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(54) **METHOD OF FABRICATING ELECTRODE CATALYST LAYERS WITH DIRECTIONALLY ORIENTED CARBON SUPPORT FOR PROTON EXCHANGE MEMBRANE FUEL CELL**

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(57) **ABSTRACT**

A method of making a membrane electrode assembly (MEA) having an anode and a cathode and a proton conductive membrane there between. A bundle of longitudinally aligned carbon nanotubes with a catalytically active transition metal incorporated in the nanotubes forms at least one portion of the MEA and is in contact with the membrane. A combination selected from one or more of a hydrocarbon and an organometallic compound containing an catalytically active transition metal and a nitrogen containing compound and an inert gas and a reducing gas is introduced into a first reaction zone maintained at a first reaction temperature for a time sufficient to vaporize material therein. The vaporized material is transmitted to a second reaction zone maintained at a second reaction temperature for a time sufficient to grow longitudinally aligned carbon nanotubes with a catalytically active transition metal incorporated throughout the nanotubes. The nanotubes are in contact with a portion of the MEA at production or being positioned in contact thereafter. Methods of forming a PEMFC are also disclosed.

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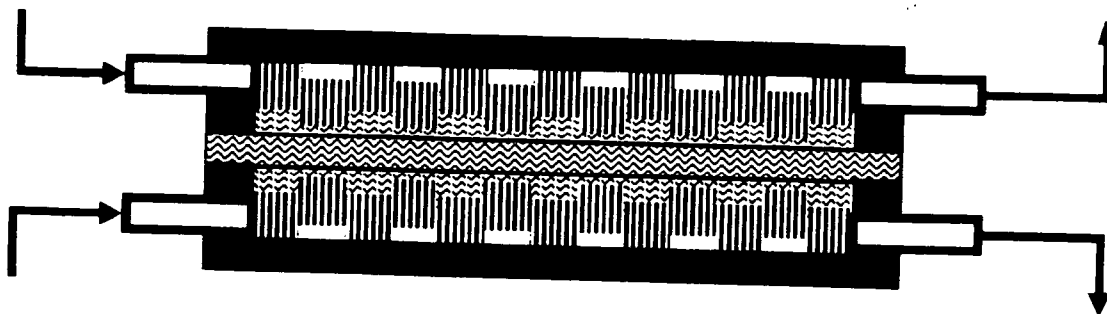
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Related U.S. Application Data

(60) Provisional application No. 60/684,864, filed on May 26, 2005. Provisional application No. 60/692,773, filed on Jun. 21, 2005.



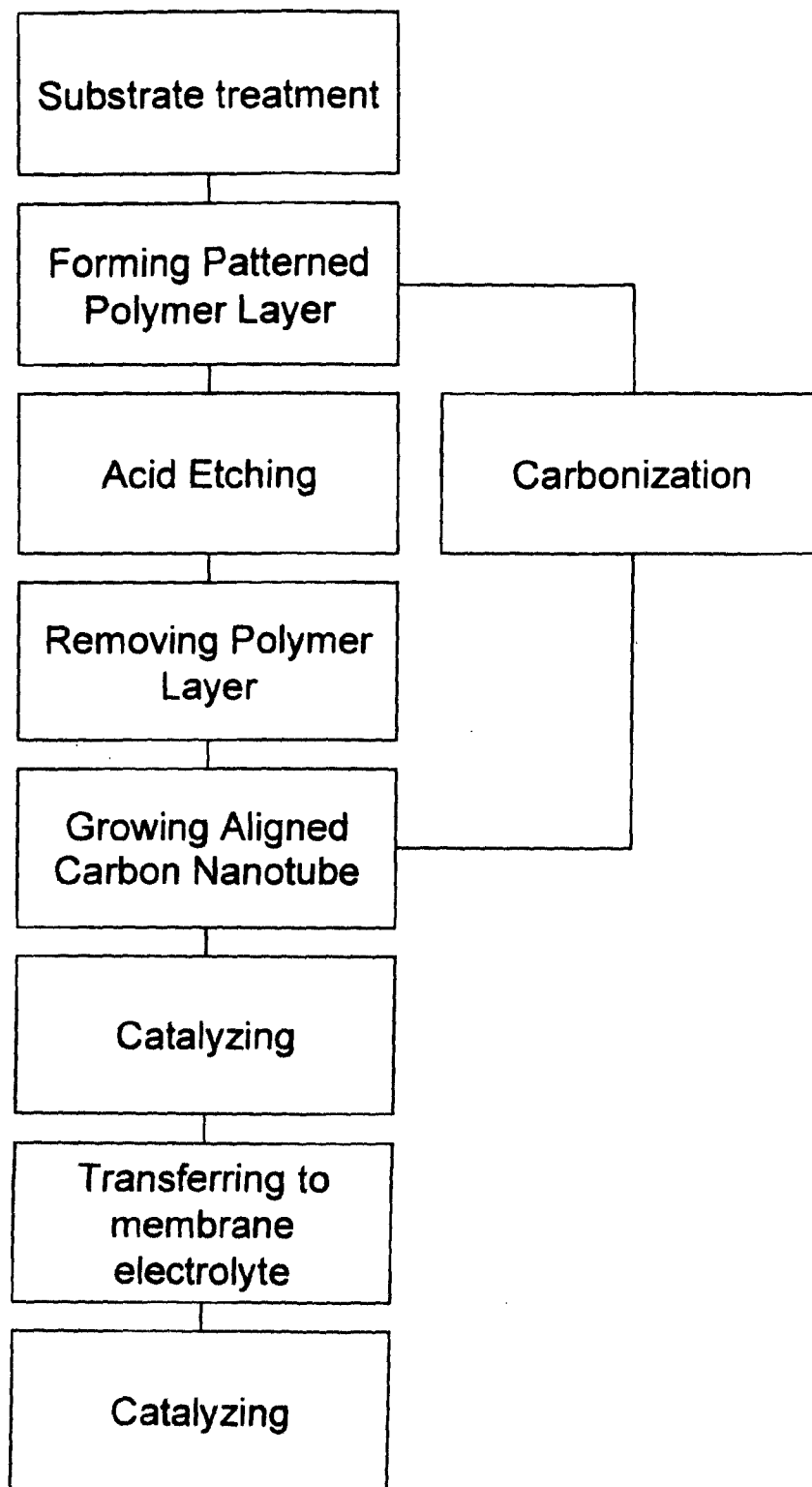


Fig.1

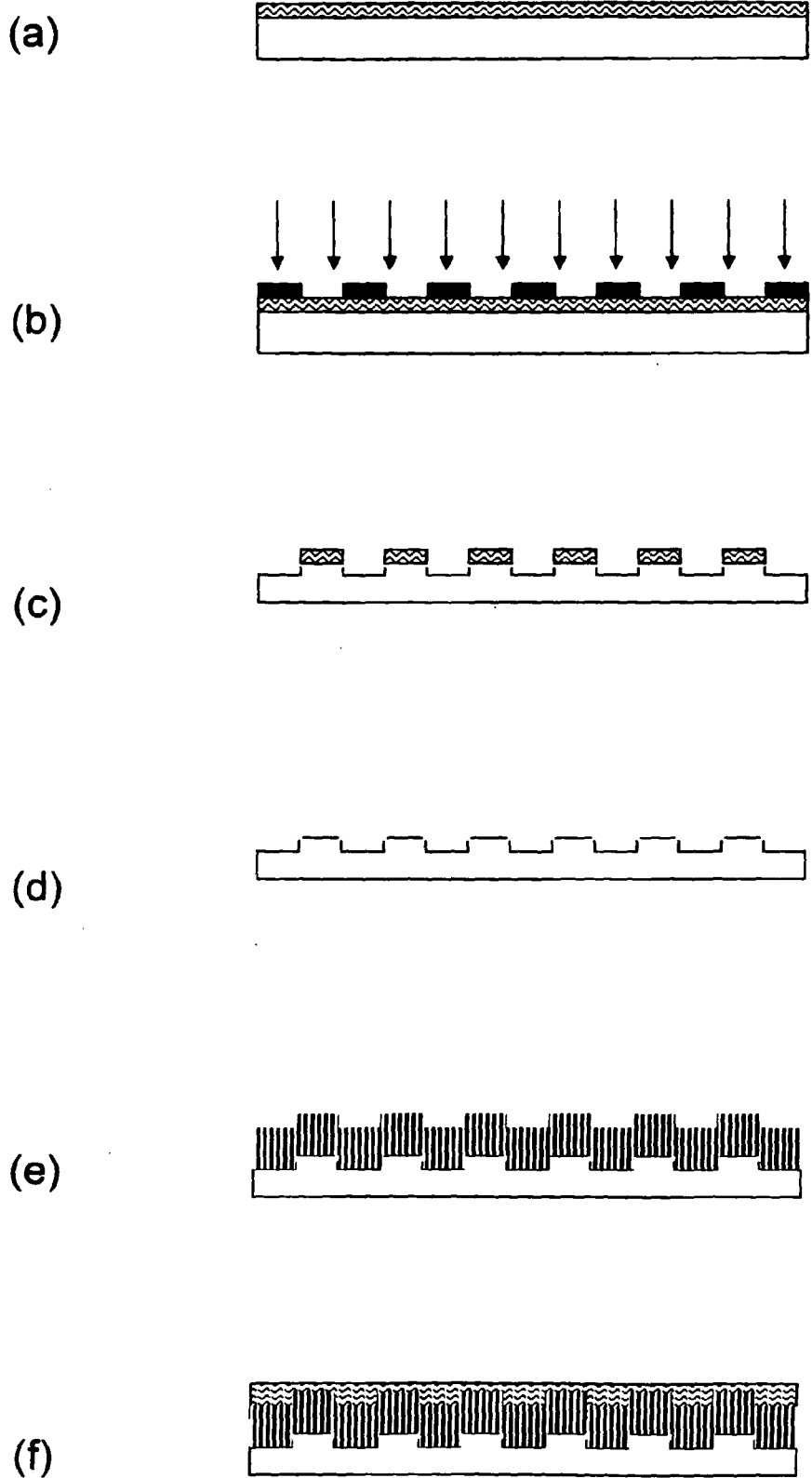
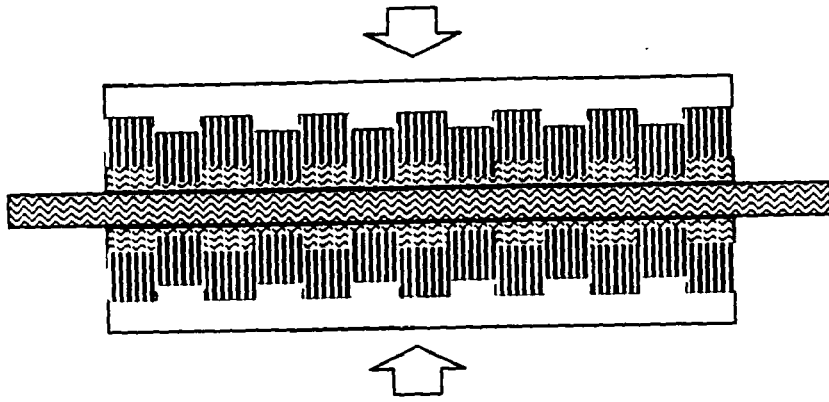
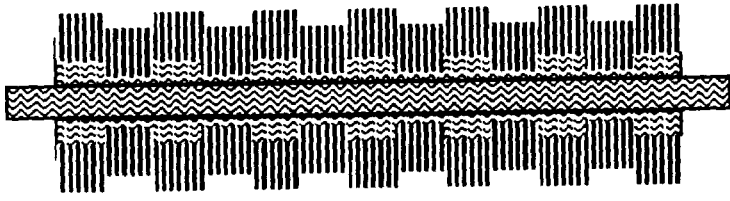


Fig. 2

(g)



(h)



(i)

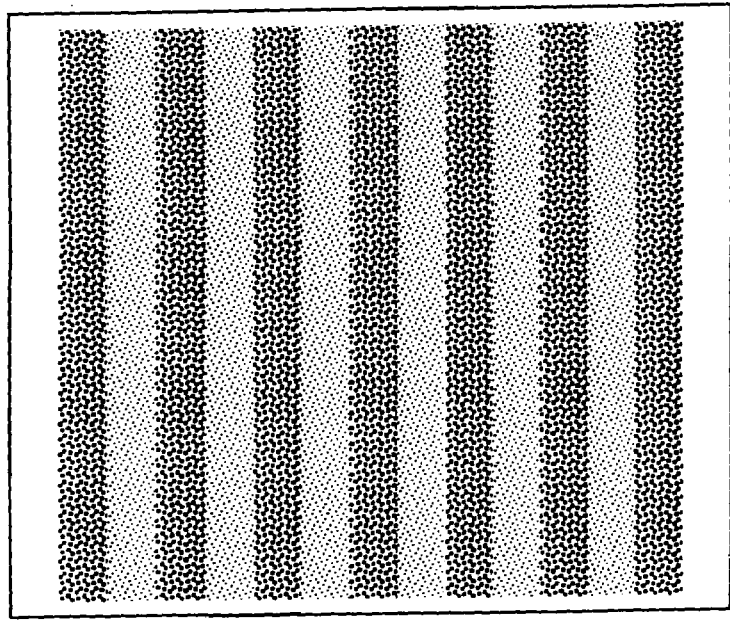
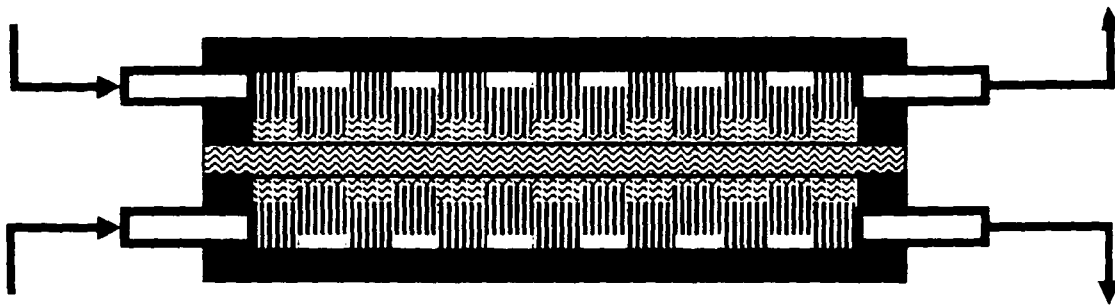


Fig. 2.



(j)

Fig. 2



Fig. 3 (a)

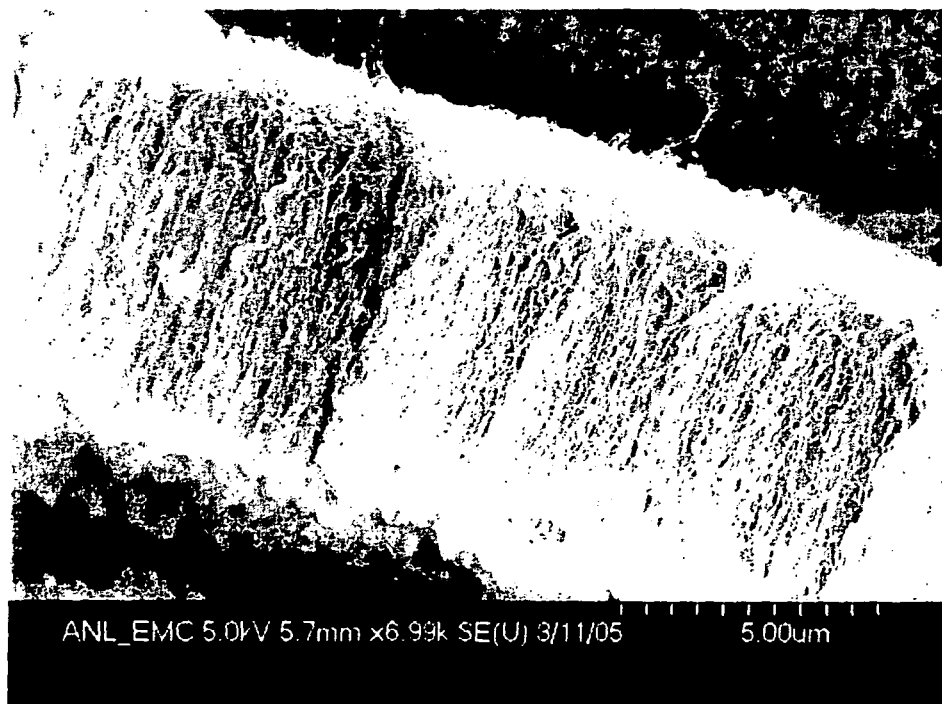


Fig. 3 (b)

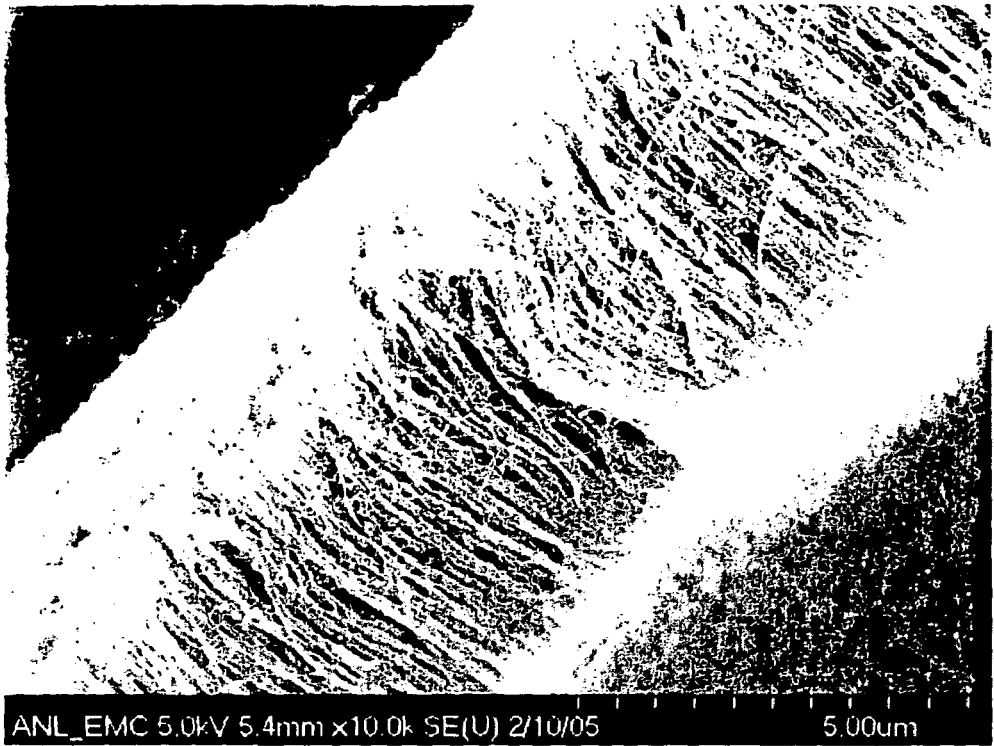


Fig. 3 (c)



Fig. 4(a)

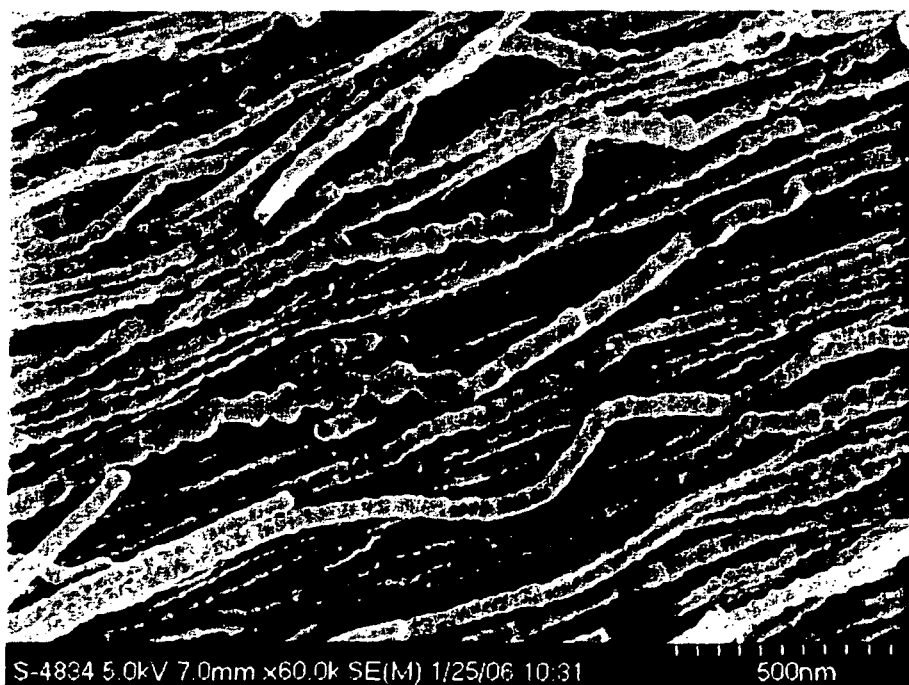
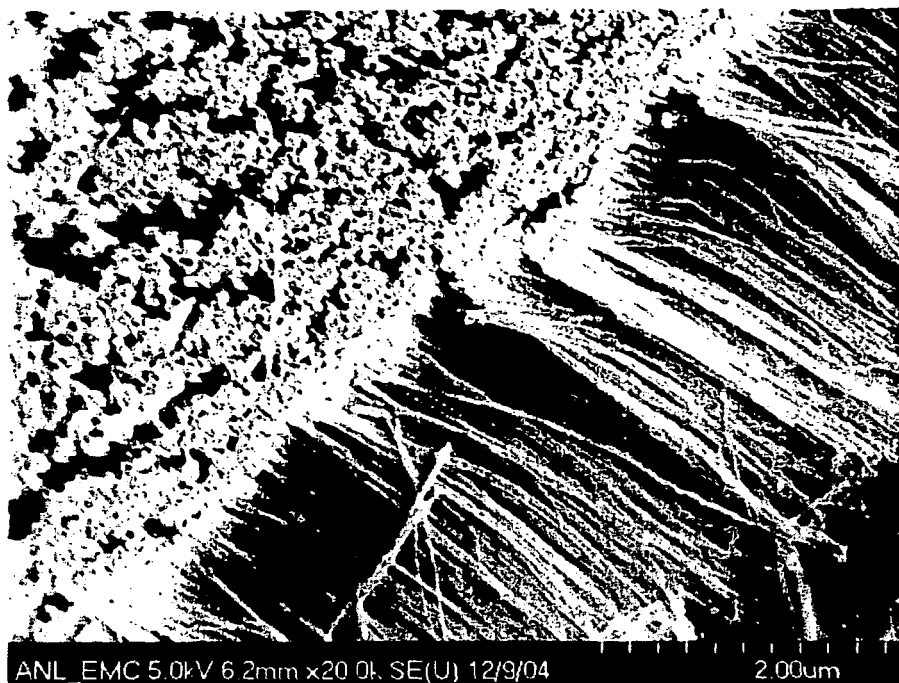
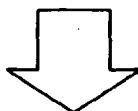


Fig. 4(b)



Aligned carbon nanotube bundles

Fig. 5(a)



Aligned carbon nanotube bundles transferred over electrolyte membrane

Fig. 5(b)

3D aligned carbon nanotube layer on quartz substrate

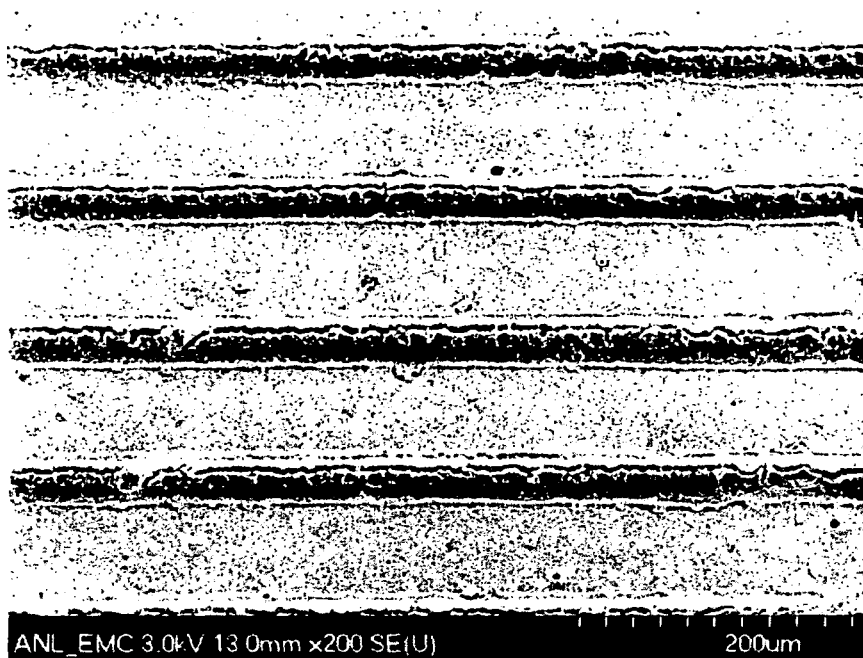
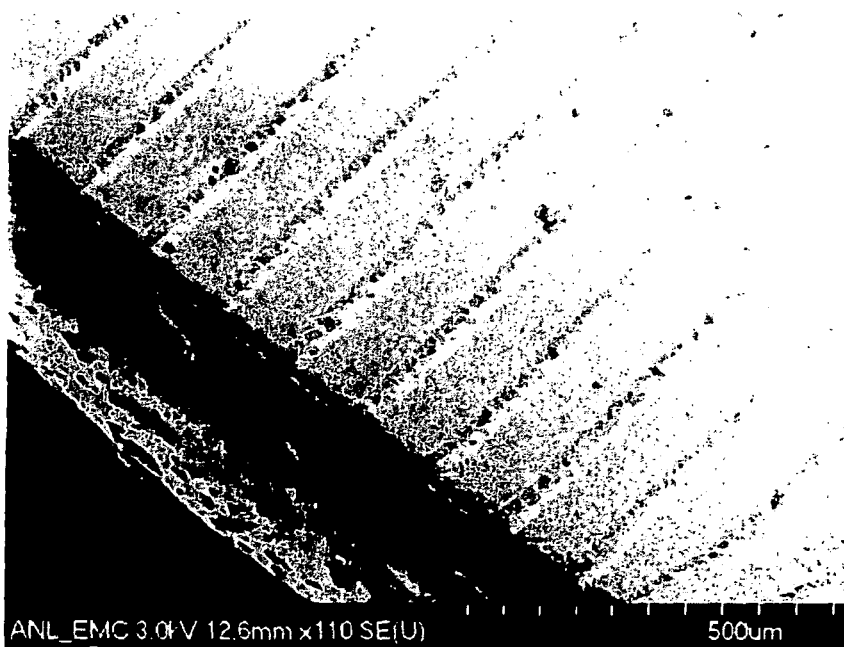


Fig. 6(a)



3D aligned carbon nanotube layer transferred on to membrane electrolyte

Fig. 6(b)

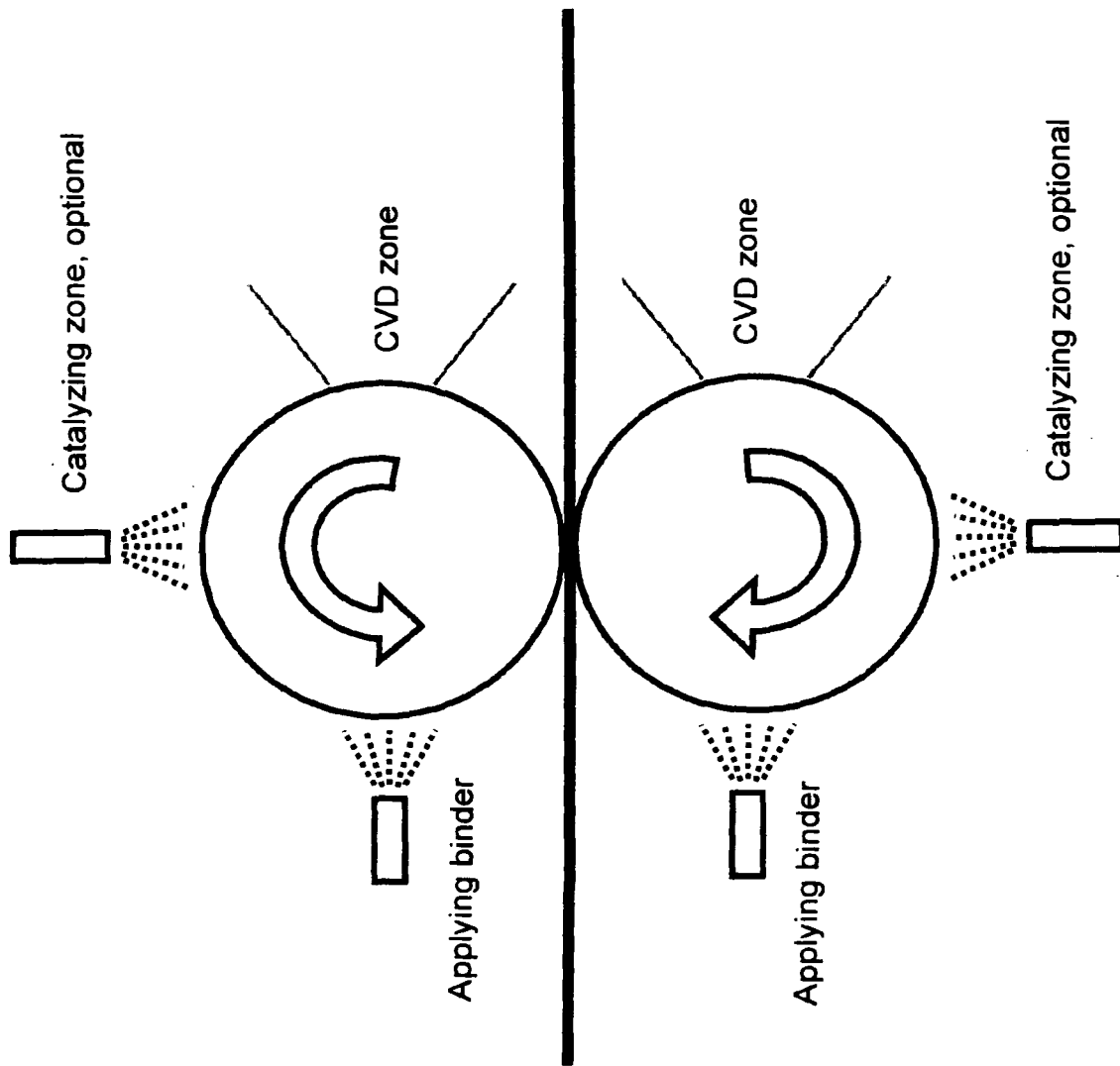


Fig. 7

**METHOD OF FABRICATING ELECTRODE
CATALYST LAYERS WITH DIRECTIONALLY
ORIENTED CARBON SUPPORT FOR PROTON
EXCHANGE MEMBRANE FUEL CELL**

RELATED APPLICATIONS

[0001] This application, pursuant to 37 C.F.R. § 1.78©, claims priority based on provisional application Ser. No. 60/684,864 filed May 26, 2005.

CONTRACTUAL ORIGIN OF THE INVENTION

[0002] The United States Government has rights in this invention pursuant to Contract No. W-31-109-ENG-38 between the U.S. Department of Energy (DOE) and The University of Chicago representing Argonne National Laboratory.

FIELD OF THE INVENTION

[0003] This invention relates to the preparation of aligned carbon nanotubes with transition metal catalyst sites longitudinally spaced therealong and is related to Provisional Application Ser. No. 60/692,773, filed Jun. 21, 2005, to which the non-provisional application Serial No. _____ filed _____, is being filed concurrently herewith, the entire disclosure thereof being incorporated by reference.

BACKGROUND INFORMATION

[0004] The proton exchange membrane fuel cell (PEMFC) continues to benefit from intense development efforts for its potential application in automobiles and distributed power generation due to a number of inherent advantages including high efficiency, low noise and chemical emissions, and low operating temperature. A PEMFC typically consists of a membrane electrode assembly (MEA), gas diffusion electrode (GDE) layers and bipolar plates. The MEA consists of an anode, a cathode and a membrane electrolyte and is the key element of the fuel cell. During PEMFC operation, hydrogen is electro-oxidized at the anode. The proton thus produced is transported through the electrolyte and is combined with an oxide ion formed through the reduction of oxygen at the cathode. At present, the electrode catalyst materials used at the anode and the cathode are primarily platinum supported over amorphous carbon. Since platinum is a precious metal with limited supply, reducing its usage will result in significant reduction in PEMFC cost for the commercialization. One of the contributing causes of high precious metal usage is inefficient utilization of the precious metal in the present electrode catalyst preparation method. Generally, the MEA preparation steps involve catalyst synthesis, ionomer/catalyst ink preparation and casting catalyst ink onto the membrane electrolyte. The catalyst synthesis usually is accomplished through a wet chemical process in which the precious metal precursor is deposited over a high surface area carbon followed by a chemical reduction. The electrode catalyst thus prepared has highly dispersed metal crystallites distributed throughout the surface of carbon black. The catalyst is subsequently mixed with a polymer solution, known as ionomer, to form the ink. The ink is then cast over each side of the polymer electrolyte through a hot-pressing method to form the MEA. An intrinsic limitation to this approach is that a significant amount of catalyst is embedded underneath of the polymer matrix during the hot-pressing, rendering it inaccessible to gas flow. There-

fore, these catalyst can not participate in the electro-chemical reaction are thus considered underutilized.

[0005] A GDE is another key component in a PEMFC. The GDE is typically made of carbon paper or cloth treated with a hydrophobic coating. A GDE is packed at each side of the MEA between electrodes and the bipolar plates to improve the electric conductivity, humidity control as well as reactant gas distribution. A GDE adds additional manufacturing cost and complexity to a PEMFC fabrication. The bipolar plate in PEMFC is made of corrosion resistant, electric conducting materials such as graphite or surface treated stainless steel. Complicated gas flow channels, known as the flow field, are often required to be embossed on the bipolar plate surface to distribute the hydrogen or oxygen uniformly over each side of the MEA. The bipolar plate also electrically connects the adjacent fuel cell modules to form the PEMFC stack. Construction of a flow field on a bipolar plate adds cost and complexity to the PEMFC fabrication process.

[0006] Wilson and Gottesfeld summarized the conventional method of preparing membrane electrode assemblies for a PEM fuel cell as disclosed in Wilson and Gottesfeld, *Journal of Applied Electrochemistry* 22, (1992) pp. 1-7, incorporated herein by reference, discloses the method of forming thin film catalyst layers for MEA by preparing ink containing amorphous carbon supported precious metal, followed by applying the ink and hot-pressing. Grot and Banerjee, U.S. Pat. No. 5,330,860 incorporated herein by reference, further describes a method of preparing electrocatalyst ink and friction of MEAs with such ink. Harada U.S. Pat. No. 5,399,184 incorporated herein by reference, discloses a method of making MEAs and a fuel cell assembly with gas diffusion electrodes (GDE). Wilkinson et al. U.S. Pat. No. 5,521,018 and disclosed herein by reference, discloses a design of bipolar plate with embossed fluid flow field that has functions of conducting electricity and directing the reactant gas flow.

[0007] The inventive method is different from these conventional approaches because: a) there is no need to prepare a carbon based catalyst ink through mixing before transferring the films to MEAs. Aligned carbon nanotube layers are transferred to a membrane electrolyte with the nanotube orientation and pattern remaining intact; b) the aligned carbon nanotubes in the present invention have excellent electric conductivity and hydrophobicity, therefore rendering the application of GDE unnecessary; c) a gas flow field pattern can be optionally built during the preparation of the aligned carbon nanotube bundles according to the invention; therefore, there is no need for embossing the flow field in bipolar plate thus minimizing the manufacturing cost.

[0008] A recent patent application by McElrath et al. U.S. publication no. 2004/0197638 A1, incorporated herein by reference, discloses a method of preparing a membrane electrode using carbon nanotube materials including the steps of suspending nanotubes in solution, filtering nanotubes to form thin mat or dried catalyst ink over a membrane electrolyte. This invention is different in the following aspects: a) carbon nanotubes are transferred directly to the membrane electrolyte without liquid suspension or filtration; b) carbon nanotube bundles are aligned in the same direction with optional 3-dimensional pattern whereas the carbon nanotubes in the prior art can not be aligned due to limitations in the method of preparation.

[0009] Another recent patent application by Toops, U.S. publication no. US 2004/0224217 A1 disclosed herein by reference, discloses a method of preparing aligned carbon nanotube for MEA fabrication by pyrolyzing hydrocarbons inside of porous channels of an anodized alumina template, followed by dissolving the alumina with acid. This invention is superior in the following aspects; a) the aligned carbon nanotubes in this invention are prepared through growth over a substrate plate through chemical vapor deposition without the need of an alumina template to guide the vertical alignment, obviating the cost of an alumina template and the acid removal process; b) this method can produce carbon nanotube electrodes with three dimensional patterns as the result of the preparation of substrate. After transferring on to the membrane electrolyte, a pattern can be formed in which certain nanotubes are lower in height than the neighboring ones. One of such patterns is the straight channel, as is shown in **FIG. 6**. These channels serve as the distribution conduits for the reactant gas flows uniformly throughout the electrodes, which have advantage of replacing flow field in bipolar plate in the conventional design and c) the electrode prepared with the aligned carbon nanotubes according to the invention has higher nanotube density than the prior art. Because the inventive method is template free, nanotubes can grow closely and in contact with each other, as is shown in **FIG. 4**. The prior art requiring alumina templates does not have this flexibility.

SUMMARY OF THE INVENTION

[0010] This invention relates to a new method of preparing a membrane electrode assembly (MEA) for a PEMFC that reduces precious metal usage, eliminates the need for GDE and simplifies the design and fabrication of bipolar plates. The inventive method consists of multiple steps including growing template-free aligned carbon nanotubes, transferring directionally aligned nanotubes onto the surface of a polymer electrolyte, and fabricating a fuel cell with flow field-free bipolar plates. This new method also leads to a new PEM fuel cell design in which either or both anode and cathode are made of aligned carbon nanotubes with a portion of the nanotubes embedded in a proton conduction polymer and another portion exposed to reactant gas flow contacting the bipolar plates directly. The aligned nanotubes can also be built optionally with a pre-designed flow field pattern. MEA design eliminates the need for GDE and the necessity of embossing flow fields on the surface of bipolar plates.

[0011] An important object of the invention is to prepare a three-dimensional, aligned carbon nanotube with a pre-designed gas flow pattern, using a silicon or a silica transfer substrate with a 3D gas flow pattern prepared through coating a layer of photo-sensitive polymer, followed by exposing ultraviolet light over the photo-mask, washing off the unpolymerized coating layer, acid etching of the substrate and removal of polymerized layer. Carbon nanotube bundles can be grown and form a vertical 3D layer with the same pattern as that of the photomask. Both positive and negative photo-resist coatings, as is known in the art, can be used for this purpose.

[0012] Another object of the invention is providing a metal substrate for the aligned carbon nanotube growth such as nickel and stainless steel, with a 3-dimensional pattern therein by machining such as milling, stamping, engraving as is known in the art.

[0013] Yet another object of the invention is to provide a three-dimensional pattern ACNT having a pattern of a fluid flow field channel distributing reactant gas uniformly throughout the area defined by the nanotube bundles. Such flow field channels can have a wide variety of patterns, i.e. straight line, wavy line, serpentine line, and other shapes known in the art.

[0014] Another object of the invention is to transfer precious metal based electrode catalyst material to the aligned carbon nanotubes through wet chemistry method or through vapor deposition method, as known in the field of the art.

[0015] A further object of the invention is to incorporate highly dispersed catalytically active transition metals into the aligned carbon nanotube during the chemical vapor deposition step with or without chemically associated nitrogen.

[0016] A still further object of the invention is to transfer aligned carbon nanotubes from the substrate to a membrane electrode through a hot-press method to produce a MEA with aligned carbon nanotube oriented perpendicular to the membrane surface.

[0017] Another object of the invention is to provide a MEA containing aligned carbon nanotubes with 3-D pattern on one or both sides of the electrolyte membrane and perpendicular thereto and may function as flow fields for reactant gases to improve the electric conductivity or the distribution of gases. The aligned carbon nanotubes can be used as the support for electrode catalysts or have electrocatalytic function for an oxygen reduction reaction.

[0018] A final object of the invention is to provide PEM fuel cells wherein the inventive MEA remove the need of embossing a flow field on the bipolar plates. Furthermore, graphitic carbon nanotubes contact directly the bipolar plates with improved electric conductivity and remove the need of a gas distribution electrode (GDE). Such improvements simplify the PEM fuel cell manufacturing process and reduce the cost.

[0019] The invention consists of certain novel features and a combination of parts hereinafter fully described, illustrated in the accompanying drawings, and particularly pointed out in the appended claims, it being understood that various changes in the details may be made without departing from the spirit, or sacrificing any of the advantages of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0020] For the purpose of facilitating an understanding of the invention, there is illustrated in the accompanying drawings a preferred embodiment thereof, from an inspection of which, when considered in connection with the following description, the invention, its construction and operation, and many of its advantages should be readily understood and appreciated.

[0021] **FIG. 1** is a flow chart illustrating steps in the inventive process;

[0022] **FIGS. 2(a)-(j)** are schematic representations of articles made during the process of producing a PEMFC;

[0023] **FIG. 3** is a SEM image taken after a nanotube bundle was removed from a substrate **FIG. 4** is a SEM image of the ends of a nanotube bundle after removal from a quartz substrate;

[0024] FIGS. 5(a) and (b) are SEM images of a nanotube bundle removed from a substrate (a) and transferred to an electrolyte membrane (b) showing the transfer did not change the tube orientation; and

[0025] FIGS. 6(a) and (b) show three dimensional (3D) patterns formed by nanotube on a substrate (a) and transferred to a membrane (b) forming a flow pattern thereon.

DETAILED DESCRIPTION OF THE INVENTION

[0026] The method of preparing an electrode catalyst layer with a 3-dimensional aligned carbon nanotube for a PEMFC can be described according to the process map shown in FIG. 1.

[0027] The first step involves the preparation of the surface of the substrate for nanotube growth. In the preferred embodiment of the invention, the substrate is made of silicon or silica (silicon dioxide) plates that are tolerant to temperature up to 1000° C. Specifically, the substrate plate is made by quartz. The preparation includes immersing the quartz substrate plate into a hot liquid bath containing a mixture of concentrated sulfuric acid (98%) and hydrogen peroxide solution (30%) at the temperature below 100° C. After rinsing with deionized water, the substrate plate is further cleaned in an ultrasonic bath containing acetone for 30 to 60 minutes, before being dried at room temperature. After drying, the substrate is coated with a layer of photo-resist polymer through a spin-on coating process. The photo-resist polymers used for this purpose can be either positive or negative, or any other types known in the art. An example of the negative photo-resist polymer solution for the coating process contains N-(Hydroxymethyl)acrylamide, Triphenyl-sulfonium triflate and polyvinyl alcohol (PVA) mixed in a deionized water and acetonitrile solution. After drying and curing in a vacuum oven at mild temperatures around 80° C., a thin layer of photo-resist layer was formed on the surface of the glass substrate, as is shown in FIG. 2a. In the preferred embodiment of invention, the coating layer thickness ranges from about 0.5 to about 3 μm microns. An example of the positive photo-resist polymer solution is diazonaphthoquinone and Novalac resin dissolved in propylene glycol methyl ether acetate, such as that marketed under brand name Shipley S1818. A similar drying and curing process is also needed for positive photo-resist coating. Other substrate materials such as nickel, stainless steel, and other metals can be used as substrates. In the case of metal substrate, a 3-dimensional pattern can be applied to the surface of the substrate through method of machining such as milling, stamping, engraving as is known to those of ordinary skill in the art.

[0028] The second step involved forming a pattern polymer layer over the substrate surface through a photolithographic method, with a method known in the art, as described in L. F. Thompson et al., *Introduction to Micro Lithography*, 2d Ed., American Chemical Society, Washington, D.C. (1994), and incorporated herein by reference. A photo-mask with a preselected pattern, such as that of a gas flow field channel pattern, was placed over the substrate coated with a photo-resist layer, followed by the exposure of a light source, such as an ultraviolet lamp. The optical opaque region of the photo-mask blocked the illumination from reaching the coated layer underneath while the

unblocked region was fully exposed, as is shown in FIG. 2b. For a negative photo-resist, the polymer coating in the exposed region undergoes a cross-linking process and become insoluble whereas the coating in the unexposed region is washed away by the deionized water. In the case of positive photo-resist, the coated layer exposed under the radiation becomes soluble in the developing solution and subsequently is removed. The unexposed coating remains intact after the development. The gas flow field channel can have a variety of patterns such as straight line, wavy line, serpentine line, and any other shapes that are desired.

[0029] The third step of the invention involves forming a three-dimensional pattern on the substrate over the photo lithographed coating from step 2 using an acid etching method. An acid solution, generally containing the mixture of hydrofluoric acid and ammonia fluoride, is used to dissolve uncovered glass surfaces at ambient or slightly above ambient temperature. The acid etching process did not stop until a predetermined depth was reached, as that is shown in FIG. 2c. In the preferred embodiment of invention, the depth ranged from about 1 micron to about 50 microns.

[0030] An alternative embodiment of the invention in step 3 is to remove the patterned polymer layer from 2nd step through a carbonization step without undergoing the acid etching process. The removal can be accomplished by carbonizing the coated layer in dry air at an elevated temperature in the range of from about 4000 to about 900° C. The glass substrate thus prepared can also be used for growing aligned carbon nanotube in step 5, as will be discussed later.

[0031] The fourth step of the invention involves removing the coated layer and re-cleaning the surface after acid etching process. The removal can be accomplished by calcining the patterned substrate in dry air at the temperature ranging from about 400° C. to about 900° C., followed by a cleaning procedure similar to that discussed in the step one. A 3-D surface on the substrate is thus formed ready for aligned carbon nanotube growth, as is shown in FIG. 2d.

[0032] The fifth step of the invention involves forming the aligned carbon nanotube over the prepared substrates from the above steps using a chemical vapor deposition (CVD) method. The CVD process is carried out inside of tubular quartz reactor in a two-zone furnace in which the temperature of each zone can be individually controlled. In one embodiment of the invention, phthalocyanine containing transitional metals such as iron phthalocyanine (FePc) or cobalt phthalocyanine (CoPc) is placed in the first heating zone of the reactor which is typically operated from about 300° C. to 800° C. In the preferred embodiment, FePc is placed in 1st heating zone operated from about 500° C. to about 700° C. The iron phthalocyanine is vaporized at these temperatures and the vapor is carried by a flowing gas mixture of argon and hydrogen into the second heating zone of the reactor where the patterned substrates are placed. The ratio of Ar/H₂ ranges from about 10:1 to about 5:5 and the temperature of the 2nd heating zone ranges from about 700° C. to about 1000° C. The phthalocyanine vapor pyrolyzes at these temperatures on the surface of the substrates and forms three-dimensional aligned carbon nanotube bundles, as is shown in FIG. 2e. In addition to Fe and Co phthalocyanines, other transition metal compounds such as nickel phthalocyanine (NiPc) can also be used. Furthermore, the organo-

metallic compounds with the structure of a transition metal coordinated by four nitrogen from the surrounding pyrrolic nuclei can also be used for this purpose. Such compounds include transition metal porphyrins and their derivatives. Examples include iron porphyrin, cobalt porphyrin. Moreover, various mixtures of any of the above are useful.

[0033] Another embodiment of the invention involves preparing aligned carbon nanotube using an organometallic compound and organic aromatics mixture. In the preferred embodiment, the organometallic compounds are transition metal phthalocyanines and metallocenes such as iron phthalocyanine and ferrocene. The organic aromatics are xylene, toluene, benzene, pyridine, as well as others. The organometallic is generally fully dissolved in the aromatics to form a liquid mixture. The liquid was injected into the 1st heating zone of the reactor with a temperature ranging from about 150° C. to 500° C. The injected mixture vaporized and mixed instantaneously with an Ar—H₂ carrying gas and was carried into the 2nd heating zone of the reactor where the temperature was controlled at from about 600° C. to about 900° C. The mixture decomposed on the surface of the patterned substrate and aligned nanotube bundles were formed through pyrolysis. The aligned carbon nanotubes produced through the above described CVD processes have, in general, a multi-wall configuration which refers to a tube composed of multiple layers of cylindrical graphitic sheets. The graphitic carbon nanotubes thus prepared had average diameters ranging from about 5 to about 100 nanometers and lengths ranging from about 3 to about 80 microns. The aligned carbon nanotubes on the surface of the substrate generally had similar lengths, as are shown in FIG. 2e when the reaction temperature and gas mixture were identical and when the substrate was treated according to step 4.

[0034] Yet another embodiment of the invention is to grow the patterned aligned carbon nanotube following the carbonization process as an alternative step to bypass step 3 and 4. In this case, a very thin layer of amorphous carbon is formed after calcination of the coated layer. Such amorphous carbon layer prohibits the growth of aligned nanotube whereas the aligned nanotube will grow over the uncoated portion. Therefore, a pattern nanotube layer can still be formed on the cleaned substrate surface whereas the amorphous carbon layer is free of nanotubes.

[0035] Yet another embodiment of the invention involves using a gas mixture containing ammonia instead of argon-hydrogen only. More specifically, the gas mixture consisted of NH₃, H₂ and Ar with the relative ratios ranging from about 1:4:10 to about 3:6:6 used as carrying gas for the application in both embodiments mentioned above, especially when FePc and Ferrocene were selected for the nanotube growth. N—Fe—N bond may have been formed during the pyrolysis processes in the 2nd reactor zone when NH₃ is present in the carrier gas. The functioned group was embedded in the graphitic structure on the surface of carbon nanotubes longitudinally spaced and had electro-catalytic activity for reducing oxygen to oxide ion in an oxygen reduction reaction (ORR) occurring at a cathode during PEM fuel cell operation as disclosed in M. Lefevre et al., *Electrochimica Acta* 48 (2003), pp. 2749-2760, and incorporated herein by reference. The advantage of such approach is to reduce or to eliminate the usage of platinum at the

cathode with aligned carbon nanotubes with embedded N—Fe—N groups to significantly decrease the cost of a PEM fuel cell.

[0036] The sixth step of the invention involves catalyzing the aligned carbon nanotubes to functionalize them with electro-catalytic activity for either anode or cathode application. Highly dispersed transitional metal or precious metal crystallites can be formed on the nanotube surface through various wet chemical methods with the catalytic precursor solution followed by the heat treatment, as known in the art. The catalyst precursors include the solutions of transitional metal or precious metal salts, such as nitrate, sulfate, sulfite, chloride, etc. The methods of depositing metal solution over aligned carbon nanotube include impregnation, wet-incipient, redox precipitation, etc. After the wet chemical treatment, the aligned carbon nanotubes were dried in dry air, followed by the reduction in flowing hydrogen at elevated temperature. The reduction temperature typically ranges from about 150 to about 550° C. In a preferred approach, the reduction is carried in flowing hydrogen in the temperature range of from about 150 to about 450° C. The metal ions were reduced to their zero valence state after the reduction and the catalyzed carbon nanotube can now be used as electrode catalyst. In an alternative embodiment of the invention, the electrode catalyst can also be coated over aligned carbon nanotubes through vapor deposition of a precious metal precursor in vacuum at elevated temperature, as is known in the art. Yet another alternative embodiment to the current invention is to postpone the catalyzing step after transferring the aligned carbon nanotube to the polymer electrolyte, as is shown in the process map in FIG. 1.

[0037] The seventh step of the invention involves transferring and connecting the aligned carbon nanotubes to the surface of the membrane electrolyte. This is actually a two-stage process. The first stage involves applying a solution of polymer that is compatible to the electrolyte material to the top of the aligned carbon nanotube layer over the substrate. For example, if Nafion® is used as the membrane electrolyte, Nafion ionomer solution is used. For the preferred embodiment, the Nafion ionomer solution contains 5% polymer solid content. The application methods can be spraying, painting, liquid dropping, or any other art recognized method. After coating by polymer solution, the supported carbon nanotube tube is dried in air or in vacuum at the room temperature or up to about 150° C. A decal with a polymer layer coated on the top of aligned carbon nanotube is formed at the end of the stage, as is shown in FIG. 2f. The second stage of the process involves transferring the decal to the polymer electrolyte using a hot-press method. The hot-press is accomplished by applying pressure uniformly over the substrate surface while maintaining the platen at elevated temperature. The pressure of the press ranges from about 1.5×10^5 N/m² to about 7.5×10^6 N/m² and the temperature of the platen ranges from about 180° C. to about 230° C. The pressing time ranges from about 3 to about 8 minutes. In the preferred embodiment, the pressure of the press ranges from 3.5×10^5 N/m² to 7.5×10^5 N/m² and the temperature of the platen ranges from about 200 to about 220° C. The hot-pressing can be carried from both side of the membrane simultaneously, as shown in FIG. 2g, or to be performed on individual side separately. The polymer coating from the first stage will be fused into the membrane during the hot-press process. After the completion of hot-press, the decal/membrane assembly is removed and cooled

to room temperature. The MEA can subsequently be peeled off from the substrate with the aligned carbon nanotube layer attached, as is shown in FIG. 2h. In another embodiment, the peeling off can be assisted after briefly immersing the substrate with nanotube coated MEA in a fluoric acid solution. FIG. 2i shows the top view of the MEA with channel aligned nanotube bundle patterns originated from step 2 and step 3. The channels pattern can be straight (as is shown in FIG. 2i), wavy, serpentine, or any other desired shape that can be generated through any applicable photolithographic method. The channels serve as flow fields to guide the reactant gas at both the anode and the cathode; therefore the shape is determined by the required gas distribution in a specific PEM fuel cell.

[0038] The aligned carbon nanotubes can be catalyzed after the MEA fabrication if they have not been previously catalyzed. The catalyzing method is similar to that outlined in step 6 except that the hydrogen reduction temperature is limited to less than about 200° C. to minimize the potential damage to the polymer membrane.

[0039] The eighth step of the invention involves assembling the individual PEMFC by packaging the aligned carbon nanotube MEAs with the bipolar plates, as is shown in FIG. 2j. In the current embodiment of the invention, the bipolar plate contains a gas inlet and a gas outlet. The bipolar plate does not need to have flow field patterns embossed on its contact surface with the MEA, as the pre-designed aligned carbon nanotube pattern serves as the conduit for gas distribution. A portion of the aligned nanotubes protruding outward against the surface of the bipolar plate generates the electric contact between the MEA and the bipolar plate. The bipolar plate can be fabricated from a variety of electric conducting materials such as graphite, stainless steel and other metals with corrosion prevention treatment, if required.

EXAMPLE 1

[0040] A thin quartz plate with dimension of $\frac{5}{8}$ " \times 1.5" \times 0.1" was cleaned in a solution containing 70 vol. % concentrated H₂SO₄ and 30 vol. % H₂O₂. The solution temperature was maintained between 70° C. to 100° C. After cleaning and rinsing with deionized water, it was ultrasonically cleaned in acetone for 30 min. The dried quartz plate was ready for the use as the substrate.

EXAMPLE 2

[0041] A negative photo-resist solution was prepared by mixing the solution A and B where A is made by dissolving 184 mg of Triphenylsulfonium triflate in 12 ml water/acetonitrile solution followed by mixing with 725 mg of N-(Hydroxymethyl)acrylamide solution, and B was made by dissolving 2.029 g PVA in 20 ml water. The photo-resist solution was subsequently filtered through a 0.1 μ m filtration paper and used for spin-coating on the treated quartz substrate according to Example 1 with a high speed spin-coater (Model 1—EC11DT-R485, Headway research, Inc.). A pipette was filled with the photo-resist solution. The solution was dispensed over the quartz substrate in a droplet fashion while the coater spun at 2500 rpm for 30 seconds. The coating was baked at 90° C. for 30 minutes inside of a vacuum oven. A photo-mask with linear strip pattern was placed over the top of the coated quartz plate. An ultraviolet

radiation with wavelength of 254 nm generated from an UV lamp (Mineralight, UVG-11) was applied to the coated plate through the photo-mask for 5 minutes. The exposed plate was subsequently baked in a vacuum oven at 130° C. for 8 min to complete the polymerization process for the irradiated region. The plate was then immersed in deionized water after being cooled to ambient temperature and was rinsed for 5 min. The unexposed portion of the coating was thus washed away. The quartz plate with a coated polymer pattern was then dipped into a hydrofluoric acid (HF) solution made with 9 parts of water and one part of HF (49%) for 100 minutes. After rinsing and drying, the plate was calcined in flow air at 500° C. for one hour before cleaned again according to the method described in Example 1.

EXAMPLE 3

[0042] A positive photo-resist solution was obtained under the brand name Shipley S1818, that contains diazonaphthoquinone and Novalac resin dissolved in propylene glycol methyl ether acetate. The substrate prepared according to the Example 1 was first coated by a thin layer of hexamethyldisilazane (HMDS) via a spin coater before being coated with the photo-resist solution with the dry thickness about 2 μ m. After baking in vacuum oven at 90° C. for 30 minutes, a photo-mask with linear strip pattern was placed over the top of coated substrate plate. An ultraviolet radiation with wavelength of 365 nm generated from an UV lamp (Ultra Violet Products, Model UVL-23RW) was applied to the coated plate through the photo-mask for 15 seconds. The exposed substrate was subsequently developed in an aqueous solution containing 5% tetramethylammonium hydroxide for 1 minute followed by rinsing in deionized water to wash away the exposed portion of the coating. After baking at 130° C. for 30 minutes, the patterned quartz substrate was etched in an acidic solution containing NH₄F and HF for about 1 hour. The unprotected portion of the quartz was etched to form a 3 dimensional pattern. The substrate was then heated in air to 500° C. to burn off the remaining coating and cleaned again according to the steps described in Example 1. The substrate is now ready for growth of carbon nanotube.

EXAMPLE 4

[0043] A quartz substrate prepared according to the Example 2 was placed inside of a tubular two-zone reactor where the temperature of each zone was controlled independently. 0.1 gram of iron phthalocyanine (FePc, 97% Aldrich) was placed in the first zone whereas the quartz plate is placed in the second zone. An argon-hydrogen (55%-45%) gas mixture entered the first zone with a total flow rate of 330 ml/min and carried the vaporized FePc into the second zone while the temperatures for the first and second zone were controlled at 550° C. and 850° C., respectively. After 30 minutes reaction time, a layer of aligned carbon nanotube was formed on the surface of the quartz substrate. Shown in FIG. 3 is a SEM image taken after the a nanotube bundle was removed from the substrate.

EXAMPLE 5

[0044] A quartz substrate prepared according to the Example 2 was placed inside of a tubular two-zone reactor as described in Example 4. One gram of ferrocene was

dissolved in 10 ml xylene and injected continuously into the first zone of the reactor using a syringe pump. The liquid feed was passed through a capillary tube and preheated to 180° C. to 225° C. prior to its entry into the furnace. At this temperature, the liquid exiting the capillary tube was immediately volatilized and swept into the second zone, which was kept at 725° C., by a gas mixture of argon-hydrogen-ammonia mixture (8:5:2) at the flow rate of 300 ml/min. After 30 minutes, aligned carbon nanotubes were formed on the surface of the quartz substrate. Shown in **FIG. 4** is the top view image of a nanotube bundle after it was removed from the quartz plate.

EXAMPLE 6

[0045] A layer of aligned carbon nanotube was prepared on a cleaned quartz substrate according to the procedure described in Example 4. The quartz plate with aligned nanotube was subsequently loaded on the spin coater and layer of Nafion ionomer solution (5 wt. % solid, Aldrich) was spread over the nanotube layer by pipetting the solution while the coater rotated at 1000 rpm. The process lasted about 30 seconds. The process was repeated to apply a Nafion ionomer solution on the second aligned nanotube substrate. After the solution was dried completely, the two substrates were placed at top and bottom of a Nafion membrane (Nafion 115, Aldrich) with the aligned nanotube side facing the film. The assembly was then placed on the platen of a commercial heated hydraulic press (Carver Laboratory) where the platen temperature was maintained at 200° C. A pressure was subsequently applied to the assembly at 7.5×10^5 N/m² for 5 minutes before it was removed. After the assembly was cooled to ambient temperature, the quartz plates were slowly peeled from the film. The aligned nanotubes were transferred to the surface of the membrane electrolyte without changing the tube orientation, as is shown in **FIG. 5**.

EXAMPLE 7

[0046] A quartz substrate prepared according to the Example 3 was placed inside of a tubular two-zone reactor using the same chemical vapor deposition mixture as described in Example 4. A uniform, three dimensional aligned carbon nanotube layer was grown on both low and high areas of the substrate, as is shown by the ridges and planes in **FIG. 6a**. Following the nanotube growth, Nafion ionomer solution was applied to the top of the nanotube layer which was subsequently transferred to the Nafion membrane through the hot press method described in Example 6. After the transfer, the side of the nanotube layer previously attached to the substrate was now exposed to the surface. The high and low areas of the nanotube layer were now reversed, as is shown in **FIG. 6b**.

[0047] While there has been disclosed what is considered to be the preferred embodiments of the present invention, it is understood that various changes in the details may be made without departing from the spirit, or sacrificing any of the advantages of the present invention.

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A method of making a membrane electrode assembly (MEA) having an anode and a cathode and a proton conductive membrane therebetween, wherein a bundle of lon-

gitudinally aligned carbon nanotubes with a catalytically active transition metal incorporated in the nanotubes forms at least one portion of the MEA and is in contact with the membrane, said method comprising introducing a combination selected from one or more of a hydrocarbon and an organometallic compound containing a catalytically active transition metal and a nitrogen containing compound and an inert gas and a reducing gas into a first reaction zone maintained at a first reaction temperature for a time sufficient to vaporize material therein, introducing the vaporized material to a second reaction zone maintained at a second reaction temperature for a time sufficient to grow longitudinally aligned carbon nanotubes with a catalytically active transition metal incorporated throughout the nanotubes, the nanotubes being in contact with a portion of the MEA at production or being positioned in contact thereafter.

2. The method of claim 1, wherein a substrate is present in the second reaction zone and has a predetermined pattern thereon prior to formation of the longitudinally aligned carbon nanotubes thereon to cause the carbon nanotubes to form a preselected pattern on the substrate.

3. The method of claim 1, wherein the vapor in the first reaction zone contains one or more of argon and hydrogen and ammonia and a nitrogen-containing hydrocarbon and an organometallic compound of Fe or Ni or Co or Cr or Mn or mixtures thereof.

4. The method of claim 1, wherein the temperature in the first reaction zone is maintained in the range of from about 150° C. to about 700° C. and the temperature in the second reaction zone is maintained in the range of from about 700° C. to about 1000° C.

5. The method of claim 1, wherein material is maintained in the reaction zones for a time in the range of from about 5 to about 45 minutes.

6. The method of claim 1, wherein the organic moiety of the organometallic compound is one or more of the compounds in Table 1.

7. The method of claim 1, wherein the nanotubes form a three dimension (3D) pattern.

8. The method of claim 2, wherein the substrate has thereon or thereon a 3D pattern prior to the formation of the nanotubes.

9. The method of claim 1, wherein a substrate is in the second reaction zone for the deposition of the aligned carbon nanotubes thereon, applying a layer of a suitable polymer to the nanotubes and fusing the polymer to the membrane at an elevated temperature and/or pressure to provide contact between the membrane and the nanotubes.

10. A method of forming a membrane electrode assembly (MEA) for a proton exchange membrane fuel cell (PEMFC), comprising forming an assembly of an anode and a cathode and a proton conductive membrane therebetween, forming longitudinally aligned graphitic nanotubes with a catalytically active transition metal incorporated in the nanotubes on one or more of the cathode or the anode by chemical vapor deposition (CVD), at least some of the graphitic nanotubes being in contact with the membrane.

11. The method of claim 10, wherein the transition metal is one or more of Fe, Ni, Co or mixtures thereof.

12. The method of claim 10, wherein the nanotubes are generally straight or include spiral or bamboo shaped or bellows shaped nanotubes.

13. A method of forming a combination of longitudinally aligned graphitic nanotubes with a catalytically active tran-

sition metal incorporated in the nanotubes in contact with one or more of a cathode or an anode and in contact with the proton conductive membrane, comprising preparing longitudinally aligned graphitic nanotubes with a catalytically active transition metal incorporated in the nanotubes by CVD and having a portion thereof in contact with one or more of the cathode or the anode and in contact with the proton conductive membrane and arranging a layered combination of the anode and cathode separated by the membrane, the longitudinally aligned graphitic nanotubes being generally perpendicular to the membrane.

14. The method of claim 13, wherein the transition metal is one or more of Fe, Ni, Co or mixtures thereof.

15. The method of claim 14, wherein most of the transition metal is chemically associated with nitrogen.

16. The method of claim 15, wherein the vapor deposited by CVD includes one or more of an organometallic compound and a hydrocarbon compound and a nitrogen containing compound and a reducing material and an inert gas.

17. The method of claim 16, wherein the organometallic compound is selected from Table 1 and the reducing material is hydrogen and the nitrogen containing compound is ammonia and the inert gas is argon.

18. The method of claim 17, wherein the CVD occurs in one zone of a multiple zone reactor.

19. The method of claim 18, wherein the nanotubes are supports for either an oxidation catalyst or a reduction catalyst.

20. The method of claim 19, wherein the catalyst is an oxidation catalyst formed on the cathode.

21. The method of claim 19, wherein the catalyst is a reduction catalyst formed on the anode.

22. The method of claim 13, wherein a plurality of the layered combinations are assembled into a PEMFC.

23. A method of forming a membrane electrode assembly (MEA) for a proton exchange membrane fuel cell (PEMFC), comprising forming an assembly of an anode and a cathode and a proton conductive membrane therebetween, forming longitudinally aligned graphitic nanotubes on one or more of the cathode or the anode by chemical vapor deposition (CVD), at least some of the graphitic nanotubes being in contact with the membrane.

24. A method of forming a membrane for a proton exchange membrane fuel cell (PEMFC), comprising providing a proton conductive membrane, forming longitudinally aligned graphitic nanotubes with a catalytically active transition metal in the nanotubes on a substrate by chemical vapor deposition (CVD), transferring the longitudinally aligned graphitic nanotubes from or with the substrate to the proton exchange membrane with the longitudinally aligned graphitic nanotubes being generally perpendicular to the proton exchange membrane and in contact therewith.

25. The method of claim 24, wherein the substrate is a cathode or an anode and most of the nanotubes are in contact with the membrane and the cathode or the anode.

26. The method of claim 24, wherein the nanotubes are transferred by forming a layer of a suitable polymer on the nanotubes and hot pressing the layer with the nanotubes onto the membrane and thereafter removing polymer from the membrane where possible.

27. A MEA made according to the method of claim 1.

28. A combination of longitudinally aligned graphitic nanotubes made according to the method of claim 13.

29. A MEA made according to the method of claim 23.

30. A membrane made according to the method of claim 24.

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