

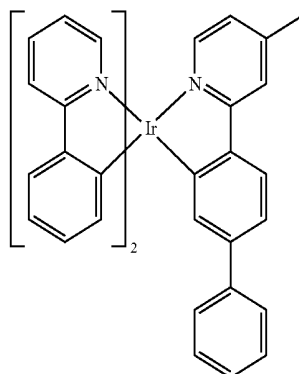


, and

Compound 8



Compound 9



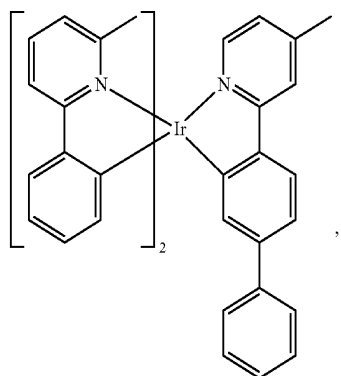
[0019] In one aspect, Compound 1 may be preferred. In another aspect, Compound 2 may be preferred.

[0020] Additionally, an organic light emitting device is provided. The device has an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer comprises a compound selected from Compounds 1-6. The organic layer may further comprise a host. Preferably, the host includes a triphenylene group. More preferably, the host includes a triphenylene further substituted with terphenyl. Most preferably, the host is H1.

[0021] A consumer product is also provided. The product contains a device that has an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer further comprises a compound selected from Compounds 1-6.

[0022] Heteroleptic iridium compounds are provided, which may be advantageously used in organic light emitting devices. The heteroleptic compounds are selected from the group consisting of:

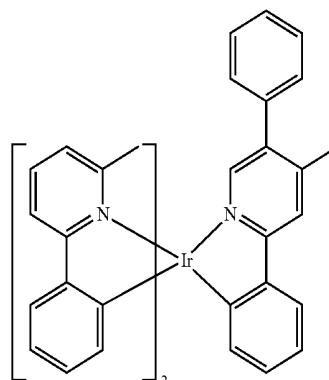
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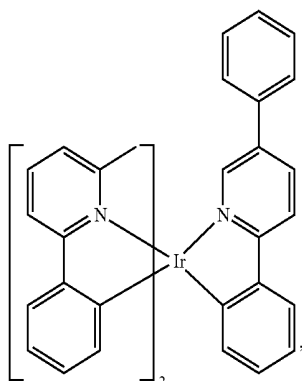
Compound 10

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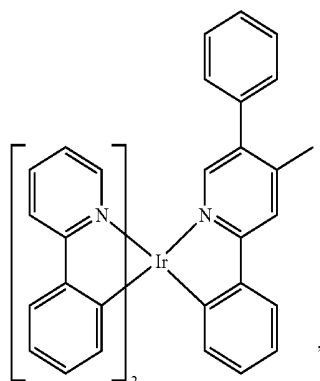
Compound 14



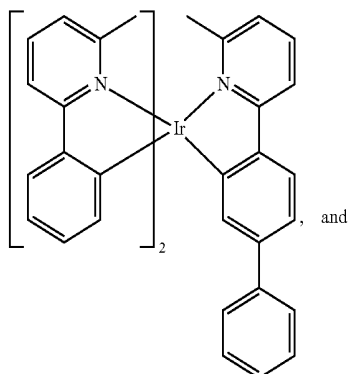
Compound 11



Compound 12



Compound 13



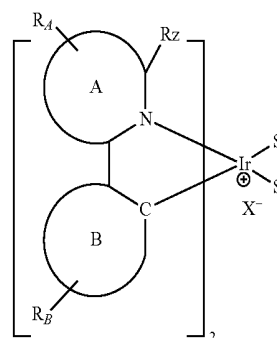
[0023] In one aspect, Compound 8 may be preferred. In another aspect, Compound 9 may be preferred. In yet another aspect, Compound 10 may be preferred. In a further aspect, Compound 11 may be preferred. In yet another aspect, Compound 12 may be preferred. In a further aspect, Compound 13 may be preferred. In yet another aspect, Compound 14 may be preferred.

[0024] Additionally, an organic light emitting device is provided. The device has an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer comprises a compound selected from Compounds 8-14. The organic layer may further comprise a host having a triphenylene group further substituted with an aryl or a heteroaryl. Preferably, the host contains a triphenylene group further substituted with a terphenyl or a dibenzothiophene. More preferably, the host is H1 or H2.

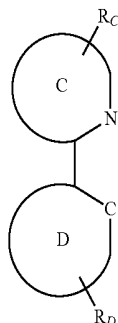
[0025] A consumer product is also provided. The product contains a device that has an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer further comprises a compound selected from Compounds 8-14.

[0026] Additionally, a method for making heteroleptic compounds without significant ligand scrambling is provided. The method, comprising:

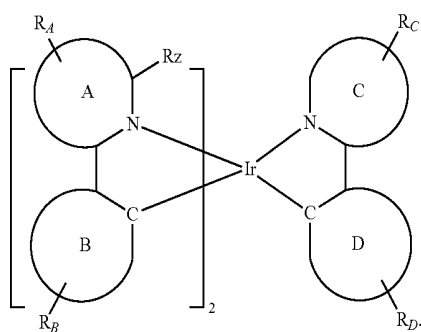
reacting



with

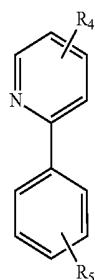


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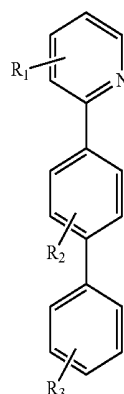
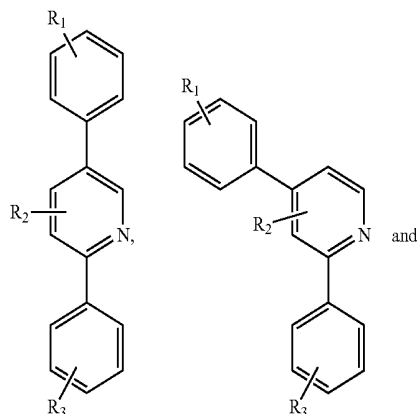


S is a neutral ligand. X is a counterion. Preferably, X is selected from the group consisting of triflate, tosylate, trifluoroborate, and hexafluorophosphate. A and B are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and A-B represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. C and D are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and C-D represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen ring atom on ring C and an sp^2 hybridized carbon atom on ring D. R_A , R_B , R_C , and R_D are each independently selected from the group consisting of no substitution, alkyl, heteroalkyl, aryl, or heteroaryl groups, and each of R_A , R_B , R_C , and R_D represent one or more substituents. Preferably, R_A , R_B , R_C , and R_D are selected from the group consisting of benzene, pyrimidine, pyridine, thiophene, thianaphthene, fluorine, carbazole, and dibenzothiophene. R_Z is not H. Preferably, R_Z is methyl.

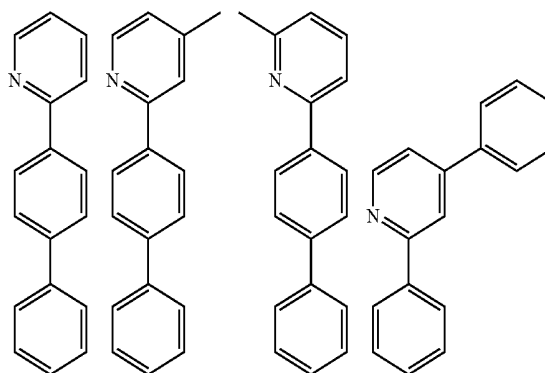
[0027] A heteroleptic compound having the formula $Ir(L_{A-B})_2(L_{C-D})$ is provided. L_{A-B} is

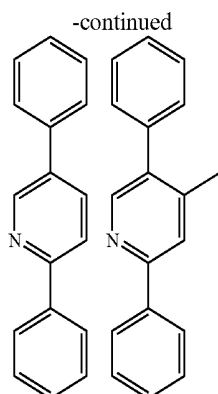


L_{C-D} is selected from the group consisting of



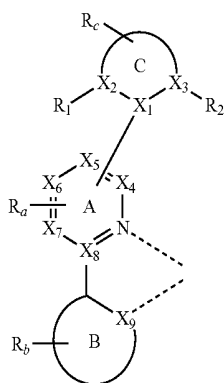
R_1 , R_2 , R_3 , R_4 and R_5 are each independently selected from the group consisting of hydrogen and alkyl, and each of R_1 , R_2 , R_3 , R_4 and R_5 may represent mono, di, tri, tetra, or penta substitutions. Preferably, R_1 , R_2 , R_3 , R_4 and R_5 are each independently hydrogen and methyl. More preferably, L_{C-D} is selected from the group consisting of:





[0028] Novel phosphorescent organic materials are provided. The organic materials are compounds containing at least one ligand having an alkyl substituent and an aryl substituent such that the substituent aryl is twisted out of plane (i.e., twisted aryl in this document) more than the usual unsubstituted phenyl-phenyl. The compounds may be advantageously used in organic light emitting devices. In particular, the compounds may be useful as an emitting dopant in such devices.

[0029] Compounds are provided, the compounds comprising a ligand L having the structure:

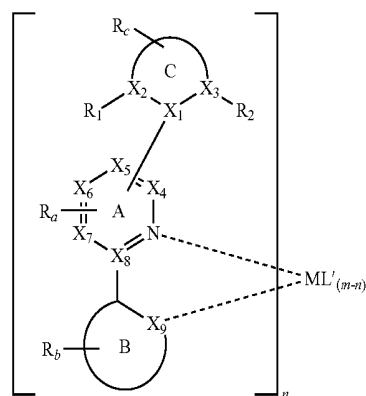


Formula I

[0030] B and C are each independently a 5 or 6-membered carbocyclic or heterocyclic ring. A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to a metal M via a nitrogen atom on ring A and a sp^2 hybridized carbon atom on ring B. A-C represents a bonded pair of carbocyclic and heterocyclic rings. R_a , R_b , and R_c may represent mono, di, tri, or tetra substitutions. R_a , R_b , and R_c are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen. Preferably, A is pyridine. R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. At least one of R_1 , R_2 , and the R_a substituents adjacent to Ring C is not hydrogen. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is alkyl. More preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is ethyl. Most preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is methyl. The ligand

L is coordinated to the metal M having an atomic number greater than 40. Preferably, the metal M is Ir.

[0031] Examples of the compounds may include compounds having the structure:



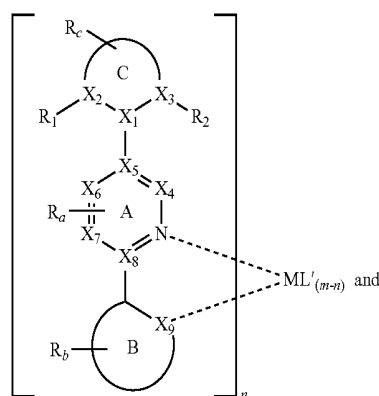
Formula II

[0032] m is the oxidation state of the metal M. Preferably, the metal M is Ir. Preferably, A is pyridine. n is at least 1. L' is a monoanionic bidentate ligand. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is alkyl. More preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is ethyl. Most preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is methyl.

[0033] Particular examples of compounds having Formula II are provided and include Compound 15-Compound 20. R is not hydrogen. Preferably, R is alkyl.

[0034] Specific examples of compounds having Formula II are provided, including Compound 21-Compound 37. In one aspect, Compounds 21, 22, 25, 29, 30, 31 and 34 may be preferred compounds.

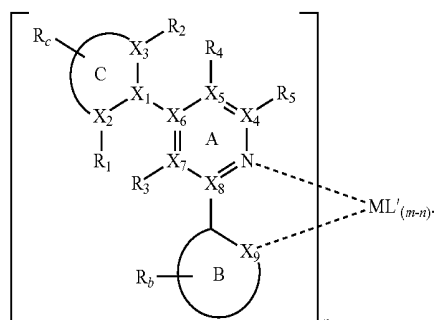
[0035] In one aspect, compounds are provided wherein the compound is selected from the group consisting of:



Formula III

-continued

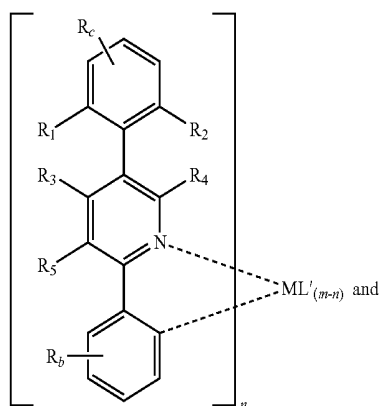
Formula IV



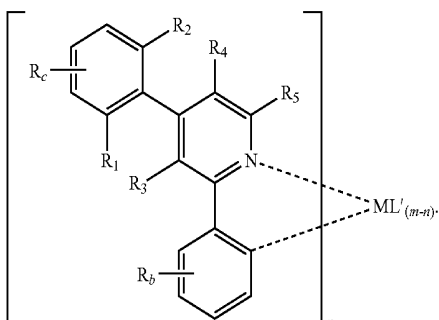
At least one of R_1 , R_2 , R_3 , and R_4 is not hydrogen. R_5 is selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. Preferably, A is pyridine. In one aspect, R_1 and R_2 are hydrogen and one of R_3 and R_4 is alkyl. Exemplary compounds may include Compounds 21-24, 29-34, 36 and 37. In another aspect, one of R_1 and R_2 is alkyl and R_3 and R_4 are hydrogen. Exemplary compounds may include Compounds 25-28 and 35.

[0036] In another aspect, the compound is selected from the group consisting of:

Formula V

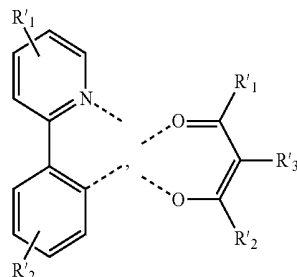


Formula VI



[0037] Compounds having Formula II include homoleptic compounds and heteroleptic compounds. Examples of homoleptic compound include Compounds 21-24 and 35. Examples of heteroleptic compounds include Compounds 25-34, 36 and 37.

[0038] In one aspect, compounds are provided having a ligand L' selected from the group consisting of:



R'_1 , R'_2 and R'_3 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

[0039] In one aspect, compounds where the alkyl substituent (i.e., the alkyl substituent inducing the twist in the aryl substituent) is present on the pyridine ring of the ligand L are preferred. Preferably the compound is selected from the group consisting of Compounds 21-23, 29-31, 34, 36 and 37.

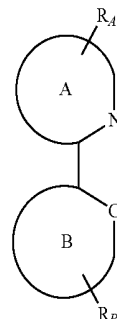
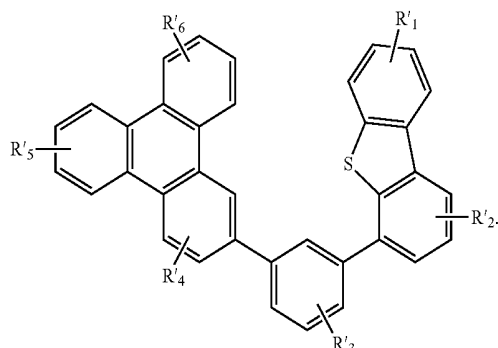
[0040] In another aspect, compounds where the alkyl substituent is para to the nitrogen of the pyridine ring may be especially preferred. Preferably, the compound is selected from the group consisting of Compounds 21, 22, 29-31, 34, 36 and 37.

[0041] An organic light emitting device is also provided. The device has an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer comprises a compound having Formula I, as described above. Selections for the substituents described as preferred for the compounds having Formula I are also preferred for use in a device that comprises a compound having Formula I. These selections include those described for the metal M ; the formulas II-VI; the substituents R , R_1 , R_2 , R_3 , R_4 , R_5 , and R_a substituents adjacent to C ; the position of ring C ; and rings A , B , and C .

[0042] In one aspect, the device comprises a compound having Formula II, as described above. Preferably, the metal M is Ir. Preferably, A is pyridine. In another aspect, the device comprises a compound having Formula III or Formula IV, as described above. Devices containing a compound wherein only one of R_1 , R_2 , and the R_a substituents adjacent to C is alkyl may also be preferred. In yet another aspect, the device comprises a compound having Formula V or Formula VI, as described above. Certain devices are provided wherein the device contains a compound selected from the group consisting of Compound 21-Compound 37. Preferably, the device contains Compound 21, Compound 22, Compound 25, Compound 29, Compound 30, Compound 31 or Compound 34.

[0043] In one aspect, devices are provided wherein the organic layer is an emissive layer and the compound having the formula of Formula I is an emitting dopant. Moreover, the organic layer may further comprise a host. Preferably, the host has the structure:

with



in the presence of a low boiling alcohol to form

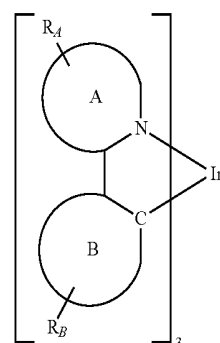
R'_1 , R'_2 , R'_3 , R'_4 , R'_5 , and R'_6 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

[0044] A consumer product comprising a device is also provided. The device comprises an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer comprises a compound having Formula I, as described above. Selections for the substituents described as preferred for the compounds having Formula I are also preferred for use in a consumer product containing a device that comprises a compound having Formula I. These selections include those described for the metal M; the formulas II-VI; the substituents R, R_1 , R_2 , R_3 , R_4 , R_5 , and R_a substituents adjacent to C; the position of ring C; and rings A, B, and C.

[0045] Additionally, low temperature methods for making homoleptic compounds are provided. In particular, the methods are for making homoleptic Ir (III) compounds. These compounds may preferably contain a twisted aryl.

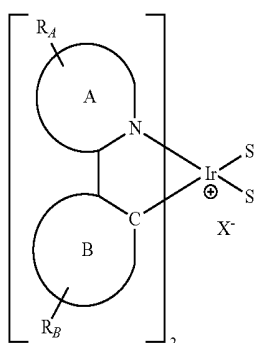
[0046] A first method for making a homoleptic Ir(III) complex is provided. The first method comprising:

reacting

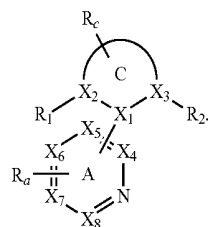


[0047] At least one of R_A and R_B is an alkyl group and the alkyl group is not adjacent to the nitrogen on the pyridine ring. S is a neutral ligand. X is a counterion. Preferably, X is triflate. A and B are each independently a 5 or 6-membered carbocyclic or heterocyclic ring. A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. Each of R_A and R_B may represent mono, di, tri, or tetra substitutions. R_A and R_B are each independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

[0048] In one aspect, the low boiling alcohol is selected from the group consisting of methanol, ethanol, n-propanol, isopropanol, n-butanol, a 1:1 ratio of ethanol and methanol, 2-methoxyethanol, and 2-ethoxyethanol. Preferably, the low boiling alcohol is selected from the group consisting of isopropanol which boils at 108° C., ethanol which boils at 78° C., and a 1:1 ratio of ethanol and methanol which has a boiling point between 65° C. and 78° C. More preferably, the low boiling alcohol is ethanol or a 1:1 ratio of ethanol and methanol. Most preferably, the low boiling alcohol is a 1:1 ratio of ethanol and methanol.

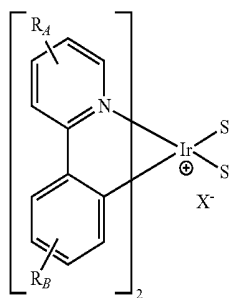


[0049] Preferably, A is:

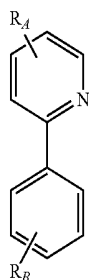


[0050] C is a 5 or 6-membered carbocyclic or heterocyclic ring. A-C represents a bonded pair of carbocyclic and heterocyclic rings. R_A and R_C may represent mono, di, tri, or tetra substitutions. R_A and R_C are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen. R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. At least one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen.

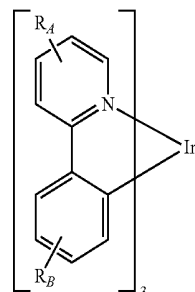
[0051] In one aspect, the first method comprises: reacting



with

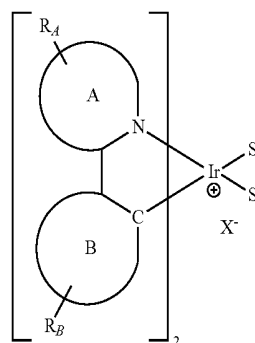


in the presence of a low boiling alcohol to form

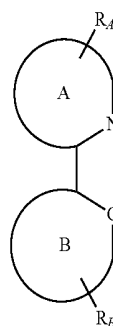


Specific compounds, including Compound 21, Compound 22, and Compound 24, may be formed using this method.

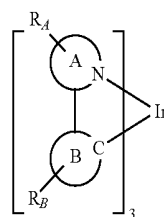
[0052] A second method for making homoleptic Ir (III) compounds is also provided. The second method comprises: reacting



with

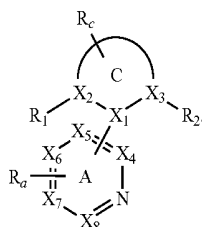


in the absence of solvent to form



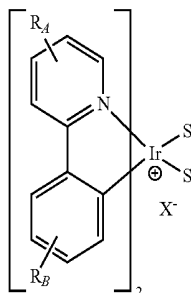
[0053] At least one of R_A and R_B is an alkyl group and the alkyl group is adjacent to the nitrogen on the pyridine ring. S is a neutral ligand. X is a counterion. Preferably, X is triflate. A and B are each independently a 5 or 6-membered carbocyclic or heterocyclic ring. A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. Each of R_A and R_B may represent mono, di, tri, or tetra substitutions. R_A and R_B are each independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

[0054] Preferably, A is:

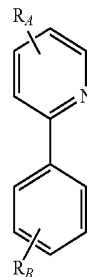


[0055] C is a 5 or 6-membered carbocyclic or heterocyclic ring. A-C represents a bonded pair of carbocyclic and heterocyclic rings. R_A and R_C may represent mono, di, tri, or tetra substitutions. R_A and R_C are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen. R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. At least one of R_1 , R_2 , and the R_A substituents adjacent to C is not hydrogen.

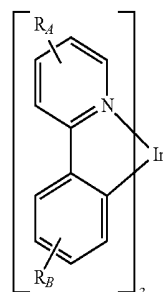
[0056] In one aspect, the second method comprises: reacting



with



in the absence of solvent to form



Specific compounds, including Compound 23, may be formed using this method.

BRIEF DESCRIPTION OF THE DRAWINGS

- [0057] FIG. 1 shows an organic light emitting device.
 [0058] FIG. 2 shows an inverted organic light emitting device that does not have a separate electron transport layer.
 [0059] FIG. 3 shows a PHOLED having a particular structure.
 [0060] FIG. 4 shows a method of making heteroleptic Ir (III) compounds.
 [0061] FIG. 5 shows heteroleptic Ir (III) complexes having extended conjugation.
 [0062] FIG. 6 shows a method for making heteroleptic Ir (III) compounds.
 [0063] FIG. 7 shows a ligand containing a twisted aryl and a compound comprising a ligand containing a twisted aryl.
 [0064] FIG. 8 shows exemplary compounds.
 [0065] FIG. 9 shows a method for making homoleptic Ir (III) compounds.

DETAILED DESCRIPTION

[0066] Generally, an OLED comprises at least one organic layer disposed between and electrically connected to an anode and a cathode. When a current is applied, the anode injects holes and the cathode injects electrons into the organic layer(s). The injected holes and electrons each migrate toward the oppositely charged electrode. When an electron and hole localize on the same molecule, an "exciton," which is a localized electron-hole pair having an excited energy state, is formed. Light is emitted when the exciton relaxes via a photoemissive mechanism. In some cases, the exciton may be localized on an excimer or an

exciplex. Non-radiative mechanisms, such as thermal relaxation, may also occur, but are generally considered undesirable.

[0067] The initial OLEDs used emissive molecules that emitted light from their singlet states (“fluorescence”) as disclosed, for example, in U.S. Pat. No. 4,769,292, which is incorporated by reference in its entirety. Fluorescent emission generally occurs in a time frame of less than 10 nanoseconds.

[0068] More recently, OLEDs having emissive materials that emit light from triplet states (“phosphorescence”) have been demonstrated. Baldo et al., “Highly Efficient Phosphorescent Emission from Organic Electroluminescent Devices,” *Nature*, vol. 395, 151-154, 1998; (“Baldo-I”) and Baldo et al., “Very high-efficiency green organic light-emitting devices based on electrophosphorescence,” *Appl. Phys. Lett.*, vol. 75, No. 3, 4-6 (1999) (“Baldo-II”), which are incorporated by reference in their entireties. Phosphorescence is described in more detail in U.S. Pat. No. 7,279,704 at cols. 5-6, which are incorporated by reference.

[0069] FIG. 1 shows an organic light emitting device **100**. The figures are not necessarily drawn to scale. Device **100** may include a substrate **110**, an anode **115**, a hole injection layer **120**, a hole transport layer **125**, an electron blocking layer **130**, an emissive layer **135**, a hole blocking layer **140**, an electron transport layer **145**, an electron injection layer **150**, a protective layer **155**, and a cathode **160**. Cathode **160** is a compound cathode having a first conductive layer **162** and a second conductive layer **164**. Device **100** may be fabricated by depositing the layers described, in order. The properties and functions of these various layers, as well as example materials, are described in more detail in U.S. Pat. No. 7,279,704 at cols. 6-10, which are incorporated by reference.

[0070] More examples for each of these layers are available. For example, a flexible and transparent substrate-anode combination is disclosed in U.S. Pat. No. 5,844,363, which is incorporated by reference in its entirety. An example of a p-doped hole transport layer is m-MTDATA doped with F.sub.4-TCNQ at a molar ratio of 50:1, as disclosed in U.S. Patent Application Publication No. 2003/0230980, which is incorporated by reference in its entirety. Examples of emissive and host materials are disclosed in U.S. Pat. No. 6,303,238 to Thompson et al., which is incorporated by reference in its entirety. An example of an n-doped electron transport layer is BPhen doped with Li at a molar ratio of 1:1, as disclosed in U.S. Patent Application Publication No. 2003/0230980, which is incorporated by reference in its entirety. U.S. Pat. Nos. 5,703,436 and 5,707,745, which are incorporated by reference in their entireties, disclose examples of cathodes including compound cathodes having a thin layer of metal such as Mg:Ag with an overlying transparent, electrically-conductive, sputter-deposited ITO layer. The theory and use of blocking layers is described in more detail in U.S. Pat. No. 6,097,147 and U.S. Patent Application Publication No. 2003/0230980, which are incorporated by reference in their entireties. Examples of injection layers are provided in U.S. Patent Application Publication No. 2004/0174116, which is incorporated by reference in its entirety. A description of protective layers may be found in U.S. Patent Application Publication No. 2004/0174116, which is incorporated by reference in its entirety.

[0071] FIG. 2 shows an inverted OLED **200**. The device includes a substrate **210**, a cathode **215**, an emissive layer **220**, a hole transport layer **225**, and an anode **230**. Device **200** may be fabricated by depositing the layers described, in order. Because the most common OLED configuration has a cathode disposed over the anode, and device **200** has cathode **215** disposed under anode **230**, device **200** may be referred to as an “inverted” OLED. Materials similar to those described with respect to device **100** may be used in the corresponding layers of device **200**. FIG. 2 provides one example of how some layers may be omitted from the structure of device **100**.

[0072] The simple layered structure illustrated in FIGS. 1 and 2 is provided by way of non-limiting example, and it is understood that embodiments of the invention may be used in connection with a wide variety of other structures. The specific materials and structures described are exemplary in nature, and other materials and structures may be used. Functional OLEDs may be achieved by combining the various layers described in different ways, or layers may be omitted entirely, based on design, performance, and cost factors. Other layers not specifically described may also be included. Materials other than those specifically described may be used. Although many of the examples provided herein describe various layers as comprising a single material, it is understood that combinations of materials, such as a mixture of host and dopant, or more generally a mixture, may be used. Also, the layers may have various sublayers. The names given to the various layers herein are not intended to be strictly limiting. For example, in device **200**, hole transport layer **225** transports holes and injects holes into emissive layer **220**, and may be described as a hole transport layer or a hole injection layer. In one embodiment, an OLED may be described as having an “organic layer” disposed between a cathode and an anode. This organic layer may comprise a single layer, or may further comprise multiple layers of different organic materials as described, for example, with respect to FIGS. 1 and 2.

[0073] Structures and materials not specifically described may also be used, such as OLEDs comprised of polymeric materials (PLEDs) such as disclosed in U.S. Pat. No. 5,247,190 to Friend et al., which is incorporated by reference in its entirety. By way of further example, OLEDs having a single organic layer may be used. OLEDs may be stacked, for example as described in U.S. Pat. No. 5,707,745 to Forrest et al, which is incorporated by reference in its entirety. The OLED structure may deviate from the simple layered structure illustrated in FIGS. 1 and 2. For example, the substrate may include an angled reflective surface to improve out-coupling, such as a mesa structure as described in U.S. Pat. No. 6,091,195 to Forrest et al., and/or a pit structure as described in U.S. Pat. No. 5,834,893 to Bulovic et al., which are incorporated by reference in their entireties.

[0074] Unless otherwise specified, any of the layers of the various embodiments may be deposited by any suitable method. For the organic layers, preferred methods include thermal evaporation, ink-jet, such as described in U.S. Pat. Nos. 6,013,982 and 6,087,196, which are incorporated by reference in their entireties, organic vapor phase deposition (OVPD), such as described in U.S. Pat. No. 6,337,102 to Forrest et al., which is incorporated by reference in its entirety, and deposition by organic vapor jet printing (OVJP), such as described in U.S. patent application Ser. No. 10/233,470, which is incorporated by reference in its

entirety. Other suitable deposition methods include spin coating and other solution based processes. Solution based processes are preferably carried out in nitrogen or an inert atmosphere. For the other layers, preferred methods include thermal evaporation. Preferred patterning methods include deposition through a mask, cold welding such as described in U.S. Pat. Nos. 6,294,398 and 6,468,819, which are incorporated by reference in their entireties, and patterning associated with some of the deposition methods such as ink-jet and OVJD. Other methods may also be used. The materials to be deposited may be modified to make them compatible with a particular deposition method. For example, substituents such as alkyl and aryl groups, branched or unbranched, and preferably containing at least 3 carbons, may be used in small molecules to enhance their ability to undergo solution processing. Substituents having 20 carbons or more may be used, and 3-20 carbons is a preferred range. Materials with asymmetric structures may have better solution processibility than those having symmetric structures, because asymmetric materials may have a lower tendency to recrystallize. Dendrimer substituents may be used to enhance the ability of small molecules to undergo solution processing.

[0075] Devices fabricated in accordance with embodiments of the invention may be incorporated into a wide variety of consumer products, including flat panel displays, computer monitors, televisions, billboards, lights for interior or exterior illumination and/or signaling, heads up displays, fully transparent displays, flexible displays, laser printers, telephones, cell phones, personal digital assistants (PDAs), laptop computers, digital cameras, camcorders, viewfinders, micro-displays, vehicles, a large area wall, theater or stadium screen, or a sign. Various control mechanisms may be used to control devices fabricated in accordance with the present invention, including passive matrix and active matrix. Many of the devices are intended for use in a temperature range comfortable to humans, such as 18 degrees C. to 30 degrees C., and more preferably at room temperature (20-25 degrees C.).

[0076] The materials and structures described herein may have applications in devices other than OLEDs. For example, other optoelectronic devices such as organic solar cells and organic photodetectors may employ the materials and structures. More generally, organic devices, such as organic transistors, may employ the materials and structures.

[0077] The terms halo, halogen, alkyl, cycloalkyl, alkenyl, alkynyl, aryl, heterocyclic group, aryl, aromatic group, and heteroaryl are known to the art, and are defined in U.S. Pat. No. 7,279,704 at cols. 31-32, which are incorporated herein by reference.

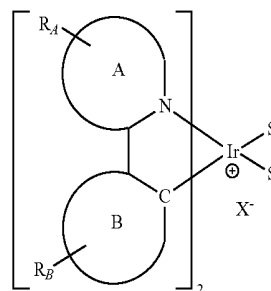
[0078] Compounds are provided, comprising a heteroleptic Ir (III) complex having extended conjugation. In particular, the complex has extended conjugation on the heterocyclic ring which coordinates to the metal through nitrogen. Heteroleptic iridium complexes are of great interest because their photophysical, thermal, and electronic properties can be tuned according to the ligands that are attached to the metal center. One advantage to using heteroleptic iridium complexes is that they offer improved device lifetime and a lower sublimation temperature, therefore offering improved manufacturing, as compared to homoleptic Ir (III) complexes. For example, a heteroleptic complex containing 2-phenylpyridine and 2-(biphenyl-3-yl)pyridine, has shown an improved lifetime compared to a related homoleptic complex. Further, the sublimation temperature of the heteroleptic complex is almost 70° C. lower than the homoleptic complex. See, U.S. Provisional Application No. 60/940,310. Heteroleptic complexes which demonstrate

improved stability and low sublimation temperatures, such as those disclosed herein, are highly desirable for use in OLEDs. In particular, the heteroleptic Ir (III) complexes may be especially desirable for use in white organic light emitting devices (WOLEDs).

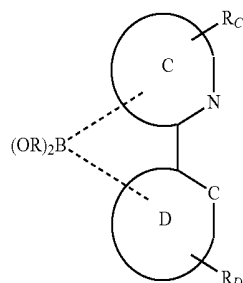
[0079] The existing synthetic methods for making many heteroleptic iridium complexes may not be practical. In particular, existing synthetic routes include the halogenation of iridium complexes and further functionalized (see, Stossel et al., *Rhodium complexes and iridium complexes*, 2005, EP1504015B1; Stossel et al., *Rhodium and iridium complexes*, 2006, U.S. Pat. No. 7,125,998), the use of boronic ester substituted iridium complexes generated from halogenated complexes and further functionalized (see, Kwong et al., *Method for synthesis of iridium (III) complexes with sterically demanding ligands*, 2006, U.S. application Ser. No. 12/044,848), and the low temperature BuLi/ZnCl₂ method (see, Huo et al, *OLEDs with mixed ligand cyclometallated complexes*, 2006, US20060134459A1). The low temperature BuLi/ZnCl₂ method, for example, produces mer-isomers of the complex, which are not normally desired, and thus must then be converted to the useful fac-isomer of the complex. See, Huo et al, *OLEDs with mixed ligand cyclometallated complexes*, 2006, US20060134459A1. Thus, this method may not be practical for large scale synthesis of the complex. While offering improved yield, the method that involves converting a brominated iridium complex to a boronic ester to ultimately yield the final product is indirect. See, Kwong et al., *Method for synthesis of iridium (III) complexes with sterically demanding ligands*, 2006, U.S. application Ser. No. 12/044, 848. Therefore, it is highly desirable to provide a more practical and direct synthetic method for making heteroleptic Ir (III) complexes.

[0080] The method, as described herein, can be used to make heteroleptic Ir (III) complexes that may be advantageously used in OLEDs and, in particular, WOLEDs. For example, the method described herein can be used to make especially desirable heteroleptic Ir (III) complexes such as Compound 1, Compound 2 and Compound 7.

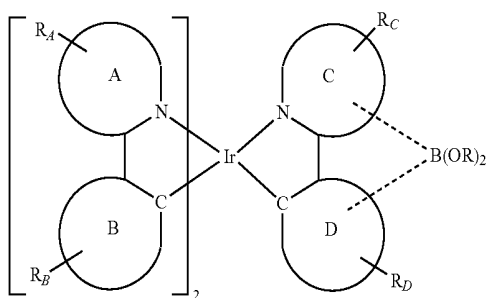
[0081] A method for making Ir (III) heteroleptic complexes having extended conjugation, the method comprising reacting



with



to form

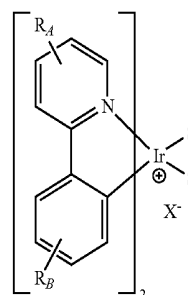


where S is a neutral ligand. X is a counterion. A and B are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and A-B represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. C and D are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and C-D represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen ring atom on ring C and an sp^2 hybridized carbon atom on ring D. R_A , R_B , R_C , and R_D are each independently selected from the group consisting of no substitution, alkyl, heteroalkyl, aryl, or heteroaryl groups. Each of R_A , R_B , R_C , and R_D represent one or more substituents. R is an alkyl, heteroalkyl, or perfluoroalkyl group and the two R_S are optionally joined to form a cycle.

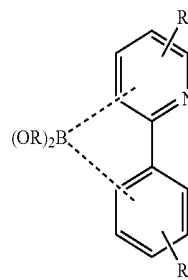
[0082] In one aspect of the method, the counterion X is selected from the group consisting of triflate, tosylate, trifluoroacetate, tetrafluoroborate, and hexafluorophosphate.

[0083] In one aspect, R_A , R_B , R_C , and R_D are selected from the group consisting of benzene, pyrimidine, pyridine, thiophene, thianaphthene, fluorine, carbazole, and dibenzothio-
phene.

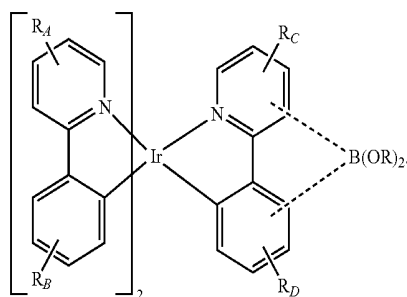
[0084] In another aspect, the method includes reacting



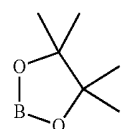
with



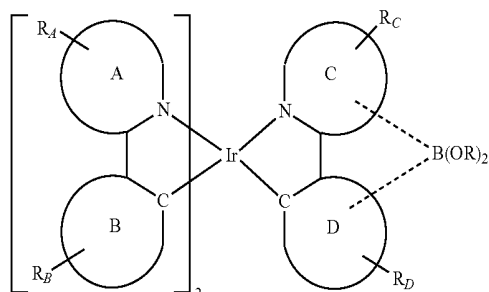
to form



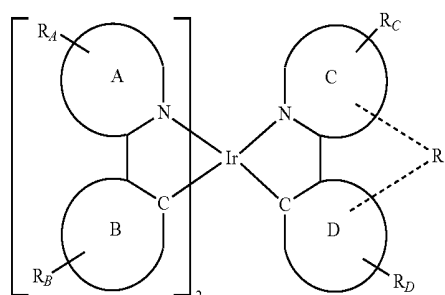
[0085] In one aspect of the method, the group $B(OR)_2$ is attached to ring C. In another aspect, the group $B(OR)_2$ is attached to ring D. In a particular aspect of the method, the group $B(OR)_2$ is



[0086] In one aspect, the method includes reacting

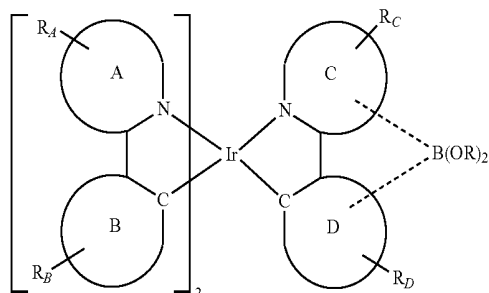


with RX to form

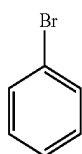


wherein R is aryl or heteroaryl and X is selected from the group consisting of I, Br, Cl, and OTf.

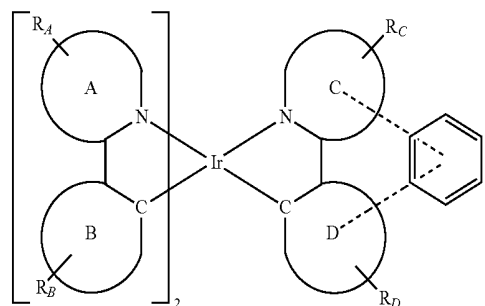
[0087] In one aspect, the method includes reacting



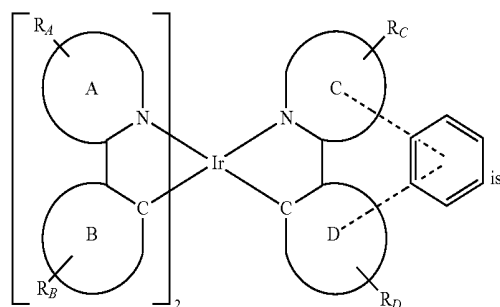
with



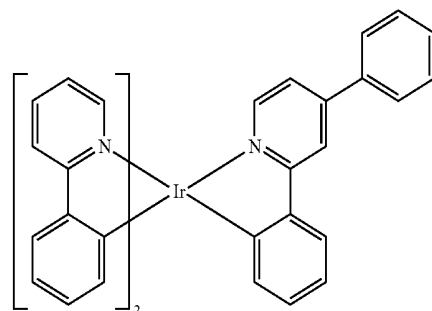
to form



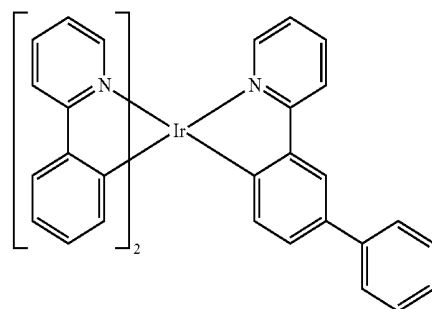
In a certain aspect of the method, the complex



Compound 1

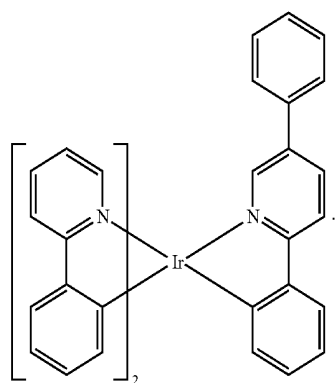


In another aspect, the complex is



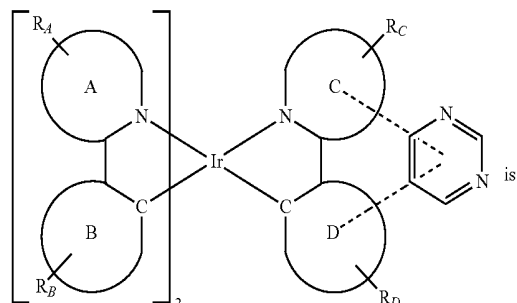
Compound 7

In yet another aspect, the complex is

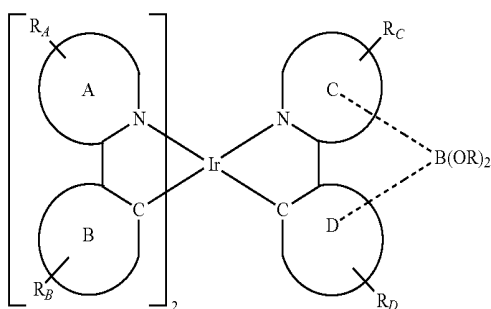


Compound 2

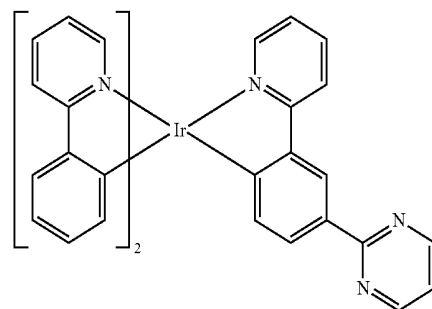
In a certain aspect of the method, the complex



[0088] In another aspect, the method includes reacting

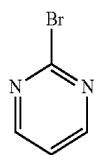


Compound 3

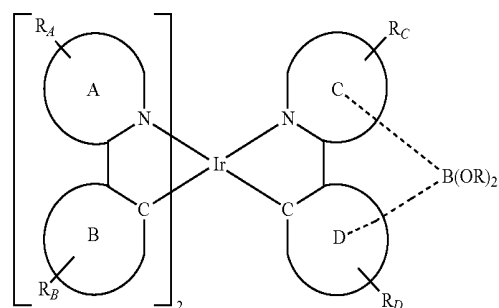
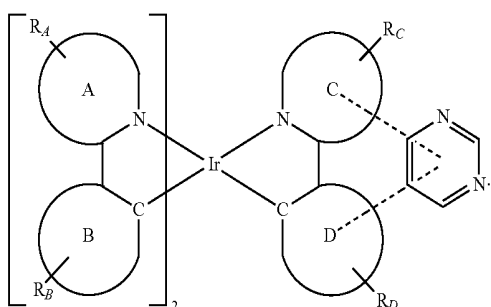


[0089] In another aspect, the method includes reacting

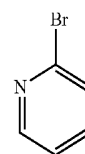
with



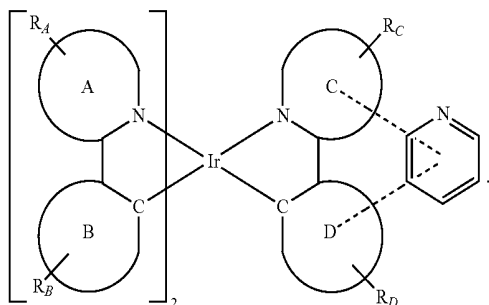
to form



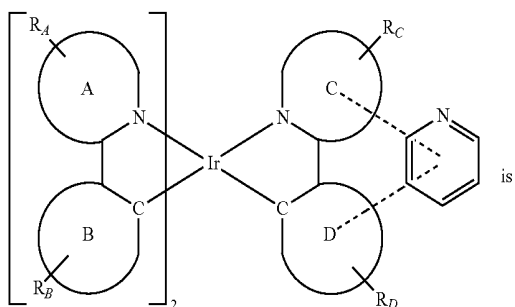
with



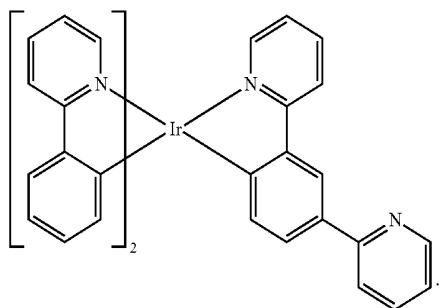
to form



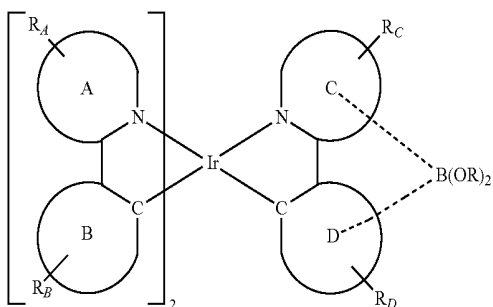
In a certain aspect, the complex



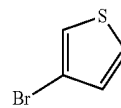
Compound 4



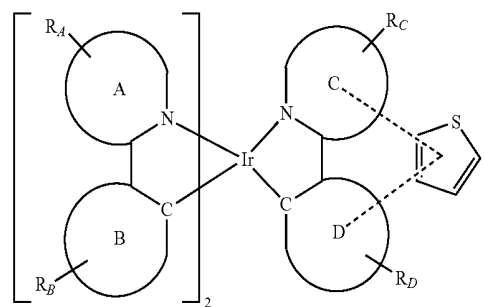
[0090] In another aspect, the method includes reacting



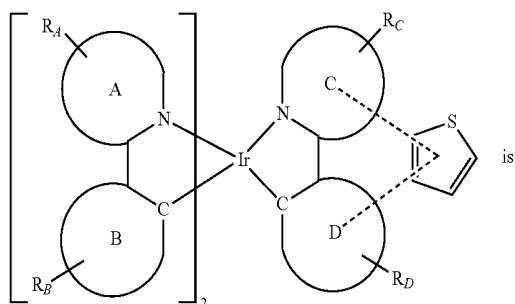
with



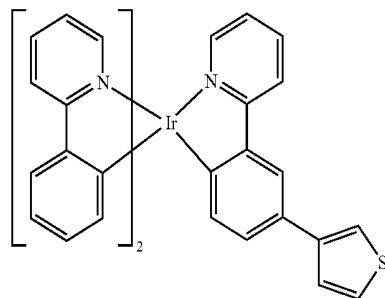
to form



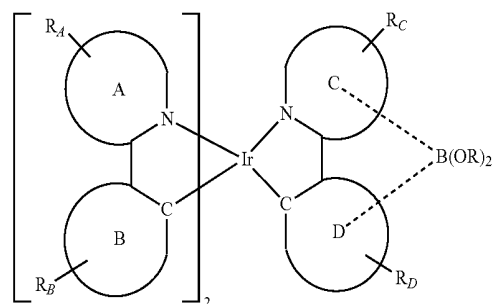
In a certain aspect, the complex



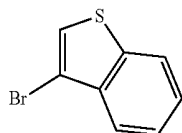
Compound 5



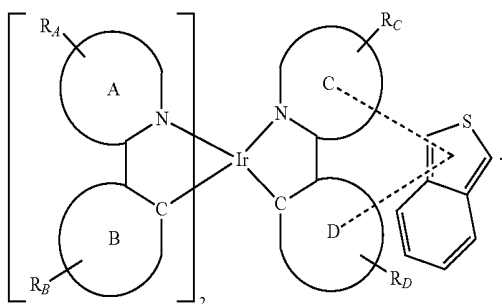
[0091] In yet another aspect, the method includes reacting



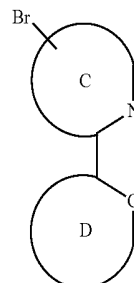
with



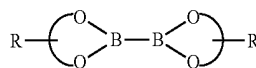
to form



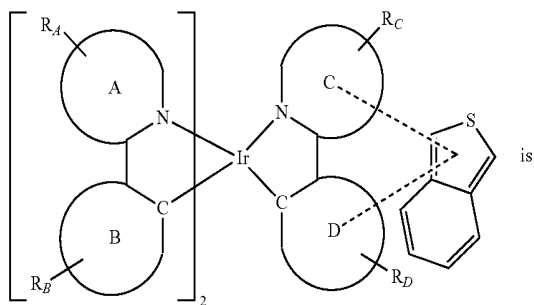
[0092] In another aspect, the method further includes reacting



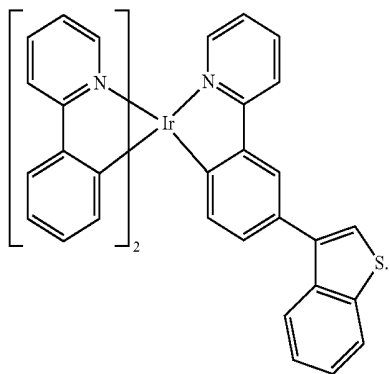
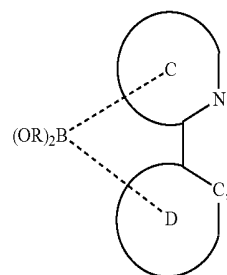
with



In a certain aspect of the method, the complex

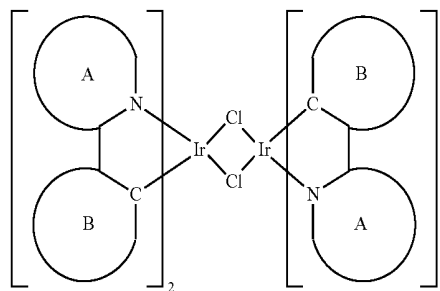


to form

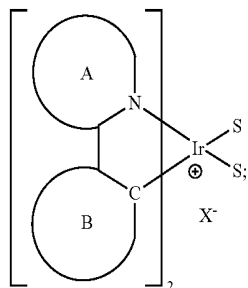


Compound 6

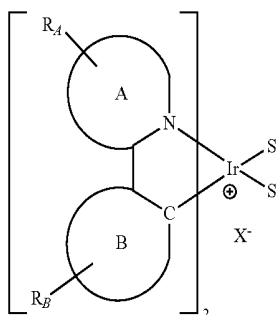
and reacting



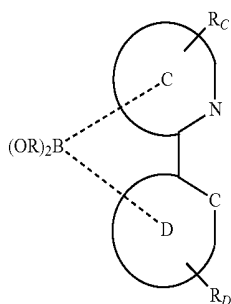
with AgX to form



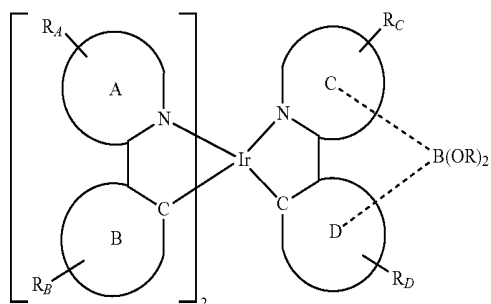
and then reacting



with



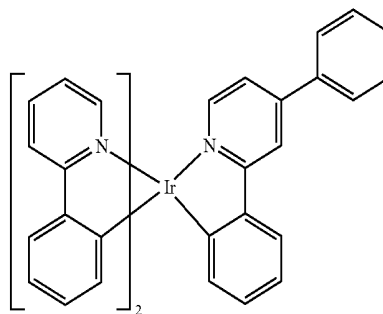
to form



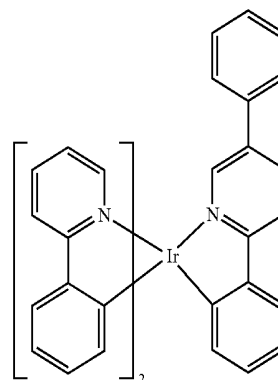
[0093] Additionally, phosphorescent emissive compounds are provided. In particular, the compounds are Ir (III) heteroleptic complexes having extended conjugation on the heterocyclic ring which coordinates to the metal through

nitrogen. The compounds provided have the formula selected from the group consisting of:

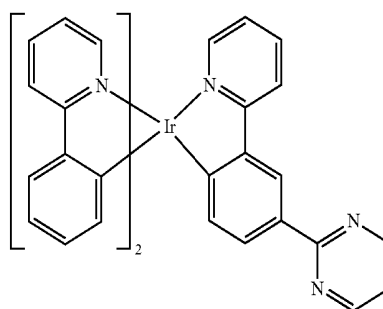
Compound 1



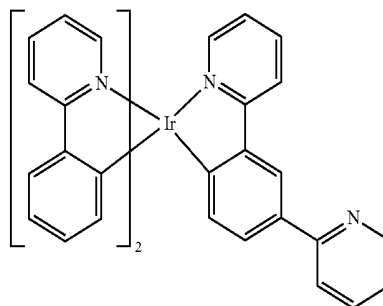
Compound 2



Compound 3

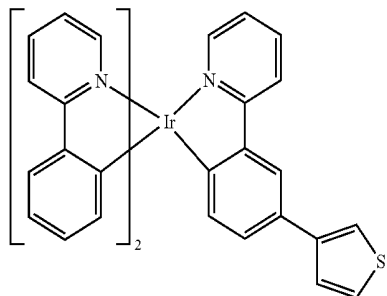


Compound 4



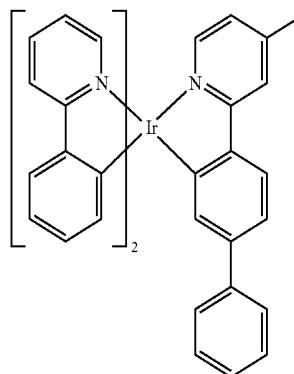
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Compound 5

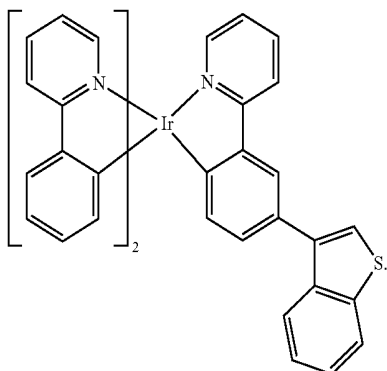


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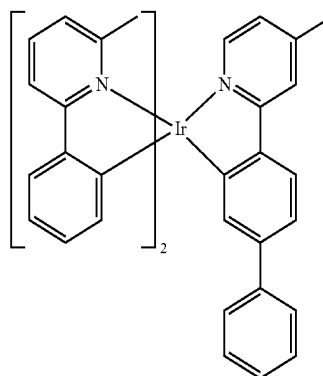
Compound 9



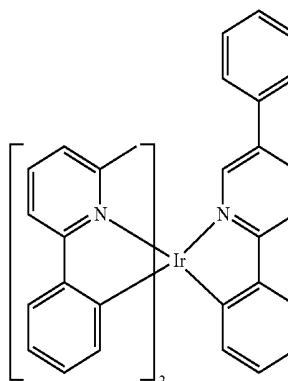
Compound 6



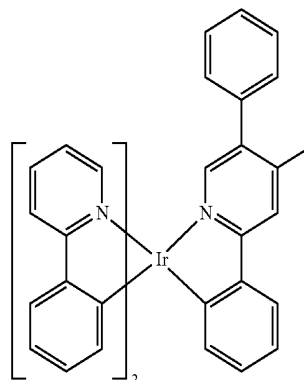
Compound 10



Compound 11



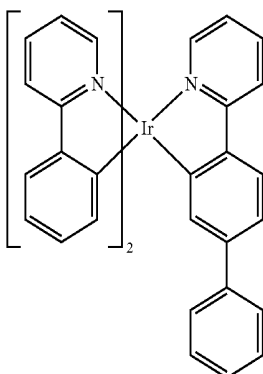
Compound 12



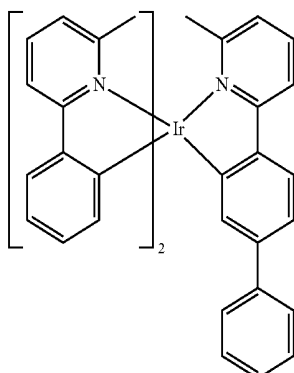
[0094] Certain compounds may be particularly beneficial. In one aspect, preferably the compound is Compound 1. In another aspect, preferably the compound is Compound 2.

[0095] Heteroleptic iridium compounds are provided, which may be advantageously used in organic light emitting devices. In particular, the compounds may be useful as the emissive dopant of such devices. The heteroleptic compounds are selected from the group consisting of:

Compound 8

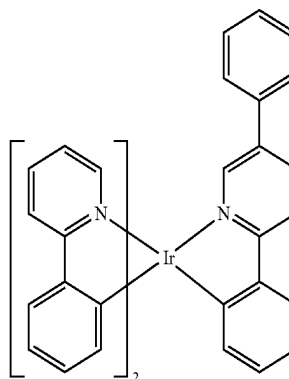


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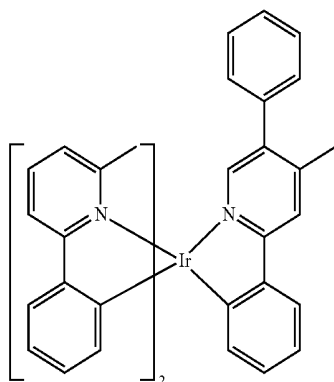


Compound 13

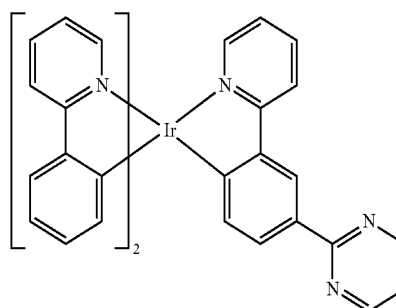
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Compound 2



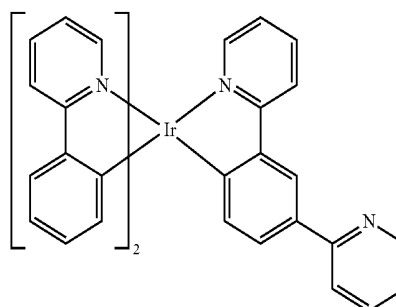
Compound 14



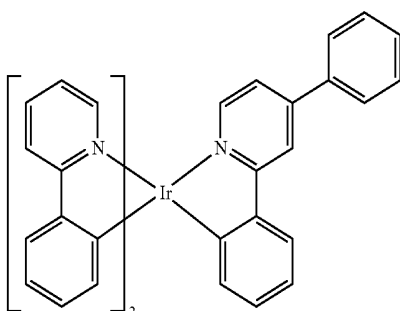
Compound 3

[0096] Certain compounds may be particularly beneficial. In one aspect, preferably the compound is Compound 8. In another aspect, preferably the compound is Compound 9. In yet another aspect, preferably the compound is Compound 10. In a further aspect, preferably the compound is Compound 11. In yet another aspect, preferably the compound is Compound 12. In a further aspect, preferably the compound is Compound 13. In yet another aspect, preferably the compound is Compound 14.

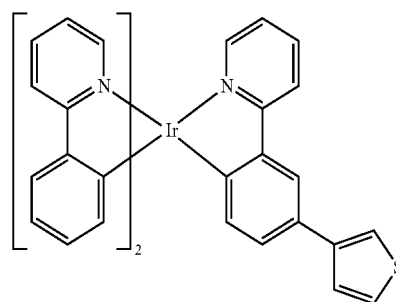
[0097] Additionally, an organic light emitting device is provided, the device comprising an anode, a cathode, and an organic layer disposed between the anode and the cathode, and the organic layer further comprising a compound selected from the group consisting of:



Compound 4



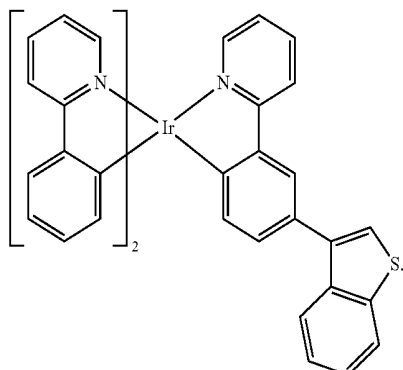
Compound 1



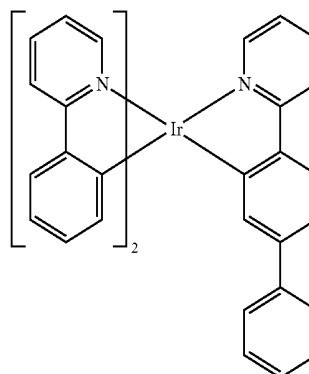
Compound 5

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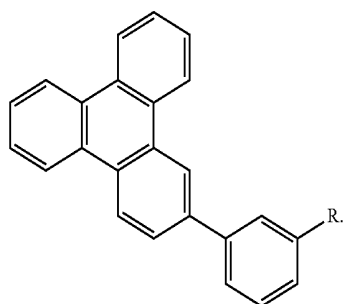
Compound 6



Compound 8

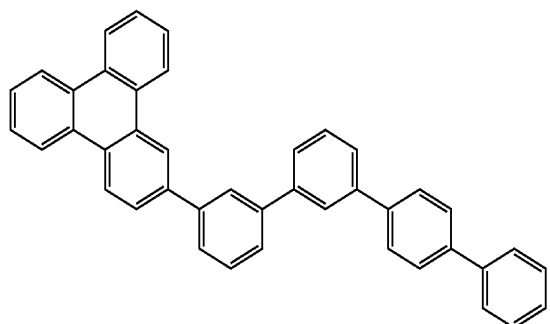


[0098] In one aspect, the organic layer of the device further comprises a host. Compounds 1 and 2 have been shown to work particularly well in devices having a host that contains a triphenylene group. In particular, these compounds are advantageously used in devices wherein the host has the formula



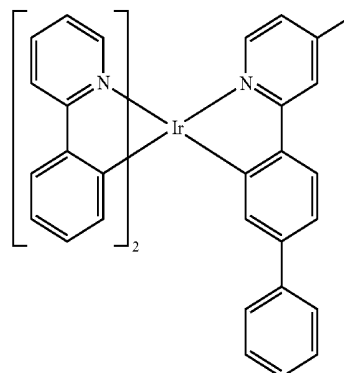
R is aryl or heteroaryl. In a certain aspect, the host compound has the formula where R is terphenyl. Moreover, the inventive compounds may be especially useful in a device wherein the host has the structure

H1

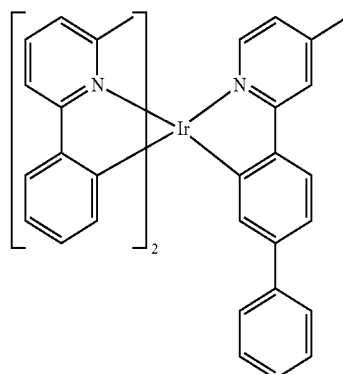


[0099] An organic light emitting device is provided, the device comprising an anode, a cathode, and an organic layer disposed between the anode and the cathode. The organic layer further comprises a compound selected from the group consisting of:

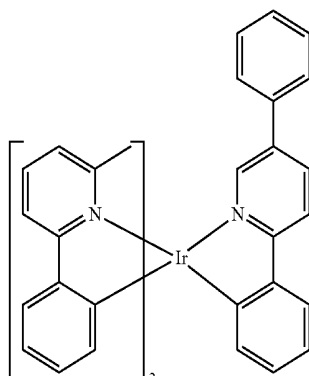
Compound 9



Compound 10

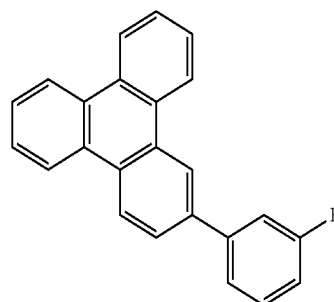
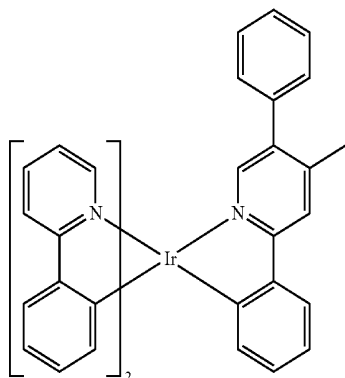


Compound 11



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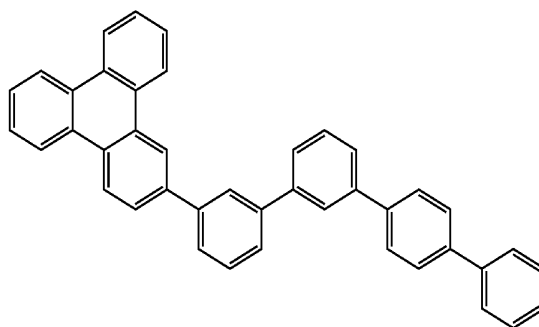
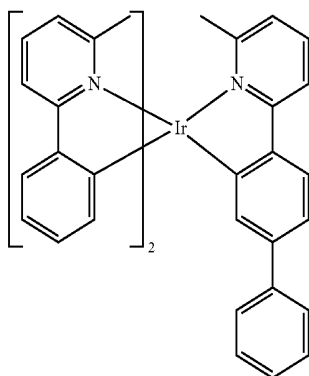
Compound 12



where R is aryl or heteroaryl. In one aspect, the host compound has the formula described above where R is terphenyl. Preferably, the compounds may be used in a device wherein the host has the structure

H1

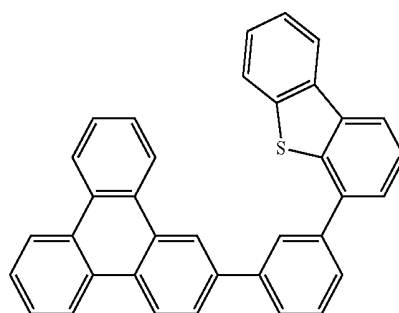
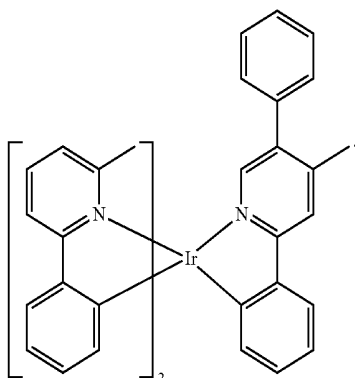
Compound 13



In another aspect, the compounds may be used in a device wherein the host has the formula described above where R is dibenzothiophene. Preferably, the compounds may be used in a device wherein the host has the structure

H2

Compound 14

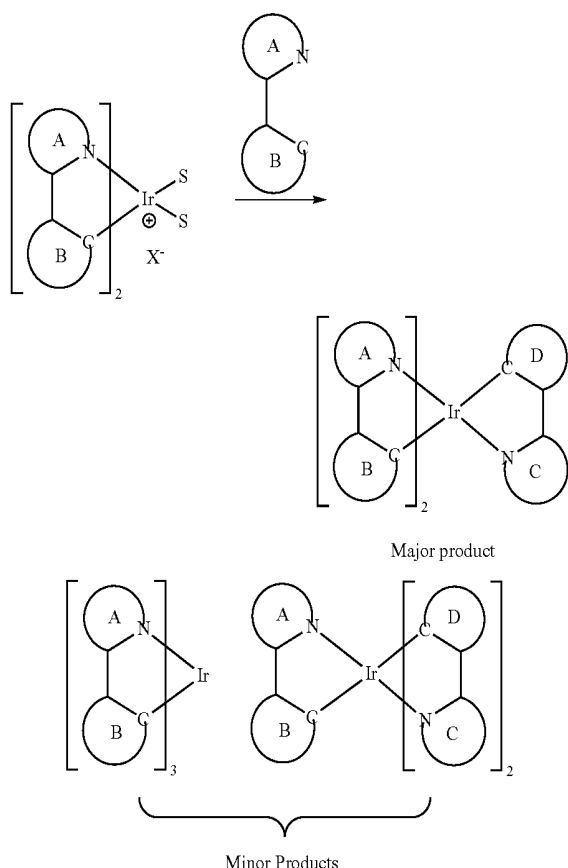


[0100] The organic layer of the device may further comprise a host. Compounds 7-12 have been shown to work particularly well in devices having a host that contains a triphenylene group. In particular, the compounds may be used in a device wherein the host has the formula

[0101] Additionally, a consumer product comprising the device is also provided. The device further comprises an anode, a cathode, and an organic layer disposed between the anode and the cathode. The organic layer contains a compound selected from Compounds 1-6.

[0102] A consumer product comprising a device is also provided, wherein the device further comprises an anode, a cathode and an organic layer which is disposed between the anode and the cathode. The organic layer further comprises a compound selected from the group consisting of Compounds 8-14.

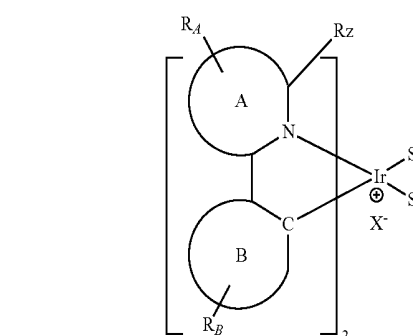
[0103] As discussed previously, the existing synthetic methods for making heteroleptic iridium complexes may not be practical for the production of many compounds. One commonly used synthetic route involves reacting an iridium triflate intermediate with a second ligand in an organic solvent to produce heteroleptic iridium complexes.



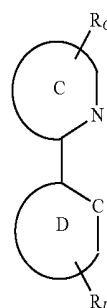
However, this method often produces a mixture of products because of the ligand scrambling during the reaction. Specifically, this method generates both major and minor products in varying yields. The mixture of product compounds can cause problems in purifying the desired product and therefore may limit the practicality of the synthesis.

[0104] Of note, several of the heteroleptic iridium compounds provided herein (i.e., Compounds 10, 11 and 14) were generated in high yield and without a significant amount of contaminating minor products using a triflate intermediate synthesis when an alkyl-substituted triflate intermediate (e.g., 6'-methylphenylpyridine) was used. The very low degree of ligand scrambling in the synthesis of Compounds 10, 11 and 14 was unexpected at least in part because the same synthesis failed to provide the same results when used to make other compounds structurally similar to Compound 11 (e.g., Compound 2). See Example 8 and Experimental Section.

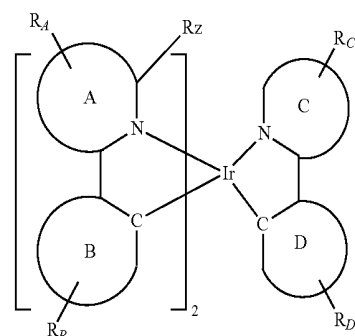
[0105] Accordingly, a method for making heteroleptic compounds having extended conjugation is provided herein (illustrated in FIG. 6). The method comprises reacting



with



to form

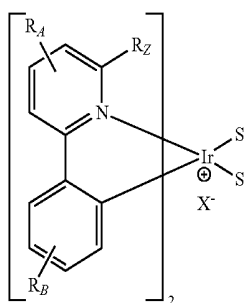


S is a neutral ligand. X is a counterion. A and B are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and A-B represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. C and D are each independently a 5 or 6-membered aromatic or heteroaromatic ring, and C-D represents a bonded pair of aromatic or heteroaromatic rings coordinated to the iridium via a nitrogen ring atom on ring C and an sp^2 hybridized carbon atom on ring D. R_A , R_B , R_C , and R_D are each independently selected from the group consisting of no substitution, alkyl, heteroalkyl, aryl, or heteroaryl groups, and each of R_A , R_B , R_C , and R_D represent one or more substituents. R_Z is not H.

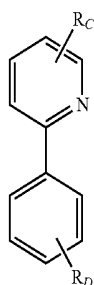
[0106] Preferably, the counterion X is selected from the group consisting of triflate, tosylate, trifluoroborate, and hexafluorophosphate.

[0107] R_A , R_B , R_C , and R_D are preferably selected from the group consisting of benzene, pyrimidine, pyridine, thiophene, thianaphthene, fluorine, carbazole, and dibenzothio-
 phene. Additionally, R_Z is preferably an alkyl and more preferably R_Z is methyl.

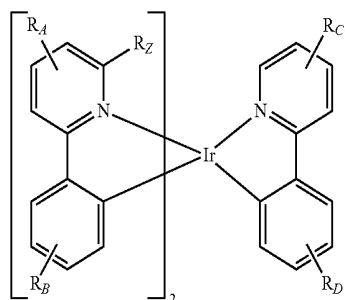
[0108] In one aspect, the method includes reacting



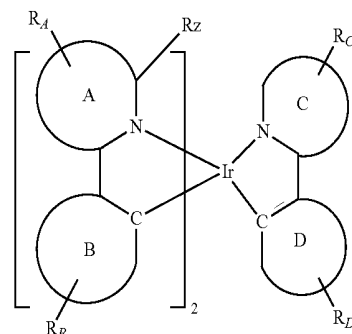
with



to form

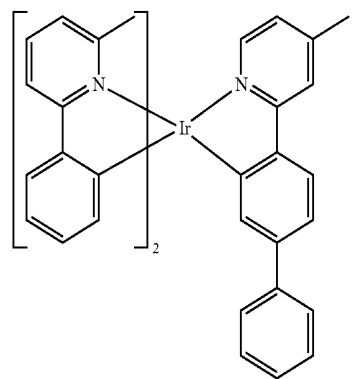


[0109] Preferably,

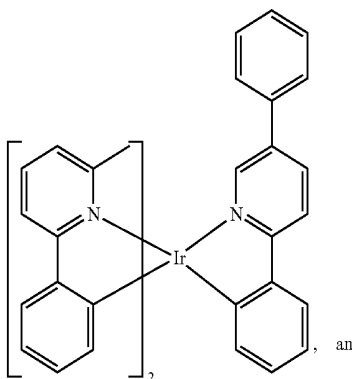


is selected from the group consisting of

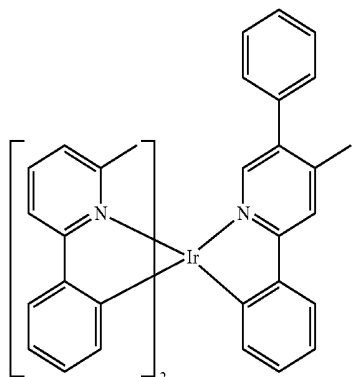
Compound 10



Compound 11

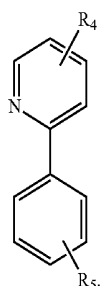


Compound 14

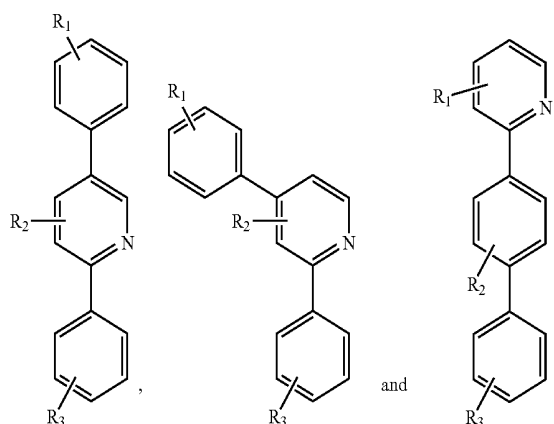


[0110] The method comprises an alkyl substituted-phenylpyridine (e.g., 6-methylphenylpyridine), instead of phenylpyridine, as the A-B ligand which when reacted with the C-D ligand may result in no significant scrambling of the reaction products thereby providing an easier to purify product. In particular, the method described above was used to synthesize Compounds 10, 11 and 14 and demonstrated high yield of the desired product with very low contamination with scrambled product. After the reaction was complete, the reaction product was analyzed chromatographically. Specifically, HPLC percentages of the major product for Compounds 10, 11, and 14 were calculated as 99.4%, 99.4 and 99.4%, respectively, whereas the minor products have combined HPLC percentages of 0.3%, 0.5%, and 0.5%, respectively, in the unpurified precipitated product. On the other hand, if the existing triflate intermediate method was used to make heteroleptic compounds, i.e., the 6-position of L_{A-B} is not substituted, significant scrambling of the product can occur. In particular, synthesis of Compounds 2 and 7 using the existing method provided 92% and 91% respectively of the major product, and 8% and 9% respectively of the minor products in the unpurified reaction mixture (as determined by HPLC). Thus, the method using alkyl substituted-phenylpyridine ligands described above provide an improved synthesis for heteroleptic compounds.

[0111] Additionally, heteroleptic compounds having the formula $\text{Ir}(L_{A-B})_2(L_{C-D})$ are provided. L_{A-B} is

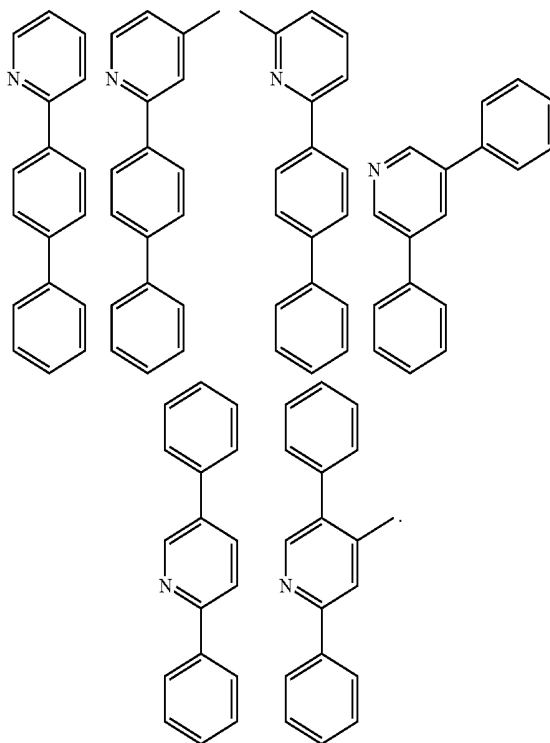


L_{C-D} is selected from the group consisting of:



R_1 , R_2 , R_3 , R_4 and R_5 are each independently selected from the group consisting of hydrogen and alkyl, and each of R_1 , R_2 , R_3 , R_4 and R_5 may represent mono, di, tri, tetra, or penta substitutions. Preferably, R_1 , R_2 , R_3 , R_4 and R_5 are each independently selected from hydrogen and methyl.

[0112] The ligand L_{C-D} is preferably selected from the group consisting of:



[0113] 2-Phenylpyridine and alkyl substituted 2-phenylpyridine ligands may provide beneficial properties. In particular, these ligands bind strongly with iridium (III). Thus, 2-phenylpyridine and alkyl substituted 2-phenylpyridine provide good chemical stability. Additionally, the tris complexes of iridium and 2-phenylpyridine ligands evaporate under high vacuum at low temperatures (i.e., $<250^\circ\text{C}$). However, the operational stability of PHOLEDs using these complexes as emitters is poor and thus needs to be improved. Aryl substitution on 2-phenylpyridine can improve device stability. Unfortunately, the tris iridium complexes of aryl substituted 2-phenylpyridine can only be evaporated at high temperatures (i.e., $>290^\circ\text{C}$). High evaporation temperature is not desirable for long term manufacturing due to decomposition. Therefore, the use of such tris aryl substituted 2-phenylpyridine in PHOLEDs may be limited. The heteroleptic compounds provided herein comprise two non-substituted 2-phenylpyridine ligands or alkyl substituted 2-phenylpyridine ligands, and one aryl substituted 2-phenylpyridine ligand. Thus, the heteroleptic compounds provided herein may provide lower evaporation temperature and improve device operational lifetime.

[0114] In particular, compound 7, which has two 2-phenylpyridine ligands and one 2-(biphenyl-3-yl)pyridine ligand, demonstrated improved stability in a PHOLED compared with tris(2-phenylpyridine)iridium(III). The emission spectrum of compound 7 was slightly red shifted. However, the emission was blue shifted in comparison to tris(2-(biphenyl-3-yl)pyridine)iridium(III). Taken together, this suggests that both ligands, i.e., 2-phenylpyridine and 2-(biphenyl-3-yl)pyridine, probably contributed to the emission. In addition, the oxidation and reduction properties of compound 7, tris(2-phenylpyridine)iridium(III), and tris(2-(biphenyl-3-yl)pyridine)iridium(III) were measured by cyclic

voltammetry and there was no significant difference between the values for the three different compounds. Therefore, the substitution pattern of the compound may not significantly shift the HOMO and LUMO levels of the complexes.

[0115] For the heteroleptic compounds $\text{Ir}(\text{L}_{A-B})_2(\text{L}_{C-D})$ provided herein, the combination of the ligand L_{C-D} with the ligand L_{A-B} provided better conjugation to the pyridine ring, where the LUMO locates. Without being bound by theory, it is thought that the LUMO of the provided heteroleptic compounds was reduced significantly as a result of the conjugation and stabilized the pyridine ring. At the same time, the emission spectrum became almost identical to $\text{Ir}(\text{L}_{C-D})_3$, i.e., tris(2-phenylpyridine)iridium (III) with aryl on the pyridine, suggesting that the emission is dominated by L_{C-D} while L_{A-B} is a non-emitting ligand. The heteroleptic compounds $\text{Ir}(\text{L}_{A-B})_2(\text{L}_{C-D})$ disclosed herein provide high device stability. For the heteroleptic compounds $\text{Ir}(\text{L}_{A-B})(\text{L}_{C-D})_2$ provided herein, the effect is similar.

[0116] As discussed in previous paragraphs, the synthesis of heteroleptic Ir (III) complexes may be improved by a method wherein a boronic ester functionalized ester is reacted directly with an iridium complex intermediate. The method is also shown in FIG. 4. In particular, the synthesis may be more practical for large scale synthesis of the complexes. The products of the reaction can be separated by column or other methods. In addition, heteroleptic Ir (III) complexes having extended conjugation from the heterocyclic ring may be made according to the method described herein. These compounds are also shown in FIG. 5. The use of these complexes in devices may result in improved device stability and manufacturing.

[0117] As discussed above, the synthesis of heteroleptic Ir (III) compounds may be improved by a method wherein a substituted triflate iridium intermediate is reacted with a second ligand. The method is also shown in FIG. 6. In particular, the synthesis may provide improved product purification due to significantly reduced ligand scrambling.

[0118] Novel compounds are provided, the compounds comprise at least one ligand containing a twisted aryl (illustrated in FIG. 7). Specific compounds provided include Ir(2-phenylpyridine) type compounds containing a twisted phenyl ring (illustrated in FIG. 8). These twisted aryl compounds may be advantageously used in OLEDs to provide devices having improved efficiency, stability and manufacturing. Preferably, these compounds may be used as an emitting dopant in such devices.

[0119] Compounds containing a twisted aryl group have been reported in the literature (see, e.g., US2007/0003789 and US2009/0124805).

[0120] While 2-phenylpyridine and alkyl substituted 2-phenylpyridine ligands form iridium(III) compounds with good properties, these compounds may have limited practical use in devices (e.g., poor operational stability). Aryl substitution on 2-phenylpyridine can improve device efficiency, but tris iridium compounds of aryl substituted 2-phenylpyridine can only be evaporated at high temperatures (i.e., above 290° C.) thereby limiting the use of these compounds as well (i.e., decomposition in manufacturing). It was found that 2-phenylpyridine type ligands having particular substitution patterns may be particularly beneficial. In particular, the strategic combination of alkyl and phenyl substitutions on the 2-phenylpyridine type ligand may result in the substituent aryl group twisting out of plane (i.e., twisted aryl) thereby reducing packing and lowering the evaporation temperature. The compounds provided herein comprise at least one ligand with an alkyl and aryl substituent such that the substituent aryl is a twisted aryl. Thus, these compounds may provide lower evaporation temperature, improve device manufacturing and improve device operational lifetime.

[0121] Aryl groups substituted on 2-phenylpyridine may also increase the conjugation of the ligand thereby resulting in a red shifted emission. Such compounds having emission at longer wavelengths in the yellow part of the spectrum, such as 540 nm to 580 nm, may have limited use because there emission is limited to the yellow part of the spectrum. Therefore, compounds having emission at a different range, such as a blue shifted range, may be desirable. In particular, compounds with an emission in the target energy range of about 521 nm to about 540 nm may be particularly desirable. It is believed that compounds in which the substituent aryl ring is twisted by the addition of an alkyl group may have limited conjugation and demonstrate a blue shifted emission. In particular, the twisted aryl compounds provided herein may have emission energies that are blue shifted relative to the corresponding compounds containing untwisted aryl substituents. Therefore, these blue shifted compounds may be particularly preferable.

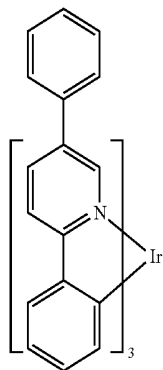
[0122] Compounds containing at least one ligand with a twisted aryl are provided. The effect of different twisted aryl substitution patterns on the emissive ligand was studied to establish a structure-property relationship for substituted Ir(2-phenylpyridine) type phosphorescent materials and devices containing such materials. Several aspects of material processability, including evaporation temperature, evaporation stability, and solubility, as well as device characteristics of PHOLEDs using twisted phenyl containing compounds were studied. Strategically positioned substituents present on the compound may lead to the twisting of the substituent aryl ring. For example, substituents present on the aryl group (i.e., ring C) or on the pyridine ring adjacent to the twisted aryl (i.e., ring A) may induce the extra twisting of the aryl group. As a result, the compounds having a twisted aryl moiety may provide (i) reduced conjugation thereby minimizing the red-shifting effect that is usually associated with increased conjugation (i.e., the additional of a phenyl), (ii) reduced stacking thereby lowering evaporation temperatures and increasing long-term thermal stability and processability, and (iii) narrow emission thus resulting in high luminous efficiency (i.e., high LE/EQE).

[0123] Compounds containing a twisted aryl and a limited number of substituents (e.g., a single substituent) may provide improved stability while maintaining the benefits of the twisted aryl, such as improved efficiency and manufacturing. Further, certain compounds provided herein may demonstrate particularly narrow emission thus providing devices having especially good luminous efficiency in addition to the other noted improvements. Therefore, the compounds provided herein may be particularly desirable.

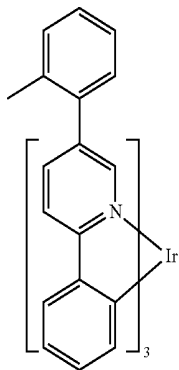
[0124] Without being bound by theory, it is believed that compounds having only one substituent inducing the twist in the substituent aryl may be especially beneficial. In particular, compounds with a single substituent inducing the twist of the aryl substituent may be more stable than corresponding compounds containing multiple substituents. It is thought that compounds having a single substituent may have a smaller degree of twisting between the substituent aryl and the remainder of the ligand, and thus more conjugation, as compared to compounds with multiple substituents which may have a higher degree of twisting out of plane. Specifically, it is thought that compounds with a single methyl substituent may have improved stability compared to compounds having multiple methyl substituents. For example, Device Example 28 and Comparative Device Example 6 have the same device structure and composition except that Device Example 28 uses Compound 35 as the emitting dopant whereas Comparative Device Example 6 uses E4 as the emitting dopant. Compound 35 and E4 are both tris homoleptic compounds (i.e., IrL_3) with a ligand which has a twisted aryl group attached to 5 position of

2-phenylpyridine. Their only difference is that in Compound 35, the aryl is a 2-methylphenyl group whereas in E4, the aryl is a 2,6-dimethylphenyl.

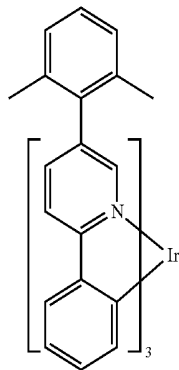
E3



Compound 35



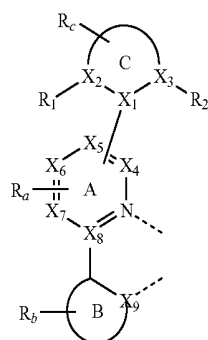
E4



[0125] The extra methyl group in E4 makes the twisted aryl twist more than that in Compound 35. The result (Table 8) shows that the device with Compound 35 (Device Example 28, $RT_{80}\%$ =200 h) is much more stable than the device with E4 (Comparative Device Example 6, $RT_{80}\%$ =42 h). It is believed that a more conjugated ligand can lead to more stable emitting dopant. The conjugation in the series of E3, Compound 35 and E4 decreases as the number of methyl group increases from zero to one to two (i.e., increasing twist between pyridine and the C-ring). It is therefore reasonable to believe a device with E3 as the emitting dopant would be even more stable than a device with Compound 35 as the emitting dopant. However, the increase in conjugation also causes red shift in the emission of the corresponding Ir complexes. Table 7 shows that E3 (Comparative Device Example 5) has a λ_{max} of 548 nm and CIE of (0.430, 0.560), whereas Compound 35 (Device Example 28) has a λ_{max} of

532 nm and CIE of (0.368, 0.607) and E4 (Comparative Device Example 6) has a λ_{max} of 520 nm and CIE of (0.320, 0.632). Therefore, although E3 may be more stable, but the emission is yellow which is not suitable for full color RGB display. Compound 35 has conjugation between E3 and E4, achieving much improved stability over E4 (little conjugation) and better green color over E3 (too much conjugation). [0126] Compounds are provided, comprising a ligand L having an alkyl substituent and an aryl substituent such that the substituent aryl is twisted and having the structure:

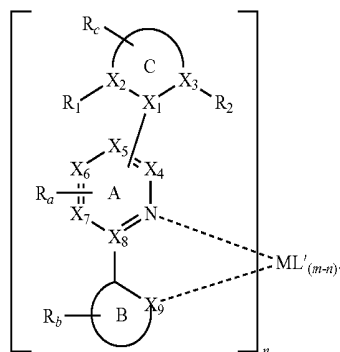
Formula I



[0127] B and C are each independently a 5 or 6-membered carbocyclic or heterocyclic ring. A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to a metal M via a nitrogen atom in ring A and an sp^2 hybridized carbon atom in ring B. A-C represents a bonded pair of carbocyclic and heterocyclic rings. R_a , R_b , and R_c may represent mono, di, tri, or tetra substitutions. R_a , R_b , and R_c are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen. Preferably, A is pyridine. R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. At least one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is alkyl. More preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is ethyl. Most preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is methyl. The ligand L is coordinated to the metal M having an atomic number greater than 40. Preferably, the metal M is Ir.

[0128] Particular compounds are provided having the structure:

Formula II

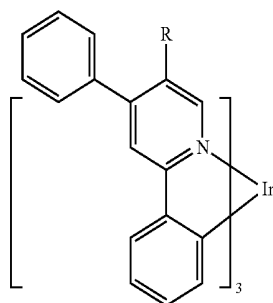


[0129] m is the oxidation state of the metal M . n is at least 1. L' is a monoanionic bidentate ligand. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen. Preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is alkyl. More preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is ethyl. Most preferably, only one of R_1 , R_2 , and the R_a substituents adjacent to C is methyl. Preferably, A is pyridine.

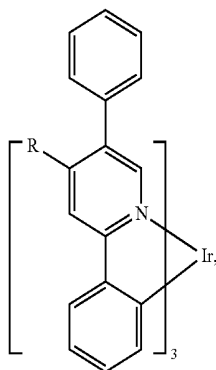
[0130] Particular examples of compounds having Formula II are provided. The compound is selected from the group consisting of:

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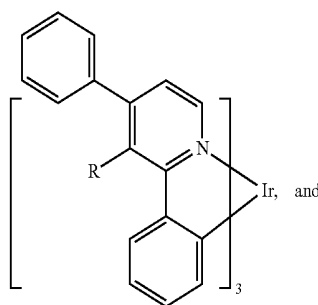
Compound 18



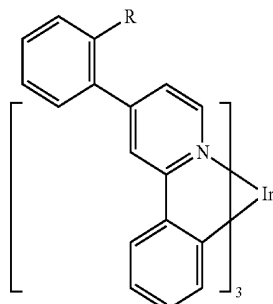
Compound 15



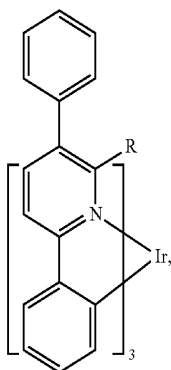
Compound 19



Compound 20



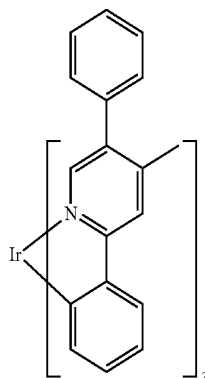
Compound 16



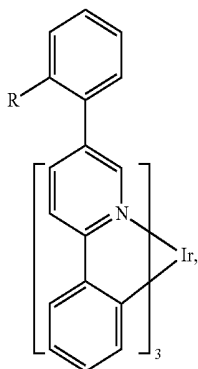
[0131] R is not hydrogen. Preferably, R is alkyl.

[0132] Specific examples of compounds having Formula II are provided. In one aspect, the compound is selected from the group consisting of:

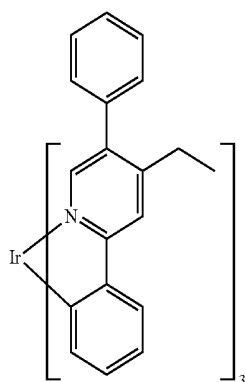
Compound 21



Compound 17



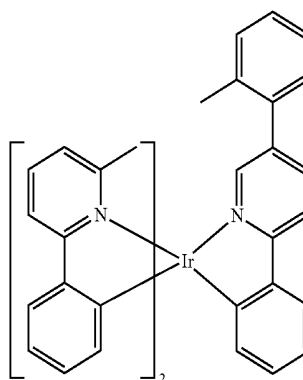
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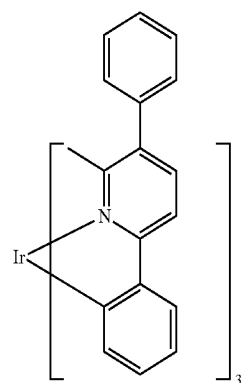
Compound 22

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Compound 26

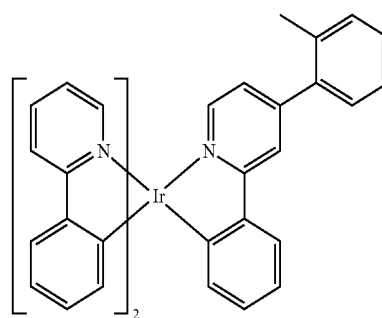


Compound 23

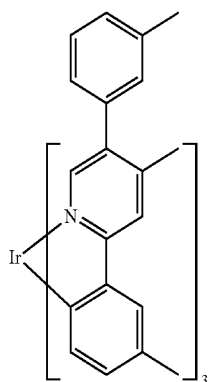


Compound 24

Compound 27

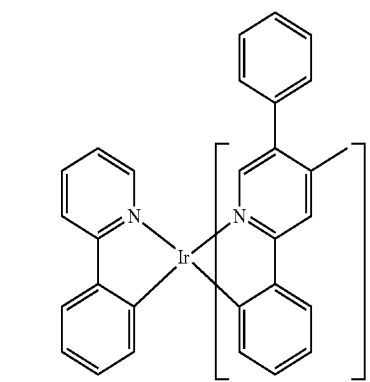
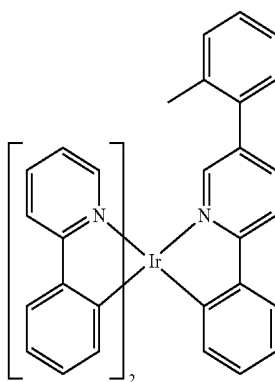


Compound 28

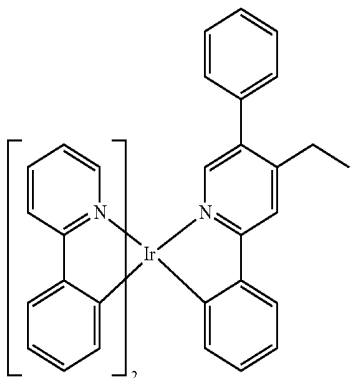


Compound 25

Compound 29

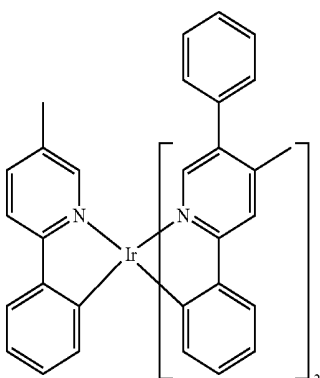


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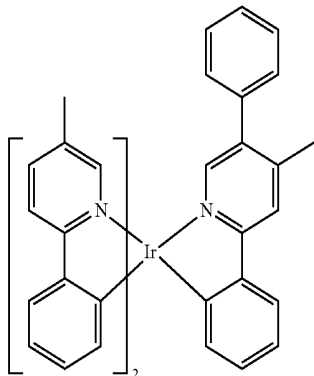
Compound 30

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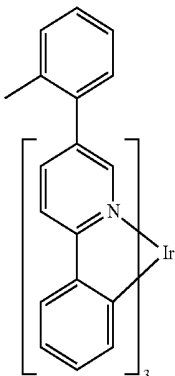


Compound 31

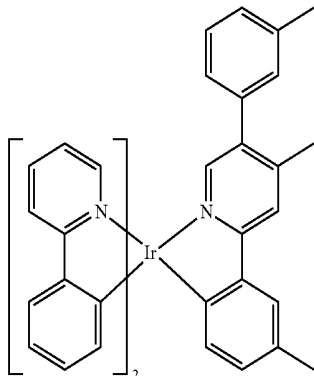
Compound 34



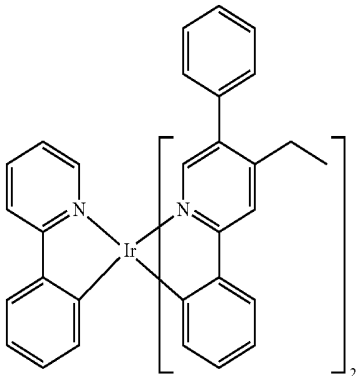
Compound 32



Compound 35

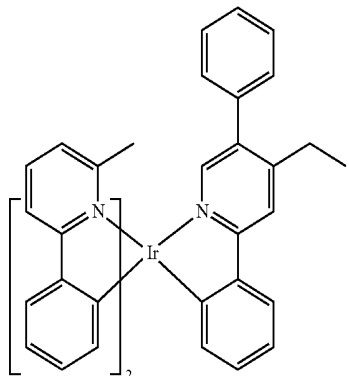
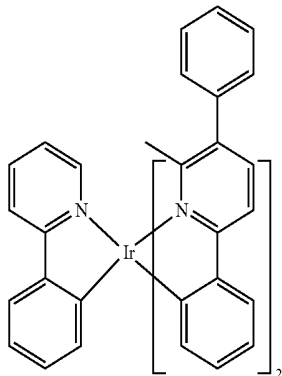


Compound 36



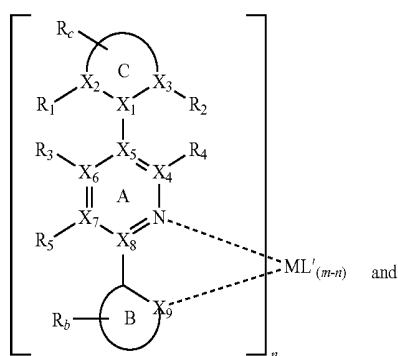
Compound 33

Compound 37

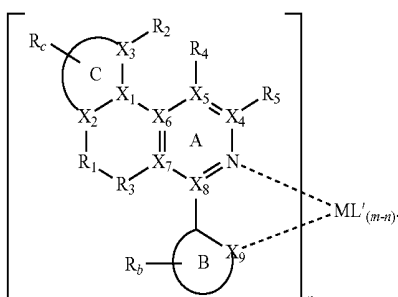


[0133] Preferably, the compound is selected from the group consisting of Compound 21, Compound 22, Compound 25, Compound 29, Compound 30, Compound 31 and Compound 34.

[0134] In one aspect, compounds are provided wherein the compound is selected from the group consisting of:



Formula III



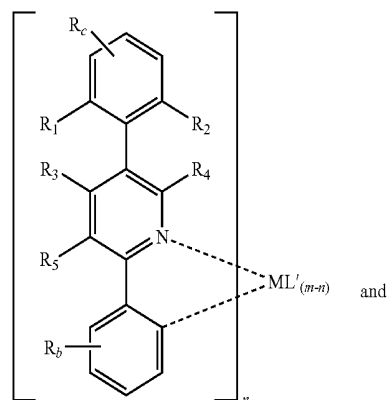
Formula IV

[0135] At least one of R_1 , R_2 , R_3 , and R_4 are not hydrogen. R_5 is selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

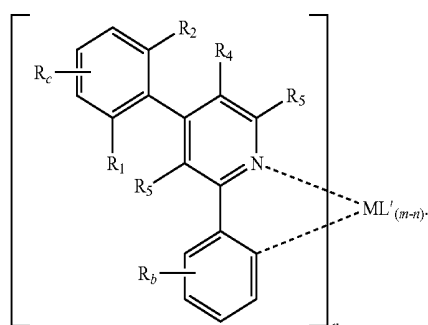
[0136] As discussed above, the position of the twist inducing substituent adjacent to the substituent aryl ring (i.e., C ring) results in the twisting of the C ring out of plane thereby reducing packing and offering a wide range of tunability in terms of evaporation temperature, solubility, energy levels, device efficiency and narrowness of the emission spectrum. In addition, the substituents can be stable functional groups chemically as well as in device operation.

[0137] In one aspect, R_1 and R_2 are hydrogen and one of R_3 and R_4 is alkyl. Exemplary compounds may include Compounds 21-24 and 29-34, 36 and 37. In another aspect, one of R_1 and R_2 is alkyl and R_3 and R_4 are hydrogen. Exemplary compounds may include Compounds 25-28 and 35.

[0138] In another aspect, the compound is selected from the group consisting of:



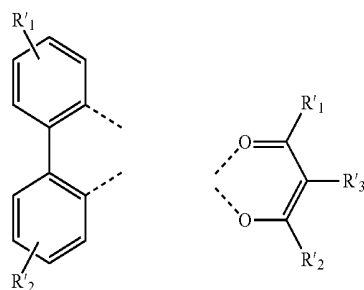
Formula V



Formula VI

[0139] The compounds having Formula II include homoleptic compounds and heteroleptic compounds. Non-limiting examples of homoleptic compound include Compounds 21-24 and 35. Non-limiting examples of heteroleptic compounds include Compounds 25-34, 36 and 37.

[0140] Particular heteroleptic compounds are provided where the compound has a ligand L' selected from the group consisting of:



[0141] R'_1 , R'_2 and R'_3 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

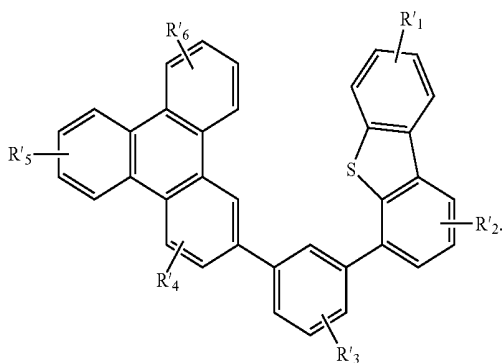
[0142] Twisted aryl containing compounds having an alkyl substituent present on the pyridine ring of the 2-phenylpyridine ligand also having the aryl substituent may be preferred. In particular, preferred compounds are provided wherein the compound selected from the group consisting of Compound 21-Compound 23, Compound 29-Compound 31, Compound 34, Compound 36 and Compound 37. Even more preferred compounds are Compound 21, Compound 22,

Compound 29-31, Compound 34, Compound 36 and Compound 37 which has the alkyl group at the 4-position of the 2-phenylpyridine ligand (i.e., para to the pyridine nitrogen). It is because such substitution can provide the twist and also a slight blue shifting effect to make the compound emit in a deeper green emission. For example, Device Example 13 has λ_{max} of 525 nm and CIE of (0.342, 0.612) whereas Device Example 19 has λ_{max} of 532 nm and CIE of (0.372, 0.599). Example 13 uses Compound 12 as the emitting dopant which has a methyl group at the 4-position of the 2-phenylpyridine ligand whereas Example 19 uses Compound 25 as the emitting dopant which has a methyl group at the 2-position of the twist phenyl. Although the twist induced structurally in both cases is believed to be similar, the methyl para to the pyridine nitrogen provides electron donating effect, raising the LUMO energy level of complex and also the triplet energy, resulting in a blue shift in emission.

[0143] An organic light emitting device is also provided. The device has an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer comprises a compound having Formula I, as described above. Selections for the substituents described as preferred for the compounds having Formula I are also preferred for use in a device that comprises a compound having Formula I. These selections include those described for the metal M; the formulas II-VI; R, R₁, R₂, and R_a substituents adjacent to C; the position of ring C; and rings A, B, and C.

[0144] In one aspect, the device comprises a compound having Formula II, as described above. Preferably, the metal M is Ir. Preferably, A is pyridine. In another aspect, the device comprises a compound having Formula III or Formula IV, as described above. Devices containing a compound wherein only one of R₁, R₂, and the R_a substituents adjacent to C is alkyl may also be preferred. In another aspect, the device comprises a compound having Formula V or Formula VI, as described above. Certain devices are provided wherein the device contains a compound selected from the group consisting of Compound 21-Compound 37. Preferably, the device contains Compound 21, Compound 22, Compound 25, Compound 29, Compound 30, Compound 31 or Compound 34.

[0145] In one aspect, devices are provided wherein the organic layer is an emissive layer and the compound having the formula of Formula I is an emitting dopant. Moreover, the organic layer may further comprise a host. Preferably, the host has the formula:

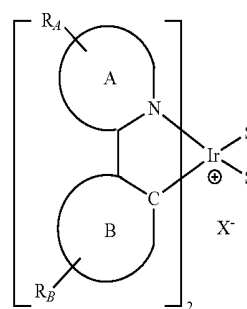


R'₁, R'₂, R'₃, R'₄, R'₅, and R'₆ are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

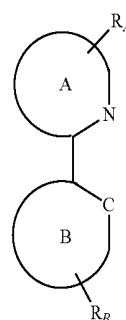
[0146] A consumer product comprising a device is also provided. The device comprises an anode, a cathode, and an organic layer disposed between the anode and the cathode, where the organic layer comprises a compound having Formula I, as described above. Selections for the substituents described as preferred for the compounds having Formula I are also preferred for use in a consumer product containing a device that comprises a compound having Formula I. These selections include those described for the metal M; the formulas II-VI; R, R₁, R₂, and R_a substituents adjacent to C; the position of ring C; and rings A, B, and C.

[0147] Additionally, novel methods are provided for making homoleptic Ir (III) compounds (illustrated in FIG. 9). A commonly used method of making homoleptic Ir (III) compounds involves heating a mixture of Ir(acac)₃ with the ligand at refluxing glycerol (~180° C.) or without solvent at >230° C. Such high temperature of reaction can cause problems such as thermal degradation of the ligand and the resulting complex. Therefore, it is highly desirable to provide a new method for making homoleptic Ir (III) compounds at lower temperatures. The methods, as described herein, can be used to make homoleptic Ir (III) compounds that may be advantageously used in OLEDs. In particular, a first method for making a homoleptic Ir (III) compound having is provided. The first method may be used to synthesize compounds having an alkyl group which is not adjacent to the nitrogen in the heteroleptic ring of the ligand. Compounds 21, 22, and 24, for example, may be synthesized using the first method provided. A second method for making homoleptic Ir (III) compounds is also provided. The second method may be used to make compounds having an alkyl group which is adjacent to the nitrogen in the heterocyclic ring of the ligand. Compound 23, for example, may be synthesized using the second method provided.

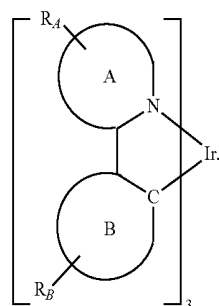
[0148] A first method for making a homoleptic Ir(III) complex is provided. The first method comprising: reacting



with



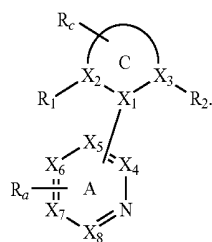
in the presence of a low boiling alcohol to form



[0149] At least one of R_A and R_B is an alkyl group and the alkyl group is not adjacent to the nitrogen on the pyridine ring. X is triflate. S is a neutral ligand. X is a counterion. Preferably, X is triflate. A and B are each independently a 5 or 6-membered carbocyclic or heterocyclic ring. A - B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B . Each of R_A and R_B may represent mono, di, tri, or tetra substitutions. R_A and R_B are each independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

[0150] Low boiling alcohols may include any alcohol which has a boiling temperature equal to or less than 108°C . In one aspect, the low boiling alcohol is selected from the group consisting of methanol, ethanol, n-propanol, isopropanol, n-butanol, a 1:1 ratio of ethanol and methanol, 2-methoxyethanol, and 2-ethoxyethanol. Preferably, the low boiling alcohol is selected from the group consisting of isopropanol which boils at 108°C ., ethanol which boils at 78°C ., and a 1:1 ratio of ethanol and methanol which boils between 64°C . and 78°C . More preferably, the low boiling alcohol is ethanol or a 1:1 ratio of ethanol and methanol. Most preferably, the low boiling alcohol is a 1:1 ratio of ethanol and methanol.

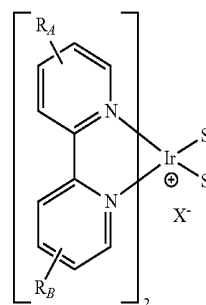
[0151] Preferably, A is:



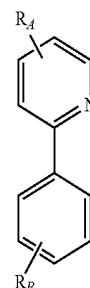
[0152] C is a 5 or 6-membered carbocyclic or heterocyclic ring. A - C represents a bonded pair of carbocyclic or heterocyclic rings. R_A and R_C may represent mono, di, tri, or tetra substitutions. R_A and R_C are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen. R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. At least one of R_1 , R_2 , and the R_A substituents adjacent to C is not hydrogen.

[0153] In one aspect, the first method comprises

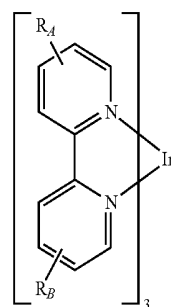
reacting



with



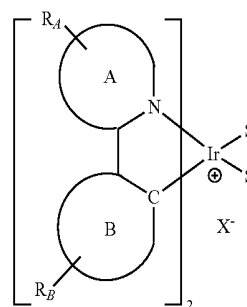
in the presence of a low boiling alcohol to form



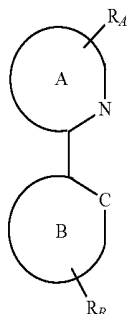
[0154] Specific compounds, including Compounds 21, 22, and 24, may be formed using this method.

[0155] A second method for making homoleptic Ir (III) compounds is provided. The second method comprises:

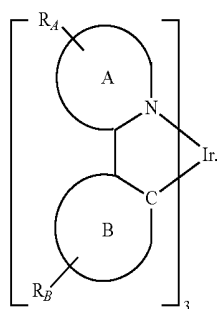
reacting



with

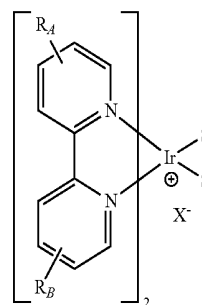


in the absence of solvent to form

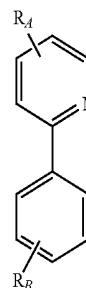


cyclic rings. R_A and R_C may represent mono, di, tri, or tetra substitutions. R_A and R_C are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen. R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl. At least one of R_1 , R_2 , and the R_A substituents adjacent to C is not hydrogen.

[0159] In one aspect, the second method comprises: reacting

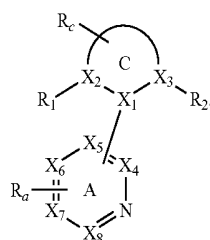


with



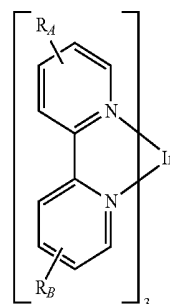
[0156] At least one of R_A and R_B is an alkyl group and the alkyl group is adjacent to the nitrogen on the pyridine ring. S is a neutral ligand. X is a counterion. Preferably, X is triflate. A and B are each independently a 5 or 6-membered carbocyclic or heterocyclic ring. A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B. Each of R_A and R_B may represent mono, di, tri, or tetra substitutions. R_A and R_B are each independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

[0157] Preferably, A is:

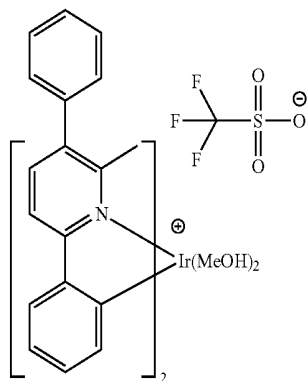


[0158] C is a 5 or 6-membered carbocyclic or heterocyclic ring. A-C represents a bonded pair of carbocyclic or hetero-

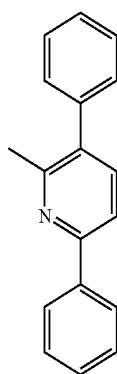
in the absence of solvent to form



[0160] Specific compounds, including Compound 23, may be formed using this method. In particular, Compound 23 can be made using the synthetic method, as follows: reacting

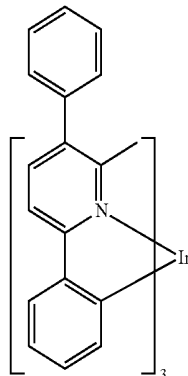


with



in the absence solvent for 16 h at 130° C. to form

Compound 23



[0161] The materials described herein as useful for a particular layer in an organic light emitting device may be used in combination with a wide variety of other materials present in the device. For example, emissive dopants disclosed herein may be used in conjunction with a wide variety of hosts, transport layers, blocking layers, injection layers, electrodes and other layers that may be present. The materials described or referred to below are non-limiting examples of materials that may be useful in combination with the compounds disclosed herein, and one of skill in the art can readily consult the literature to identify other materials that may be useful in combination.

[0162] In addition to and/or in combination with the materials disclosed herein, many hole injection materials, hole transporting materials, host materials, dopant materials, exciton/hole blocking layer materials, electron transporting and electron injecting materials may be used in an OLED. Non-limiting examples of the materials that may be used in an OLED in combination with materials disclosed herein are listed in Table 1 below. Table 1 lists non-limiting classes of materials, non-limiting examples of compounds for each class, and references that disclose the materials.

TABLE 1

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Hole injection materials		
Phthalocyanine and porphyrin compounds		Appl. Phys. Lett. 69, 2160 (1996)

TABLE 1-continued

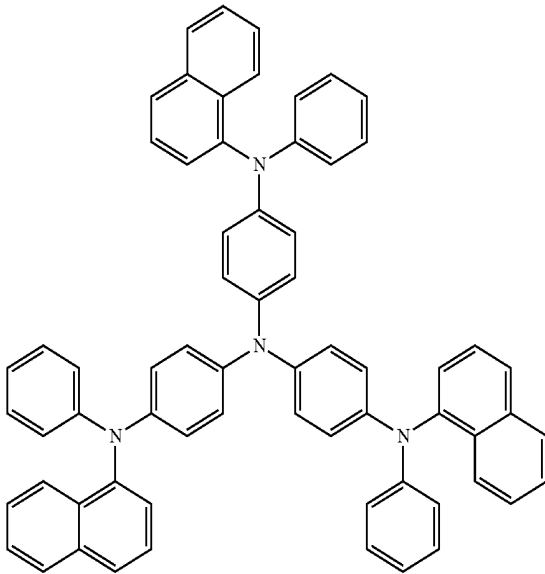
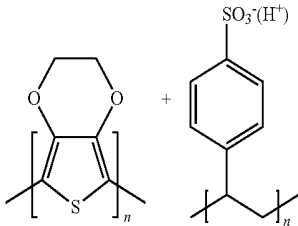
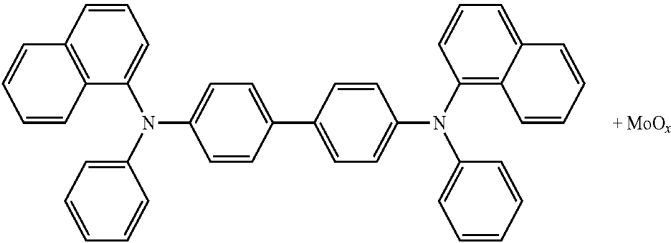
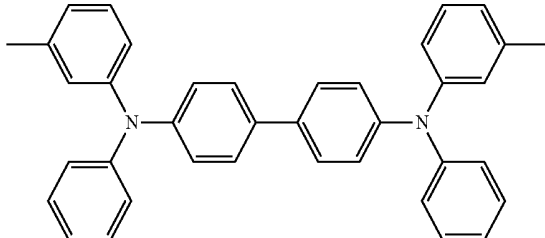
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Starburst triarylaminines		J. Lumin. 72-74, 985 (1997)
CF _x Fluorohydrocarbon polymer	$\text{---}[\text{CH}_x\text{F}_y]_n\text{---}$	Appl. Phys. Lett. 78, 673 (2001)
Conducting polymers (e.g., PEDOT:PSS, polyaniline, polythiophene)		Synth. Met. 87, 171 (1997)
Arylamines complexed with metal oxides such as molybdenum and tungsten oxides	 + MoO _x	SID Symposium Digest, 37, 923 (2006)
Hole transporting materials		
Triarylaminines (e.g., TPD, α-NPD)		Appl. Phys. Lett. 51, 913 (1987)

TABLE 1-continued

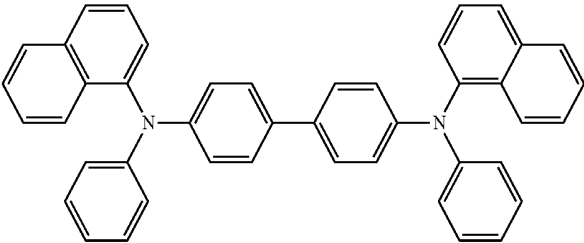
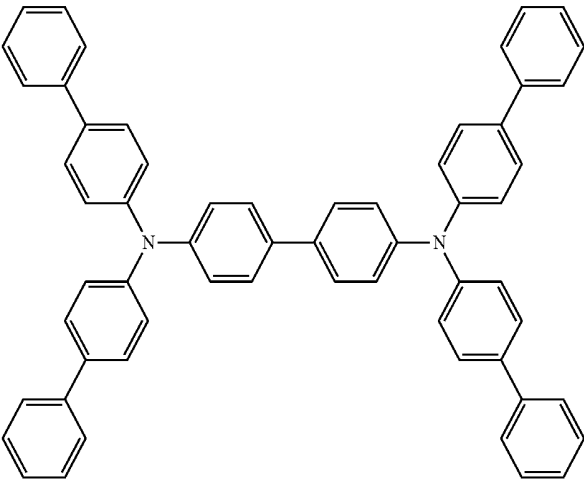
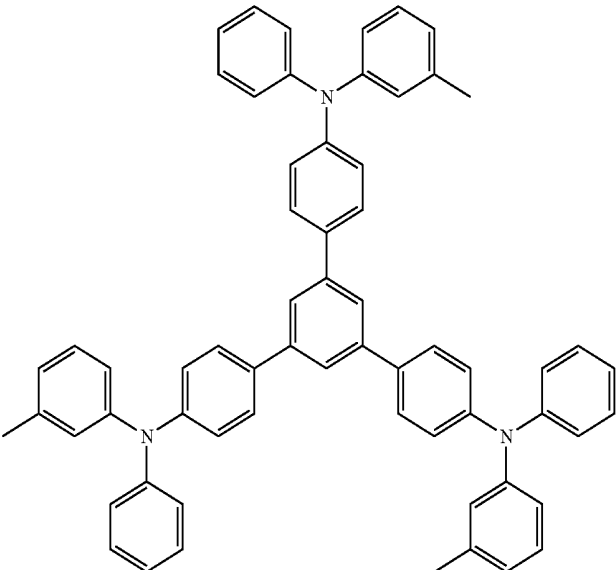
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		U.S. Pat. No. 5,061,569
		EP650955
		J. Mater. Chem. 3, 319 (1993)

TABLE 1-continued

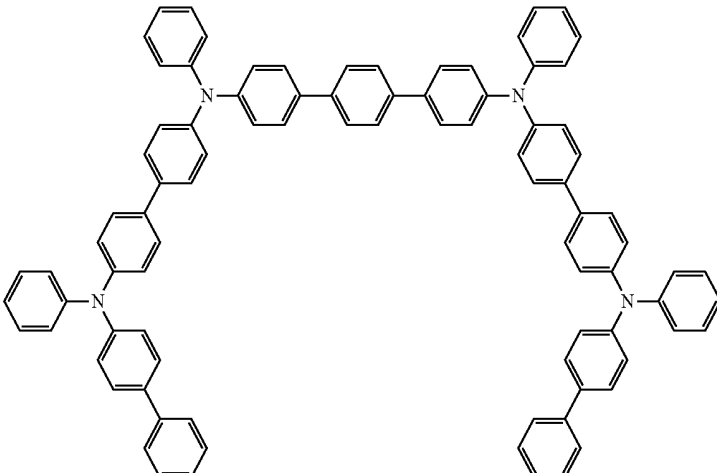
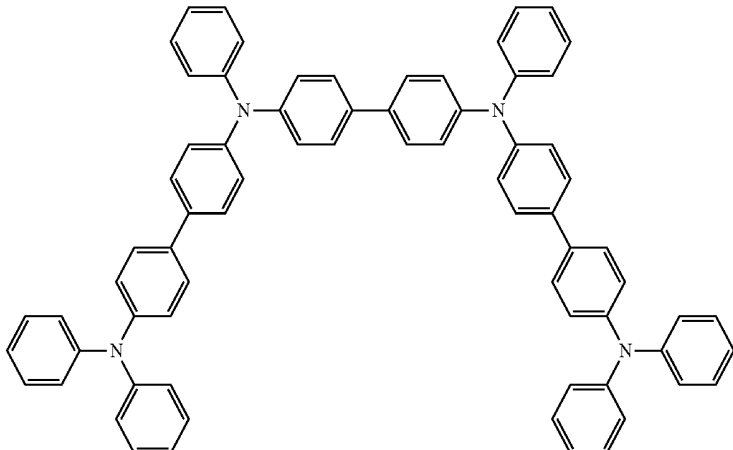
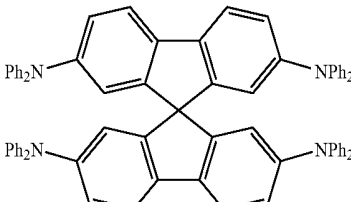
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		Appl. Phys. Lett. 90, 183503 (2007)
		Appl. Phys. Lett. 90, 183503 (2007)
Triarylamine on spirofluorene core		Synth. Met. 91, 209 (1997)

TABLE 1-continued

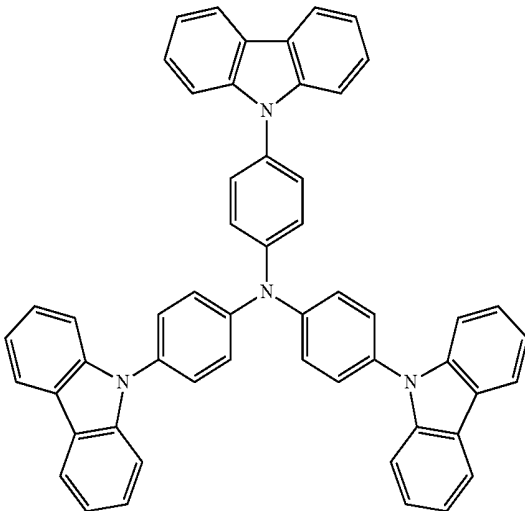
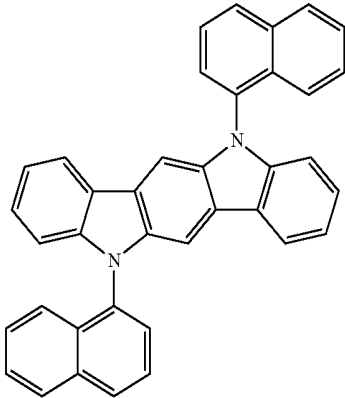
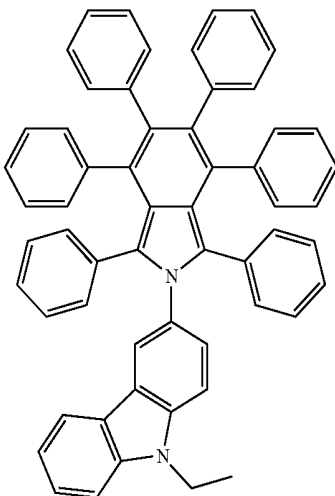
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Arylamine carbazole compounds		Adv. Mater. 6, 677 (1994)
Indolocarbazoles		Synth. Met. 111, 421 (2000)
Isoindole compounds		Chem. Mater. 15, 3148 (2003)

TABLE 1-continued

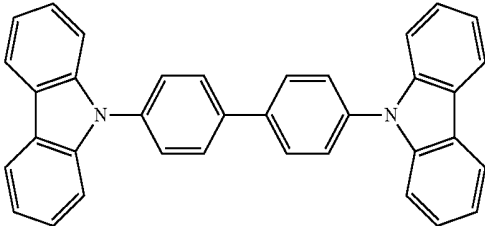
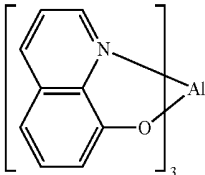
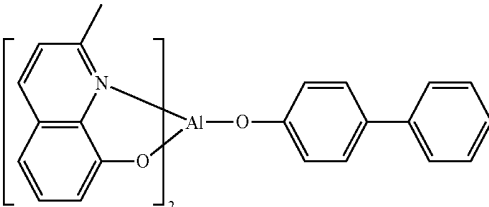
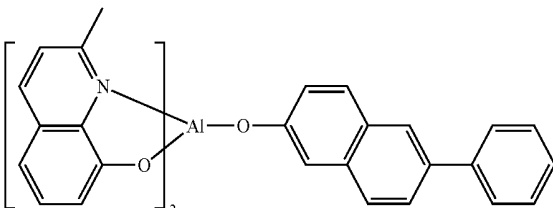
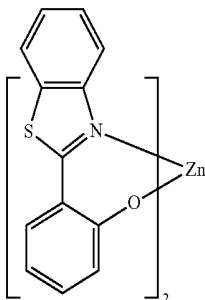
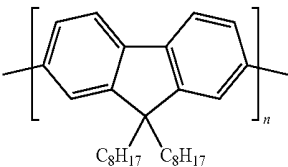
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Phosphorescent OLED host materials		
Red hosts		
Arylcarbazoles		Appl. Phys. Lett. 78, 1622 (2001)
Metal 8-hydroxyquinolates (e.g., Alq ₃ , BALq)		Nature 395, 151 (1998)
		US20060202194
		WO2005014551
Metal phenoxybenzothiazole compounds		Appl. Phys. Lett. 90, 123509 (2007)
Conjugated oligomers and polymers (e.g., polyfluorene)		Org. Electron. 1, 15 (2000)

TABLE 1-continued

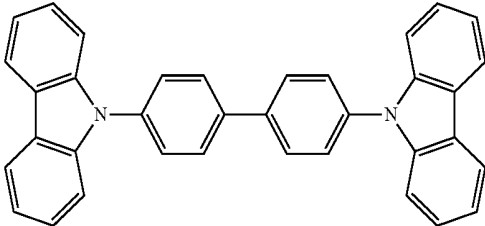
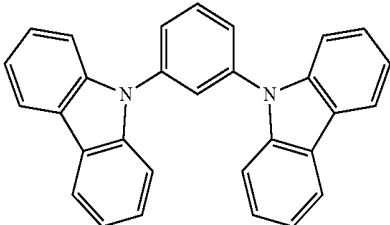
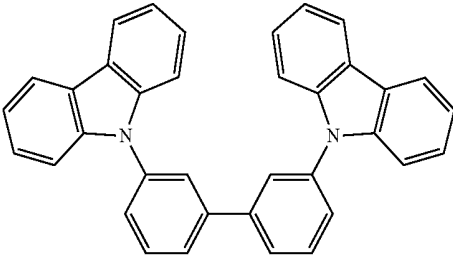
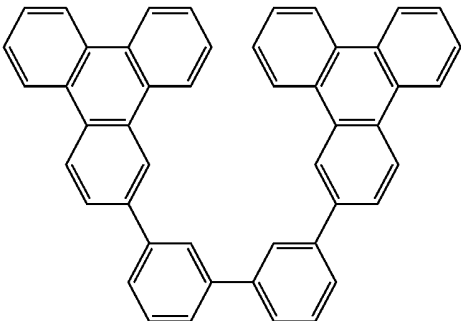
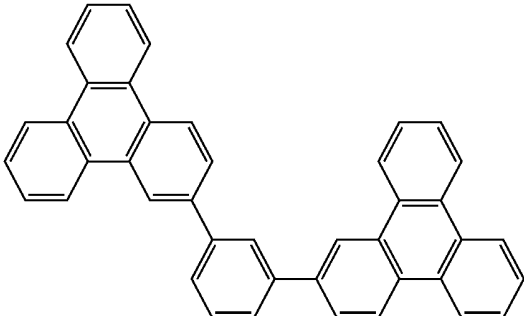
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Green hosts		
Arylcarbazoles		Appl. Phys. Lett. 78, 1622 (2001)
		US2003175553
		WO2001039234
Aryltriphenylene compounds		US20060280965
		US20060280965

TABLE 1-continued

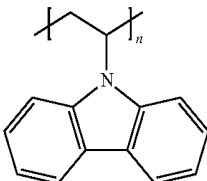
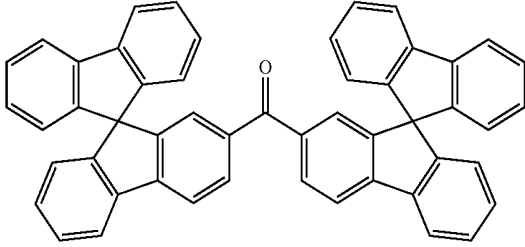
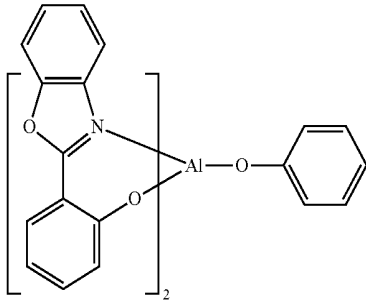
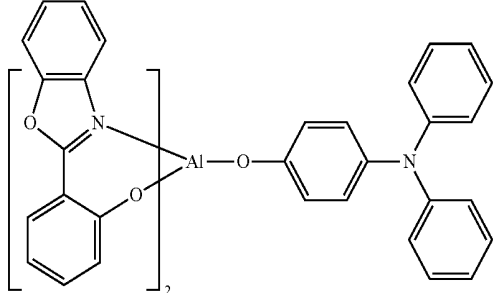
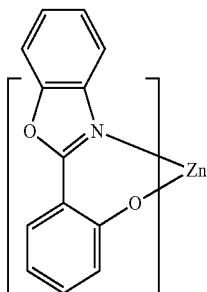
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Polymers (e.g., PVK)		Appl. Phys. Lett. 77, 2280 (2000)
Spirofluorene compounds		WO2004093207
Metal phenoxybenzoxazole compounds		WO05089025
		WO06132173
		JP200511610

TABLE 1-continued

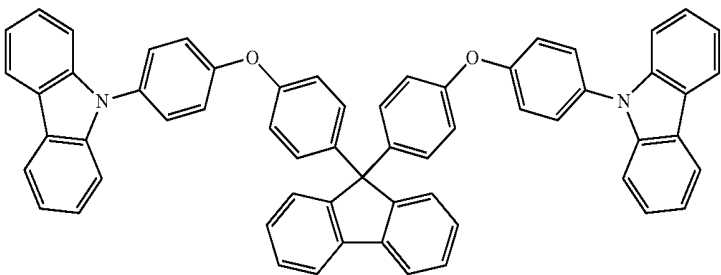
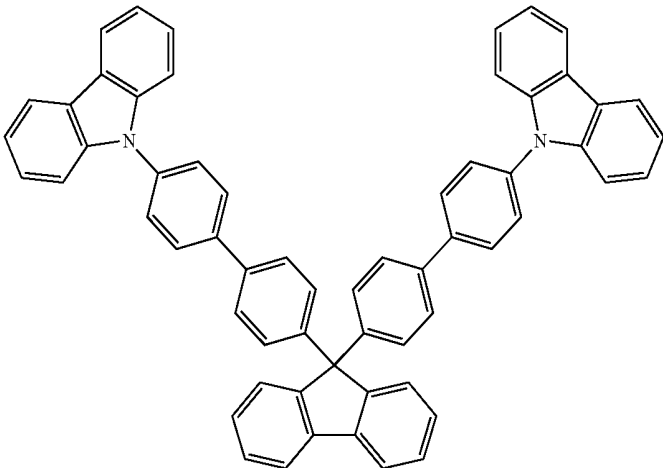
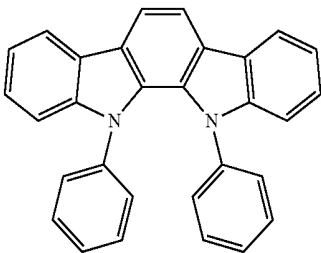
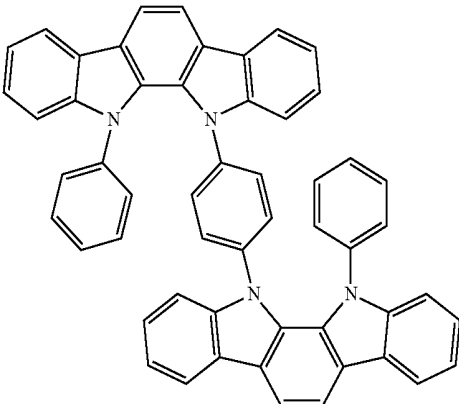
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Spirofluorene-carbazole compounds		JP2007254297
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Indolocabazoles		WO07063796
		WO07063754

TABLE 1-continued

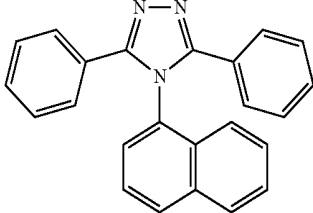
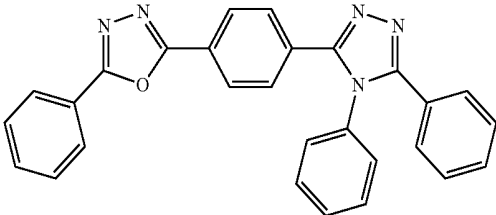
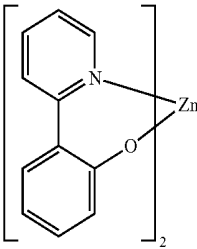
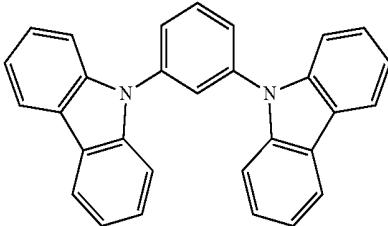
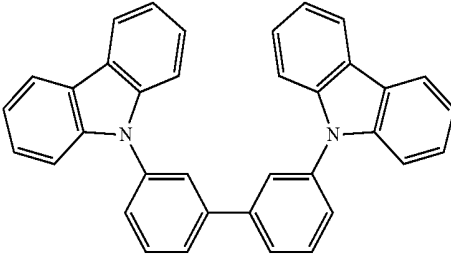
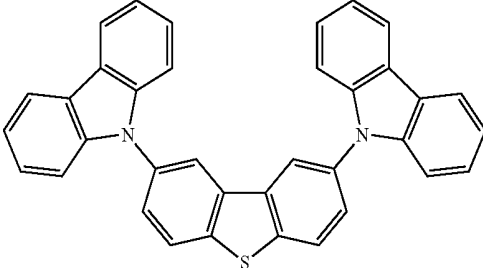
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
5-member ring electron deficient heterocycles (e.g., triazole, oxadiazole)		J. Appl. Phys. 90, 5048 (2001)
		WO04107822
Metal phenoxypyridine compounds		WO05030900
Blue hosts		
Arylcarbazoles		Appl. Phys. Lett, 82, 2422 (2003)
		US20070190359
Dibenzothiophene- carbazole compounds		WO2006114966

TABLE 1-continued

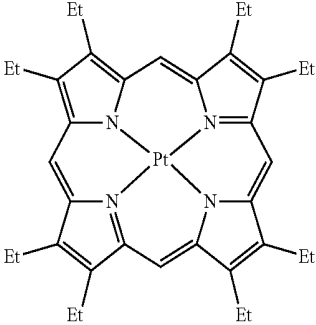
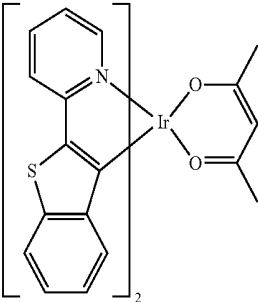
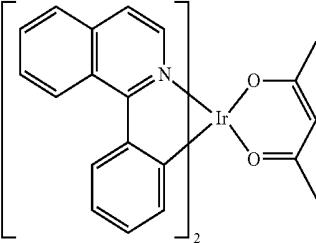
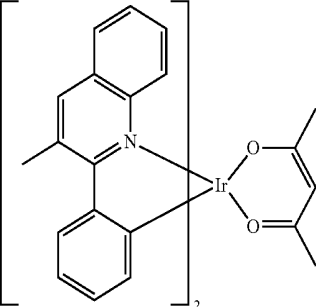
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
	Phosphorescent dopants	
	Red dopants	
Heavy metal porphyrins (e.g., PtOEP)		Nature 395, 151 (1998)
Iridium(III) organometallic complexes		Appl. Phys. Lett. 78, 1622 (2001)
		U.S. Pat. No. 06,835,469
		U.S. Pat. No. 06,835,469

TABLE 1-continued

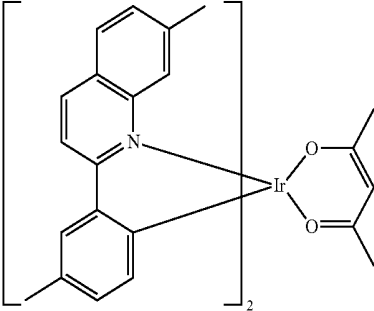
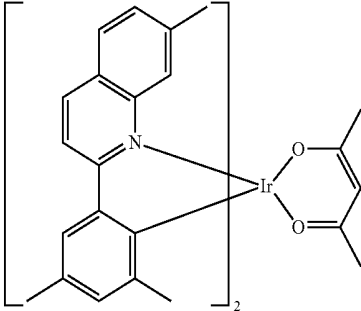
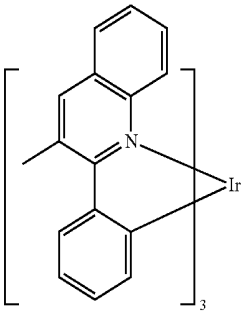
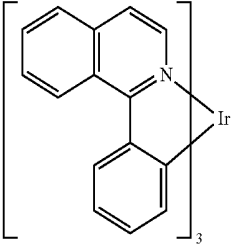
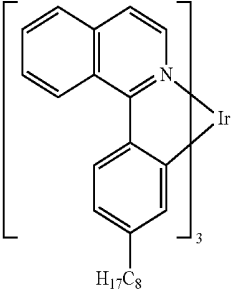
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
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		Adv. Mater. 19, 739 (2007)

TABLE 1-continued

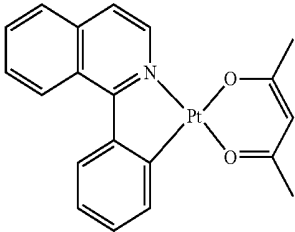
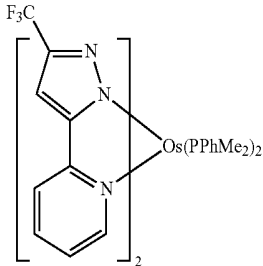
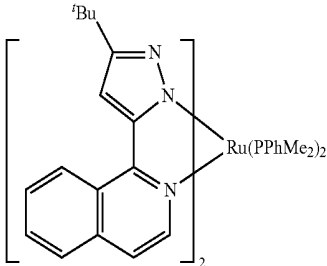
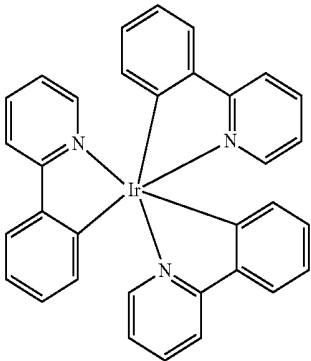
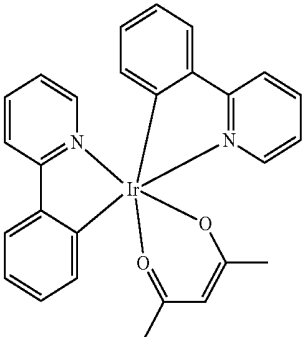
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Platinum(II) organometallic complexes		WO2003040257
Osmium(III) complexes		Chem. Mater. 17, 3532 (2005)
Ruthenium(II) complexes		Adv. Mater. 17, 1059 (2005)
Green dopants		
Iridium(III) organometallic complexes	 and its derivatives	Inorg. Chem. 40, 1704 (2001)
		US2002034656

TABLE 1-continued

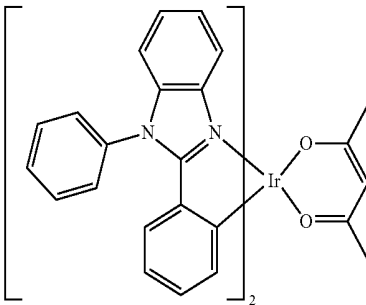
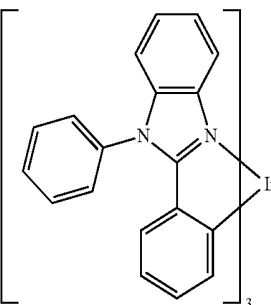
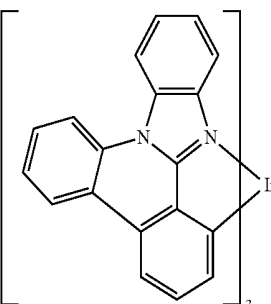
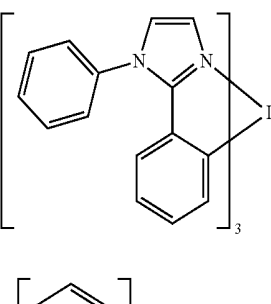
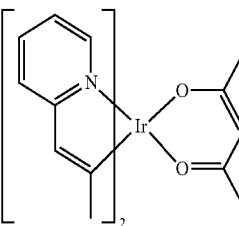
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		US2007190359
		US2006008670 JP2007123392
		Adv. Mater. 16, 2003 (2004)

TABLE 1-continued

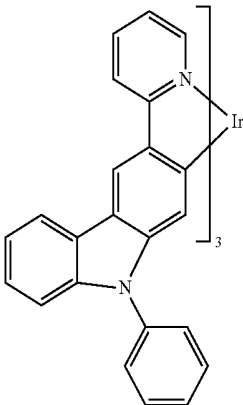
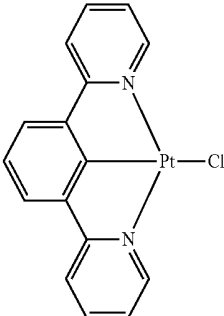
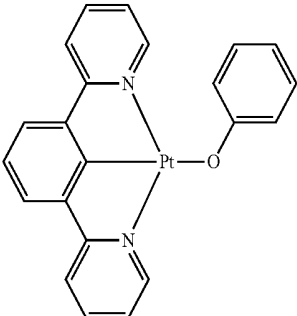
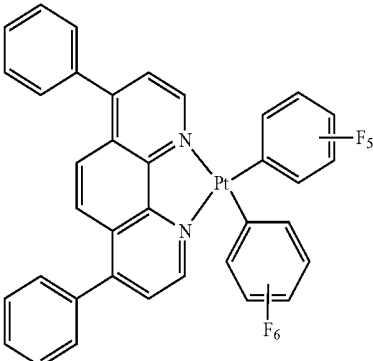
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
		Angew. Chem. Int. Ed. 2006, 45, 7800
Pt(II) organometallic complexes		Appl. Phys. Lett. 86, 153505 (2005)
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		Chem. Lett. 34, 592 (2005)

TABLE 1-continued

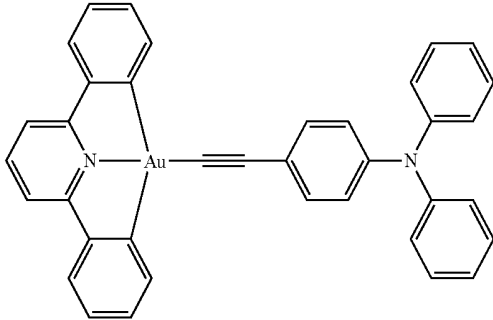
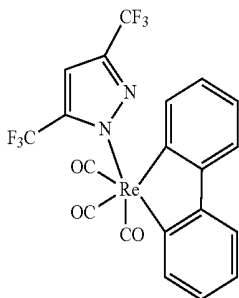
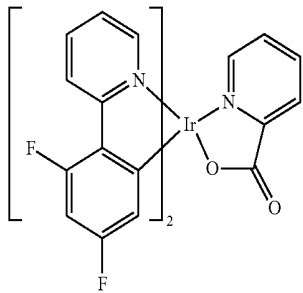
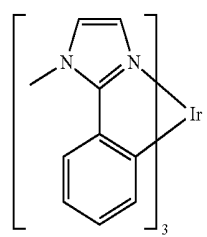
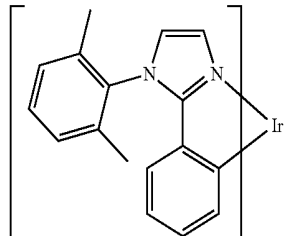
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Gold complexes		Chem. Commun. 2906 (2005)
Rhenium(III) complexes		Inorg. Chem. 42, 1248 (2003)
Blue dopants		
Iridium(III) organometallic Complexes		WO2002002714
		WO2006009024
		US2006251923

TABLE 1-continued

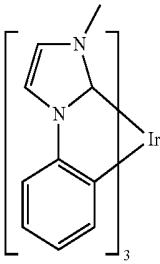
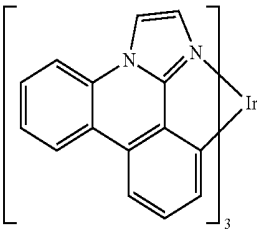
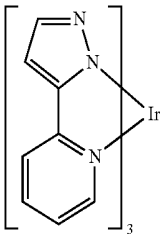
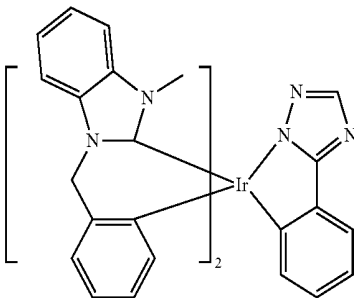
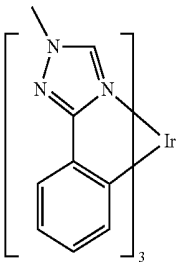
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		Angew. Chem. Int. Ed. 47, 1 (2008)
		Chem. Mater. 18, 5119 (2006)

TABLE 1-continued

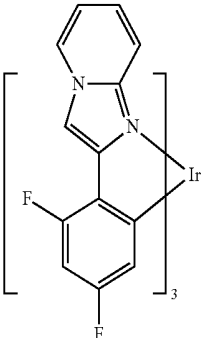
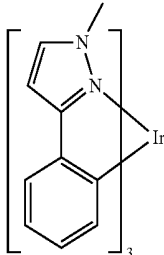
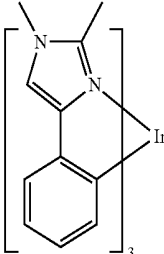
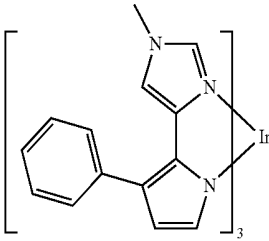
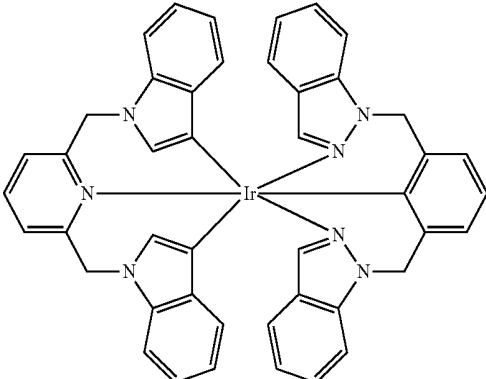
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
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		WO07004380
		WO06082742

TABLE 1-continued

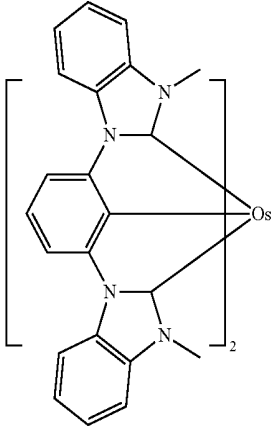
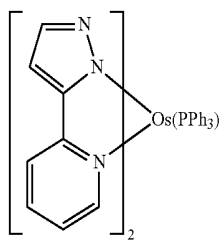
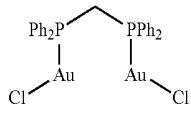
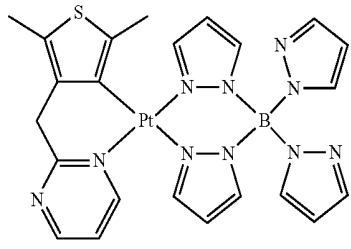
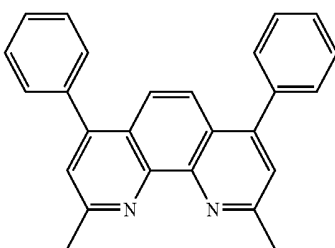
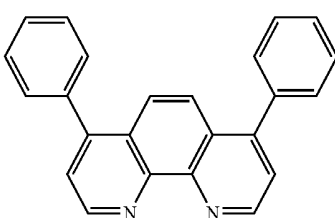
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Osmium(II) complexes	 	US2005260449 Organometallics 23, 3745 (2004)
Gold complexes		Appl. Phys. Lett. 74, 1361 (1999)
Platinum(II) complexes		WO06098120, WO06103874
Exciton/hole blocking layer materials		
Bathocuprine compounds (e.g., BCP, BPhen)	 	Appl. Phys. Lett. 75, 4 (1999) Appl. Phys. Lett. 79, 449 (2001)

TABLE 1-continued

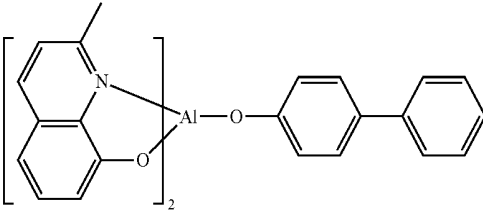
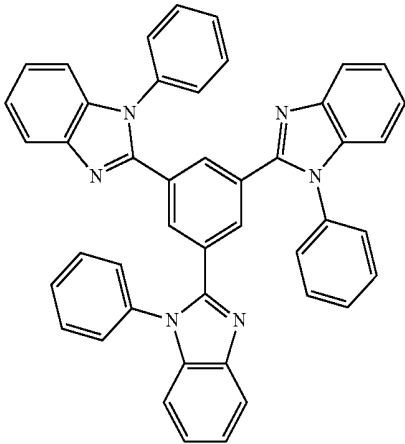
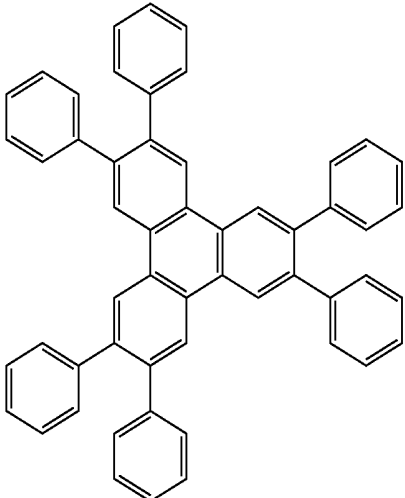
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Metal 8-hydroxyquinolates (e.g., BAlq)	 The structure shows an aluminum (Al) atom coordinated to two 8-hydroxyquinolate ligands and a biphenyl group. Each 8-hydroxyquinolate ligand is shown in brackets with a subscript of 2, indicating two such ligands. The ligands are 8-hydroxyquinolate anions, which are fused bicyclic systems with a nitrogen atom at position 1 and an oxygen atom at position 8. The biphenyl group consists of two benzene rings connected by a single bond.	Appl. Phys. Lett. 81, 162 (2002)
5-member ring electron deficient heterocycles such as triazole, oxadiazole, imidazole, benzimidazole	 The structure shows a central triphenylamine core, where a nitrogen atom is bonded to three phenyl rings. Each phenyl ring is further substituted with a benzimidazole group. The benzimidazole groups are fused bicyclic systems with a five-membered imidazole ring fused to a benzene ring.	Appl. Phys. Lett. 81, 162 (2002)
Triphenylene compounds	 The structure shows a central triphenylene core, which is a large polycyclic aromatic hydrocarbon. It is substituted with six phenyl groups at the 1, 3, 6, 7, 9, and 10 positions.	US20050025993

TABLE 1-continued

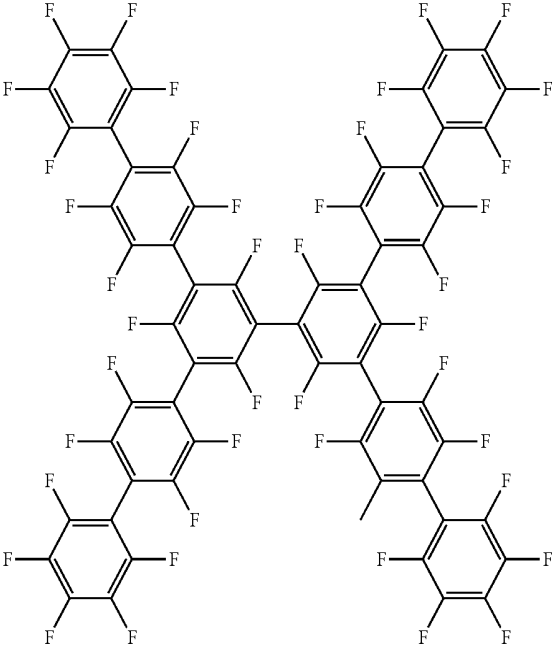
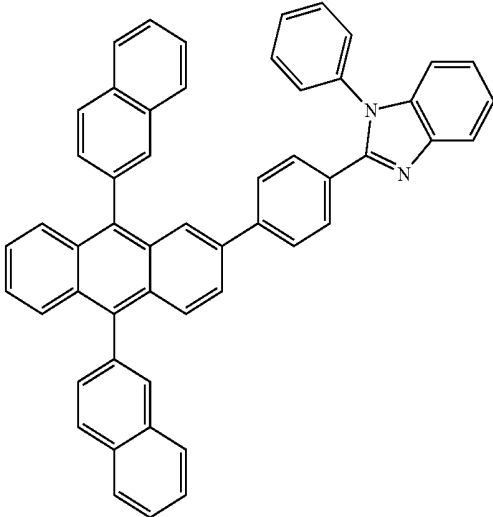
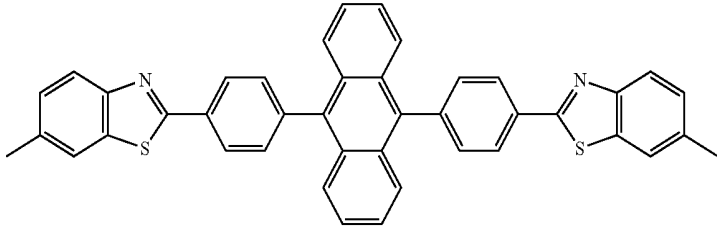
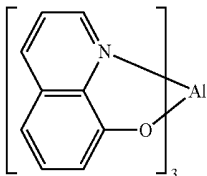
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Fluorinated aromatic compounds		Appl. Phys. Lett. 79, 156 (2001)
Electron transporting materials		
Anthracene-benzimidazole compounds		WO03060956
Anthracene-benzothiazole compounds		Appl. Phys. Lett. 89, 063504 (2006)
Metal 8-hydroxyquinolates (e.g., Alq ₃)		Appl. Phys. Lett. 51, 913 (1987)

TABLE 1-continued

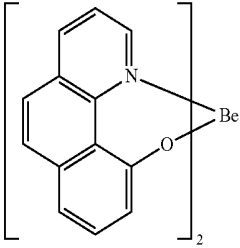
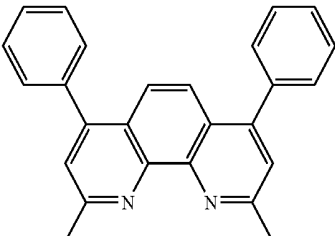
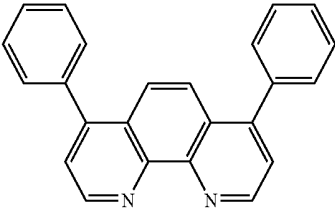
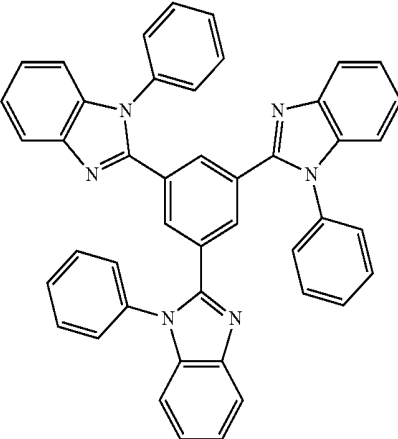
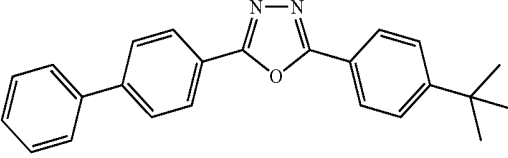
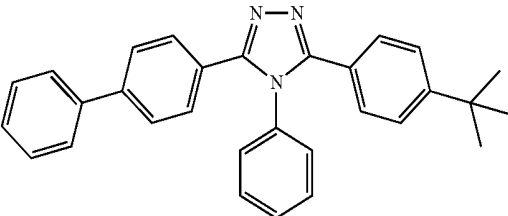
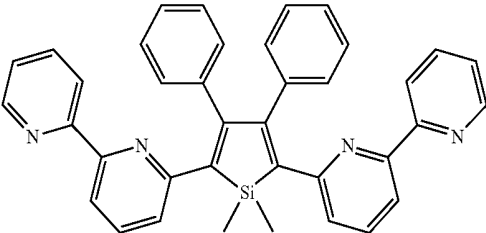
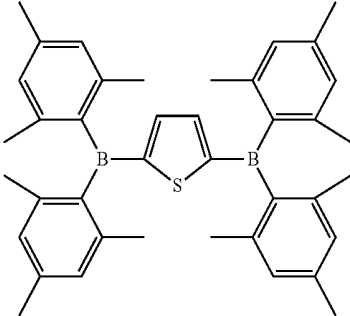
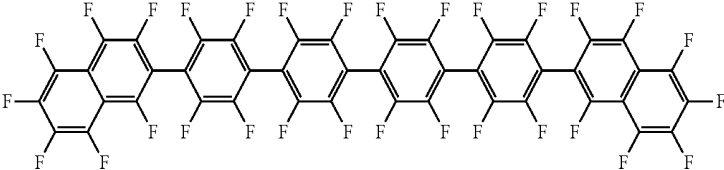
MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Metal hydroxybenzo-quinolates		Chem. Lett. 5, 905 (1993)
Bathocuprine compounds such as BCP, BPhen, etc		Appl. Phys. Lett. 91, 263503 (2007)
		Appl. Phys. Lett. 79, 449 (2001)
5-member ring electron deficient heterocycles (e.g., triazole, oxadiazole, imidazole, benzoimidazole)		Appl. Phys. Lett. 74, 865 (1999)
		Appl. Phys. Lett. 55, 1489 (1989)
		Jpn. J. Apply. Phys. 32, L917 (1993)

TABLE 1-continued

MATERIAL	EXAMPLES OF MATERIAL	PUBLICATIONS
Silole compounds		Org. Electron. 4, 113 (2003)
Arylborane compounds		J. Am. Chem. Soc. 120, 9714 (1998)
Fluorinated aromatic compounds		J. Am. Chem. Soc. 122, 1832 (2000)

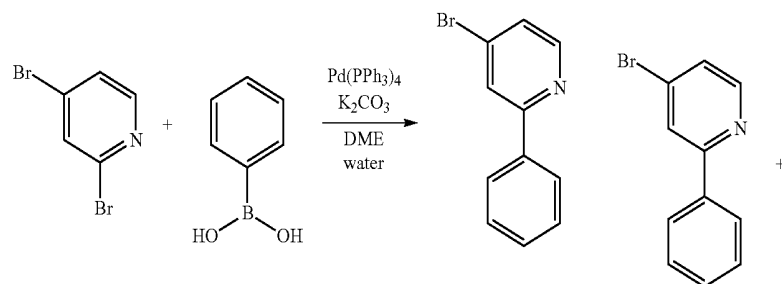
EXPERIMENTAL

Compound Examples

[0163] Some heteroleptic Ir (III) complexes were synthesized as follows:

Example 1. Synthesis of Compound 1

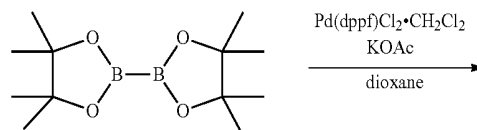
[0164]



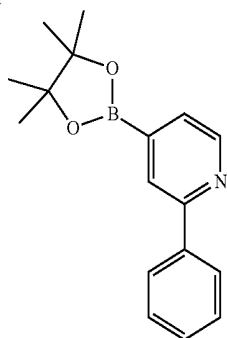
Synthesis of 2-phenyl-4-bromopyridine

[0165] A mixture was prepared of 2,4-dibromopyridine (10 g, 42.21 mmol), phenylboronic acid (5.1 g, 42.21 mmol), and potassium carbonate (11.7 g, 84.42 mmol) in 100 mL

dimethoxyethane and 40 mL of water. Nitrogen was bubbled directly into the mixture for 30 minutes. Next, tetrakis (triphenylphosphine)palladium(0) was added (244 mg, 2.11 mmol) and the mixture was heated to reflux under nitrogen overnight. The mixture was cooled and diluted with ethyl acetate and water. The layers were separated and the aqueous layer was extracted with ethyl acetate. The organic layers were washed with brine, dried over magnesium sulfate, filtered, and evaporated to a residue. The residue was purified by column chromatography eluting with 0, 2, and 5% ethyl acetate/hexanes. Obtained 4.28 g of a yellow liquid (43%).

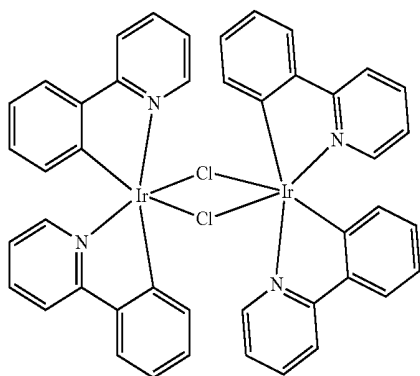
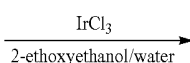
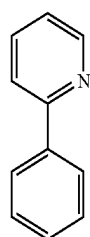


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Synthesis of 2-phenyl-4-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)pyridine

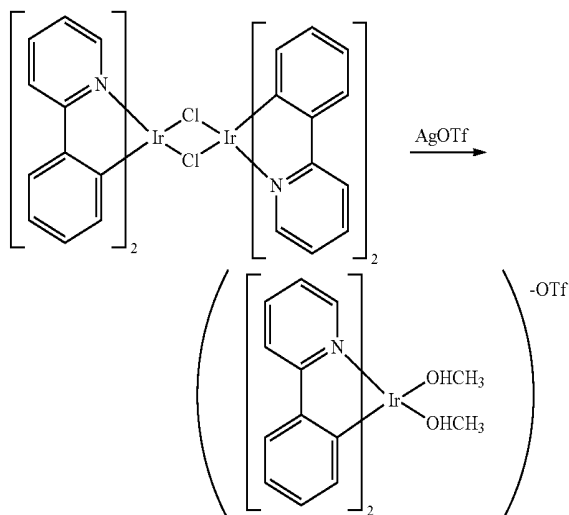
[0166] A mixture was prepared of 2-phenyl-4-bromopyridine (4.28 g, 18.28 mmol), bis(pinacolato)diboron (9.29 g, 36.57 mmol), and potassium acetate (5.38 g, 54.84 mmol) in 100 mL of dioxane. Nitrogen was bubbled directly into the mixture for 30 minutes. Dichloro[1,1'-ferrocenylbis(diphenylphosphine)]palladium(II) dichloromethane (448 mg, 0.55 mmol) was added, and nitrogen bubbled for another 15 minutes. The reaction mixture was heated to 90° C. internally. After 1 h the reaction was complete, and the heat was shut off. The solvent was evaporated to an oil. The oil was purified by Kugelrohr at 200° C. to remove excess bis(pinacolato)diboron. The residue left in the boiling pot was dissolved in ethyl acetate and filtered through magnesium sulfate, rinsed with ethyl acetate, and the filtrate was evaporated. Used as described in the next step. Yield was approximately 4 g of product.



Synthesis of PPY Dimer

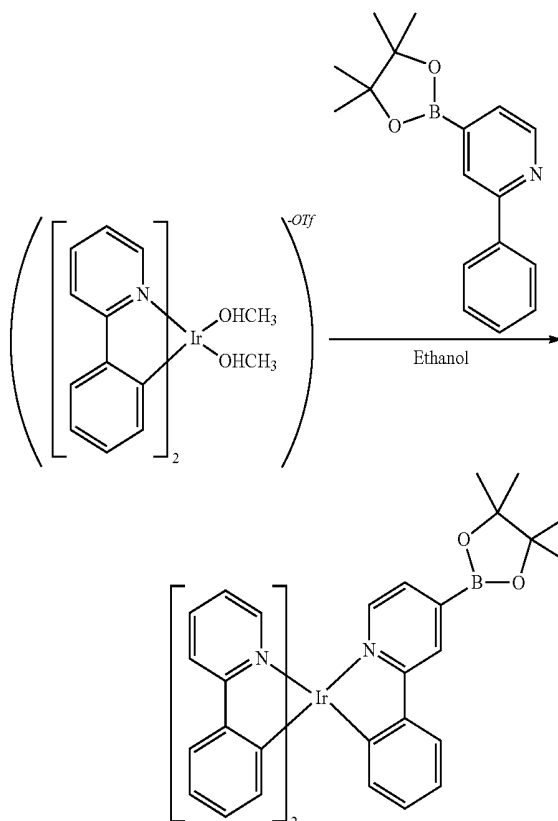
[0167] 14.7 g (0.04 mol) of iridium chloride and 26.0 g (0.17 mol) of 2-phenylpyridine was placed in a 1 L round bottomed flask. 300 ml of 2-ethoxyethanol and 100 ml of water was added. The mixture was refluxed under nitrogen

atmosphere overnight. After having cooled to room temperature, the precipitate was filtered and washed with methanol. After drying, 22 g of dimer was obtained. (99% yield).



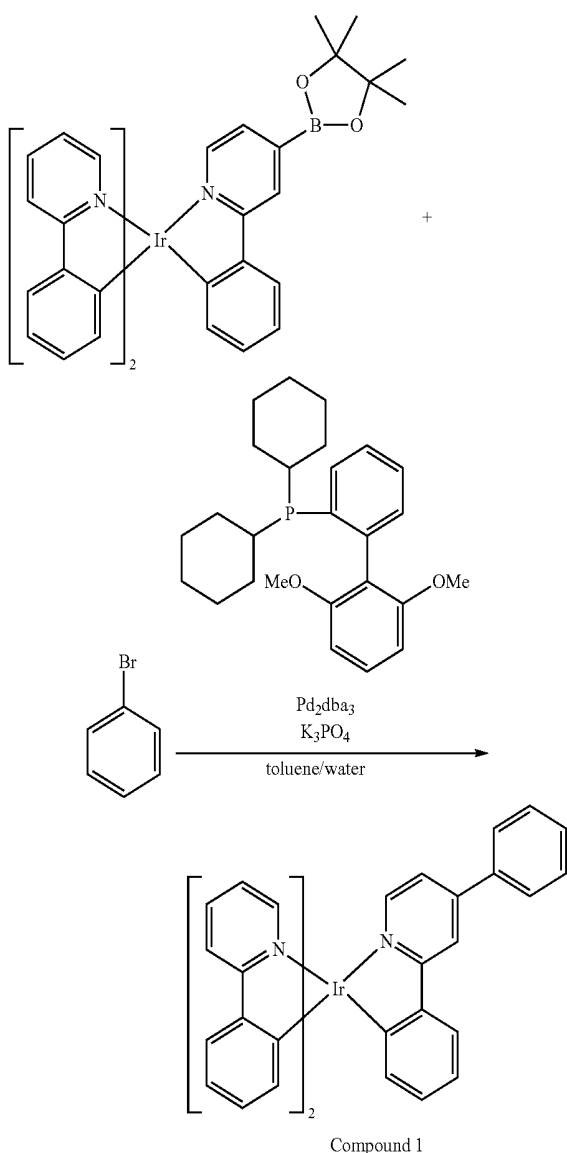
Synthesis of Triflate

[0168] 22 g of dimer was dissolved in 1 L of dichloromethane. 10.5 g (0.04 mol) of silver triflate was added to the solution. 25 ml of methanol was then added. The solution was stirred for 5 h. The silver chloride was filtered off. The solvent was evaporated. 26 g of product was obtained. The solid was used for next step without further purification.



Synthesis of Boronic Ester Precursor

[0169] A mixture was prepared of the triflate (4.6 g, 7.11 mmol) and 2-phenyl-4(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)pyridine (~4 g, ~14.23 mmol) in 100 mL of ethanol. The mixture was heated at reflux for 6 h under nitrogen. The solvent was evaporated and hexanes was added. A solid was filtered off which was washed with hexanes. The solid was purified by column chromatography eluting with dichloromethane and later some methanol was added. Obtained 0.92 g of an orange solid (approximately 17%).



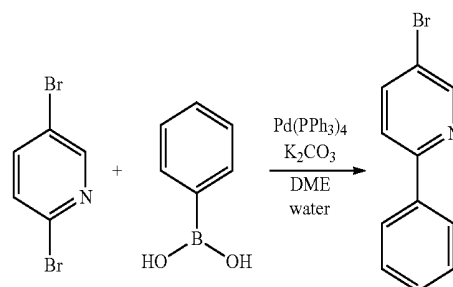
Synthesis of Compound 1

[0170] Mixed the boronic ester precursor (0.92 g, 1.18 mmol), bromobenzene (0.6 g, 3.54 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (19 mg, 0.047 mmol), and potassium phosphate tribasic (0.82 g, 3.54 mmol) in 50 mL of toluene and 5 mL of water. Bubbled nitrogen directly into the mixture for 30 minutes after which tris(dibenzylideneacetone)dipalladium(0) (11 mg, 0.0118 mmol) was added.

Nitrogen was bubbled for another 5 minutes then the reaction mixture was heated to reflux for 1 h under nitrogen. The mixture was cooled and an orange solid precipitated out. The solid was filtered off and washed with hexanes followed by methanol. Some solid was seen in filtrate so the filtrate was evaporated and methanol was added. More orange solid was filtered off. All the solid was purified by column chromatography eluting with 50% dichloromethane/hexanes. The solid was sublimed at 280° C. Obtained 0.53 g (62%).

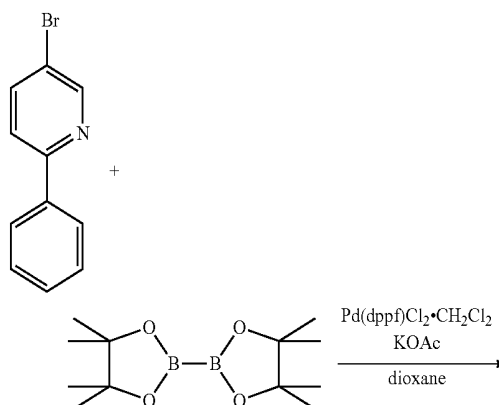
Example 2. Synthesis of Compound 2

[0171] The following synthesis could be used to make Compound 2.

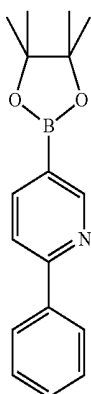


Synthesis of 2-phenyl-5-bromopyridine

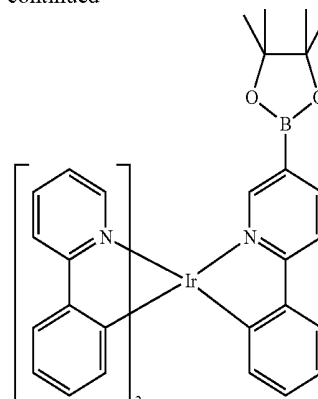
[0172] A mixture is prepared of 2,5-dibromopyridine (10 g, 42.21 mmol), phenylboronic acid (5.1 g, 42.21 mmol), and potassium carbonate (11.7 g, 84.42 mmol) in 100 mL dimethoxyethane and 40 mL of water. Nitrogen is bubbled directly into the mixture for 30 minutes. Next, tetrakis(triphenylphosphine)palladium(0) was added (244 mg, 2.11 mmol) and the mixture is heated to reflux under nitrogen overnight. The mixture is cooled and diluted with ethyl acetate and water. The layers are separated and the aqueous layer is extracted with ethyl acetate. The organic layers are washed with brine, dried over magnesium sulfate, filtered, and evaporated to a residue. The residue is purified by column chromatography eluting with 0, 2, and 5% ethyl acetate/hexanes.



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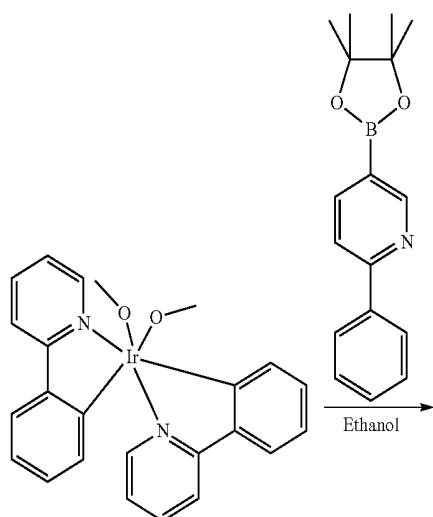


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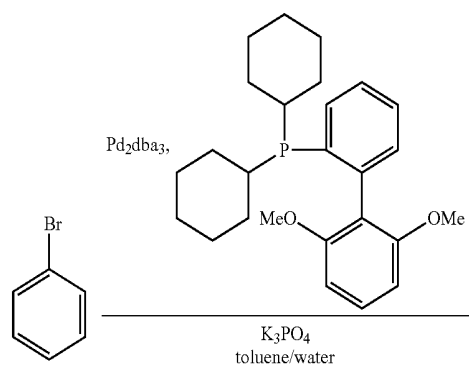
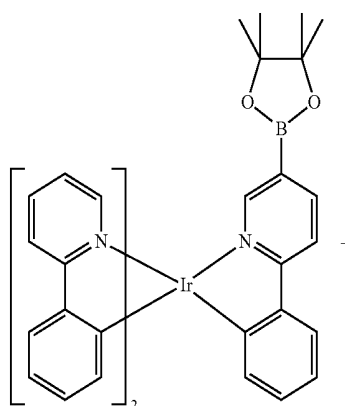
Synthesis of 2-phenyl-5-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)pyridine

[0173] A mixture is prepared of 2-phenyl-4-bromopyridine (4.28 g, 18.28 mmol), bis(pinacolato)diboron (9.29 g, 36.57 mmol), and potassium acetate (5.38 g, 54.84 mmol) in 100 mL of dioxane. Nitrogen is bubbled directly into the mixture for 30 minutes. Dichloro[1,1'-ferrocenylbis(diphenylphosphine)]palladium(II) dichloromethane (448 mg, 0.55 mmol) is added. The reaction mixture is heated to 90° C. internally for 3 h. The solvent is evaporated to an oil. The oil was purified by Kugelrohr to remove excess bis(pinacolato)diboron. The residue left in the boiling pot is dissolved in ethyl acetate and filtered through magnesium sulfate, rinsed with ethyl acetate, and the filtrate is evaporated. The product can be used without purification in the next step.

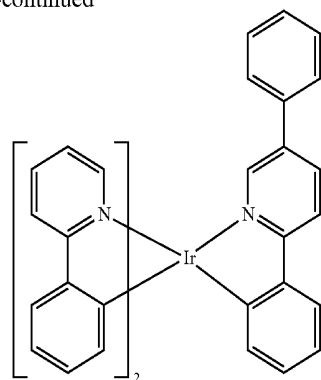


Synthesis of Boronic Ester Precursor

[0174] A mixture is prepared of the triflate (4.6 g, 7.11 mmol) and 2-phenyl-5-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)pyridine (~4 g, ~14.23 mmol) in 100 mL of ethanol. The mixture is heated at reflux for 24 h under nitrogen. The solvent is evaporated and hexanes is added. A solid is filtered off which is washed with hexanes. The solid is purified by column chromatography eluting with dichloromethane and later some methanol is added.



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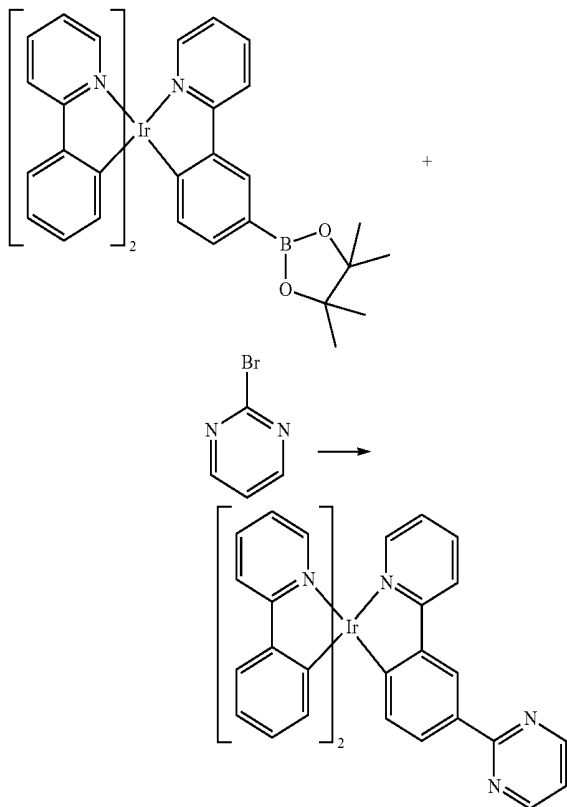
Compound 2

Synthesis of Compound 2

[0175] The boronic ester precursor (0.92 g, 1.18 mmol), bromobenzene (0.6 g, 3.54 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (19 mg, 0.047 mmol), and potassium phosphate tribasic (K_3PO_4) (0.82 g, 3.54 mmol) are mixed in 50 mL of toluene and 5 mL of water. Nitrogen is bubbled directly into the mixture for 30 minutes after which tris(dibenzylideneacetone)dipalladium(0) (11 mg, 0.0118 mmol) is added. Nitrogen is bubbled for another 5 minutes then the reaction mixture is heated to reflux for 1 h under nitrogen. The mixture is cooled and an orange solid formed. The solid is filtered off and washed with hexanes followed by methanol. The solid is purified by column chromatography eluting with 50% dichloromethane/hexanes.

Example 3. Synthesis of Compound 3

[0176]

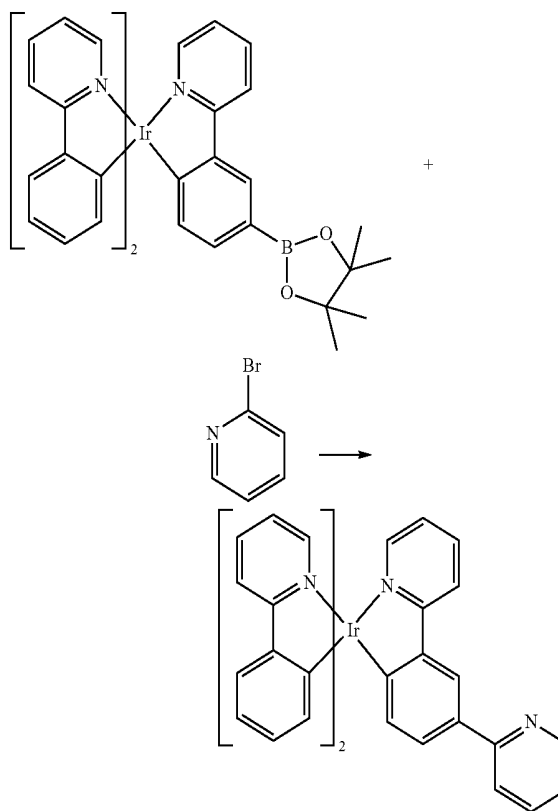


Compound 3

[0177] Irppy intermediate (0.70 g, 0.90 mmol), 2-bromopyrimidine (0.71 g, 4.5 mmol), tris(dibenzylideneacetone)dipalladium(0) [$Pd_2(dba)_3$] (0.01 g, 1 mol %), tricyclohexylphosphine (0.05 g, 0.18 mmol) and potassium phosphate tribasic (K_3PO_4) (0.7 g, 3.3 mmol) were weighed into a 100 mL 3-neck round bottom flask. 40 mL toluene and 10 mL water were added to the reaction vessel. The reaction mixture was degassed by bubbling nitrogen directly in the mixture for an hour. The solution was heated to reflux for 2 h. After cooling, the product was filtered, dissolved in methylene chloride and chromatographed using silica gel with methylene chloride:hexanes (50:50) as the mobile phase. The solvent was removed using the rotary evaporator and the product dried under vacuum to give 0.6 g of product (90% yield).

Example 4. Synthesis of Compound 4

[0178]

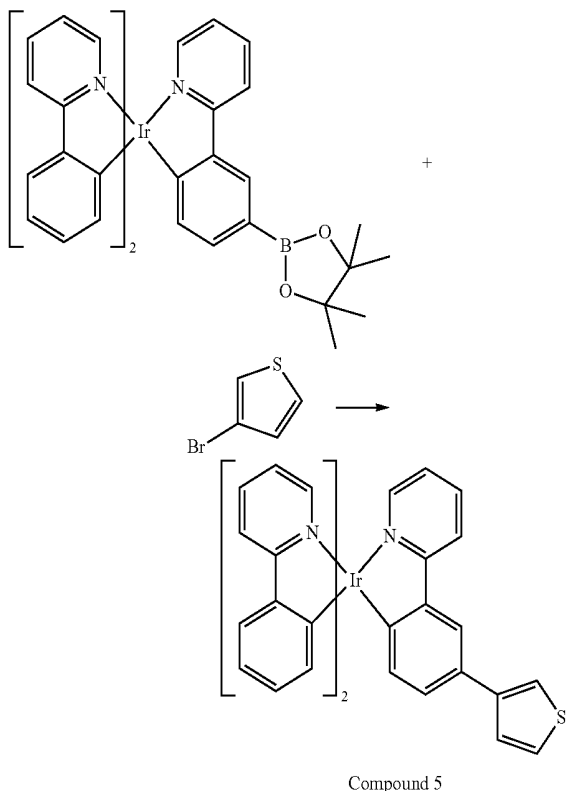


Compound 4

[0179] Irppy intermediate (1.0 g, 1.3 mmol), 2-bromopyridine (1.01 g, 6.4 mmol), tris(dibenzylideneacetone)dipalladium(0) [$Pd_2(dba)_3$] (0.05 g, 1 mol %), tricyclohexylphosphine (0.08 g, 5 mol %) and potassium phosphate tribasic (K_3PO_4) (4.0 g, 19.0 mmol) were weighed into a 100 mL 3-neck round bottom flask. 50 mL dioxane and 10 mL water were added to the reaction vessel. The reaction mixture was degassed by bubbling nitrogen directly in the mixture for an hour. The solution was heated to reflux for 2 h. After cooling, the product was filtered, dissolved in methylene chloride and chromatographed using silica gel with methylene chloride:hexanes (50:50) as the mobile phase. The solvent was removed using the rotary evaporator and the product dried under vacuum to give 0.8 g of product (86% yield).

Example 5. Synthesis of Compound 5

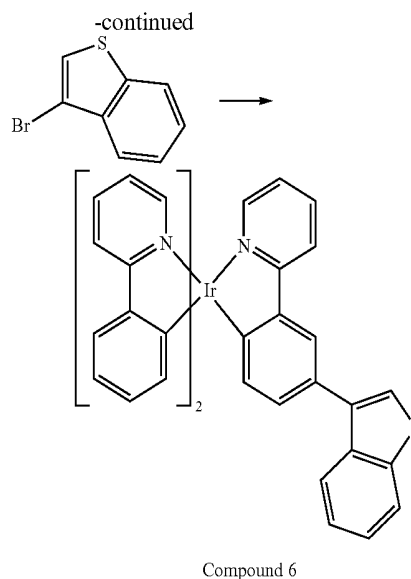
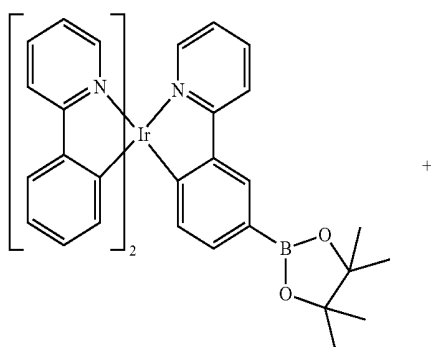
[0180]



[0181] Irppy intermediate (1.50 g, 1.90 mmol), 3-bromothiophene (1.61 g, 9.6 mmol), tris(dibenzylideneacetone)dipalladium(0) [$\text{Pd}_2(\text{dba})_3$] (0.02 g, 1 mol %), tricyclohexylphosphine (0.04 g, 4 mol %) and potassium phosphate tribasic (K_3PO_4) (1.2 g, 5.6 mmol) were weighed into a 250 mL 3-neck round bottom flask. 100 mL toluene and 10 mL water were added to the reaction vessel. The reaction mixture was degassed by bubbling nitrogen directly in the mixture for an hour. The solution was heated to reflux for 2 h. After cooling, the product was filtered, dissolved in methylene chloride and chromatographed using silica gel with methylene chloride:hexanes (50:50) as the mobile phase. The solvent was removed using the rotary evaporator and the product dried under vacuum to give 1.0 g of product (74% yield).

Example 6. Synthesis of Compound 6

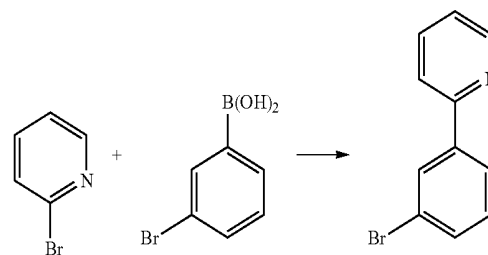
[0182]



[0183] Irppy intermediate (1.50 g, 1.90 mmol), 3-bromothiophene (2.0 g, 9.6 mmol), tris(dibenzylideneacetone)dipalladium(0) [$\text{Pd}_2(\text{dba})_3$] (0.08 g, 1 mol %), tricyclohexylphosphine (0.2 g, 0.5 mmol) and potassium phosphate tribasic (K_3PO_4) (1.2 g, 5.6 mmol) were weighed into a 250 mL 3-neck round bottom flask. 100 mL toluene and 10 mL water were added to the reaction vessel. The reaction mixture was degassed by bubbling nitrogen directly in the mixture for an hour. The solution was heated to reflux for 2 h. After cooling, the product was filtered, dissolved in methylene chloride and chromatographed using silica gel with methylene chloride:hexanes (50:50) as the mobile phase. The solvent was removed using the rotary evaporator and the product dried under vacuum to give 1.2 g of product (80% yield).

Example 7. Synthesis of Compound 7

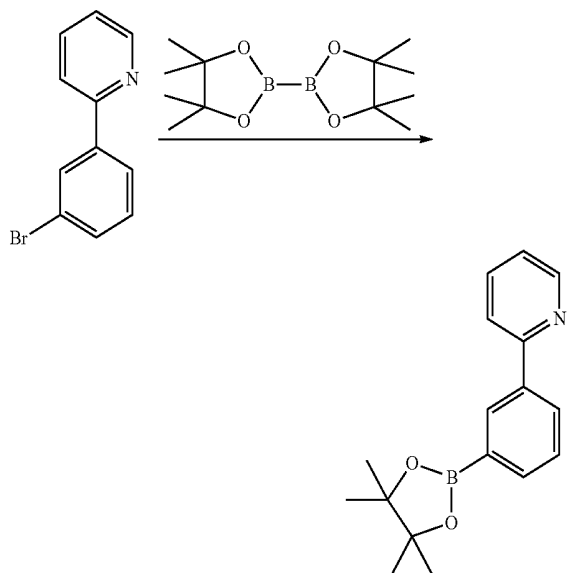
[0184]



Synthesis of 2-(3-bromophenyl)pyridine

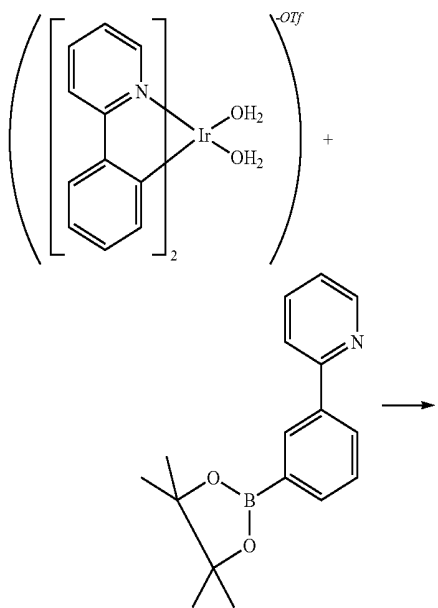
[0185] 2-bromopyridine (75.0 g, 475 mmol), 3-bromophenylboronic acid (104.8 g, 520 mmol), palladium acetate (2.6 g, 2.5 mol %), triphenylphosphine (5.37 g, 5 mol %) and potassium carbonate (196.0 g, 1425 mmol) was placed in a 2 L 3-neck round bottom flask. 500 mL of dimethoxyethane and 500 mL of H_2O was added to the flask. Nitrogen was bubbled through the solution for 30 minutes and then the solution was refluxed for 8 h in an atmosphere of nitrogen. The reaction was then allowed to cool to room temperature and the organic phase was separated from the aqueous phase. The aqueous phase was washed with ethylacetate and the organic fractions were combined and dried over magnesium sulfate and the solvent removed under vacuum. The

product was chromatographed using silica gel with ethylacetate and hexanes as the eluent. The solvent was removed to give 84.0 g of a clear oil (76% yield).

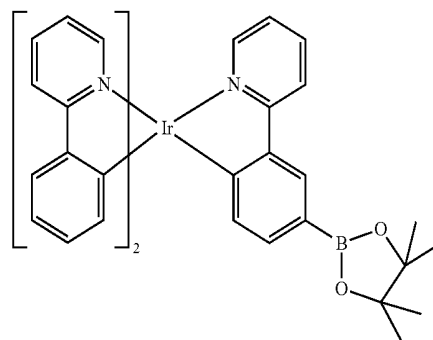


Synthesis of 2-(3-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)pyridine

[0186] 2-(3-bromophenyl)pyridine (25.0 g, 107 mmol), bis(pinacolato)diboron (54.2 g, 214 mmol), Pd(dppf)₂Cl₂ (1.0 g, 10 mol %), and potassium acetate (31.5 g, 321 mmol) were placed in 1 L round bottom flask. 600 mL of dioxane was then added to the flask. Nitrogen was bubbled into the reaction mixture for 1 h and then the flask was heated to 90° C. for 12 h in an atmosphere of nitrogen. The dioxane was removed under reduced pressure by a rotary evaporator. The dark solid was dissolved in 400 mL of dichloromethane and passed through a 2 inch thick silica gel plug. The dichloromethane was removed under reduced pressure by a rotary evaporator to leave a yellow oil. The product was then distilled using a Kuglerohr apparatus to give 23 g of a white solid (77% yield).



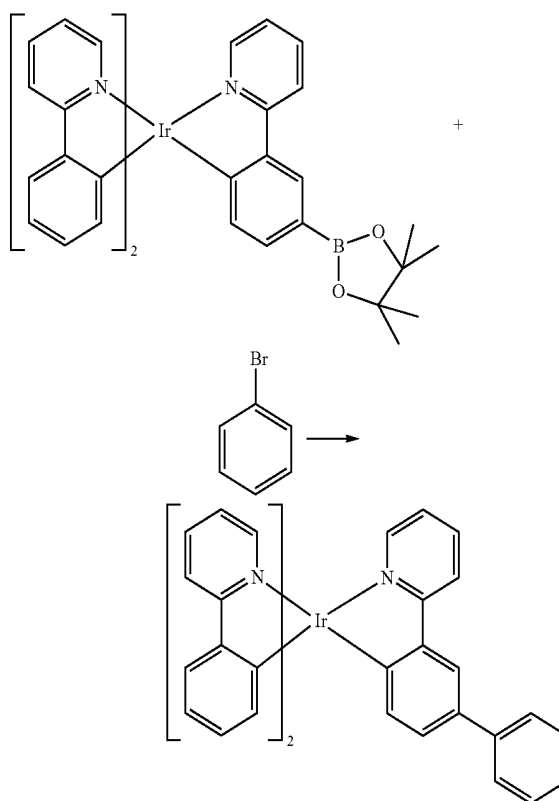
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Synthesis of Irppy Intermediate

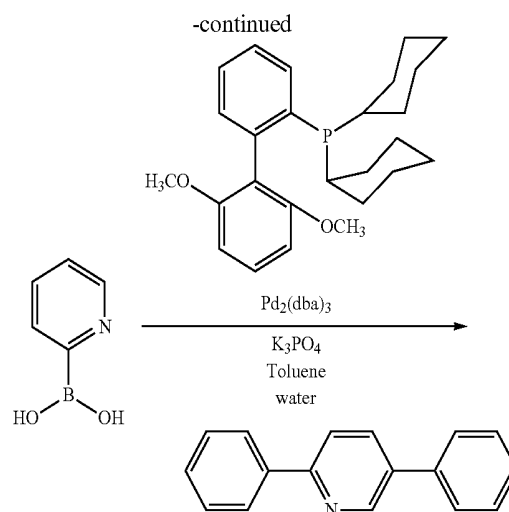
[0187] Irppy triflate (17.5 g, 25 mmol) and 3 molar equivalent 2-(3-(4,4,5,5-tetramethyl-1,3,2-dioxaborolan-2-yl)phenyl)pyridine (21.50 g, 117 mmol) was placed in a 2 L 3 neck round bottomed flask. 600 mL of alcohol was added to the reaction mixture. The reaction mixture was degassed by bubbling nitrogen directly in the mixture for an hour. The reaction mixture was then refluxed (internal temp of the reaction mixture was 78 degrees) for overnight. After about 18 h the product had already precipitated from the hot reaction mixture. After cooling to room temperature 200 mL isopropanol was added to precipitate any more product from the reaction mixture. The reaction mixture was then filtered and the product/residue was washed with isopropanol (to remove excess ligand) and then air dried to give 12 g of product (60% yield).

Compound 7



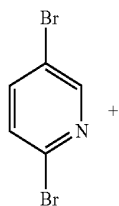
Synthesis of Compound 7

[0188] Irppy intermediate (0.50 g, 0.64 mmol), bromobenzene (0.5 g, 3.2 mmol), tris(dibenzylideneacetone)dipalladium(0) [$\text{Pd}_2(\text{dba})_3$] (0.006 g, 0.0064 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (0.10 g, 0.025 mmol) and potassium phosphate tribasic (K_3PO_4) (0.4 g, 1.92 mmol) were weighed into a 100 mL 3 neck round bottom flask. 40 mL toluene and 10 mL water were added to the reaction vessel. The reaction mixture was degassed by bubbling nitrogen directly in the mixture for an hour. The solution was heated to reflux for 2 h. After cooling, the product was filtered, dissolved in methylene chloride and chromatographed using silica gel with methylene chloride: hexanes (50:50) as the mobile phase. The solvent was removed using the rotary evaporator and the product dried under vacuum to give 0.5 g of product (95% yield).



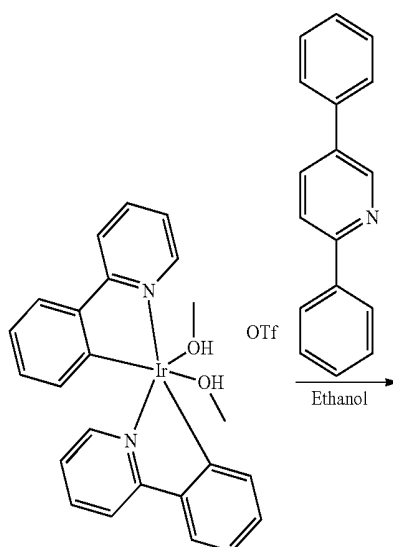
Example 8. Synthesis of Compound 2

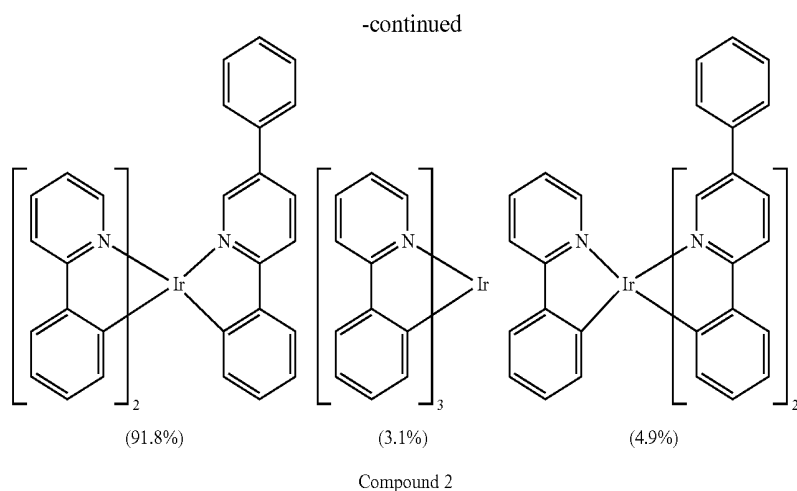
[0189] This following alternate synthesis was used to make Compound 2.



Synthesis of 2, 5-diphenylpyridine

[0190] 2,5-dibromopyridine (10 g, 42 mmol), phenylboronic acid (13.4 g, 110 mmol), dicyclohexyl(2', 6'-dimethoxybiphenyl-2-yl)phosphine (S-Phos) (0.7 g, 1.6 mmol), and potassium phosphate (22 g, 105 mmol) were mixed in 200 mL of toluene and 20 mL of water. Nitrogen is bubbled directly into the mixture for 30 minutes. Next, $\text{Pd}_2(\text{dba})_3$ was added (0.38 g, 0.4 mmol) and the mixture was heated to reflux under nitrogen for 2 h. The mixture was cooled and the organic layer was separated. The organic layers are washed with brine, dried over magnesium sulfate, filtered, and evaporated to a residue. The residue was purified by column chromatography eluting with 10% ethyl acetate/hexanes. 7 g of desired product was obtained after purification. (91.8% yield)





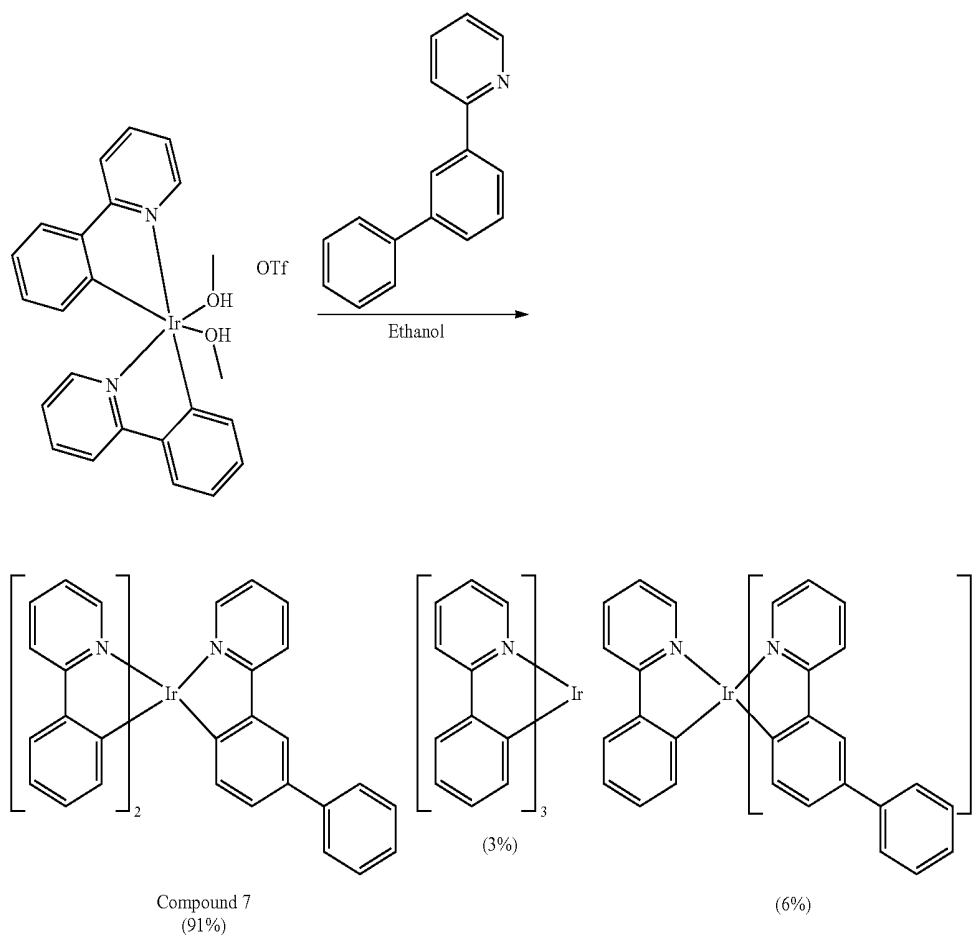
Synthesis of Compound 2

[0191] The iridium triflate precursor (2.5 g, 3.5 mmol) and 2,5-diphenylpyridine (2.4 g, 11 mmol) were mixed in 200 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was

dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 1.2 g of pure product was obtained after the column purification. (HPLC purity: 99.8%)

Example 9. Alternate Synthesis of Compound 7

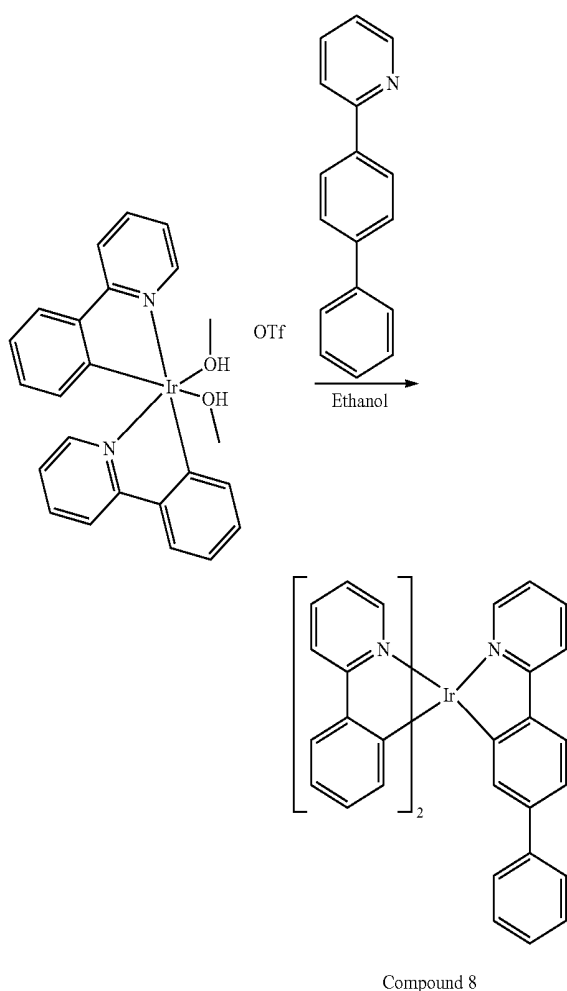
[0192] The following alternate synthesis was used to make Compound 2.



[0193] The iridium triflate precursor (2.5 g, 3.5 mmol) and 2-(biphenyl-3-yl)pyridine (2.4 g, 11 mmol) were mixed in 200 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 1.5 g of pure product was obtained after the column purification, (HPLC purity: 99.6%)

Example 10. Synthesis of Compound 8

[0194]

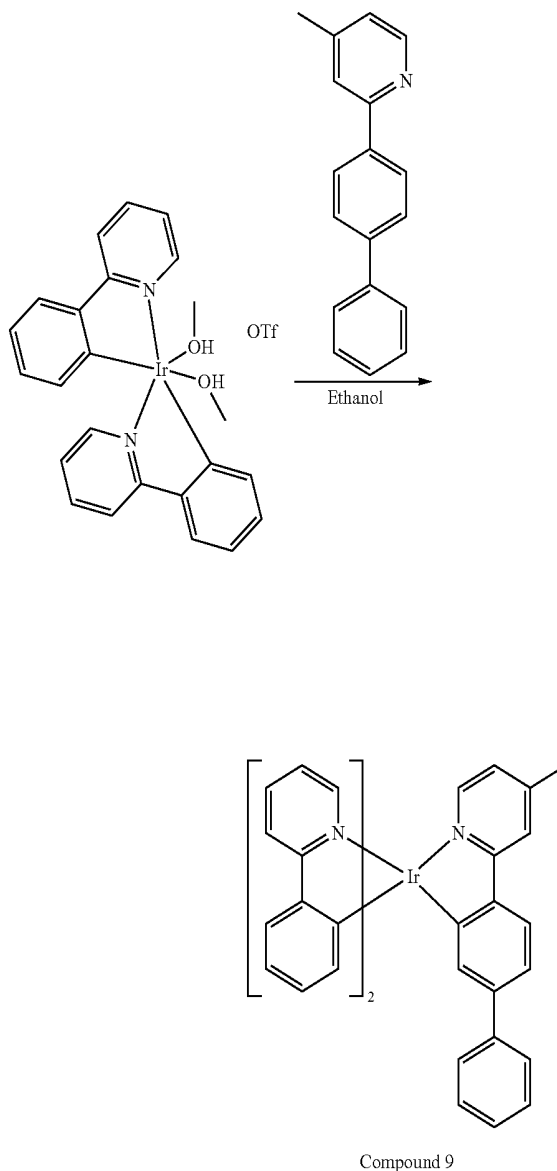


Compound 8

[0195] The iridium triflate precursor (2.5 g, 3.5 mmol) and 2-(biphenyl-4-yl)pyridine (2.4 g, 11 mmol) were mixed in 100 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 1.2 g of pure product was obtained after the column purification. (HPLC purity: 99.8%)

Example 11. Synthesis of Compound 9

[0196]

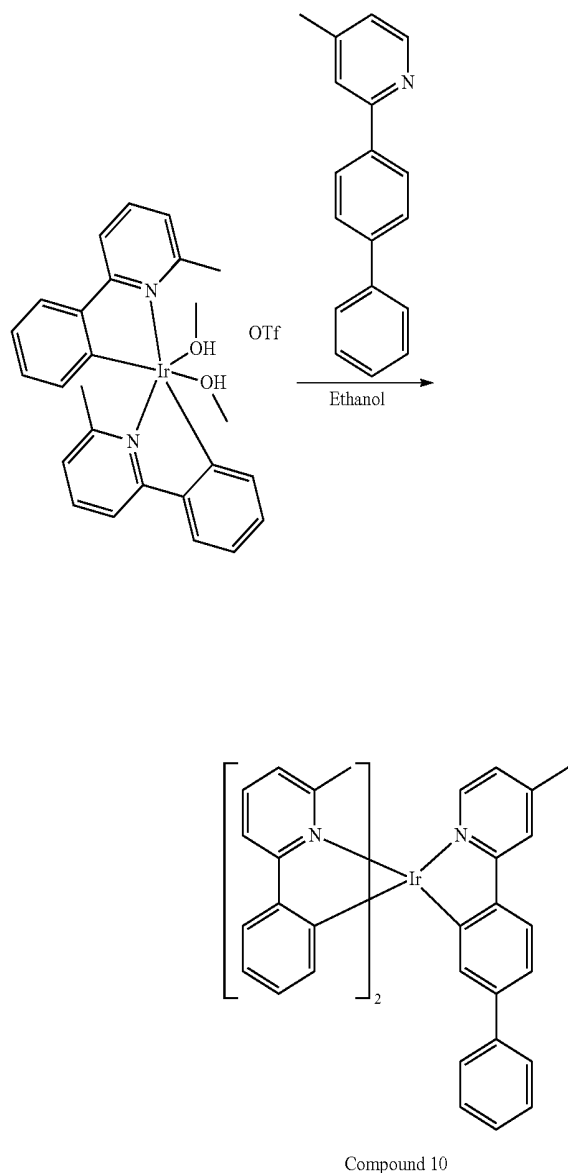


Compound 9

[0197] The iridium triflate precursor (2.5 g, 3.5 mmol) and 2-(biphenyl-4-yl)-4-methylpyridine (2.6 g, 11 mmol) were mixed in 100 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 1.3 g of pure product was obtained after the column purification. (HPLC purity: 99.9%)

Example 12. Synthesis of Compound 10

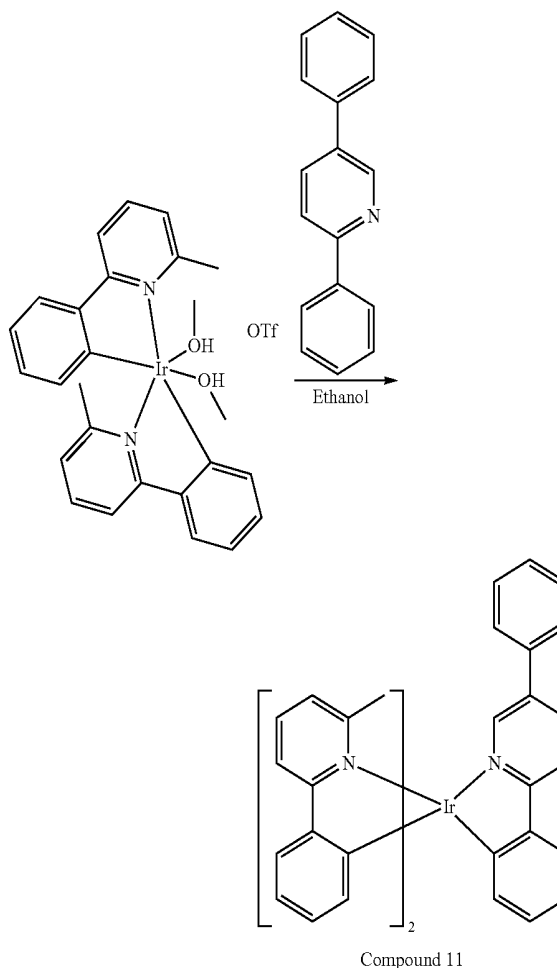
[0198]



[0199] The iridium triflate precursor (2.0 g, 2.7 mmol) and 2-(biphenyl-4-yl)-4-methylpyridine (2.0 g, 8.2 mmol) were mixed in 60 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 1.6 g of pure product was obtained after the column purification. (HPLC purity: 99.4%)

Example 13. Synthesis of Compound 11

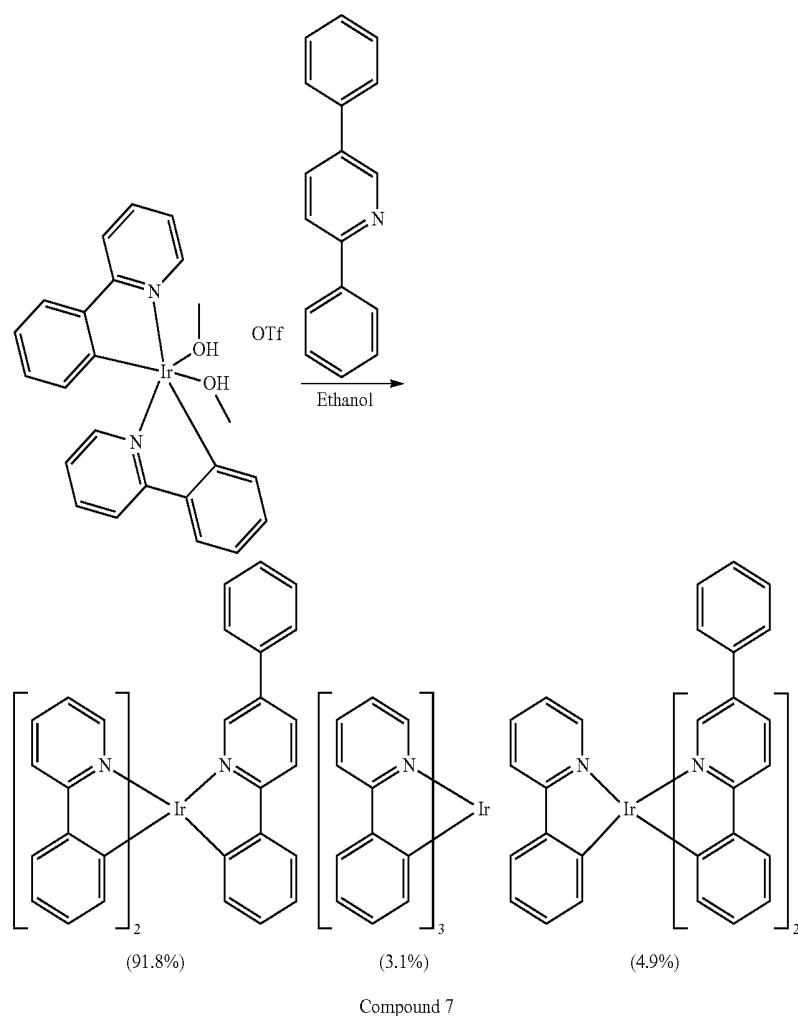
[0200]



[0201] The iridium triflate precursor (1.2 g, 1.6 mmol) and 2,5-diphenylpyridine (1.2 g, 4.8 mmol) were mixed in 50 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 1.0 g of pure product was obtained after the column purification. (HPLC purity: 99.3%)

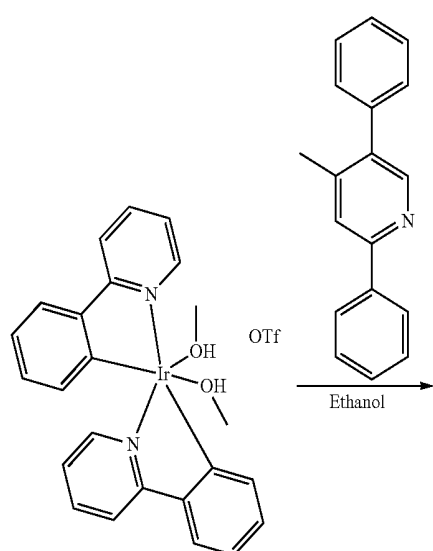
[0202] The reaction of the iridium triflate intermediate with the second ligand in an organic solvent, as shown for Compound 11, often produces a mixture because of the ligand scrambling during the reaction. Interestingly, during the synthesis of Compound 11, no significant scrambling occurred.

[0203] However, the synthesis of Compound 7 using this method resulted in significant scrambling despite the structural similarity between Compounds 11 and 7 (i.e., Compound 7 is identical to Compound 11 except for a methyl group on the phenyl pyridine ligand). In particular, the iridium triflate intermediate was reacted with 2,5-diphenylpyridine in ethanol under reflux condition. The product was a mixture of Compound 7 and other two scrambled products as shown below. Due to the similarity of polarity of the compounds, it is very difficult to separate these impurities from Compound 7 using normal phase silica gel chromatography.

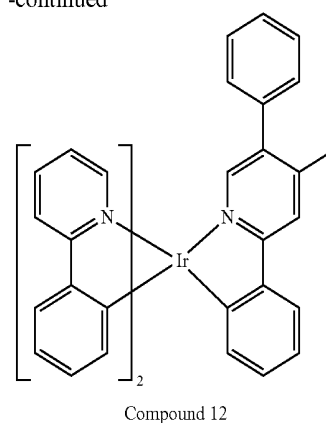


Example 14. Synthesis of Compound 12

[0204]



-continued

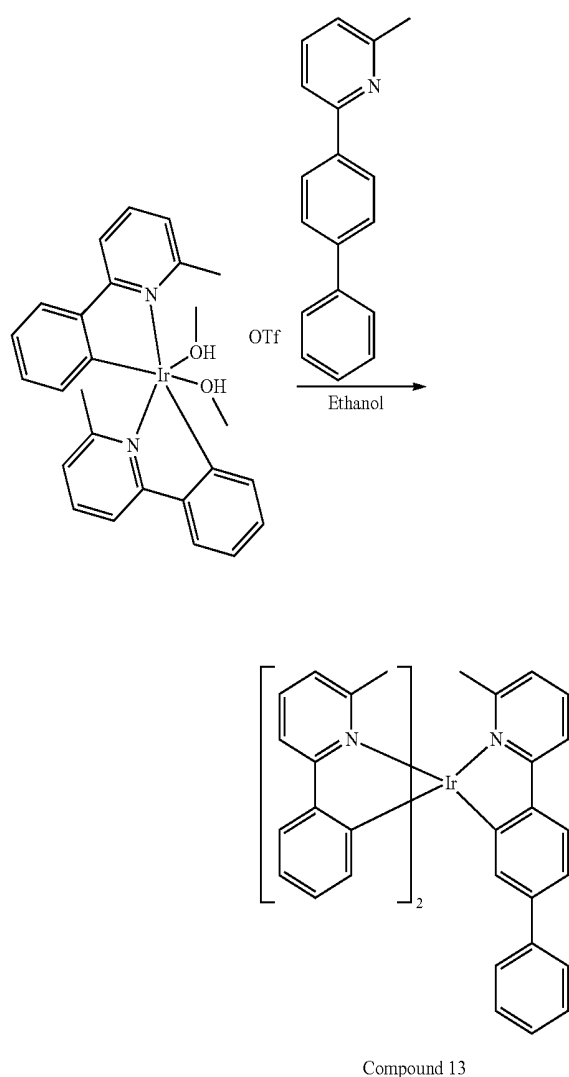


[0205] The iridium triflate precursor (2.5 g, 3.5 mmol) and 4-methyl-2,5-diphenylpyridine (2.6 g, 10.5 mmol) were mixed in 100 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by

column using 1:1 of dichloromethane and hexanes. 1.2 g of pure product was obtained after the column purification. (HPLC purity: 99.9%)

Example 15. Synthesis of Compound 13

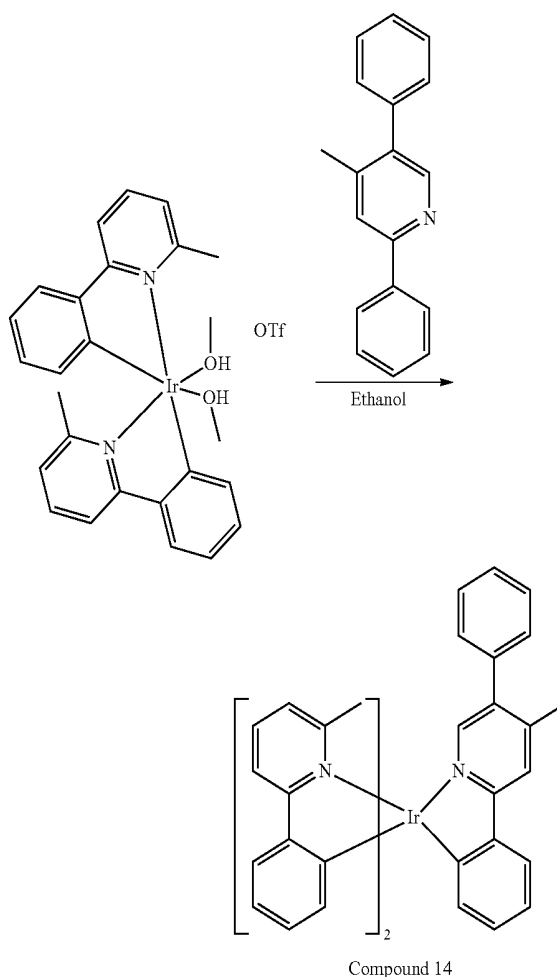
[0206]



[0207] The iridium triflate precursor (2.5 g, 2.7 mmol) and 2-(biphenyl-4-yl)-6-methylpyridine (2.0 g, 8.1 mmol) were put into a 20 mL reaction tube. The reaction tube was evacuated and then refilled with nitrogen. The process was repeated three times. The mixture was heated at 130° C. for 24 h under nitrogen. The reaction mixture was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 0.98 g of pure product was obtained after the column purification. (HPLC purity: 99.8%)

Example 16. Synthesis of Compound 14

[0208]



[0209] The iridium triflate precursor (0.86 g, 1.15 mmol) and 4-methyl-2,5-diphenylpyridine (0.85 g, 3.46 mmol) were mixed in 30 mL of ethanol. The mixture was heated at reflux for 24 h under nitrogen. Precipitate formed during reflux. The reaction mixture was filtered through a celite bed. The product was washed with methanol and hexanes. The solid was dissolved in dichloromethane and purified by column using 1:1 of dichloromethane and hexanes. 0.7 g of pure product was obtained after the column purification. (HPLC purity: 99.5%)

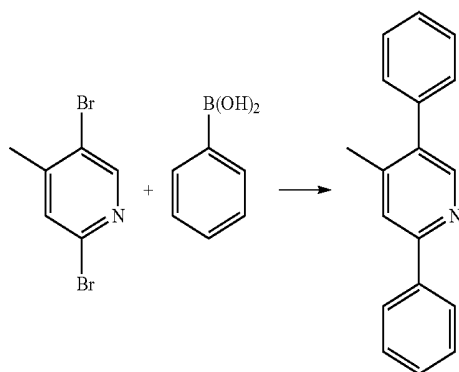
[0210] The reaction of the iridium triflate intermediate with the second ligand in an organic solvent, as shown for Compound 11, often produces a mixture of products because of ligand scrambling during the reaction. Interestingly, during the synthesis of Compounds 10, 11, and 14, no significant scrambling occurred. The content of the desired product in the precipitate was higher than 99% in all cases.

[0211] In particular, the synthesis of Compound 7 using this method resulted in significant scrambling despite the structural similarity between Compounds 11 and 7 (i.e., Compound 7 is identical to Compound 11 except for a methyl group on the phenyl pyridine ligand). In particular, the iridium triflate intermediate was reacted with 2,5-diphenylpyridine in ethanol under reflux condition. The product

was a mixture of Compound 7 and other two scrambled products as shown below. Due to the similarity of polarity of the compounds, it is very difficult to separate these impurities from Compound 7 using normal phase silica gel chromatography.

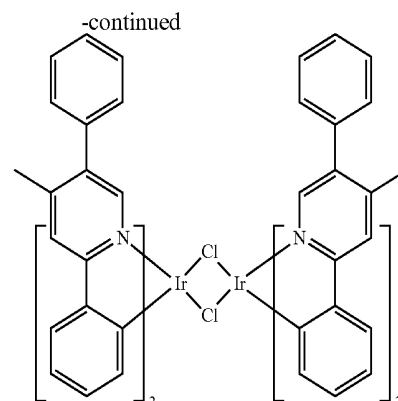
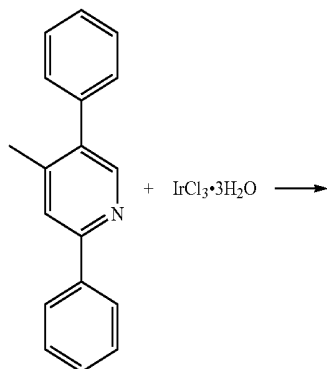
Example 17. Synthesis of Compound 21

[0212]



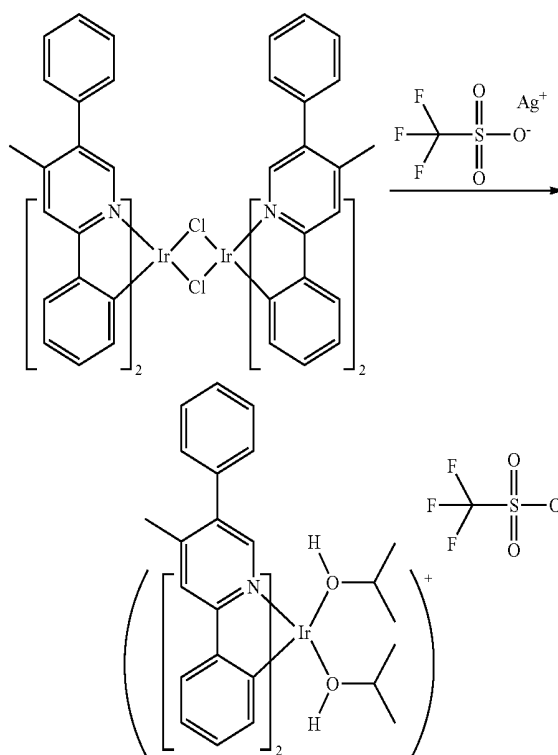
Synthesis of 2,5-diphenyl-4-methylpyridine

[0213] Phenylboronic acid (72.9 g, 598 mmol), 2,5-dibromo-4-methylpyridine (50 g, 199 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (3.3 g, 8 mmol), potassium phosphate tribasic monohydrate (137 g, 595 mmol), 650 mL of toluene and 150 mL of water were placed in a 2 L round-bottom flask. Nitrogen was bubbled directly into the reaction mixture for 30 min after which tris(dibenzylideneacetone)dipalladium(0) (1.79 g, 1.96 mmol) was added. Nitrogen was bubbled into the reaction mixture for another 15 min before the reaction mixture was heated to reflux for 16 h under nitrogen. After the reaction was completed the mixture was cooled and the organic layer was separated from the aqueous layer. The organic layer was washed with a saturated brine solution and then dried over magnesium sulfate. The solution was filtered, and the solvent was removed under vacuum to give a yellow solid as the crude. The crude was purified by column chromatography using silica gel as the stationary phase and 10% ethyl acetate in hexanes as the mobile phase. The product was further purified by recrystallization from hexanes. 42.6 g of desired product was obtained after purification (87.2% yield).



Synthesis of Ir Dimer

[0214] $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$ (7.54 g, 20.4 mol) and 2,5-diphenyl-4-methylpyridine (15.0 g, 61 mol) were placed in a 1 L round bottomed flask. 100 mL of 2-ethoxyethanol and 35 mL of water were then added. The mixture was refluxed under nitrogen atmosphere for 16 h. The reaction mixture was cooled to room temperature and the precipitate was filtered and washed with methanol followed by hexanes. 13.6 g of the iridium dimer was obtained (99% yield)

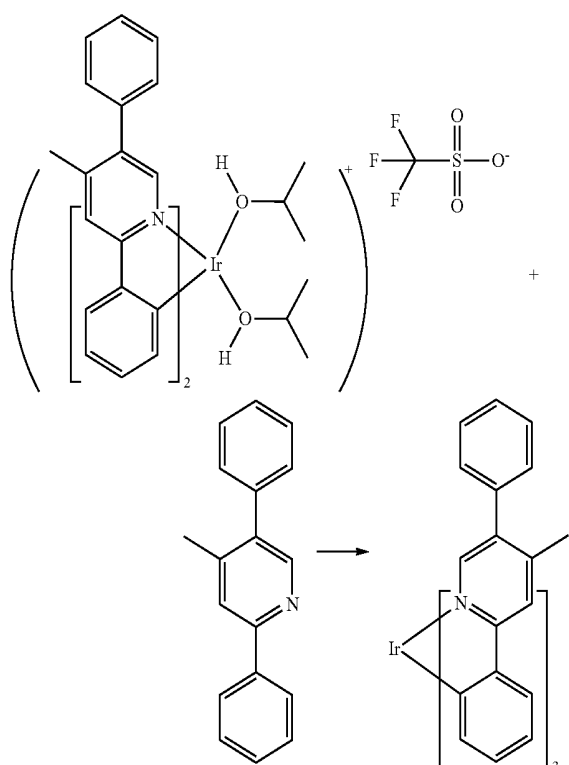


Synthesis of Ir Triflate

[0215] 13.3 g of the iridium dimer was dissolved in 1.5 L of dichloromethane. Silver triflate (5.11 g, 19.9 mmol) was dissolved in 500 mL of isopropanol and added to the iridium dimer solution. The resulting mixture was stirred for 18 h at room temperature. The solution was then poured through a

celite plug to remove silver chloride and the solvent was evaporated under vacuum to give 17.0 g of the iridium triflate. The solid was used for the next step without further purification.

Compound 21

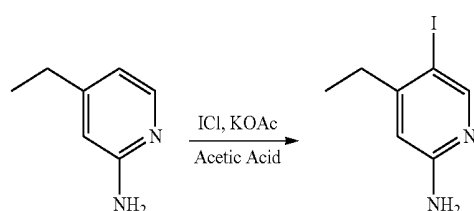


Synthesis of Compound 21

[0216] The iridium triflate (17.0 g, 17.9 mmol) and a 3 molar equivalent of 2,5-diphenyl-4-methylpyridine (13.1 g, 53.7 mmol) were placed in a 1 L round bottom flask. 150 mL of ethanol was added and the reaction mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2x50 mL), followed by hexanes (2x50 mL). The product was then eluted through a silica gel plug with dichloromethane. Most of the dichloromethane was removed under vacuum and the product was precipitated with 2-propanol and filtered, washed with hexanes and dried to give 9.69 g product (90.6% yield).

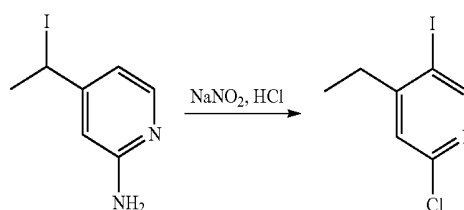
Example 18. Synthesis of Compound 22

[0217]



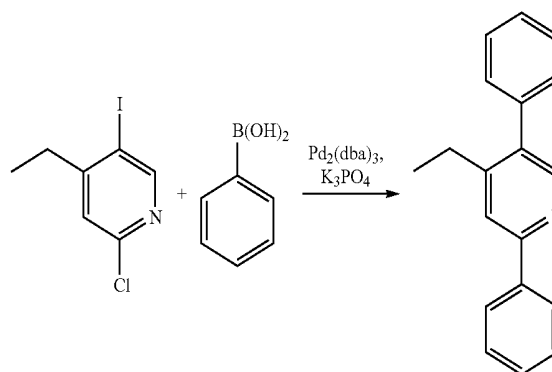
Synthesis of 2-amino-4-ethyl-5-iodopyridine

[0218] 4-ethyl-2-aminopyridine (10.0 g, 81.9 mmol) and potassium acetate (8.00 g, 81.9 mmol) were dissolved in 100 mL of acetic acid and heated to 80° C. with continuous stirring. In a separate flask, iodomonochloride (13.2 g, 81.9 mmol) was dissolved in 30 mL of acetic acid and added to the above reaction mixture drop wise. Once the addition was completed, the reaction mixture was heated for an additional 4 h. Progress of the reaction was monitored by gas chromatography and HPLC. When the reaction was completed, the reaction mixture was cooled to room temperature and quenched with an aqueous solution of saturated sodium bisulfate (10 mL). Acetic acid was removed under vacuum and the residue was dissolved in ethyl acetate and neutralized with saturated NaHCO₃. The organic layer was separated from the aqueous layer and the solvent was removed under vacuum. The crude was purified by silica gel column chromatography eluting with 25% ethyl acetate/hexanes. 15 g of desired product was obtained (74% yield).



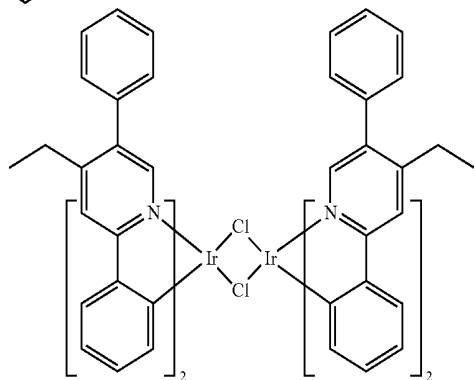
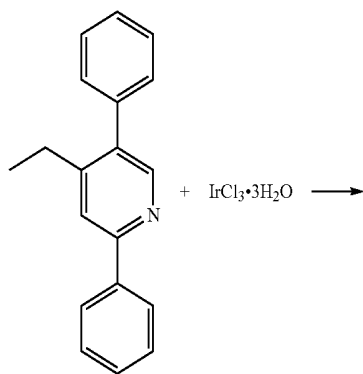
Synthesis of 2-chloro-4-ethyl-5-iodopyridine

[0219] 4-ethyl-5-iodopyridin-2-amine (15.0 g, 60.48 mmol) was dissolved in 140 mL conc. HCl. NaNO₂ was dissolved in 40 mL of water and added drop wise to the above solution at 0° C. Care was taken to prevent the temperature of the reaction mixture from rising above 0° C. When all of the NaNO₂ solution was added, the reaction mixture was allowed to warm up to room temperature and was stirred for a further 2 h at room temperature. Progress of the reaction was monitored by GC and HPLC. The reaction mixture was then re-cooled to 0° C. and the pH was adjusted to 01=12 by the addition of sat. NaOH. The mixture was extracted with dichloromethane (2x200 mL) and the solvent removed under vacuum. The crude was purified by silica gel column chromatography eluting with 5% ethyl acetate/hexanes. 8.0 g of desired product was obtained after purification (49% yield).



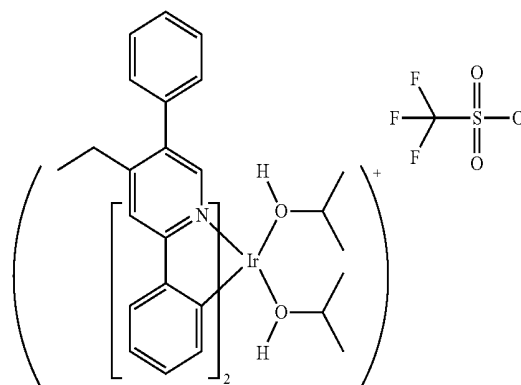
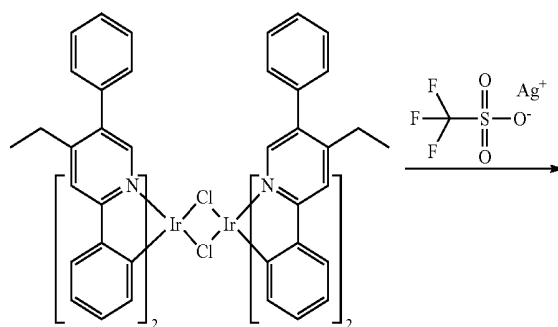
Synthesis of 2,5-diphenyl-4-ethylpyridine

[0220] Phenylboronic acid (11.0 g, 90 mmol), 2-chloro-4-ethyl-5-iodopyridine (8.00 g, 30 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (492 mg, 1.2 mmol), and potassium phosphate tribasic (20.7 g, 90 mmol), 250 mL of toluene and 25 mL of water were placed in a 1 L round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min after which tris(dibenzylideneacetone) dipalladium(0) (275 mg, 0.3 mmol) was added. Nitrogen was bubbled for another 15 min, then the reaction mixture was heated to reflux for 16 h under nitrogen. After the reaction was completed the mixture was cooled and the organic layer was separated from the aqueous layer. The organic layer was washed with saturated brine solution and dried over magnesium sulfate. The solution was filtered and the solvent was removed under vacuum to give a off-white solid. This crude was purified by silica gel column chromatography eluting with 10% ethyl acetate/hexanes. 7.0 g of desired product was obtained after purification (90.9% yield).



Synthesis of Ir Dimer

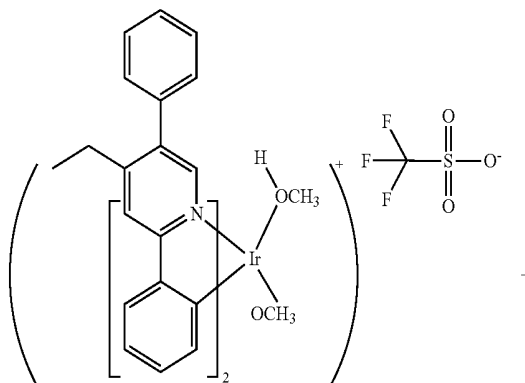
[0221] $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$ (1.5 g, 4.41 mmol) and 2,5-diphenyl-4-ethylpyridine (4.0 g, 15.44 mmol) was placed in a 250 mL round bottomed flask. 30 mL of 2-ethoxyethanol and 10 mL of water was added. The mixture was refluxed under nitrogen atmosphere for 16 h. The reaction mixture was then allowed to cool to room temperature and the precipitate was filtered and washed with methanol followed by hexanes. After drying, 2.57 g of the iridium dimer was obtained (81% yield).

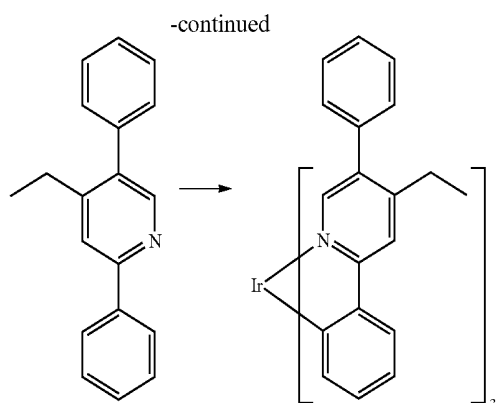


Synthesis of Ir Triflate

[0222] The iridium dimer (2.57 g, 1.725 mmol) was dissolved in 250 mL of dichloromethane. Silver triflate (1.0 g, 3.8 mmol) was dissolved in 150 mL of 2-propanol and added to the dimer solution. The resulting mixture was stirred for 5 h. The solution was then poured through a celite plug to remove silver chloride. The solvent was evaporated under vacuum to give 3.2 g of the iridium triflate. The solid was used for next step without further purification.

Compound 22



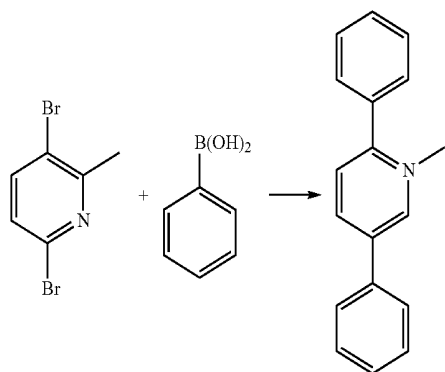


Synthesis of Compound 22

[0223] The iridium triflate (3.2 g) and 2,5-diphenyl-4-ethylpyridine (3.2 g) were placed in a 250 mL round bottom flask. 50 mL of ethanol was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. Most of the dichloromethane was removed under vacuum and the product was precipitated with 2-propanol and filtered, washed with hexanes and dried to give 1.67 g of product (52.8% yield).

Example 19. Synthesis of Compound 23

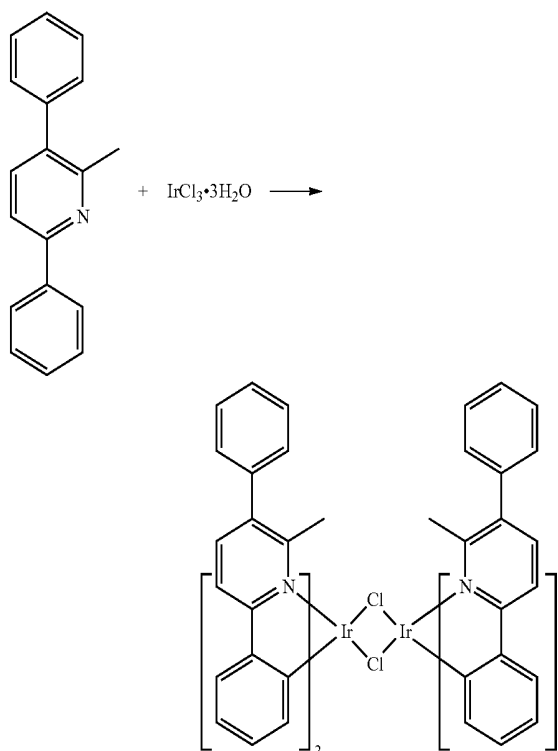
[0224]



Synthesis of 2,5-diphenyl-6-methylpyridine

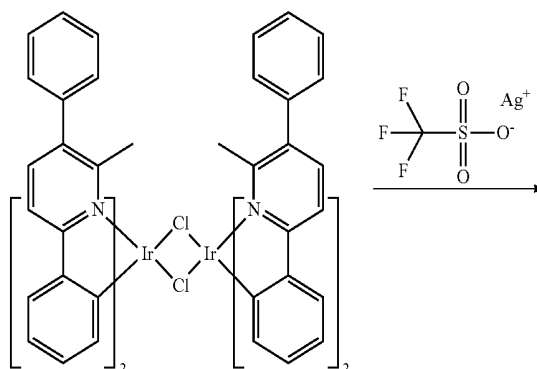
[0225] Phenylboronic acid (24.3 g, 199.25 mmol), 2,5-dibromo-6-methylpyridine (10 g, 39.85 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (654 mg, 1.5 mmol), and potassium phosphate tribasic (27.5 g, 119.5 mmol), 300 mL of toluene and 30 mL of water were placed in a 1 L round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min after which tris(dibenzylideneacetone)dipalladium(0) (364 mg, 0.398 mmol) was added. Nitrogen was bubbled for another 15 min then the reaction mixture was heated to reflux for 16 h under nitrogen. After the reaction was completed, the mixture was cooled and the

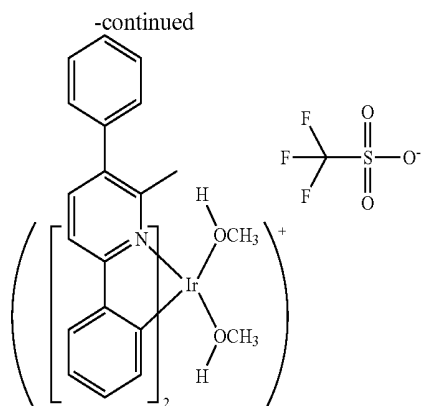
organic layer was separated. The organic layer was washed with a saturated brine solution and dried over magnesium sulfate. The solution was filtered and the solvent removed under vacuum. The crude was purified by column chromatography using silica gel as the stationary phase and 10%-20% ethyl acetate in hexanes as the mobile phase. 9.0 g of desired product was obtained after purification (92.7% yield)



Synthesis of Ir Dimer

[0226] $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$ (1.6 g, 4.66 mmol) and 2,5-diphenyl-6-methylpyridine (4.0 g, 16.31 mmol) was placed in a 250 mL round bottomed flask. 45 mL of 2-ethoxyethanol and 15 mL of water were added. The mixture was refluxed under nitrogen for 16 h. The reaction mixture was then allowed to cool to room temperature. The precipitate was filtered and washed with methanol followed by hexanes. After drying, 2.75 g of dimer was obtained (84.6% yield).

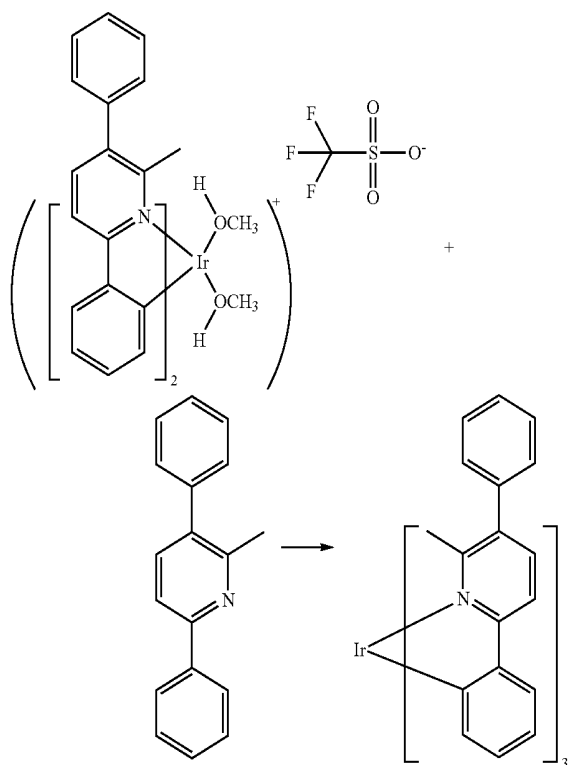




Synthesis of Ir Triflate

[0227] The iridium dimer (2.75 g, 2.2 mmol) was dissolved in 200 mL of dichloromethane. Silver triflate (1.19 g, 4.6 mmol) was dissolved in 100 mL of methanol and added to the iridium dimer solution. The resulting mixture was stirred for 5 h. The solution was then passed through a celite plug to remove silver chloride. The solvent was evaporated under vacuum to give 3.5 g of the iridium triflate. The solid was used for next step without further purification.

Compound 23



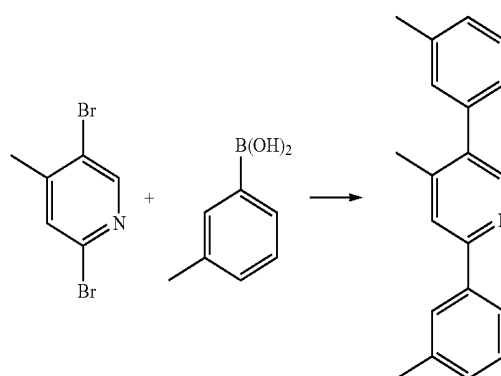
Synthesis of Compound 23

[0228] The iridium triflate (3.0 g) and 2,5-diphenyl-6-methylpyridine (3.0 g) was placed in a 100 mL round bottom flask. The solid mixture was heated to 130° C. for 16 h. After

cooling the reaction mixture was dissolved in 200 mL of dichloromethane. The solution was then passed through a 2 inch silica gel plug. The solvent was removed under vacuum and the residue was chromatographed using silica gel with dichloromethane as the mobile phase. Most of the solvent was evaporated and the product was precipitated with 2-propanol and filtered, washed with hexanes and then dried to give 2.65 g of product (71% yield).

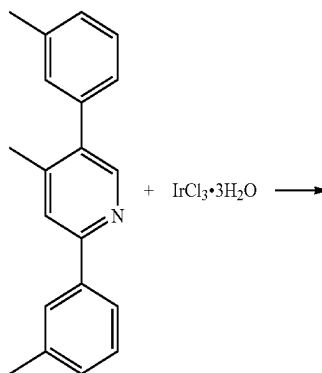
Example 20. Synthesis of Compound 24

[0229]

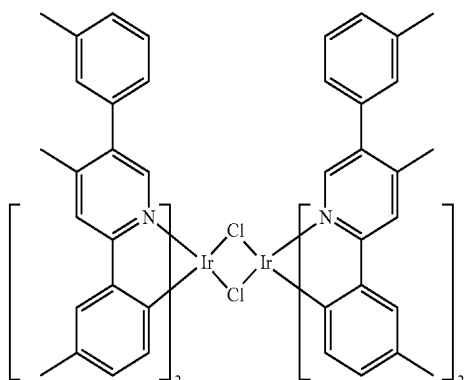


Synthesis of 2,5-(m-tolyl)-4-methylpyridine

[0230] m-tolylboronic ester (17.9 g, 132 mmol), 2,5-dibromo-4-methylpyridine (11.0 g, 44.0 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (726 mg, 1.77 mmol), and potassium phosphate tribasic monohydrate (30 g, 130 mmol), 143 mL of toluene and 33 mL of water were placed in a 500 mL round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min after which tris(dibenzylideneacetone)dipalladium(0) (394 mg, 43 mmol) was added. Nitrogen was bubbled for another 15 min then the reaction mixture was heated to reflux for 16 h under nitrogen. The mixture was allowed to cool to room temperature and the organic layer was separated from the aqueous layer. The organic layer was washed with a saturated brine solution and dried over magnesium sulfate. The solution was filtered and the solvent removed under vacuum to give an off white product. The crude was purified by column chromatography using silica gel as the stationary phase and 10% ethyl acetate in hexanes as the mobile phase. 11.2 g of desired product was obtained after purification. (93.3% yield)

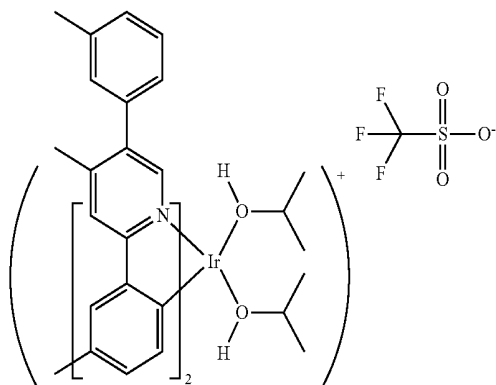
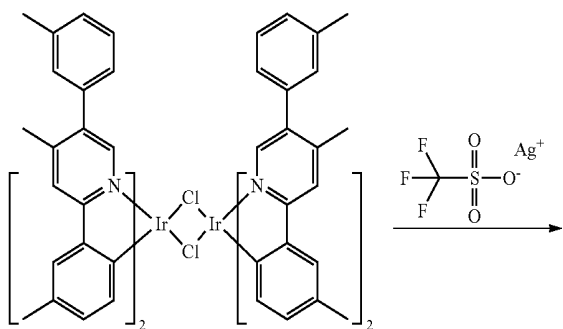


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Synthesis of Ir Dimer

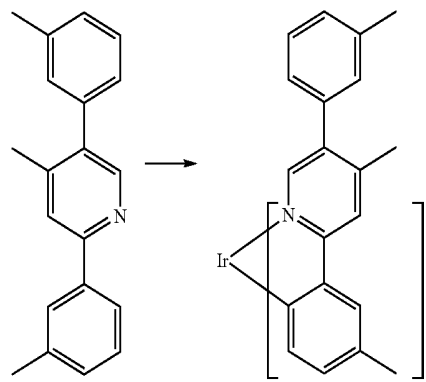
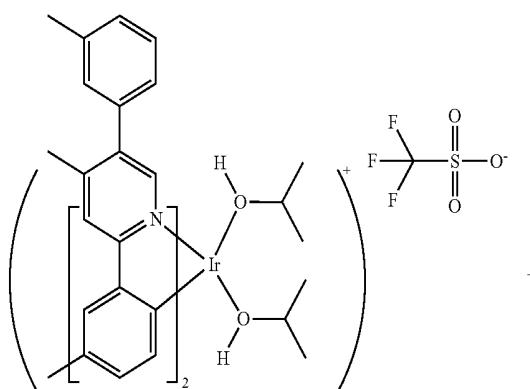
[0231] $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$ (1.8 g, 4.86 mmol) and 2,5-ditolyl-4-methylpyridine (4.0 g, 14.6 mmol) was placed in a 100 mL round bottomed flask. 24 mL of 2-ethoxyethanol and 8 mL of water were added. The mixture was refluxed under nitrogen atmosphere for 16 h. The reaction mixture was then allowed to cool to room temperature. The precipitate was filtered and washed with methanol followed by hexanes. After drying, 3.0 g of the iridium dimer was obtained (79.6% yield).



Synthesis of Ir Triflate

[0232] 3.0 g of the iridium dimer was dissolved in 380 mL of dichloromethane. Silver triflate (1.0 g, 4.08 mmol) was dissolved in 20 mL of isopropanol and added to the iridium dimer solution. The resulting mixture was stirred for 5 h. The solution was then poured through a celite plug to remove silver chloride. The solvent was evaporated under vacuum to give 2.7 g of the iridium triflate. The solid was used for next step without further purification.

Compound 24

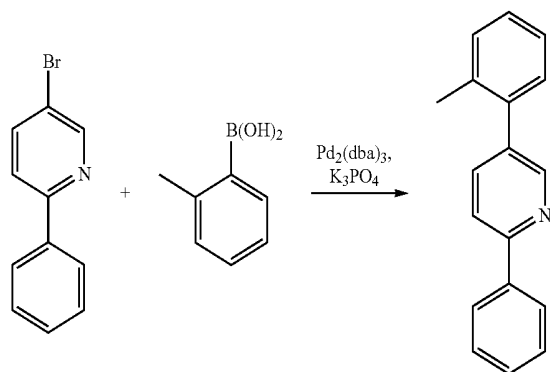


Synthesis of Compound 24

[0233] The iridium triflate (2.7 g, 2.95 mmol) and (3.6 g, 112 mmol) of 2,5-ditolyl-4-methylpyridine was placed in a 250 mL round bottom flask. 100 mL of ethanol was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2x50 mL), followed by hexanes (2x50 mL). The product was then eluted through the silica plug with dichloromethane. Most of the dichloromethane was removed under vacuum and the product was precipitated with 2-propanol and filtered, washed with hexanes and dried to give 2.4 g of product (80.6% yield).

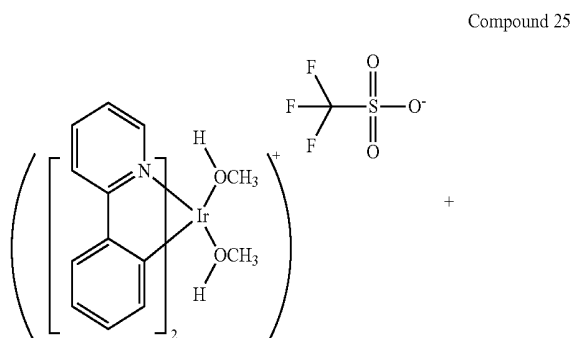
Example 21. Synthesis of Compound 25

[0234]

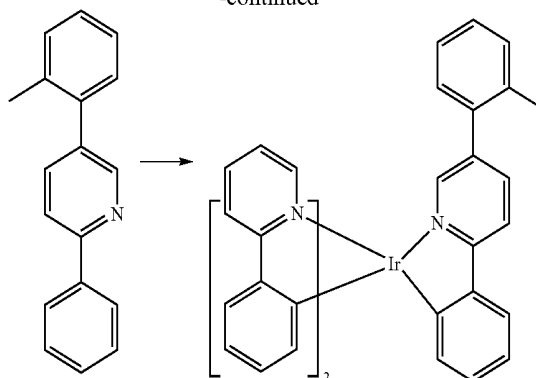


Synthesis of 2-phenyl-5-(m-tolyl)pyridine

[0235] 2-methylphenyl boronic acid (5.1 g, 37.59 mmol), 2-phenyl-5-bromopyridine (8.0 g, 34.17 mmol), 1,1'-bis(dicyclohexylphosphino)-2,2'-bis(dimethoxy)biphenyl (561 mg, 1.366 mmol), and potassium phosphate tribasic (23.50 g, 102.51 mmol), 250 mL of toluene and 25 mL of water were placed in a 1 L round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min after which tris(dibenzylideneacetone)dipalladium(0) (312 mg, 0.341 mmol) was added. Nitrogen was then bubbled for another 15 minutes and the reaction mixture was heated to reflux for 16 h under nitrogen. The mixture was cooled and the organic layer was separated from the aqueous layer. The organic layer was washed with saturated brine solution, dried over magnesium sulfate, filtered, and the solvent removed under vacuum to give an off-white solid as the crude. The crude was purified by column chromatography using silica gel as the stationary phase and 2% ethyl acetate in hexanes as the mobile phase. 6.5 g of desired product was obtained after purification (78% yield).



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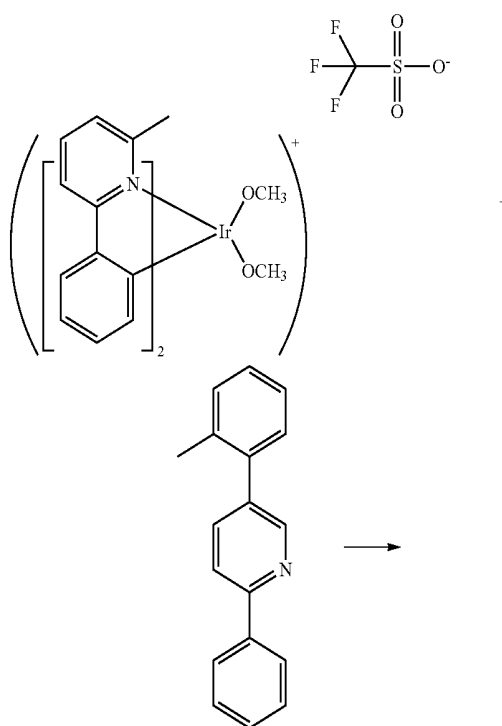


Synthesis of Compound 25

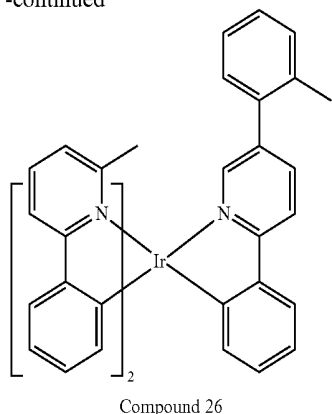
[0236] The iridium triflate (from the synthesis of compound 1) (3.25 g) and 2-phenyl-5-tolylpyridine (3.2 g) were placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (100 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 0.53 g of desired product was obtained after purification (15.6% yield).

Example 22. Synthesis of Compound 26

[0237]



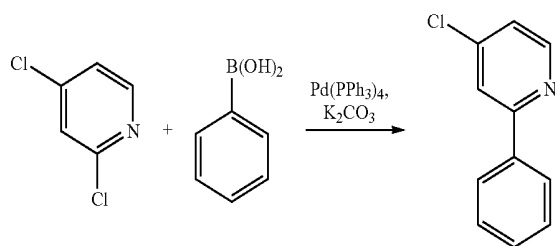
-continued



Synthesis of Compound 26

[0238] The iridium triflate (3.25 g) and 2-phenyl-5-tolylpyridine (3.2 g) were placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (100 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as the desired compound. The compound was further purified by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 3.38 g of desired product was obtained after purification (100% yield).

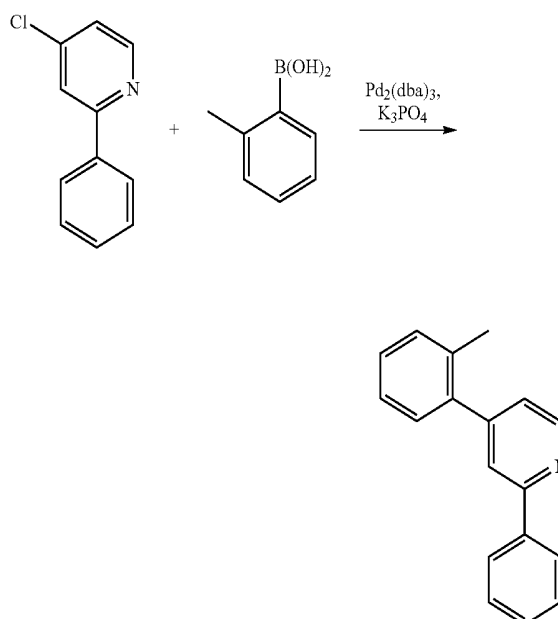
Example 23. Synthesis of Compound 27

[0239]

Synthesis of 2-phenyl-4-chloropyridine

[0240] 2,4-dichloropyridine (10 g, 67.57 mmol), phenylboronic acid (9.0 g, 74.32 mmol), and potassium carbonate (28 g, 202.70 mmol), 300 mL dimethoxyethane and 30 mL of water was placed in a 1 L round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min. Tetrakis(triphenylphosphine)palladium(0) (780 mg, 0.675 mmol) was added and nitrogen was bubbled into the reaction mixture for another 15 min. The reaction mixture was then heated to reflux under nitrogen for 16 h. The reaction was

then allowed to cool to room temperature and diluted with ethyl acetate and water. The organic and aqueous layers were separated and the aqueous layer was extracted with ethyl acetate. The organic layers were combined and washed with a saturated brine solution. The organic layer was then dried over magnesium sulfate, filtered, and the solvent was removed under vacuum to give an off-white solid as crude. The crude was purified by column chromatography using silica gel as the stationary phase and 2% ethyl acetate in hexanes as the mobile phase. 8.0 g of desired product was obtained after purification (54% yield). 11.5 g of desired product was obtained after purification (89.77% yield).

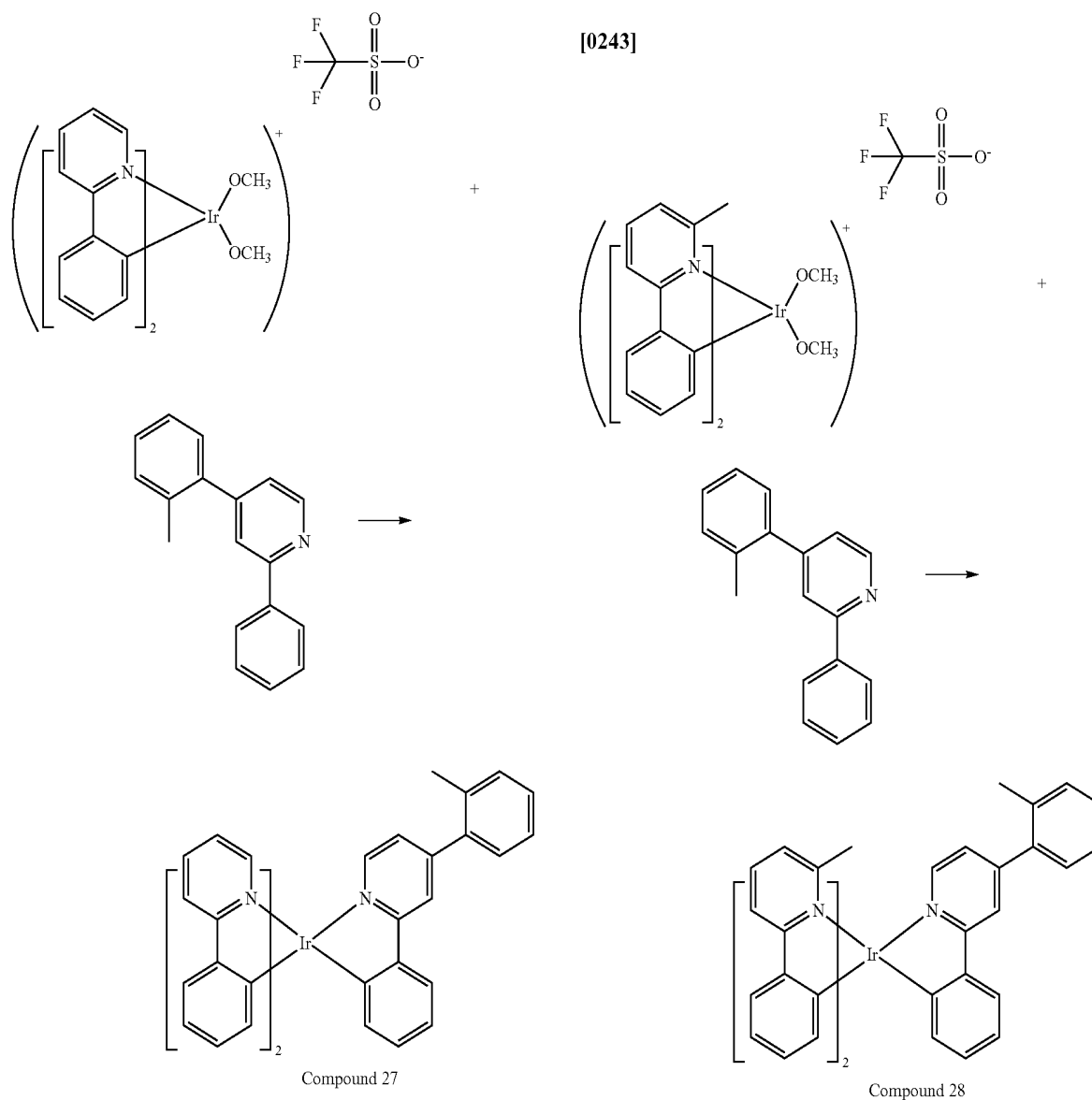


Synthesis of 2-phenyl-4-(m-tolyl)pyridine

[0241] 2-methylphenyl boronic acid (6.3 g, 46.40 mmol), 2-phenyl-4-chloropyridine (8.0 g, 42.18 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (692 mg, 1.68 mmol), and potassium phosphate tribasic (29.10 g, 126.54 mmol) 250 mL of toluene and 25 mL of water were placed in a 500 mL round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min after which tris(dibenzylideneacetone)dipalladium(0) (386 mg, 0.421 mmol) was added. Nitrogen was then bubbled for another 15 minutes then the reaction mixture was heated to reflux for 16 h under nitrogen. The mixture was cooled and the organic layer was separated from the aqueous layer. The organic layer was washed with a saturated brine solution, dried over magnesium sulfate, filtered, and the solvent removed under vacuum to give an off-white solid as the crude. The crude was purified by column chromatography using silica gel as the stationary phase and 2% ethyl acetate in hexanes as the mobile phase. 8.0 g of desired product was obtained after purification (77.4% yield).

Example 24. Synthesis of Compound 28

[0243]



Synthesis of Compound 27

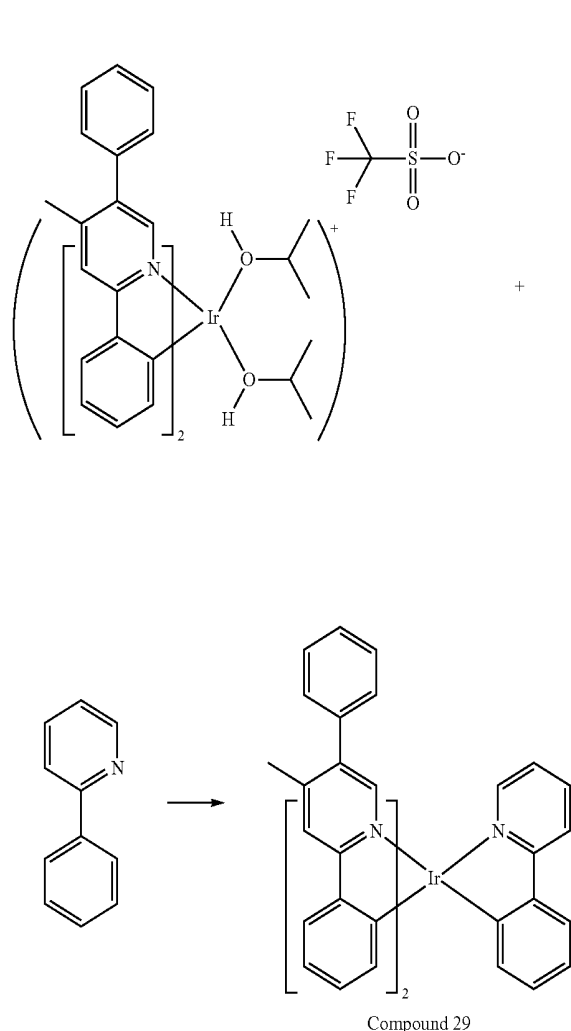
[0242] The iridium triflate (4.0 g) and 2-phenyl-4-o-tolylpyridine (4.0 g) were placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (100 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 2.0 g of desired product was obtained after purification (48% yield).

Synthesis of Compound 28

[0244] The iridium triflate (4.0 g) and 2-phenyl-4-o-tolylpyridine (4.0 g) was placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (100 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as the desired compound. The compound was further purified by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 3.6 g of desired product was obtained after purification (86.6% yield).

Example 25. Synthesis of Compound 29

[0245]

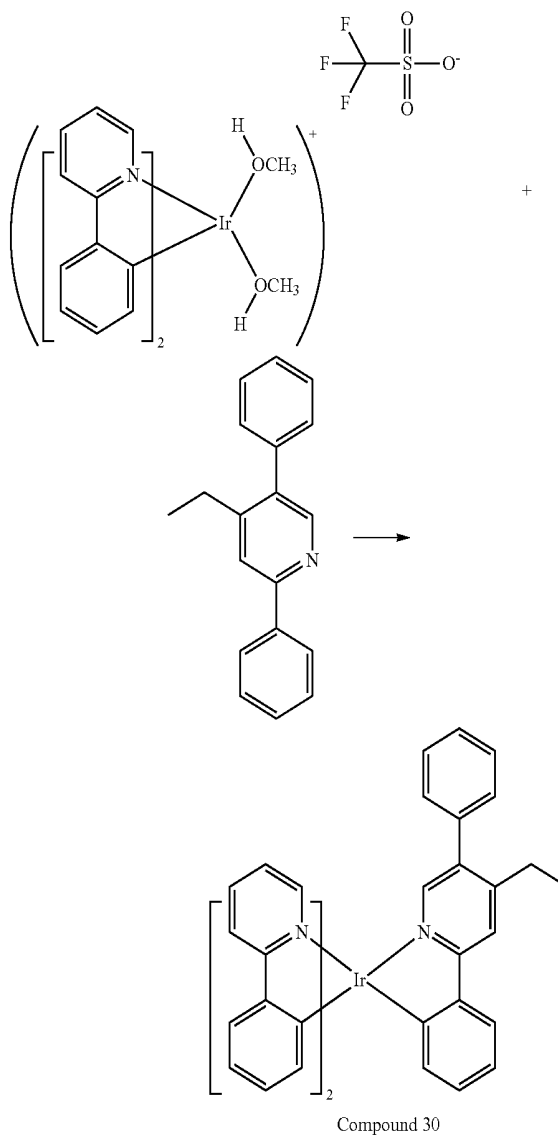


Synthesis of Compound 29

[0246] The iridium triflate (4.0 g, 4.62 mmol) and (2.15 g, 13.87 mmol) of 2-phenylpyridine were placed in a 100 mL round-bottom flask. A 50:50 mixture of methanol and ethanol (60 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×50 mL), followed by hexanes (2×50 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 1.1 g of desired product was obtained after purification (31.6% yield).

Example 26. Synthesis of Compound 30

[0247]

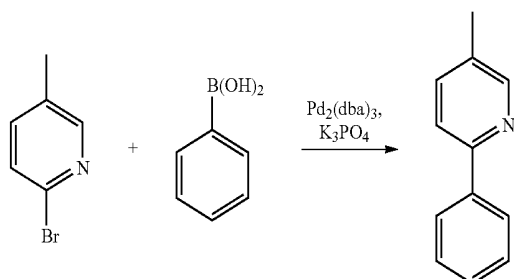


Synthesis of Compound 30

[0248] The iridium triflate (3.2 g) and 2,5-diphenyl-4-ethylpyridine (3.2 g) was placed in a 250 mL round bottom flask. 50 mL of ethanol was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×50 mL), followed by hexanes (2×50 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 1.22 g of desired product was obtained after purification (31.6% yield).

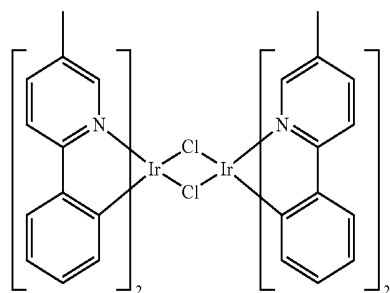
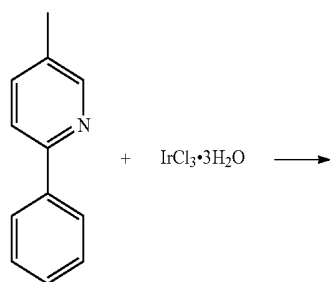
Example 27. Synthesis of Compound 31

[0249]



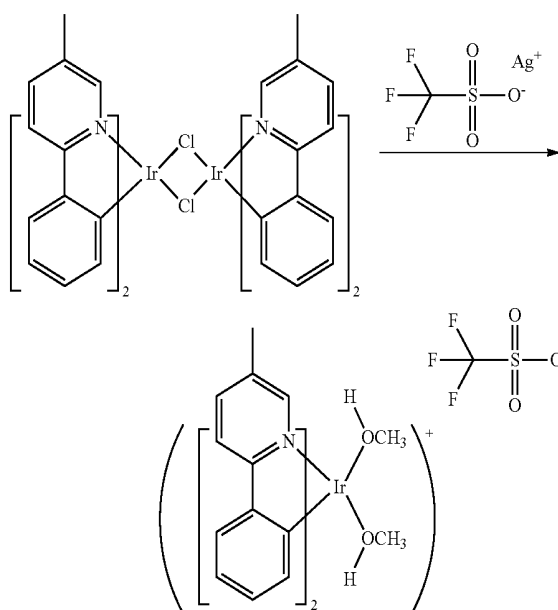
Synthesis of 2-phenyl-5-methylpyridine

[0250] 2-bromo-5-methylpyridine (11.25 g, 65.39 mmol), phenylboronic acid (9.5 g, 78.47 mmol), 2-dicyclohexylphosphino-2', 6'-dimethoxybiphenyl (1.0 g, 2.61 mmol), and potassium phosphate tribasic (45 g, 196.17 mmol), 250 mL of toluene and 25 mL of water were placed in a 500 mL round-bottom flask. Nitrogen was bubbled directly into the mixture for 30 min after which tris(dibenzylideneacetone) dipalladium(0) (598 mg, 0.653 mmol) was added. Nitrogen was bubbled for another 15 min then the reaction mixture was heated to reflux for 16 h under nitrogen. The mixture was cooled and the organic layer was separated from the aqueous layer. The organic layers are washed with saturated brine solution, dried over magnesium sulfate, filtered, and the solvent removed under vacuum to give an off-white solid as the crude. The crude was purified by column chromatography using silica gel as the stationary phase and 5%-10% ethyl acetate in hexanes as the mobile phase. 10.11 g of desired product was obtained after purification (92% yield).



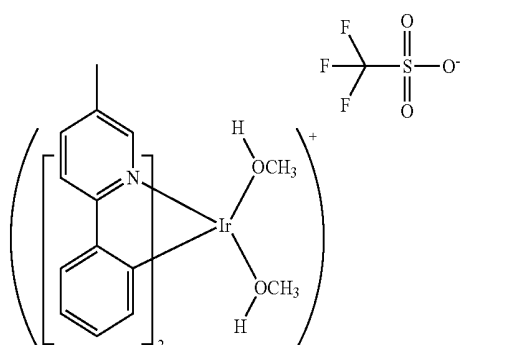
Synthesis of Ir Dimer

[0251] 2-phenyl-5-methylpyridine (10.11 g, 59.8 mmol) and $\text{IrCl}_3 \cdot 3\text{H}_2\text{O}$ (6.0 g, 17 mmol) were dissolved in 90 mL of 2-ethoxyethanol and 30 mL of water in a 250 mL round-bottom flask. The reaction mixture was refluxed under nitrogen for 16 h. The reaction mixture was then allowed to cool to room temperature and the precipitate was filtered and washed with methanol followed by hexanes. The iridium dimer was then dried under vacuum and used for the next step without further purification. 8.75 g of the dimer was obtained after vacuum drying (91.0% yield).

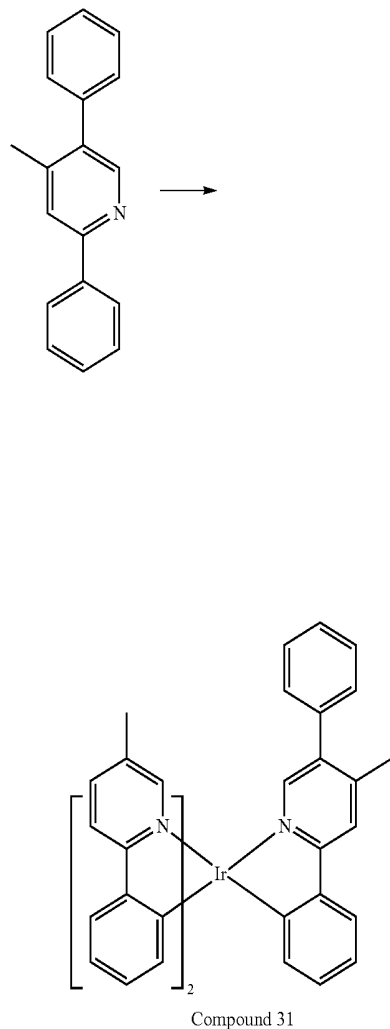


Synthesis of Ir Triflate

[0252] The iridium dimer (8.74 g, 7.75 mmol) was dissolved in 1.0 L of dichloromethane. Silver triflate (4.18 g, 16.27 mmol) was dissolved in 500 mL of methanol and added to the iridium dimer solution. The resulting mixture was stirred for 18 h. The solution was then passed through a celite plug to remove silver chloride and the solvent was evaporated to give 4.0 g of iridium triflate. The solid was used for next step without further purification.



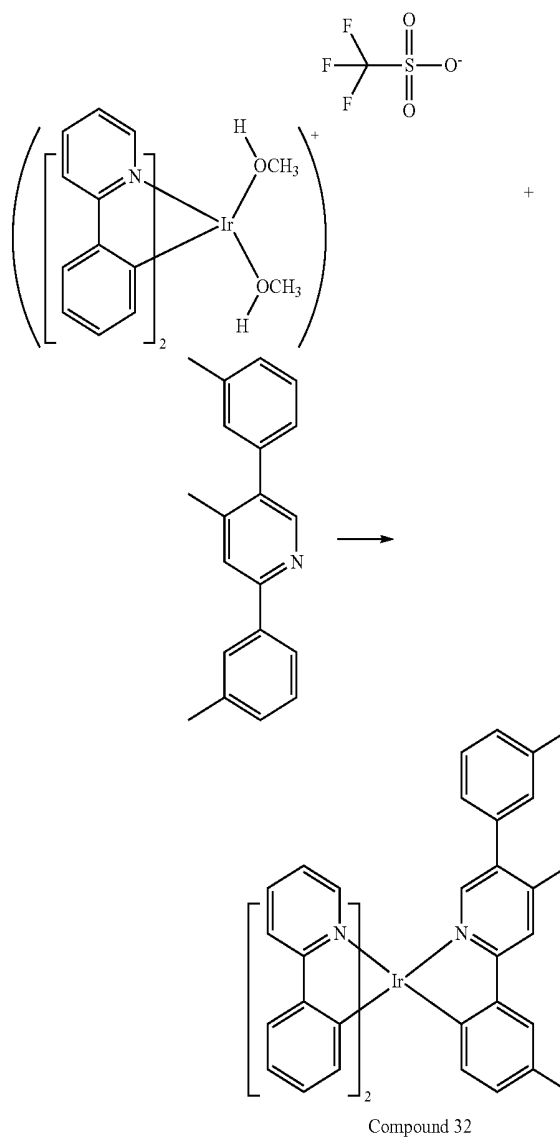
-continued



Synthesis of Compound 31

[0253] The iridium triflate (4.0 g) and 2,5-diphenyl-4-methylpyridine (4.0 g) were placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (80 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 3.75 g of desired product was obtained after purification (90% yield).

Example 28. Synthesis of Compound 32

[0254]

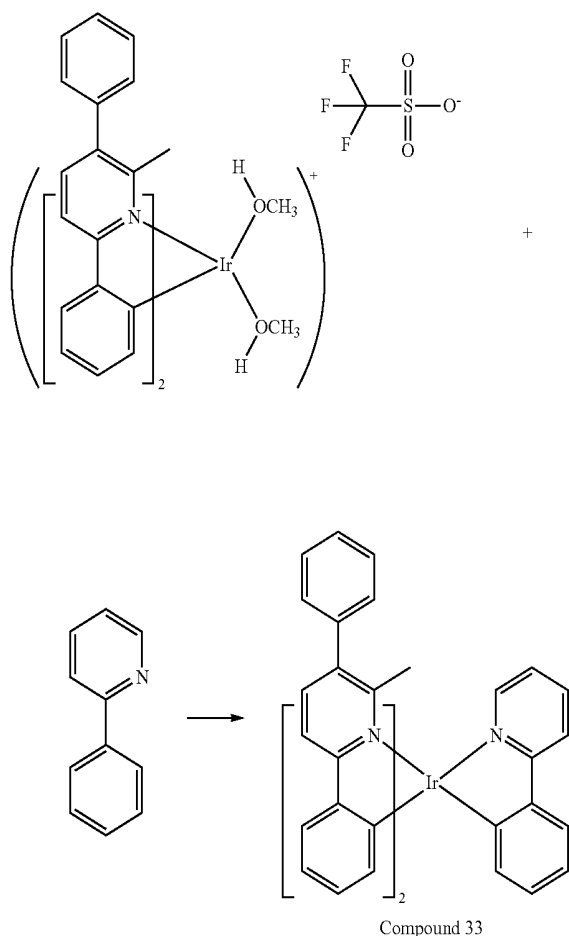
Synthesis of Compound 32

[0255] The iridium triflate (2.6 g, 3.66 mmol) and 2,5-ditolyl-4-methylpyridine (3.0 g, 11 mmol) were placed in a 100 mL round bottom flask. A 50:50 mixture of methanol and ethanol (50 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1

dichloromethane/hexanes as the mobile phase. 0.9 g of desired product was obtained after purification (31.8% yield).

Example 29. Synthesis of Compound 33

[0256]

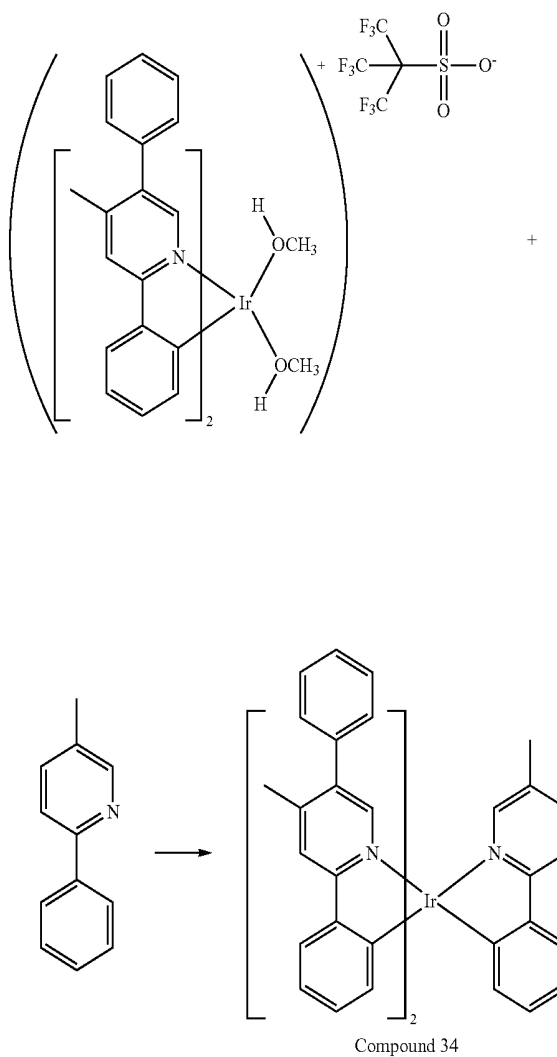


Synthesis of Compound 33

[0257] The iridium triflate (2.8 g) and 2-phenylpyridine (2.8 g) were placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (80 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as the desired compound. The compound was further purified by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 2.3 g of desired product was obtained after purification (73.2% yield).

Example 30. Synthesis of Compound 34

[0258]

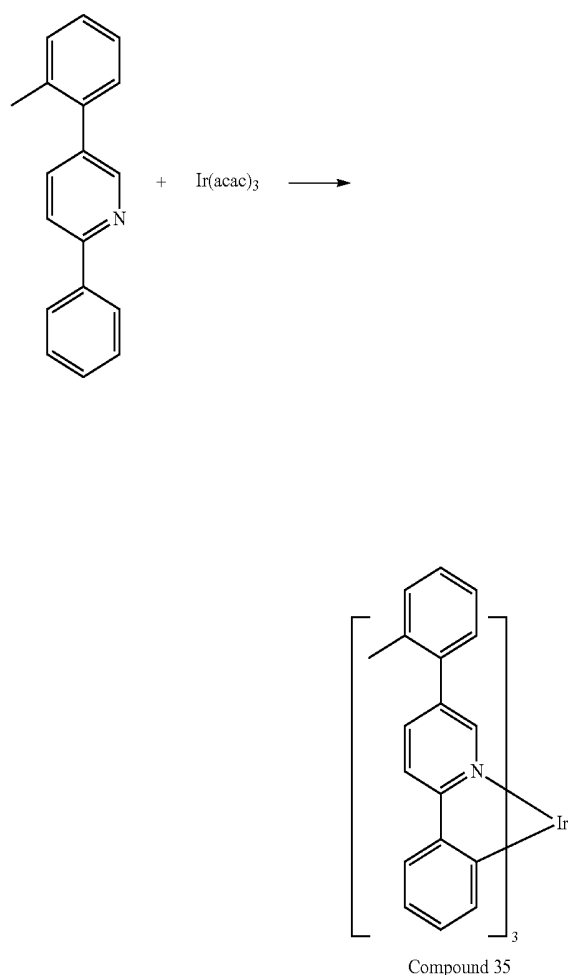


Synthesis of Compound 34

[0259] The iridium triflate (3.5 g) and 2-phenyl-5-methylpyridine (3.5 g) were placed in a 250 mL round bottom flask. A 50:50 mixture of methanol and ethanol (80 mL) was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×100 mL), followed by hexanes (2×100 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the crude product as a mixture of compounds. The desired compound was separated and isolated by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 1.25 g of desired product was obtained after purification (31.4% yield).

Example 31. Synthesis of Compound 35

[0260]

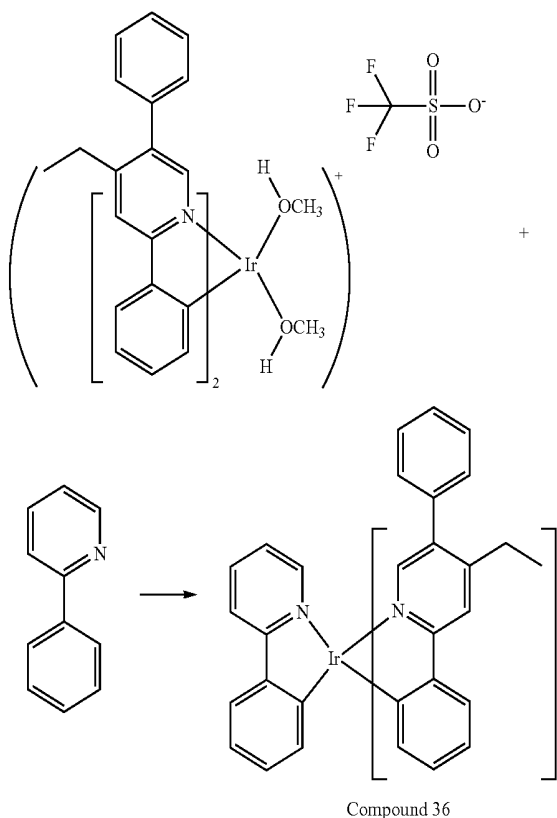


Synthesis of Compound 35

[0261] 2-phenyl-5-o-tolylpyridine (8.8 g, 35.9 mmol, 6 eq) and Iridium tris acetylacetonate (2.93 g, 5.98 mmol, 1 eq) were placed in a 50 mL round-bottom flask. The flask was purged with nitrogen for 0.5 h. The reaction mixture was then heated to 230° C. in a sand bath for 48 h. The reaction mixture was allowed to cool to room temperature and 100 mL of dichloromethane was added. The mixture was filtered through a silica gel plug. The solvent was removed under vacuum to give the crude product. The crude was purified by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 0.4 g of desired product was obtained after purification (7.2% yield).

Example 32. Synthesis of Compound 36

[0262]

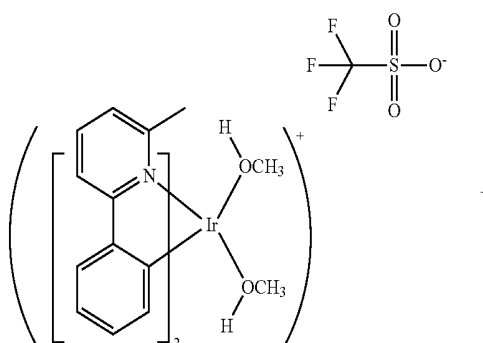


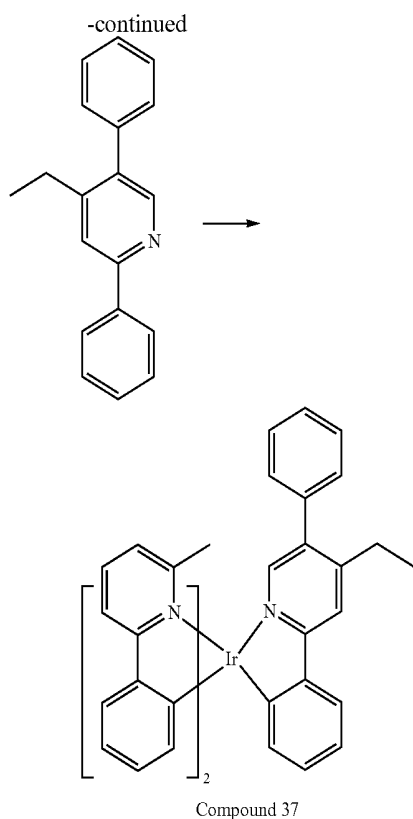
Synthesis of Compound 36

[0263] The iridium triflate and 3 molar equivalent of 2-phenylpyridine can be dissolved in a 50:50 mixture of methanol and ethanol and the mixture refluxed for 16 h. The mixture can be purified using a method similar to that described in Example 30.

Example 33. Synthesis of Compound 37

[0264]





Synthesis of Compound 37

[0265] The iridium triflate (2.45 g) and 2,5-diphenyl-4-ethylpyridine (2.58 g) was placed in a 250 mL round bottom flask. 50 mL of ethanol was added and the mixture was refluxed for 16 h. Celite was added to the cooled solution and the mixture was poured onto a 2 inch bed of silica gel. The silica bed was then washed twice with ethanol (2×50 mL), followed by hexanes (2×50 mL). The product was then eluted through the silica plug with dichloromethane. The dichloromethane was removed under vacuum to give the desired compound. The compound was further purified by column chromatography using silica gel as the stationary phase and 1:1 dichloromethane/hexanes as the mobile phase. 1.25 g of desired product was obtained after purification (48% yield).

DEVICE EXAMPLES

[0266] All device examples were fabricated by high vacuum ($<10^{-7}$ Torr) thermal evaporation. The anode electrode is 1200 Å of indium tin oxide (ITO). The cathode consisted of 10 Å of LiF followed by 1000 Å of Al. All devices were encapsulated with a glass lid sealed with an epoxy resin in a nitrogen glove box (<1 ppm of H_2O and O_2)

immediately after fabrication, and a moisture getter was incorporated inside the package.

[0267] The organic stack of the Device Examples 1 and 2 in Table 2, consisted of sequentially, from the ITO surface, 100 Å of E1 as the hole injection layer (HIL), 300 Å of 4,4'-bis[N-(1-naphthyl)-N-phenylamino]biphenyl (α -NPD) as the hole transporting later (HTL), 300 Å of H1 doped with 7% or 10% of Compound 1 as the emissive layer (EML), 50 Å of H1 as the blocking layer, and 400 Å of Alq_3 (tris-8-hydroxyquinoline aluminum) as the ETL. The device structure of the Device Examples is also summarized in FIG. 3.

[0268] Comparative Examples 1 and 2 were fabricated similarly to the Device Examples, except that E1 was used as the emissive dopant.

[0269] The device structures and data are summarized in Table 2 and Table 3. Table 2 shows device structure, and Table 3 shows the corresponding measured results for those devices. As used herein, E1, H1 and NPD, have the following structures:

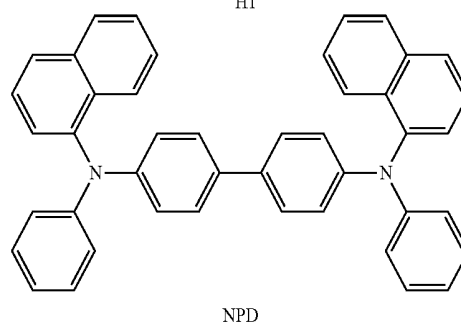
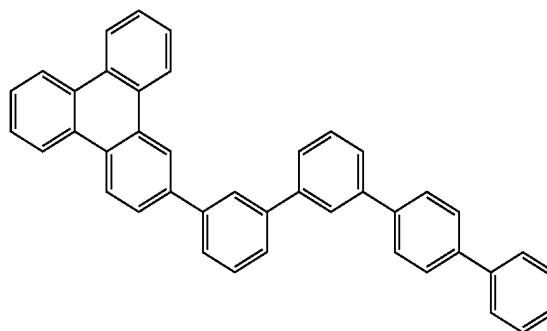
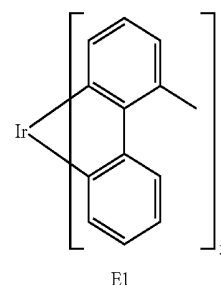


TABLE 2

Device Example	HIL	HTL	Host	Dopant %	BL	ETL
1	E1 100 Å	NPD 300 Å	H1	Compound 1 7%	H1 50 Å	Alq_3 450 Å
Comparative Example 1	E1 100 Å	NPD 300 Å	H1	E1 7%	H1 50 Å	Alq_3 450 Å

TABLE 2-continued

Device Example	HIL	HTL	Host	Dopant %	BL	ETL
2	E1 100 Å	NPD 300 Å	H1	Compound 1 10%	H1 50 Å	Alq ₃ 450 Å
Comparative Example 2	E1 100 Å	NPD 300 Å	H1	E1 10%	H1 50 Å	Alq ₃ 450 Å

TABLE 3

Ex.	λ_{max} (nm)	CIE		V (V)	LE (cd/A)	EQE (%)	PE (lm/W)	At J = 40 mA/cm ²		
		X	Y					Lo (cd/m ²)	RT _{80%} (hr)	RT _{50%} (hr)
1	558	0.440	0.546	6.2	64.4	19.2	32.6	18,504	265	900
Comp. Ex. 1	528	0.355	0.607	6	53.4	14.7	27.9	15,985	214	760
2	560	0.449	0.537	6	59.5	18.2	31.1	19,320	400	1400
Comp. Ex. 2	529	0.357	0.607	5.9	53.2	14.6	28.3	16,781	340	1130

[0270] From the Device Examples in Table 3, it can be seen that devices containing the inventive compound may have particularly good properties. Specifically, devices having an emissive layer containing Compound 1 as the emissive dopant. These devices demonstrate that Compound 1 may be beneficial to device stability. In particular, Comparative Example 1 and Device Example 1 have RT_{80%} (defined as the time taken for the initial luminance, L₀, to drop to 80% of its initial luminance) of 760 and 900 h, respectively. Comparative Example 2 and Device Example 2 have RT_{80%} of 1130 and 1400 h, respectively. These results indicate that extended conjugation of heteroleptic Ir (III) complexes may be beneficial to device stability.

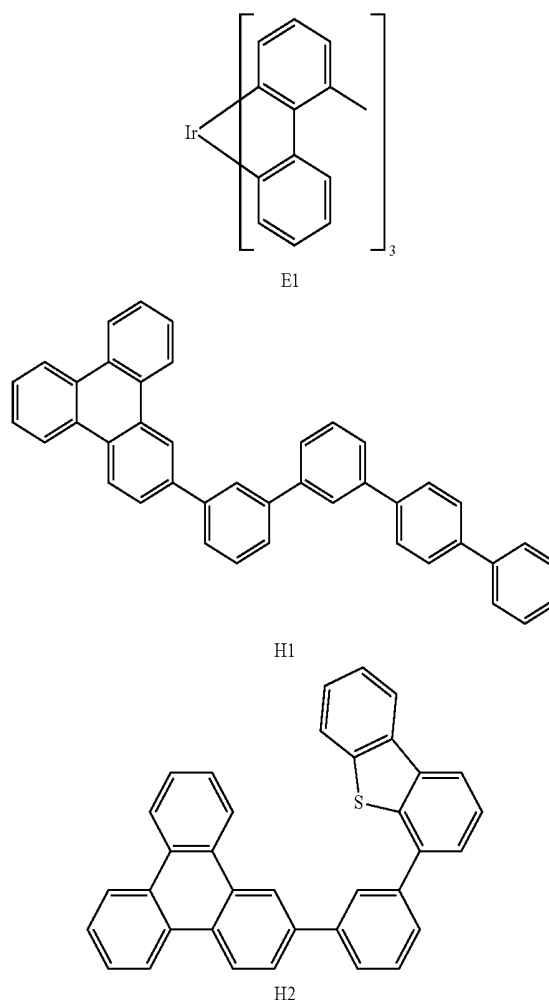
[0271] Low evaporation temperature is desirable for OLED manufacturing. Prolonged heating of the materials is required during OLED manufacturing, so materials having a low evaporation temperature have less thermal stress typically resulting in cleaner evaporations. The extended conjugation achieved by adding a phenyl to the heteroatomic ring of Compound 1 results in a low sublimation temperature. Therefore, devices with Compound 1 may have improved manufacturing.

[0272] The organic stack of the Device Examples 3-12 in Table 4, consisted of sequentially, from the ITO surface, 100 Å of E1 as the hole injection layer (HIL), 300 Å of 4,4'-bis[N-(1-naphthyl)-N-phenylamino]biphenyl (α -NPD) as the hole transporting later (HTL), 300 Å of H1 or H2 doped with 7%, 10% or 15% of an invention compound as the emissive layer (EML), 50 Å of H1 or H2 as the blocking layer, and 400 Å of Alq₃ (tris-8-hydroxyquinoline aluminum) as the ETL. The device structure of the Device Examples is also summarized in FIG. 3.

[0273] Comparative Example 3 was fabricated similarly to the Device Examples, except that E1 was used as the emissive dopant.

[0274] The device structures and data are summarized in Table 4 and Table 5. Table 4 shows device structure, and

Table 5 shows the corresponding measured results for those devices. As used herein, E1, H1, H2 and NPD, have the following structures:



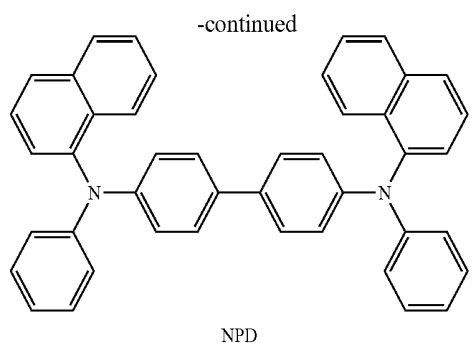


TABLE 4

Device Example	HIL	HTL	Host	Dopant %	BL	ETL
Example 1	E1 100 Å	NPD 300 Å	H1	Compound 1 7%	H1 50 Å	Alq ₃ 450 Å
Example 2	E1 100 Å	NPD 300 Å	H1	Compound 1 10%	H1 50 Å	Alq ₃ 450 Å
Example 3	E1 100 Å	NPD 300 Å	H2	Compound 2 7%	H2 100 Å	Alq ₃ 400 Å
Example 4	E1 100 Å	NPD 300 Å	H2	Compound 2 10%	H2 100 Å	Alq ₃ 400 Å
Example 5	E1 100 Å	NPD 300 Å	H2	Compound 8 7%	H2 100 Å	Alq ₃ 400 Å
Example 6	E1 100 Å	NPD 300 Å	H2	Compound 8 10%	H2 100 Å	Alq ₃ 400 Å
Example 7	E1 100 Å	NPD 300 Å	H2	Compound 9 7%	H2 100 Å	Alq ₃ 400 Å
Example 8	E1 100 Å	NPD 300 Å	H2	Compound 9 10%	H2 100 Å	Alq ₃ 400 Å
Example 9	E1 100 Å	NPD 300 Å	H2	Compound 10 7%	H2 100 Å	Alq ₃ 400 Å
Example 10	E1 100 Å	NPD 300 Å	H2	Compound 10 10%	H2 100 Å	Alq ₃ 400 Å
Example 11	E1 100 Å	NPD 300 Å	H2	Compound 11 7%	H2 100 Å	Alq ₃ 400 Å
Example 12	E1 100 Å	NPD 300 Å	H2	Compound 11 10%	H2 100 Å	Alq ₃ 400 Å
Example 13	E1 100 Å	NPD 300 Å	H2	Compound 12 7%	H2 100 Å	Alq ₃ 400 Å
Example 14	E1 100 Å	NPD 300 Å	H2	Compound 12 10%	H2 100 Å	Alq ₃ 400 Å
Example 15	E1 100 Å	NPD 300 Å	H2	Compound 12 15%	H2 100 Å	Alq ₃ 400 Å
Comparative Example 1	E1 100 Å	NPD 300 Å	H1	E1 7%	H1 50 Å	Alq ₃ 450 Å
Comparative Example 2	E1 100 Å	NPD 300 Å	H1	E1 10%	H1 50 Å	Alq ₃ 450 Å
Comparative example 3	E1 100 Å	NPD 300 Å	H2	E1 7%	H2 100 Å	Alq ₃ 400 Å

TABLE 5

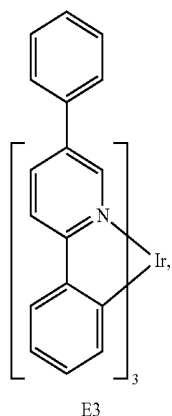
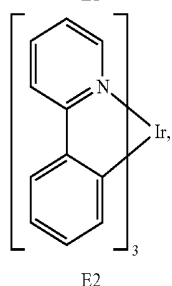
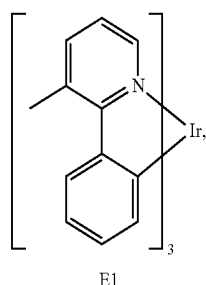
Ex.	CIE			At 1000 cd/m ²				At J = 40 mA/cm ²		
	λ max, nm	X	Y	V (V)	LE (cd/A)	EQE (%)	PE (lm/W)	Lo, (cd/m ²)	RT _{80%} , (hr)	RT _{50%} , (hr)
Ex. 1	558	0.440	0.546	6.2	64.4	19.2	32.6	8,504	265	900
Ex. 2	560	0.449	0.537	6	59.5	18.2	31.1	19,320	400	1400
Ex. 3	543	0.417	0.569	6	70.5	19.6	36.9	19,818	390	
Ex. 4	545	0.426	0.562	5.3	65.5	18.4	38.8	20,393	480	
Ex. 5	536	0.383	0.594	6.4	48.8	13.3	24.1	14,056	440	
Ex. 6	537	0.388	0.590	6.4	42.4	11.6	20.9	13,158	440	
Ex. 7	532	0.367	0.602	6.3	51.4	14.1	25.6	14,637	305	
Ex. 8	533	0.37	0.602	6	42.7	11.7	22.5	13,031	340	
Ex. 9	532	0.376	0.598	5.7	59.2	16.3	32.6	16,212	225	
Ex. 10	533	0.378	0.597	5.2	58.2	16	35.1	17,151	240	
Ex. 11	541	0.411	0.575	5.5	73.7	20.3	42.2	21,430	335	
Ex. 12	545	0.420	0.568	4.9	76	21.1	48.6	24,136	480	
Ex. 13	525	0.342	0.612	5.8	56.9	15.8	30.7	15,843	208	
Ex. 14	527	0.337	0.619	5	62.9	17.2	39.5	18,952	330	
Ex. 15	528	0.349	0.611	5	55.7	15.3	34.8	17,941	320	
Comp. Ex. 1	528	0.355	0.607	6	53.4	14.7	27.9	15,985	214	760
Comp. Ex. 2	529	0.357	0.607	5.9	53.2	14.6	28.3	16,781	340	1130
Comp. Ex. 3	528	0.361	0.601	6.5	52.1	14.6	25.2	14,768	250	

[0275] From the Device Examples in Table 4, it can be seen that devices containing the inventive compound may have particularly good properties. Specifically, devices having an emissive layer containing Compound 1, Compound 2, Compound 8-12 as the emissive dopant demonstrate that these inventive compounds may be beneficial to device stability.

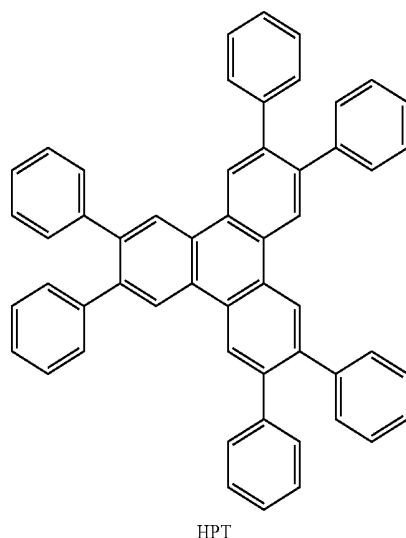
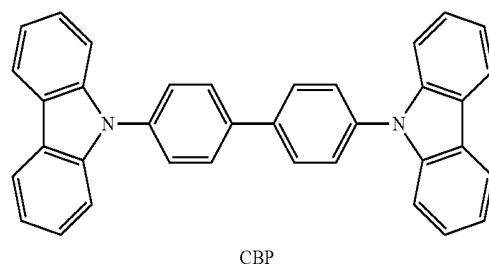
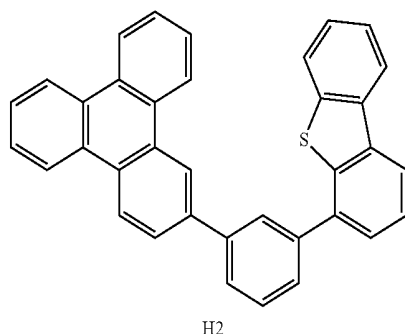
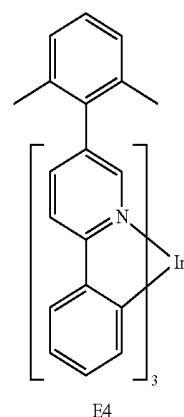
[0276] Particular devices are provided wherein inventive compounds, Compound 21 through Compound 35, are the emitting dopant and H-2 is the host. The organic stack of the Device Examples 21-35 consisted of sequentially, from the ITO surface, 100 Å of E1 as the hole injection layer (HIL), 300 Å of 4,4'-bis[N-(1-naphthyl)-N-phenylamino]biphenyl (α -NPD) as the hole transporting layer (HTL), 300 Å of 112 doped with 7% of Compound 21-35 and 37 as the emissive layer (EML), 100 Å of H2 as the electron transporting layer (ETL2), and 400 Å of Alq₃ (tris-8-hydroxyquinoline aluminum) as the electron transporting layer (ETL1).

[0277] Comparative Device Examples 4-6 were fabricated similarly to the Device Examples, except E2 was used as the emitting dopant in Comparative Device Example 4; CBP was as the host, E3 was used as the emitting dopant, and 50 Å of HPT was used as the ETL2 and 450 Å of Alq₃ was used as the ETL1 in Comparative Device Example 5; in E4 was used as the emitting dopant in Comparative Device Example 6.

[0278] As used herein, the following compounds have the following structures:



-continued



[0279] Particular materials for use in an OLED are provided. The materials may be used as an emitting dopant in the emissive layer of such a device. The materials provided herein may be used to provide devices having high efficiency and a narrow electroluminescence. In addition, these mate-

rials may provided improved stability and improved processibility, such as high solubility and low evaporation temperature.

TABLE 6

Device Example	Compound	Evaporation temperature (° C.)
Example 16	21	239
Example 17	22	232
Example 18	23	250
Example 19	25	216
Example 20	26	202
Example 21	27	205
Example 22	28	208
Example 23	29	204
Example 24	30	203
Example 25	31	213
Example 26	32	209
Example 27	34	236
Example 28	35	216
Example 29	37	202
Comparative example 4	E2	230
Comparative example 5	E3	270
Comparative example 6	E4	204

TABLE 7

Device Example	CIE			
	λ_{max} (nm)	FWHM (nm)	x	y
Example 16	526	68	0.337	0.623
Example 17	528	64	0.342	0.622
Example 18	520	66	0.324	0.622
Example 27	532	68	0.368	0.607
Comparative example 4	519	74	0.321	0.621
Comparative example 5	548	70	0.43	0.56
Comparative example 6	520	74	0.320	0.632

[0281] Table 7 shows additional device data for Device Examples and Comparative Examples. In particular, Table 7 provides λ_{max} and CIE coordinates for Device Examples 16-18 and 27 compared to the Comparative Device Examples 4, 5 and 6. From the data, it can be seen that Device Examples 16-18 and 27 are significantly blue shifted from Comparative Device Example 5. This result suggests that the conjugation may be reduced by the presence of the twisted phenyl C-ring.

TABLE 8

Ex.	CIE				At 1000 cd/m ²				At J = 40 mA/cm ²		
	λ_{max}	FWHM (nm)	x	y	V (V)	LE (cd/A)	EQE (%)	PE (lm/W)	LE EQE	L ₀ (cd/m ²)	RT _{80%} (h)
16	526	68	0.337	0.623	6.9	49.3	13.3	22.4	3.7	16,895	210
17	528	64	0.342	0.622	6.0	55.1	14.8	28.7	3.7	18,175	260
18	520	66	0.324	0.622	6.9	43.7	12.0	19.9	3.6	16,240	54
19	532	72	0.372	0.599	5.4	65.6	17.8	38.0	3.7	18,482	245
20	532	70	0.36	0.608	5.6	69	18.6	39	3.7	19,934	142
21	538	82	0.371	0.594	5.8	59.8	16.6	32.2	3.6	17,658	174
22	532	74	0.346	0.613	7.1	59.7	16.2	26.5	3.7	14,187	90
23	528	70	0.345	0.616	5.4	62.5	17	36.5	3.7	19,280	237
24	522	70	0.327	0.623	5.4	63.3	17.3	36.7	3.7	18,212	223
25	528	70	0.342	0.618	5.2	66.6	18.1	40.5	3.7	19,280	254
26	532	74	0.369	0.600	5.9	59.7	16.3	31.6	3.7	16,240	42
27	532	72	0.361	0.608	4.9	59.6	16.0	43.2	3.7	20,057	290
28	532	68	0.368	0.607	5.2	67.6	18	40.6	3.8	20,324	200
29	522	72	0.333	0.619	5.6	62.7	17.2	35.0	3.6	17,205	121
Comp. 4	519	74	0.321	0.621	6	45.1	12.6	23.6	3.6	13,835	196
Comp. 6	520	74	0.320	0.632	5.5	54.9	14.9	31.2	3.7	17,153	42

[0280] Table 6 shows the evaporation temperature of the emitting compounds, Compounds 21-33, used in the Device Examples compared to the evaporation temperatures of the emitting compounds E2 and E3 used in Comparative Device Examples 4 and 5, respectively. In particular, Compounds 21-24 have significantly lower evaporation temperatures than E3. A lower evaporation temperature may be a desirable property for the thermal evaporation and long term thermal stability of dopants. It is believed that the C-ring phenylpyridine in Compounds 21-23 has more twist between the two rings than the phenyl-pyridine twist, as is present in E3. The heteroleptic compounds (Compounds 25-33 and 37) which contain the twisted C-ring feature have similar or lower evaporation temperatures than E2 which does not have a C-ring at all. The result indicates that the twisted C-ring feature may lower evaporation temperature while keeping the molecular weight as high or even higher than the structurally similar compounds without this feature.

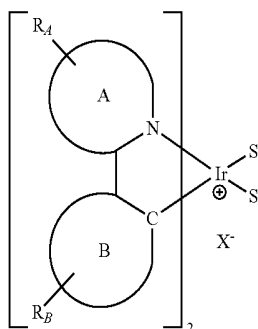
[0282] Table 8 provides a comparison of device properties between Device Examples 16-29 and Comparative Examples 4 and 6. From the data, it can be seen that Device Examples 16 (Compound 21), 17 (Compound 22), 19 (Compound 25), 20 (Compound 26), 21 (Compound 27), 23 (Compound 29), 24 (Compound 30), 25 (Compound 31), 27 (Compound 34), 28 (Compound 35), 29 (Compound 37) provide high efficiency and long device lifetime. Particularly, Device Examples 16, 17, 19, 23, 24, 25 and 27, which use Compounds 21, 22, 25, 29, 30, 31 and 34 respectively as the emitting dopant, have very good device performance. These particular devices show an RT_{80%} (defined as the time required for the initial luminance L₀ to drop to from 100% to 80% at room temperature under constant DC drive) of 210, 260, 245, 237, 223, 254 and 290 h compared to an RT_{80%} of 196 h of Comparative Device Example 4. Furthermore, Device Examples 16, 17, 19, 23, 24, 25 and 27 all operate at higher L₀ than Comparative Device Example 4.

The result indicates that the phenyl C-ring may improve the device stability by adding some conjugation to emitting dopant. However, the conjugation is limited by the presence of the twist feature, described above, which does not cause significant red-shift in emission compared to a phenyl in regular conjugation as in E-3. In addition, the EL spectra of Device Examples 16-20, 23-25 and 27-29 are all narrower than that of Comparative Example 4. Narrow emission may be an desirable factor for achieving saturated color coordinates, high LE:EQE conversion, microcavity tuning, and color filter matching in OLED technology.

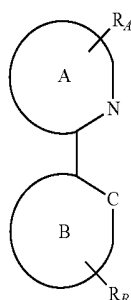
[0283] It is understood that the various embodiments described herein are by way of example only, and are not intended to limit the scope of the invention. For example, many of the materials and structures described herein may be substituted with other materials and structures without deviating from the spirit of the invention. The present invention as claimed may therefore include variations from the particular examples and preferred embodiments described herein, as will be apparent to one of skill in the art. It is understood that various theories as to why the invention works are not intended to be limiting.

We claim:

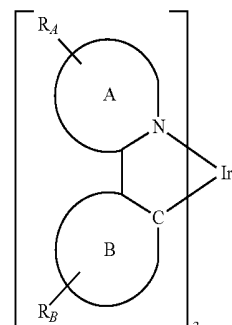
1. A method for making a homoleptic Ir(III) complex, comprising:
reacting



with



in the presence of a low boiling alcohol to form



wherein at least one of R_A and R_B is an alkyl group and the alkyl group is not adjacent to the nitrogen on the pyridine ring;

wherein S is a neutral ligand;

wherein X is a counterion;

wherein A and B are each independently a 5 or 6-membered carbocyclic or heterocyclic ring;

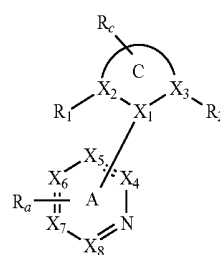
wherein A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B;

wherein each of R_A and R_B may represent mono, di, tri, or tetra substitutions; and

wherein R_A and R_B are each independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.

2. The method of claim 1, wherein the low boiling alcohol is selected from the group consisting of methanol, ethanol, n-propanol, isopropanol, n-butanol, 1:1 ratio of ethanol and methanol, 2-methoxyethanol, and 2-ethoxyethanol.

3. The method of claim 1, wherein A is



wherein C is a 5 or 6-membered carbocyclic or heterocyclic ring;

wherein A-C represents a bonded pair of carbocyclic and heterocyclic rings;

wherein R_A and R_C may represent mono, di, tri, or tetra substitutions;

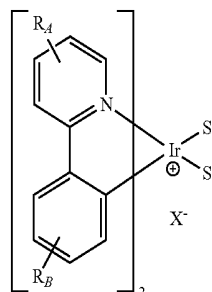
wherein R_A and R_C are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl;

wherein X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 , and X_9 are independently selected from carbon and nitrogen;

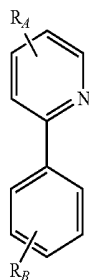
wherein R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl; and

wherein at least one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen.

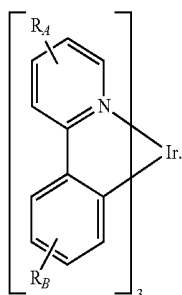
4. The method of claim 1, wherein X is triflate.
 5. The method of claim 1, comprising:
 reacting



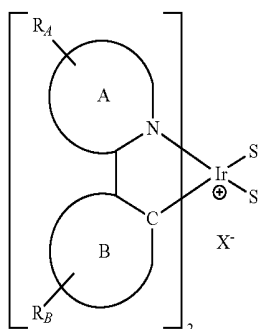
with



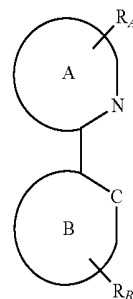
in the presence of a low boiling alcohol to form



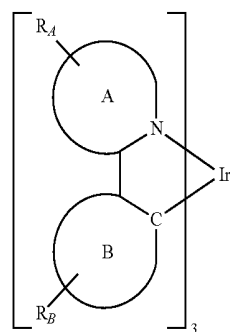
6. A method for making a homoleptic Ir(III) complex,
 comprising:
 reacting



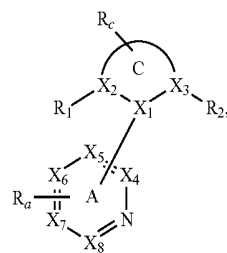
with



in the absence of solvent to form



- wherein at least one of R_A and R_B is an alkyl group and the alkyl group is adjacent to the nitrogen on the pyridine ring;
 wherein S is a neutral ligand;
 wherein X is a counterion;
 wherein A and B are each independently a 5 or 6-membered carbocyclic or heterocyclic ring;
 wherein A-B represents a bonded pair of carbocyclic or heterocyclic rings coordinated to the iridium via a nitrogen atom on ring A and an sp^2 hybridized carbon atom on ring B;
 wherein each of R_A and R_B may represent mono, di, tri, or tetra substitutions; and
 wherein R_A and R_B are each independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl.
 7. The method of claim 6, wherein A is



- wherein C is a 5 or 6-membered carbocyclic or heterocyclic ring;
 wherein A-C represents a bonded pair of carbocyclic and heterocyclic rings;

wherein R_A and R_C may represent mono, di, tri, or tetra substitutions;

wherein R_A and R_C are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl;

wherein X_1 , X_2 , X_3 , X_4 , X_5 , X_6 , X_7 , X_8 and X_9 are independently selected from carbon and nitrogen;

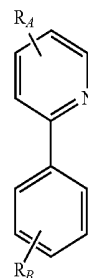
wherein R_1 and R_2 are independently selected from the group consisting of hydrogen, alkyl, alkoxy, amino, alkenyl, alkynyl, arylkyl, aryl, and heteroaryl; and

wherein at least one of R_1 , R_2 , and the R_a substituents adjacent to C is not hydrogen.

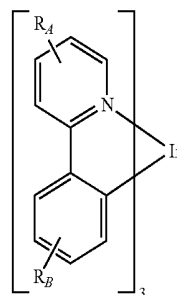
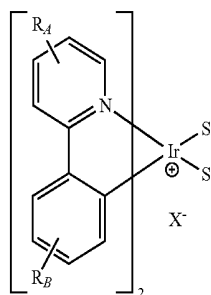
8. The method of claim 6, wherein X is triflate.

9. The method of claim 6, comprising:
reacting

with



in the absence of solvent to form



* * * * *

专利名称(译)	有机电致发光材料和器件		
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申请(专利权)人(译)	通用显示器公司		
当前申请(专利权)人(译)	通用显示器公司		
[标]发明人	XIA CHUANJUN ALLEYNE BERT KWONG RAYMOND C FIORDELISO JAMES WEAVER MICHAEL S ANSARI NASRIN DEANGELIS ALAN RAYABARAPU DINESH ADAMOVICH VADIM		
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IPC分类号	H01L51/00 C07F15/00 C09K11/06		
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其他公开文献	US10186672		
外部链接	Espacenet USPTO		

摘要(译)

提供了含有扭曲芳基的新型有机化合物的制备方法。特别地，提供的化合物含有在配体的吡啶部分上具有扭曲的芳基的2-苯基吡啶配体。这些化合物可以用于有机发光器件，特别是用作发射掺杂剂。包含含有扭曲芳基的化合物的装置可以显示出改进的颜色，效率，稳定性和制造。

