

(19) **United States**(12) **Patent Application Publication**  
**Beall et al.**(10) **Pub. No.: US 2025/0257001 A1**(43) **Pub. Date: Aug. 14, 2025**(54) **CHEMICALLY STRENGTHENABLE  
LITHIUM ALUMINOSILICATE GLASSES  
WITH INHERENT DAMAGE RESISTANCE**(71) Applicant: **CORNING INCORPORATED,**  
CORNING, NY (US)(72) Inventors: **George Halsey Beall**, Big Flats, NY  
(US); **Matthew John Dejneka**,  
Corning, NY (US); **Qiang Fu**, Painted  
Post, NY (US); **Sinue Gomez**, Corning,  
NY (US); **Robert Michael Morena**,  
Lindley, NY (US); **Charlene Marie  
Smith**, Corning, NY (US)(21) Appl. No.: **19/192,898**(22) Filed: **Apr. 29, 2025****Related U.S. Application Data**(60) Continuation of application No. 18/641,770, filed on  
Apr. 22, 2024, now Pat. No. 12,304,856, which is a  
continuation of application No. 18/195,880, filed on  
May 10, 2023, now Pat. No. 11,993,539, which is a  
continuation of application No. 17/522,221, filed on  
Nov. 9, 2021, now Pat. No. 11,718,554, which is a  
continuation of application No. 16/193,266, filed on  
Nov. 16, 2018, now Pat. No. 11,220,452, which is a  
division of application No. 15/400,267, filed on Jan.  
6, 2017, now Pat. No. 10,131,567.(60) Provisional application No. 62/276,431, filed on Jan.  
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(2013.01)

(57)

**ABSTRACT**

A group of glass compositions in the  $\text{Li}_2\text{O}-\text{Al}_2\text{O}_3-\text{SiO}_2-\text{B}_2\text{O}_3$  family that can be chemically strengthened in single or multiple ion exchange baths containing at least one of  $\text{NaNO}_3$  and  $\text{KNO}_3$  for a short time (2-4 hours) to develop a deep depth of layer (DOL). In some instances, the DOL is at least 70  $\mu\text{m}$ ; in others, at least about 100  $\mu\text{m}$ . The ion exchanged glasses have a high damage resistance (indentation fracture toughness ranging from greater than 10 kgf to greater than 50 kgf) that is better than or at least comparable to that of sodium aluminosilicate glasses.

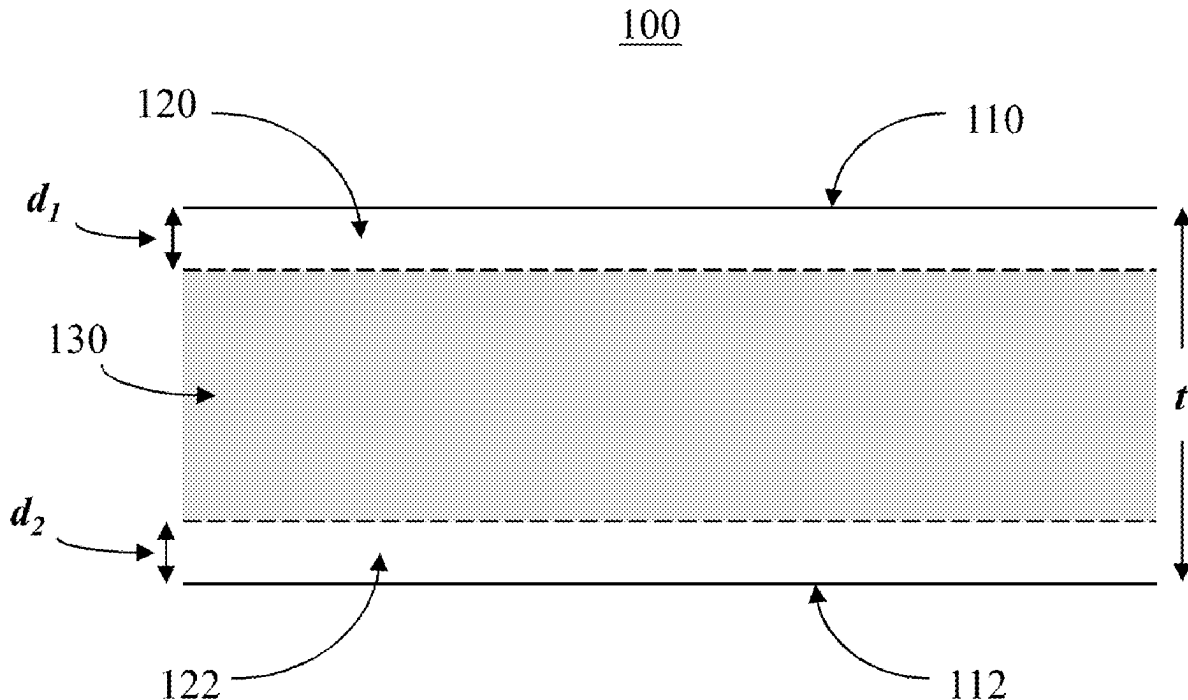


FIG. 1

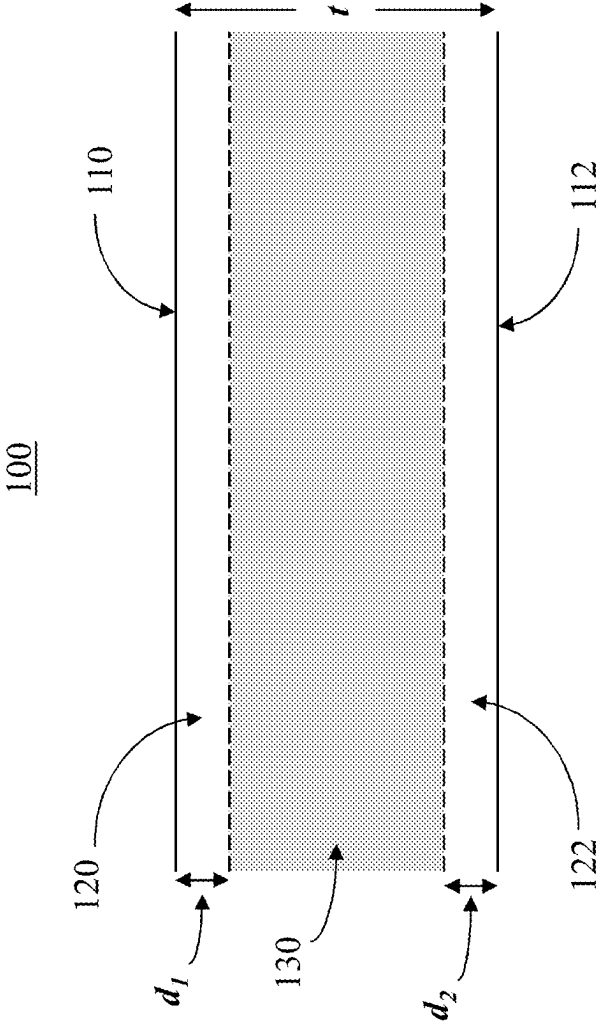


FIG. 2

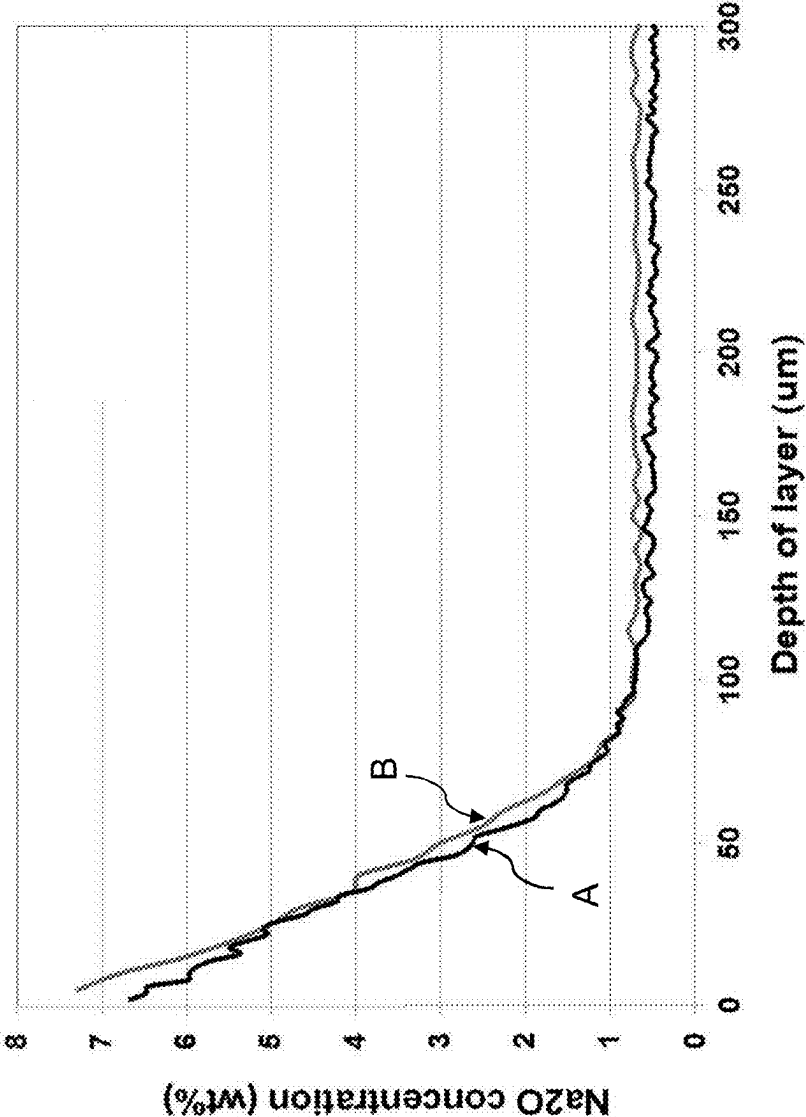


FIG. 3

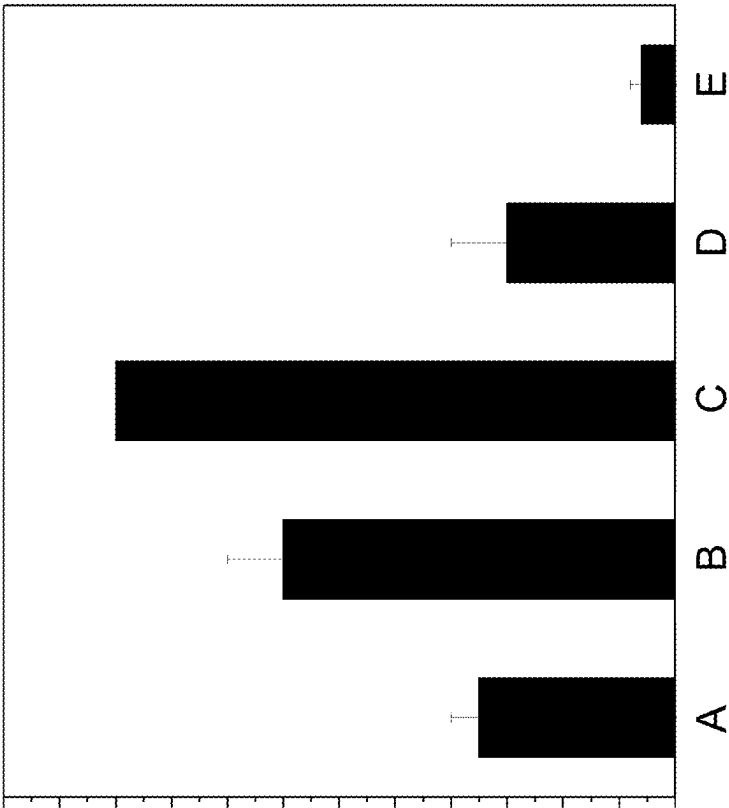


FIG. 4

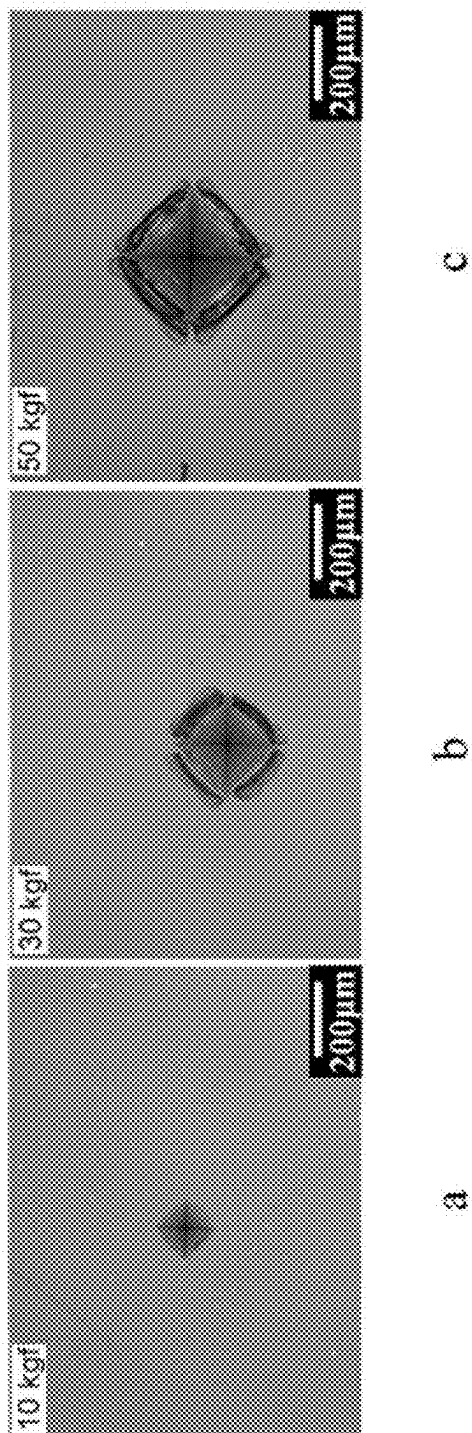


FIG. 5A

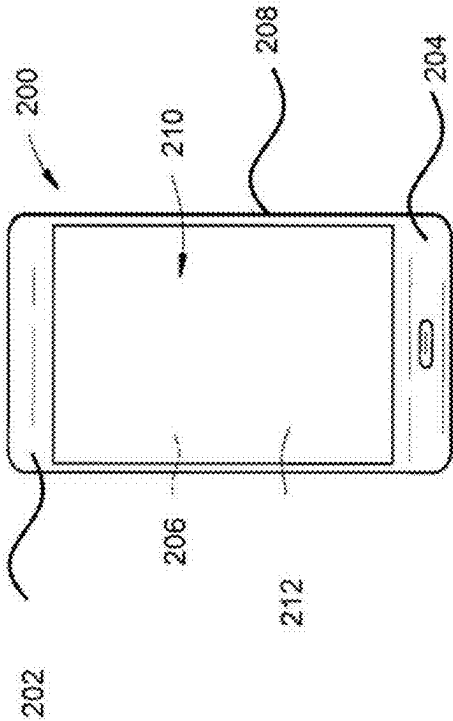
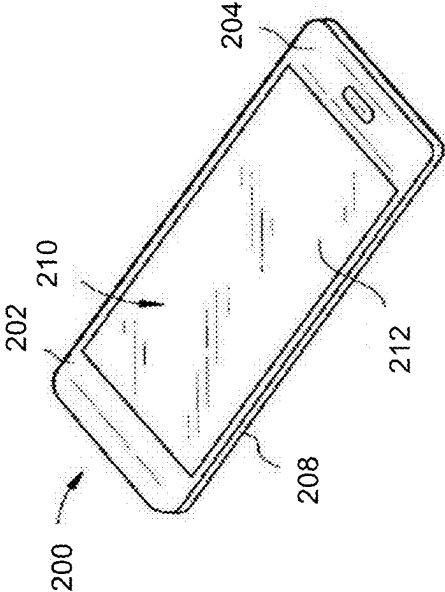


FIG. 5B



# CHEMICALLY STRENGTHENABLE LITHIUM ALUMINOSILICATE GLASSES WITH INHERENT DAMAGE RESISTANCE

## CROSS-REFERENCE TO RELATED APPLICATIONS

**[0001]** This application is a continuation of and claims the benefit of priority under 35 U.S.C. § 120 to U.S. application Ser. No. 18/641,770 filed on Apr. 22, 2024, which is a continuation of and claims the benefit of priority under 35 U.S.C. § 120 to U.S. application Ser. No. 18/195,880 filed on May 10, 2023, now U.S. Pat. No. 11,993,539, issued May 28, 2024, which is a continuation of and claims the benefit of priority under 35 U.S.C. § 120 to U.S. application Ser. No. 17/522,221 filed on Nov. 9, 2021, now U.S. Pat. No. 11,718,554, issued Aug. 8, 2023, which is a continuation of and claims the benefit of priority under 35 U.S.C. § 120 to U.S. application Ser. No. 16/193,266, filed Nov. 16, 2018, now U.S. Pat. No. 11,220,452, issued Jan. 11, 2022, which is a divisional of and claims the benefit of priority under 35 U.S.C. § 121 to U.S. application Ser. No. 15/400,267, filed Jan. 6, 2017, now U.S. Pat. No. 10,131,567, issued Nov. 20, 2018, which claims the benefit of priority under 35 U.S.C. § 119 of U.S. Provisional Application Ser. No. 62/276,431, filed Jan. 8, 2016, the contents of each of which are relied upon and incorporated herein by reference in their entirety.

## BACKGROUND

**[0002]** The disclosure relates to ion exchangeable glasses. More particularly, the disclosure relates to ion exchangeable lithium aluminosilicate glasses. Even more particularly, the disclosure relates to lithium aluminosilicate glasses which, when ion exchanged, have high levels of inherent damage resistance.

**[0003]** There have been continuous efforts in the development of new glass compositions to improve ion exchange properties and higher damage resistance while facilitating melting and forming processes. Many glasses with high indentation threshold are based on the  $\text{SiO}_2\text{—Al}_2\text{O}_3\text{—B}_2\text{O}_3\text{—MgO—Na}_2\text{O—P}_2\text{O}_5$  glass systems. The open structure (i.e. high molar volume) resulting from the existence of boron or phosphorus leads to high inherent damage resistance (IDR).

## SUMMARY

**[0004]** A group of glass compositions in the  $\text{Li}_2\text{O—Al}_2\text{O}_3\text{—SiO}_2\text{—B}_2\text{O}_3$  family is provided. These glasses can be chemically strengthened in single or multiple ion exchange baths containing at least one of  $\text{NaNO}_3$  and  $\text{KNO}_3$  for a short time (2-4 hours) to develop a deep depth of layer (DOL). In some instances, the DOL is at least 70  $\mu\text{m}$ ; in others, at least about 100  $\mu\text{m}$ . The ion exchanged glasses have a high damage resistance (indentation fracture toughness ranging from greater than 10 kgf to greater than 50 kgf) that is better than or at least comparable to that of sodium aluminosilicate glasses.

**[0005]** Accordingly, one aspect of the disclosure is to provide a lithium aluminosilicate glass. The glass comprises: from about 55 mol % to about 75 mol %  $\text{SiO}_2$ ; from about 9 mol % to about 18 mol %  $\text{Al}_2\text{O}_3$ ; from about 2.5 mol % to about 20 mol %  $\text{B}_2\text{O}_3$ ; from about 3 mol % to about 20 mol %  $\text{Li}_2\text{O}$ ; and from 0 mol % to about 4 mol %  $\text{P}_2\text{O}_5$ .

**[0006]** Another aspect of the disclosure is to provide a lithium aluminosilicate glass. The glass is ion exchanged and has a compressive layer extending to a depth of layer of at least about 70  $\mu\text{m}$  from at least one surface into the glass. The compressive layer having a maximum compressive stress at the surface of at least about 600 MPa. The glass also has a Vickers crack initiation threshold of at least about 10 kgf and a Knoop scratch threshold of at least about 8 N.

**[0007]** According to a first aspect of the disclosure a lithium aluminosilicate glass is provided. The lithium aluminosilicate glass comprises: from about 55 mol % to about 75 mol %  $\text{SiO}_2$ ; from about 10 mol % to about 18 mol %  $\text{Al}_2\text{O}_3$ ; from about 3.5 mol % to about 9.5 mol %  $\text{B}_2\text{O}_3$ ; from about 7 mol % to about 14 mol %  $\text{Li}_2\text{O}$ ; and from 0 mol % to about 4 mol %  $\text{P}_2\text{O}_5$ , wherein  $\text{Li}_2\text{O}$  (mol %)/ $\text{R}_2\text{O}$  (mol %) is in a range from about 0.1 to about 0.4 and  $\text{R}_2\text{O}=\text{Li}_2\text{O}+\text{Na}_2\text{O}+\text{K}_2\text{O}+\text{Rb}_2\text{O}+\text{Cs}_2\text{O}$ .

**[0008]** According to a second aspect of the disclosure, the lithium aluminosilicate glass of the first aspect is ion exchanged.

**[0009]** According to a third aspect of the disclosure, the ion exchanged lithium aluminosilicate glass of the second aspect has a compressive layer extending to a depth of layer of at least about 70  $\mu\text{m}$  from at least one surface into the glass, the compressive layer having a maximum compressive stress of at least about 600 MPa.

**[0010]** According to a fourth aspect of the disclosure, in the ion exchanged lithium aluminosilicate glass of the third aspect the compressive layer has a compressive stress of at least about 100 MPa at a depth of 50  $\mu\text{m}$  below the surface.

**[0011]** According to a fifth aspect of the disclosure, the ion exchanged lithium aluminosilicate glass of any of the second through fourth aspects has a Vickers crack initiation threshold of at least about 10 kgf.

**[0012]** According to a sixth aspect of the disclosure, the ion exchanged lithium aluminosilicate glass of any of the second through fifth aspects has a Knoop scratch threshold of at least about 8 N.

**[0013]** According to a seventh aspect of the disclosure, the lithium aluminosilicate glass of any of the first through sixth aspects has a liquidus viscosity of at least about 10 kP.

**[0014]** According to an eighth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through seventh aspects has a softening point of about 840° C. or less.

**[0015]** According to a ninth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through eighth aspects has an anneal point of at least about 510° C.

**[0016]** According to a tenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through ninth aspects has an elastic modulus of at least about 68 GPa.

**[0017]** According to an eleventh aspect of the disclosure, the lithium aluminosilicate glass of any of the first through tenth aspects is provided wherein  $\text{R}_2\text{O}$  (mol %)— $\text{Al}_2\text{O}_3$  (mol %) is in a range from about −2 mol % to about 5.6 mol %.

**[0018]** According to a twelfth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through eleventh aspects is provided wherein  $\text{Al}_2\text{O}_3$  (mol %) $>\text{B}_2\text{O}_3$  (mol %).

**[0019]** According to a thirteenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through twelfth aspects is provided wherein the lithium aluminosilicate glass comprises: from about 58 mol % to about 69 mol %  $\text{SiO}_2$ ; from about 10 mol % to about 17 mol %  $\text{Al}_2\text{O}_3$ ;

from about 3.5 mol % to about 9.5 mol %  $B_2O_3$ ; from 0 mol % to about 2.5 mol %  $P_2O_5$ ; from about 7 mol % to about 14 mol %  $Li_2O$ ; from about 0.2 mol % to about 14 mol %  $Na_2O$ ; from 0 mol % to about 2.5 mol %  $K_2O$ ; from 0 mol % to about 5 mol %  $MgO$ ; and from 0 mol % to about 4 mol %  $ZnO$ , wherein  $Li_2O$  (mol %)/ $R_2O$  (mol %) is in a range from about 0.1 to about 0.4.

**[0020]** According to a fourteenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through thirteenth aspects is provided wherein the lithium aluminosilicate glass comprises: from about 5 mol % to about 9 mol %  $B_2O_3$ ; from about 7 mol % to about 10 mol %  $Li_2O$ ; from about 4 mol % to about 14 mol %  $Na_2O$ ; and from 0 mol % to about 1 mol %  $K_2O$ .

**[0021]** According to a fifteenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through fourteenth aspects is provided wherein  $(Al_2O_3$  (mol %)+ $B_2O_3$  (mol %))/ $R_2O$  (mol %) is in a range from about 0.9 to about 1.9.

**[0022]** According to a sixteenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through fifteenth aspects is provided wherein  $R_2O$  (mol %)+ $R'O$  (mol %)- $Al_2O_3$  (mol %)- $B_2O_3$  (mol %)- $P_2O_5$  (mol %) is in a range from about -10.5 mol % to about -0.11 mol %, where  $R'O=MgO+CaO+SrO+BaO$ .

**[0023]** According to a seventeenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through sixteenth aspects is provided wherein the lithium aluminosilicate glass comprises from about 5 mol % to about 12 mol %  $Li_2O$ .

**[0024]** According to an eighteenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through seventeenth aspects is provided wherein the lithium aluminosilicate glass comprises: from 0 mol % to about 5 mol %  $Na_2O$ ; from 0 mol % to about 4 mol %  $K_2O$ ; from 0 mol % to about 8 mol %  $MgO$ ; from 0 mol % to about 4 mol %  $ZnO$ ; from 0 mol % to about 5 mol %  $TiO_2$ ; and from 0 mol % to about 3 mol %  $P_2O_5$ .

**[0025]** According to a nineteenth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through eighteenth aspects is provided wherein the lithium aluminosilicate glass comprises: from about 55 mol % to about 60 mol %  $SiO_2$ ; from about 12 mol % to about 15 mol %  $Al_2O_3$ ; from about 3.5 mol % to about 7.5 mol %  $B_2O_3$ ; from about 7 mol % to about 10 mol %  $Li_2O$ ; and from 0 mol % to about 3 mol %  $P_2O_5$ .

**[0026]** According to a twentieth aspect of the disclosure, the lithium aluminosilicate glass of any of the first through nineteenth aspects is provided wherein the lithium aluminosilicate glass comprises from about 5 mol % to about 7 mol %  $B_2O_3$ .

**[0027]** According to a twenty-first aspect of the disclosure, the lithium aluminosilicate glass of any of the first through twentieth aspects is provided wherein the lithium aluminosilicate glass comprises: from 0 mol % to about 5 mol %  $Na_2O$ ; and from about 0.05 mol % to about 0.5 mol %  $SnO_2$ .

**[0028]** According to a twenty-second aspect of the disclosure a consumer electronic product is provided. The consumer electronic product comprises: a housing having a front surface, a back surface and side surfaces; electrical components provided at least partially within the housing, the electrical components including at least a controller, a memory, and a display, the display being provided at or adjacent the front surface of the housing; and a cover glass

disposed over the display, wherein at least one of a portion of the housing or the cover glass comprises the lithium aluminosilicate glass of any of the first through twenty-first aspects.

**[0029]** According to a twenty-third aspect of the disclosure a consumer electronic product is provided. The lithium aluminosilicate glass comprises: from about 55 mol % to about 75 mol %  $SiO_2$ ; from about 10 mol % to about 18 mol %  $Al_2O_3$ ; from about 2.5 mol % to about 7.5 mol %  $B_2O_3$ ; from about 5 mol % to about 14 mol %  $Li_2O$ ; from 0 mol % to about 4 mol %  $P_2O_5$ ; and from 0 mol % to about 1 mol %  $K_2O$ ; wherein  $Li_2O$  (mol %)/ $R_2O$  (mol %) is in a range from about 0.1 to about 0.4,  $R_2O=Li_2O+Na_2O+K_2O+Rb_2O+Cs_2O$ ,  $R_2O$  (mol %)+ $R'O$  (mol %)- $Al_2O_3$  (mol %)- $B_2O_3$  (mol %)- $P_2O_5$  (mol %) is in a range from about -10.5 mol % to about -0.11 mol %, and  $R'O=MgO+CaO+SrO+BaO$ .

**[0030]** According to a twenty-fourth aspect of the disclosure, the lithium aluminosilicate glass of the twenty-third aspect is ion exchanged.

**[0031]** According to a twenty-fifth aspect of the disclosure, the ion exchanged lithium aluminosilicate glass of the twenty-fourth aspect has a compressive layer extending to a depth of layer of at least about 70  $\mu m$  from at least one surface into the glass, the compressive layer having a maximum compressive stress of at least about 600 MPa.

**[0032]** According to a twenty-sixth aspect of the disclosure, in the ion exchanged lithium aluminosilicate glass of the twenty-fifth aspect the compressive layer has a compressive stress of at least about 100 MPa at a depth of 50  $\mu m$  below the surface.

**[0033]** According to a twenty-seventh aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through twenty-sixth aspects has a Vickers crack initiation threshold of at least about 10 kgf.

**[0034]** According to a twenty-eighth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through twenty-seventh aspects has a Knoop scratch threshold of at least about 8 N.

**[0035]** According to a twenty-ninth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through twenty-eighth aspects has a liquidus viscosity of at least about 10 kP.

**[0036]** According to a thirtieth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through twenty-ninth aspects has a softening point of about 840° C. or less.

**[0037]** According to a thirty-first aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirtieth aspects has an anneal point of at least about 510° C.

**[0038]** According to a thirty-second aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-first aspects has an elastic modulus of at least about 68 GPa.

**[0039]** According to a thirty-third aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-second aspects is provided wherein  $R_2O$  (mol %)- $Al_2O_3$  (mol %) is in a range from about -2 mol % to about 5.6 mol %.

**[0040]** According to a thirty-fourth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-third aspects is provided wherein  $Al_2O_3$  (mol %)> $B_2O_3$  (mol %).



**[0041]** According to a thirty-fifth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-fourth aspects is provided wherein  $(\text{Al}_2\text{O}_3 \text{ (mol \%)} + \text{B}_2\text{O}_3 \text{ (mol \%)})/\text{R}_2\text{O} \text{ (mol \%)}$  is in a range from about 0.9 to about 1.9.

**[0042]** According to a thirty-sixth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-fifth aspects is provided wherein the lithium aluminosilicate glass comprises: from 0 mol % to about 5 mol %  $\text{Na}_2\text{O}$ ; from 0 mol % to about 8 mol %  $\text{MgO}$ ; from 0 mol % to about 4 mol %  $\text{ZnO}$ ; from 0 mol % to about 5 mol %  $\text{TiO}_2$ ; and from 0 mol % to about 3 mol %  $\text{P}_2\text{O}_5$ .

**[0043]** According to a thirty-seventh aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-sixth aspects is provided wherein the lithium aluminosilicate glass comprises from about 5 mol % to about 7 mol %  $\text{B}_2\text{O}_3$ .

**[0044]** According to a thirty-eighth aspect of the disclosure, the lithium aluminosilicate glass of any of the twenty-third through thirty-seventh aspects is provided wherein the lithium aluminosilicate glass comprises: from 0 mol % to about 5 mol %  $\text{Na}_2\text{O}$ ; and from about 0.05 mol % to about 0.5 mol %  $\text{SnO}_2$ .

**[0045]** According to a thirty-ninth aspect of the disclosure a consumer electronic product is provided. The consumer electronic product comprises: a housing having a front surface, a back surface and side surfaces; electrical components provided at least partially within the housing, the electrical components including at least a controller, a memory, and a display, the display being provided at or adjacent the front surface of the housing; and a cover glass disposed over the display, wherein at least one of a portion of the housing or the cover glass comprises the lithium aluminosilicate glass of any of the twenty-third through thirty-eighth aspects.

**[0046]** According to a fortieth aspect of the disclosure a lithium aluminosilicate glass is provided. The lithium aluminosilicate glass is ion exchanged and has a compressive layer extending to a depth of layer of at least about 70  $\mu\text{m}$  from at least one surface into the glass, the compressive layer having a maximum compressive stress of at least about 600 MPa, wherein the glass has a Vickers crack initiation threshold of at least about 10 kgf and a Knoop scratch threshold of at least about 8 N.

**[0047]** According to a forty-first aspect of the disclosure a consumer electronic product is provided. The consumer electronic product comprises: a housing having a front surface, a back surface and side surfaces; electrical components provided at least partially within the housing, the electrical components including at least a controller, a memory, and a display, the display being provided at or adjacent the front surface of the housing; and a cover glass disposed over the display, wherein at least one of a portion of the housing or the cover glass comprises the lithium aluminosilicate glass of the fortieth aspect.

**[0048]** These and other aspects, advantages, and salient features of the present disclosure will become apparent from the following detailed description, the accompanying drawings, and the appended claims.

#### BRIEF DESCRIPTION OF THE DRAWINGS

**[0049]** FIG. 1 is a cross-sectional schematic view of an ion exchanged glass article;

**[0050]** FIG. 2 is a plot of  $\text{Na}^+$  concentration profile from the surface of the glass to the inner portion of the glass for a lithium aluminosilicate glass of the present disclosure (A) and a glass ceramic (B);

**[0051]** FIG. 3 is a plot of indentation fracture threshold for a lithium aluminosilicate glass of the present disclosure, ion exchanged at 390° C. in  $\text{NaNO}_3$  for 3.5 hours, and sodium aluminosilicate glasses after ion exchange in  $\text{KNO}_3$ ;

**[0052]** FIG. 4 shows optical microscopic images of Vickers indentations in the ion exchanged lithium aluminosilicate glass plotted in FIG. 3 under indenter loads of 10 kgf, 30 kgf, and 50 kgf;

**[0053]** FIG. 5A is a plan view of an exemplary electronic device incorporating any of the articles disclosed herein; and

**[0054]** FIG. 5B is a perspective view of the exemplary electronic device of FIG. 5A.

#### DETAILED DESCRIPTION

**[0055]** In the following description, like reference characters designate like or corresponding parts throughout the several views shown in the figures. It is also understood that, unless otherwise specified, terms such as “top,” “bottom,” “outward,” “inward,” and the like are words of convenience and are not to be construed as limiting terms. In addition, whenever a group is described as comprising at least one of a group of elements and combinations thereof, it is understood that the group may comprise, consist essentially of, or consist of any number of those elements recited, either individually or in combination with each other. Similarly, whenever a group is described as consisting of at least one of a group of elements or combinations thereof, it is understood that the group may consist of any number of those elements recited, either individually or in combination with each other. Unless otherwise specified, a range of values, when recited, includes both the upper and lower limits of the range as well as any ranges therebetween. As used herein, the indefinite articles “a,” “an,” and the corresponding definite article “the” mean “at least one” or “one or more,” unless otherwise specified. It also is understood that the various features disclosed in the specification and the drawings can be used in any and all combinations.

**[0056]** As used herein, the terms “glass article” and “glass articles” are used in their broadest sense to include any object made wholly or partly of glass. Unless otherwise specified, all compositions are expressed in terms of mole percent (mol %). Coefficients of thermal expansion (CTE) are expressed in terms of  $10^{-7}/^\circ\text{C}$ . and represent a value measured over a temperature range from about 20° C. to about 300° C., unless otherwise specified.

**[0057]** Unless otherwise specified, all temperatures are expressed in terms of degrees Celsius ( $^\circ\text{C}$ ). As used herein the term “softening point” refers to the temperature at which the viscosity of a glass is approximately  $10^{7.6}$  poise (P), the term “anneal point” refers to the temperature at which the viscosity of a glass is approximately  $10^{13.2}$  poise, the term “200 poise temperature ( $T^{200P}$ )” refers to the temperature at which the viscosity of a glass is approximately 200 poise, the term “1 poise temperature ( $T^{200P}$ )” refers to the temperature at which the viscosity of a glass is approximately 200 poise, the term “ $10^{11}$  poise temperature” refers to the temperature at which the viscosity of a glass is approximately  $10^{11}$  poise, the term “35 kP temperature ( $T^{35kP}$ )” refers to the temperature at which the viscosity of a glass is approximately 35 kilopoise (kP), and the term “160 kP

temperature ( $T^{160kP}$ )” refers to the temperature at which the viscosity of a glass is approximately 160 kP. As used herein, the term “liquidus temperature,” or “TL” refers to the temperature at which crystals first appear as a molten glass cools down from the melting temperature, or the temperature at which the very last crystals melt away as temperature is increased from room temperature.

[0058] It is noted that the terms “substantially” and “about” may be utilized herein to represent the inherent degree of uncertainty that may be attributed to any quantitative comparison, value, measurement, or other representation. These terms are also utilized herein to represent the degree by which a quantitative representation may vary from a stated reference without resulting in a change in the basic function of the subject matter at issue. Thus, a glass that is “substantially free of MgO” is one in which MgO is not actively added or batched into the glass, but may be present in very small amounts (e.g., less than 0.1 mol %) as a contaminant.

[0059] Referring to the drawings in general and to FIG. 1 in particular, it will be understood that the illustrations are for the purpose of describing particular embodiments and are not intended to limit the disclosure or appended claims thereto. The drawings are not necessarily to scale, and certain features and certain views of the drawings may be shown exaggerated in scale or in schematic in the interest of clarity and conciseness.

[0060] Described herein are ion exchangeable lithium aluminosilicate glasses that exhibit high levels of damage resistance—also referred to as native damage resistance or inherent damage resistance—as characterized by Vickers crack initiation threshold and Knoop scratch testing, when chemically strengthened. These glasses may in general be ion exchanged in sodium salts (e.g.,  $\text{NaNO}_3$ ) at faster rates than analogous sodium alkali aluminosilicate glasses are ion exchanged in potassium salts (e.g.,  $\text{KNO}_3$ ). Deeper depths of compression (also referred to as “depth of layer” or “DOL”) may also be achieved at lower temperatures with the lithium-containing glasses. When  $\text{Na}^+$  replaces  $\text{Li}^+$  in the glass, the rate of diffusion may be about 10 times faster than exchange of  $\text{K}^+$  for  $\text{Na}^+$  in the glass. Mixed salt baths may be used to allow for dual ion exchange in which both  $\text{K}^+$  for  $\text{Na}^+$  and  $\text{Na}^+$  for  $\text{Li}^+$  exchange occur, resulting in a deep depth of compression due to the  $\text{Na}^+$  for  $\text{Li}^+$  exchange and high surface compressive stress due to the  $\text{K}^+$  for  $\text{Na}^+$  exchange.

[0061] The lithium aluminosilicate glasses described herein comprise or consist essentially of: from about 55 mol % to about 75 mol %  $\text{SiO}_2$  (55 mol %  $\leq \text{SiO}_2 \leq 75$  mol %); from about 9 mol % to about 18 mol %  $\text{Al}_2\text{O}_3$  (9 mol %  $\leq \text{Al}_2\text{O}_3 \leq 18$  mol %); from about 2.5 mol % to about 20 mol %  $\text{B}_2\text{O}_3$  (2.5 mol %  $\leq \text{B}_2\text{O}_3 \leq 20$  mol %); from about 3 mol % to about 20 mol %  $\text{Li}_2\text{O}$  (3 mol %  $\leq \text{Li}_2\text{O} \leq 20$  mol %); and from 0 mol % to about 4 mol %  $\text{P}_2\text{O}_5$  (0 mol %  $\leq \text{P}_2\text{O}_5 \leq 4$  mol %). In some embodiments, the glass further comprises at least one of: from 0 mol % to about 5 mol %  $\text{Na}_2\text{O}$ ; from 0 mol % to about 4 mol %  $\text{K}_2\text{O}$ ; from 0 mol % to about 8 mol %  $\text{MgO}$ ; from 0 mol % to about 4 mol %  $\text{ZnO}$ , and from 0 mol % to about 5 mol %  $\text{TiO}_2$ .

[0062] In particular embodiments, the lithium aluminosilicate glasses described herein comprise or consist essentially of: from about 55 mol % to about 75 mol %  $\text{SiO}_2$ ; from about 10 mol % to about 18 mol %  $\text{Al}_2\text{O}_3$ ; from 0 mol % to about 20 mol %  $\text{B}_2\text{O}_3$ ; from about 5 mol % to about 14 mol

%  $\text{Li}_2\text{O}$ ; from 0 mol % to about 5 mol %  $\text{Na}_2\text{O}$ ; from 0 mol % to about 4 mol %  $\text{K}_2\text{O}$ ; from 0 mol % to about 8 mol %  $\text{MgO}$ ; from 0 mol % to about 4 mol %  $\text{ZnO}$ ; from 0 mol % to about 5 mol %  $\text{TiO}_2$ ; from 0 mol % to about 4 mol %  $\text{P}_2\text{O}_5$ , and from about 0.05 mol % to about 0.5 mol %  $\text{SnO}_2$ . Even more particularly, the glass may comprise or consist essentially of: from about 55 mol % to about 60 mol %  $\text{SiO}_2$  (55 mol %  $\leq \text{SiO}_2 \leq 60$  mol %); from about 12 mol % to about 15 mol %  $\text{Al}_2\text{O}_3$  (12 mol %  $\leq \text{Al}_2\text{O}_3 \leq 15$  mol %); from about 2.5 mol % to about 7.5 mol %  $\text{B}_2\text{O}_3$  (2.5 mol %  $\leq \text{B}_2\text{O}_3 \leq 7.5$  mol %); from about 7 mol % to about 10 mol %  $\text{Li}_2\text{O}$  (7 mol %  $\leq \text{Li}_2\text{O} \leq 10$  mol %); and from 0 mol % to about 3 mol %  $\text{P}_2\text{O}_5$  (0 mol %  $\leq \text{P}_2\text{O}_5 \leq 3$  mol %). Most preferably,  $\text{B}_2\text{O}_3$  is in a range from about 5 mol % to about 7 mol %. Non-limiting examples of the compositions of such glasses and a reference composition (9667) are listed in Table 1.

TABLE 1

Examples of the lithium aluminosilicate glasses.						
mol % oxide	Reference 9667	1 REN	2 REO	3 RET	4 RGC	5 RDD
$\text{SiO}_2$	69.2	65.0	63.0	59.3	63.3	67.3
$\text{Al}_2\text{O}_3$	12.6	14.4	15.5	15.4	15.3	13.5
$\text{B}_2\text{O}_3$	1.8	2.3	2.3	6.0	6.0	2.0
$\text{Li}_2\text{O}$	7.7	8.8	9.7	9.7	9.6	7.7
$\text{Na}_2\text{O}$	0.4	0.6	0.6	0.6	0.6	0.6
$\text{MgO}$	2.9	4.0	4.0	4.0	4.0	4.0
$\text{ZnO}$	1.7	1.2	1.2	1.2	1.2	1.2
$\text{TiO}_2$	3.5	3.5	3.5	3.6	0.0	3.5
$\text{SnO}_2$	0.2	0.2	0.2	0.2	0.2	0.2
$\text{P}_2\text{O}_5$	0	0	0	0	0	0
mol % oxide	6 RDE	7 RDF	8 RDG	9 RDH	10 RDI	11 RFX
$\text{SiO}_2$	65.9	64.7	63.4	62.3	61.0	68.9
$\text{Al}_2\text{O}_3$	13.2	13.0	12.7	12.5	12.2	13.9
$\text{B}_2\text{O}_3$	4.0	5.8	7.6	9.2	10.9	2.4
$\text{Li}_2\text{O}$	7.5	7.5	7.3	7.1	7.1	7.9
$\text{Na}_2\text{O}$	0.6	0.6	0.6	0.6	0.5	0.6
$\text{MgO}$	4.0	3.8	3.8	3.7	3.7	4.1
$\text{ZnO}$	1.2	1.1	1.1	1.1	1.1	1.2
$\text{TiO}_2$	3.4	3.4	3.3	3.3	3.2	0
$\text{SnO}_2$	0.2	0.2	0.2	0.2	0.2	0.1
$\text{P}_2\text{O}_5$	0	0	0	0	0	0.9
mol % oxide	12 RFY	13 RFZ	14 RGA	15 RGB		
$\text{SiO}_2$	68.2	67.6	66.9	69.5		
$\text{Al}_2\text{O}_3$	13.8	13.6	13.5	14.0		
$\text{B}_2\text{O}_3$	2.3	2.3	2.3	2.4		
$\text{Li}_2\text{O}$	7.9	7.8	7.7	8.0		
$\text{Na}_2\text{O}$	0.6	0.6	1.7	0.6		
$\text{MgO}$	4.0	4.0	4.0	4.1		
$\text{ZnO}$	1.2	1.2	1.2	1.2		
$\text{TiO}_2$	0	0	0	0		
$\text{SnO}_2$	0.1	0.1	0.1	0.1		
$\text{P}_2\text{O}_5$	1.8	2.7	2.7	0.0		

[0063] In particular embodiments, the lithium aluminosilicate glasses described herein comprise or consist essentially of: from about 58 mol % to about 69 mol %  $\text{SiO}_2$  (58 mol %  $\leq \text{SiO}_2 \leq 69$  mol %); from about 9 mol % to about 17 mol %  $\text{Al}_2\text{O}_3$  (9 mol %  $\leq \text{Al}_2\text{O}_3 \leq 17$  mol %); from about 3.5 mol % to about 9.5 mol %  $\text{B}_2\text{O}_3$  (3.5 mol %  $\leq \text{B}_2\text{O}_3 \leq 9.5$  mol %); from 0 mol % to about 2.5 mol %  $\text{P}_2\text{O}_5$  (0 mol %  $\leq \text{P}_2\text{O}_5 \leq 4$  mol %); from about 2.5 mol % to about 12 mol %  $\text{Li}_2\text{O}$  (2.5 mol %  $\leq \text{Li}_2\text{O} \leq 12$  mol %); from about 0.2 mol % to about 12 mol %  $\text{Na}_2\text{O}$  (0.2 mol %  $\leq \text{Na}_2\text{O} \leq 13$  mol %); from 0 mol %

to about 2.5 mol %  $K_2O$  (0 mol %  $\leq K_2O \leq 2.5$  mol %); 0 mol % to about 5 mol %  $MgO$  (0 mol %  $\leq MgO \leq 5$  mol %); and/or from 0 mol % to about 4 mol %  $ZnO$  (0 mol %  $\leq ZnO \leq 4$  mol %). More particularly, the glass may comprise: from about 5 mol % to about 9 mol %  $B_2O_3$  (5 mol %  $\leq B_2O_3 \leq 9$  mol %); from about 4 mol % to about 10 mol %  $Li_2O$  (4 mol %  $\leq Li_2O \leq 10$  mol %); from about 4 mol % to about 14 mol %  $Na_2O$  (4 mol %  $\leq Na_2O \leq 14$  mol %); from 0 mol % to about 1 mol %  $K_2O$  (0 mol %  $\leq K_2O \leq 1$  mol %); 0 mol % to about 3 mol %  $MgO$  (0 mol %  $\leq MgO \leq 3$  mol %); and/or from 0 mol % to about 3 mol %  $ZnO$  (0 mol %  $\leq ZnO \leq 3$  mol %). These glasses may further include from about 0.05 mol % to about 0.5 mol %  $SnO_2$  (0.05 mol %  $\leq SnO_2 \leq 0.5$  mol %). Non-limiting examples of the compositions of such glasses are listed in Table 2.

**[0064]** In some embodiments,  $(Li_2O \text{ (mol \%)} / R_2O \text{ (mol \%)})$  is in a range from about 0.1 to about 0.5 (0.1  $\leq (Li_2O \text{ (mol \%)} / R_2O \text{ (mol \%)}) \leq 0.5$ ), where  $R_2O = Li_2O + Na_2O + K_2O + Rb_2O + Cs_2O$ .

**[0065]** In some embodiments,  $R_2O \text{ (mol \%)} - Al_2O_3 \text{ (mol \%)}$  is in a range from about -2 mol % to about 5.6 mol %, where  $R_2O = Li_2O + Na_2O + K_2O + Rb_2O + Cs_2O$ . In some embodiments,  $Al_2O_3 \text{ (mol \%)} > B_2O_3 \text{ (mol \%)}$ . In some embodiments,  $(Al_2O_3 \text{ (mol \%)} + B_2O_3 \text{ (mol \%)}) / R_2O \text{ (mol \%)}$  is in a range from about 0.9 to about 1.9. In some

embodiments,  $R_2O \text{ (mol \%)} + R'O \text{ (mol \%)} - Al_2O_3 \text{ (mol \%)} - B_2O_3 \text{ (mol \%)} - P_2O_5 \text{ (mol \%)}$  is in a range from about -10.5 mol % to about -0.11 mol %, where  $R'O = MgO + CaO + SrO + BaO$ .

**[0066]** In some embodiments, the lithium aluminosilicate glasses described herein have softening points that are lower than sodium analogs, which typically have softening points of greater than about 900° C. In some embodiments, the glasses described herein have softening points of about 840° C. or less. In certain embodiments, the glass has a softening point of about 820° C. or less and, in still other embodiments, about 800° C. or less. These low softening points are accompanied by coefficients of thermal expansion (CTE) that are lower than those of sodium analogs. Lower CTE is important in maintaining dimensional stability when reforming glass sheets. In addition to use as flat plates, the relatively low CTEs of the present glasses enable their use as three-dimensional articles and in automotive applications.

**[0067]** In some embodiments, the lithium aluminosilicate glasses described herein have an anneal point of at least about 500° C. In certain embodiments the glass has an anneal point of at least about 520° C. and, in still other embodiments, the anneal point is at least about 530° C.

**[0068]** Densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) for selected glass compositions are listed in Table 2.

TABLE 2

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
mol %	196HNT	107UE	107UF	107UG	107UH	107UI
$SiO_2$	67.00	67.11	67.18	66.96	67.17	67.20
$Al_2O_3$	12.60	9.14	10.12	9.13	10.15	10.15
$B_2O_3$	7.10	0.00	0.00	0.00	0.00	0.00
$Li_2O$	5.10	8.10	7.66	6.28	5.24	5.23
$Na_2O$	6.70	11.38	10.86	13.26	13.27	13.31
$K_2O$	1.30	0.26	0.27	0.26	0.26	0.27
$MgO$		1.17	1.08	1.29	1.12	1.75
$CaO$		1.82	1.82	1.80	1.78	1.09
$SnO_2$	0.10	0.00	0.00	0.00	0.00	0.00
$R_2O - Al_2O_3$	0.50					
$Li_2O / (R_2O)$	0.389	0.410	0.408	0.317	0.279	0.278
Strain Pt. (° C.)		459.1	473.2	462.8	482.3	482.3
Anneal Pt. (° C.)		500.2	514.1	504.5	525.6	524.9
Softening Pt. (° C.)		691.8	719.3	703.8	733	739.7
CTE ( $\times 10^{-7}/^\circ C.$ )		87.8	84.2	89.9	86.9	87
Density (g/cm <sup>3</sup> )		2.474	2.471	2.479	2.477	2.473
mol %	107UJ	107UK	107UL	107UM	107UN	107UO
$SiO_2$	67.01	70.21	70.17	70.14	71.17	71.19
$Al_2O_3$	10.14	8.51	8.50	8.49	7.47	6.88
$B_2O_3$	0.00	0.00	0.00	0.00	0.00	0.00
$Li_2O$	6.30	5.45	6.49	6.93	5.33	5.28
$Na_2O$	11.32	11.30	10.32	9.82	11.49	12.09
$K_2O$	0.27	0.98	0.99	0.99	0.99	0.98
$MgO$	2.15	1.02	0.99	1.06	1.02	1.04
$CaO$	1.80	1.53	1.53	1.55	1.53	1.52
$SnO_2$	0.00	0.00	0.00	0.00	0.00	0.00
$R_2O - Al_2O_3$						
$Li_2O / (R_2O)$	0.352	0.307	0.365	0.391	0.299	0.288
Strain Pt. (° C.)	485.5	469.2	466.8	464.2	460.5	452.8
Anneal Pt. (° C.)	529	511.6	509.5	506.9	502.3	495.3

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Softening Pt. (° C.)	741	728.6	720.1	714.1	712.3	702.7
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	83.3	84.2	83.1	82.4	84.5	85.3
Density (g/cm <sup>3</sup> )	2.474	2.458	2.455	2.453	2.454	2.452
mol %	107UP	107UQ	107UR	107US	107UT	107UU
SiO <sub>2</sub>	69.60	66.42	66.49	66.27	66.33	65.31
Al <sub>2</sub> O <sub>3</sub>	7.78	9.39	9.38	8.09	8.09	6.98
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	5.10	6.39	6.37	11.73	10.66	9.65
Na <sub>2</sub> O	12.90	11.57	11.60	9.98	9.97	10.48
K <sub>2</sub> O	0.98	1.23	1.23	0.01	0.01	1.49
MgO	1.08	0.05	0.04	0.03	0.04	0.51
CaO	1.55	3.55	2.51	1.05	2.08	2.59
SnO <sub>2</sub>	0.00	0.00	0.00	0.00	0.00	0.00
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.269	0.333	0.332	0.540	0.516	0.446
Strain Pt. (° C.)	452.6	474.5	484	460.6	466.7	452.7
Anneal Pt. (° C.)	494.2	515.5	526.7	499.5	506.9	492.3
Softening Pt. (° C.)	697	711.3	732.2	693.2	697.6	678.6
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	90.5	90.1	87.6	86.7	84.9	92.5
Density (g/cm <sup>3</sup> )	2.468	2.499	2.519	2.51	2.519	2.539
mol %	107UV	107UW	107UX	107UY	107UZ	107VA
SiO <sub>2</sub>	65.28	65.86	67.91	69.80	68.09	67.98
Al <sub>2</sub> O <sub>3</sub>	6.96	9.56	8.99	8.49	10.01	10.99
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	9.67	8.42	7.96	7.40	6.77	5.91
Na <sub>2</sub> O	10.49	11.70	10.94	10.36	10.96	10.94
K <sub>2</sub> O	2.48	0.27	0.27	0.24	0.25	0.27
MgO	0.03	1.09	1.03	0.98	1.02	1.02
CaO	2.07	1.90	1.79	1.69	1.78	1.78
SnO <sub>2</sub>	0.00	0.11	0.10	0.09	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.427	0.413	0.415	0.411	0.376	0.345
Strain Pt. (° C.)	448.3	464	464	469	484	503
Anneal Pt. (° C.)	486.2	505	506	511	526	548
Softening Pt. (° C.)	671.5	697	706	716	737	772
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	84.2	90.4	86.7	86.3	83.8	82
Density (g/cm <sup>3</sup> )	2.537	2.485	2.472	2.458	2.47	2.468
mol %	107VB	107VC	107VD	107VE	107VF	107VG
SiO <sub>2</sub>	67.98	67.26	66.04	65.24	66.39	66.15
Al <sub>2</sub> O <sub>3</sub>	9.00	9.43	9.95	10.46	8.99	10.98
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	7.92	7.78	7.82	7.77	7.56	7.76
Na <sub>2</sub> O	10.96	11.39	11.96	12.37	11.94	11.93
K <sub>2</sub> O	0.26	0.26	0.27	0.26	0.26	0.27
MgO	1.34	1.00	1.04	1.01	1.00	1.03
CaO	1.42	1.78	1.82	1.77	1.77	1.78
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.414	0.400	0.390	0.381	0.382	0.389
Strain Pt. (° C.)	466	463	465	468	470	460
Anneal Pt. (° C.)	508	505	506	508	512	501
Softening Pt. (° C.)	707	706	702	706	712	697

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	86.3	86.7	89.4	89.4	88.3	89.7
Density ( $\text{g}/\text{cm}^3$ )	2.469	2.401	2.407	2.432	2.411	2.38
mol %	107VH	107VI	107VJ	107VK	107VL	107VM
SiO <sub>2</sub>	65.17	65.52	64.53	63.51	62.63	61.19
Al <sub>2</sub> O <sub>3</sub>	9.96	5.11	6.46	7.71	9.04	10.39
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	7.73	12.67	11.95	11.23	10.52	10.05
Na <sub>2</sub> O	11.94	12.40	12.78	13.29	13.59	14.13
K <sub>2</sub> O	0.27	0.27	0.27	0.27	0.26	0.27
MgO	1.78	1.05	1.05	1.04	1.03	1.04
CaO	2.04	1.85	1.83	1.84	1.80	1.81
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.388	0.500	0.478	0.453	0.432	0.411
Strain Pt. ( $^{\circ}\text{C.}$ )	465	412	416	426	435	443
Anneal Pt. ( $^{\circ}\text{C.}$ )	506	447	453	462	471	481
Softening Pt. ( $^{\circ}\text{C.}$ )	701	602	616	626	640	655
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	90.1	105.9	104.8	103.5	103.3	101.7
Density ( $\text{g}/\text{cm}^3$ )	2.413	2.485	2.49	2.495	2.499	2.511
mol %	107VN	107VU	107VW	107VX	107VY	107VZ
SiO <sub>2</sub>	60.07	68.95	66.00	66.12	68.85	68.81
Al <sub>2</sub> O <sub>3</sub>	11.72	9.97	9.96	9.98	9.96	9.94
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	9.21	7.96	5.00	4.99	7.98	9.94
Na <sub>2</sub> O	14.75	4.94	7.90	7.90	4.96	2.98
K <sub>2</sub> O	0.26	0.99	0.99	0.99	0.99	1.01
MgO	1.06	3.57	3.59	3.50	5.10	2.04
CaO	1.82	1.54	1.53	1.52	2.05	5.17
SnO <sub>2</sub>	0.10	0.09	0.10	0.09	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.380	0.573	0.360	0.359	0.573	0.714
Strain Pt. ( $^{\circ}\text{C.}$ )	452	546.8	524.5	566.4	511.7	500.4
Anneal Pt. ( $^{\circ}\text{C.}$ )	492	592.6	570.9	611.2	556.4	541.5
Softening Pt. ( $^{\circ}\text{C.}$ )	672	825	812.3	830.7	N/A	N/A
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	103.1	65.1	74.5	69.4	67.4	66.1
Density ( $\text{g}/\text{cm}^3$ )	2.506	2.478	2.493	2.531	2.434	2.445
mol %	107WA	107WB	107WC	107WD	107WE	107WF
SiO <sub>2</sub>	68.91	66.92	66.84	68.7	68.63	67.85
Al <sub>2</sub> O <sub>3</sub>	9.95	9.95	9.95	9.95	8.94	9.95
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	6.99	7.94	6.98	7.86	7.82	7.82
Na <sub>2</sub> O	3.95	4.95	3.95	3.93	4.93	3.97
K <sub>2</sub> O	2.94	0.99	2.95	2.95	0.99	2.97
MgO	5.10	5.09	5.16	5.44	6.48	6.29
CaO	2.06	2.06	2.08	1.05	2.10	1.05
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.504	0.572	0.503	0.533	0.569	0.530
Strain Pt. ( $^{\circ}\text{C.}$ )	513.9	521.2	521.3	503.2	502.8	504.1
Anneal Pt. ( $^{\circ}\text{C.}$ )	559.4	563.3	564.5	548.8	546.3	548.5
Softening Pt. ( $^{\circ}\text{C.}$ )	793.9	770.6	776.6	783.4	766	775.6
CTE ( $\times 10^{-7}/^{\circ}\text{C.}$ )	70.7	68.6	71.2	71.1	68	71.7

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.434	2.465	2.463	2.426	2.436	2.433
mol %	107WG	107WH	107WI	107WJ	107WK	107WL
SiO <sub>2</sub>	67.70	67.24	67.05	66.54	65.01	67.47
Al <sub>2</sub> O <sub>3</sub>	8.78	8.63	8.46	8.32	7.95	8.57
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	8.78	9.83	10.69	11.72	12.09	8.34
Na <sub>2</sub> O	10.89	10.68	10.46	10.33	9.87	10.87
K <sub>2</sub> O	0.21	0.17	0.11	0.06	0.27	0.72
MgO	0.83	0.64	0.41	0.21	1.04	1.01
CaO	1.45	1.08	0.72	0.35	1.79	1.63
SnO <sub>2</sub>	0.00	0.00	0.00	0.00	0.00	0.00
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.441	0.475	0.503	0.530	0.544	0.418
Strain Pt. (° C.)	458	457	454	457	444	458
Anneal Pt. (° C.)	499	497	496	497	483	499
Softening Pt. (° C.)	695	691	689	686	664	693
CTE (×10 <sup>-7</sup> /° C.)	87.6	88.2	89.7	89.3	92.5	89.4
Density (g/cm <sup>3</sup> )	2.475	2.482	2.489	2.496	2.502	2.479
mol %	107WM	107WN	107WO	107WP	107WQ	107WR
SiO <sub>2</sub>	67.14	66.58	65.94	66.97	65.95	65.18
Al <sub>2</sub> O <sub>3</sub>	8.18	7.77	7.40	8.56	8.20	7.83
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	1.37	2.66	3.92
Li <sub>2</sub> O	8.47	8.87	9.27	8.15	8.36	8.54
Na <sub>2</sub> O	10.76	10.60	10.55	10.52	10.06	9.42
K <sub>2</sub> O	1.19	1.63	2.08	0.61	0.93	1.24
MgO	1.02	1.04	1.02	1.22	1.40	1.58
CaO	1.46	1.31	1.15	1.41	1.04	0.69
SnO <sub>2</sub>	0.00	0.00	0.00	0.00	0.00	0.00
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.415	0.420	0.423	0.423	0.432	0.445
Strain Pt. (° C.)	453	449	448	455	452	454
Anneal Pt. (° C.)	493	490	488	493	491	491
Softening Pt. (° C.)	687	680	679	682	665	660
CTE (×10 <sup>-7</sup> /° C.)	93.6	94	96.1	87.2	87	87.4
Density (g/cm <sup>3</sup> )	2.491	2.505	2.517	2.475	2.48	2.485
mol %	107WS	107WT	107WU	107WV	107WW	107WX
SiO <sub>2</sub>	66.97	67.00	67.11	67.13	67.08	67.02
Al <sub>2</sub> O <sub>3</sub>	9.42	9.45	9.49	9.46	9.49	9.45
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	5.95	5.91	6.80	5.87	6.85	5.85
Na <sub>2</sub> O	11.40	11.37	11.90	12.38	11.89	12.43
K <sub>2</sub> O	0.26	0.27	0.27	0.26	0.27	0.27
MgO	1.02	3.13	1.55	2.04	1.03	1.04
CaO	3.85	1.78	1.78	1.77	2.29	2.83
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.338	0.337	0.358	0.317	0.360	0.316
Strain Pt. (° C.)	485	485.4	469.7	476.9	469.5	477.8
Anneal Pt. (° C.)	527.2	528.6	511.9	518.7	511.7	519.5
Softening Pt. (° C.)	728.3	739.8	715.7	726	712.2	720.8
CTE (×10 <sup>-7</sup> /° C.)						

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.493	2.48	2.479	2.481	2.482	2.488
mol %	107WY	107WZ	107XA	107XB	107XC	107XD
SiO <sub>2</sub>	68.09	68.08	67.11	66.13	65.19	67.16
Al <sub>2</sub> O <sub>3</sub>	10.05	10.06	10.55	11.04	11.56	11.05
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	7.86	8.78	7.34	7.83	8.22	7.24
Na <sub>2</sub> O	9.85	8.87	10.83	10.83	10.84	10.37
K <sub>2</sub> O	0.25	0.25	0.25	0.25	0.25	0.25
MgO	1.01	1.03	1.03	1.02	1.03	1.03
CaO	1.78	1.81	1.78	1.79	1.79	1.79
SnO <sub>2</sub>	0.10	0.09	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.438	0.490	0.399	0.414	0.426	0.405
Strain Pt. (° C.)	481	479	483	483	482	493
Anneal Pt. (° C.)	523	521	526	525	525	536
Softening Pt. (° C.)	736	728	736	731	731	749
CTE (×10 <sup>-7</sup> /° C.)	83.2	82.2	85.2	84.9	87.3	81.5
Density (g/cm <sup>3</sup> )	2.469	2.465	2.476	2.479	2.483	2.473
mol %	107XE	107XF	107XG	107XH	107XI	107XJ
SiO <sub>2</sub>	65.01	64.58	65.20	65.18	64.25	63.48
Al <sub>2</sub> O <sub>3</sub>	7.26	7.64	6.98	6.97	6.96	6.96
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	10.73	11.72	9.80	9.81	9.81	9.69
Na <sub>2</sub> O	9.42	8.46	10.41	10.42	10.42	10.39
K <sub>2</sub> O	2.48	2.50	2.50	2.51	2.46	2.45
MgO	0.03	0.03	0.03	0.03	1.03	2.02
CaO	2.06	2.06	2.07	2.07	2.05	2.04
SnO <sub>2</sub>	0.00	0.00	0.00	0.00	0.00	0.00
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.474	0.517	0.432	0.431	0.432	0.430
Strain Pt. (° C.)	451.8	451.7	441.9	433.9	446.9	448.8
Anneal Pt. (° C.)	489.7	491.1	480	470.6	486.5	487.5
Softening Pt. (° C.)	676.4	676.7	653.5	634	673.5	669.7
CTE (×10 <sup>-7</sup> /° C.)	2.533	2.53	2.511	2.488	2.543	2.548
Density (g/cm <sup>3</sup> )	2.533	2.53	2.511	2.488	2.543	2.548
mol %	107XK	107XL	107XM	107XN	107XO	107XP
SiO <sub>2</sub>	65.01	64.73	66.60	66.58	65.66	65.04
Al <sub>2</sub> O <sub>3</sub>	7.29	7.69	9.41	9.45	9.42	9.29
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	10.78	11.68	6.34	6.28	6.34	6.22
Na <sub>2</sub> O	9.39	8.41	11.50	11.49	11.46	11.45
K <sub>2</sub> O	1.47	1.48	1.23	1.23	1.20	1.22
MgO	0.50	0.49	0.03	0.04	0.98	1.93
CaO	2.56	2.56	2.55	2.54	2.47	2.43
SnO <sub>2</sub>	0.00	0.00	0.00	0.00	0.00	0.00
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.498	0.542	0.332	0.331	0.334	0.329
Strain Pt. (° C.)	456.5	457	478.8	470	488.6	489.5
Anneal Pt. (° C.)	494.9	496.4	519.9	509.2	531.2	532.1
Softening Pt. (° C.)	675.4	677	714.1	690.4	740	737.8
CTE (×10 <sup>-7</sup> /° C.)	675.4	677	714.1	690.4	740	737.8

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.537	2.533	2.497	2.548	2.527	2.533
mol %	107XQ	107XR	107XS	107XT	107XU	107XV
SiO <sub>2</sub>	67.16	66.15	65.20	67.09	66.09	65.07
Al <sub>2</sub> O <sub>3</sub>	10.07	11.06	12.06	10.06	11.05	12.05
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	7.74	7.71	7.70	8.81	9.76	10.73
Na <sub>2</sub> O	10.88	10.88	10.86	9.87	8.88	7.91
K <sub>2</sub> O	0.25	0.25	0.25	0.25	0.25	0.25
MgO	0.99	1.03	1.02	1.02	1.04	1.03
CaO	1.79	1.80	1.80	1.78	1.81	1.82
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>						
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.410	0.409	0.410	0.465	0.517	0.568
Strain Pt. (° C.)	475	483	494	473	480	490
Anneal Pt. (° C.)	516	525	536	514	522	532
Softening Pt. (° C.)	722	730	748	715	726	733
CTE (×10 <sup>-7</sup> /° C.)	86.5	85.3	86.5	85.1	82.9	81.6
Density (g/cm <sup>3</sup> )	2.476	2.473	2.48	2.483	2.474	2.474
mol %	107XW	107XX	107XY	107XZ	107YA	107YB
SiO <sub>2</sub>	64.13	65.70	62.52	57.42	63.87	61.20
Al <sub>2</sub> O <sub>3</sub>	7.57	7.81	6.98	6.61	4.44	4.57
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	11.36	9.48	12.12	18.97	14.62	17.79
Na <sub>2</sub> O	10.92	11.26	11.16	10.73	9.51	9.25
K <sub>2</sub> O	0.32	0.22	0.24	0.21	0.20	0.22
MgO	1.70	1.56	2.21	1.80	2.01	2.03
CaO	2.40	2.28	2.99	2.80	3.46	3.39
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>						
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.503	0.452	0.516	0.634	0.601	0.653
Strain Pt. (° C.)	439	450	432	406	420	407
Anneal Pt. (° C.)	476	490	469	438	455	441
Softening Pt. (° C.)	645	673	629	570	603	581
CTE (×10 <sup>-7</sup> /° C.)	108.7	104.3	114.1	101.7	95.1	95.9
Density (g/cm <sup>3</sup> )	2.508	2.503	2.524	2.518	2.519	2.515
mol %	107YC	107YD	107YE	107YF	107YG	107YH
SiO <sub>2</sub>	64.66	65.15	65.25	65.22	65.27	65.26
Al <sub>2</sub> O <sub>3</sub>	10.67	11.20	10.68	9.77	10.68	11.19
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	8.27	7.96	7.93	8.38	7.91	8.34
Na <sub>2</sub> O	11.71	11.22	11.18	11.88	11.20	10.73
K <sub>2</sub> O	0.27	0.26	0.26	0.28	0.26	0.26
MgO	1.27	1.21	1.21	1.28	1.69	1.21
CaO	1.95	1.88	1.86	1.98	1.86	1.87
SnO <sub>2</sub>	0.10	0.10	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>						
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.408	0.409	0.409	0.408	0.408	0.432
Strain Pt. (° C.)	471.4	479.4	483.9	462.3	476.3	480.4
Anneal Pt. (° C.)	512.2	521.6	526.1	502	518.4	521.8
Softening Pt. (° C.)						
CTE (×10 <sup>-7</sup> /° C.)	89.6	87.3	89.7	90.4	87.6	85.8



TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.491	2.485	2.498	2.49	2.487	2.484
mol %	107YL	107YN	107YP	107YQ	107YR	107YS
SiO <sub>2</sub>	65.99	66.16	65.12	65.15	65.20	65.13
Al <sub>2</sub> O <sub>3</sub>	9.52	9.54	10.62	10.69	10.69	10.69
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	6.49	6.49	6.15	9.94	7.89	7.98
Na <sub>2</sub> O	11.37	11.38	13.18	9.25	10.25	9.25
K <sub>2</sub> O	1.24	1.23	0.26	0.26	1.25	2.25
MgO	0.26	0.25	1.70	1.70	1.72	1.70
CaO	2.49	2.51	1.85	1.88	1.87	1.87
SnO <sub>2</sub>	0.09	0.09	0.10	0.10	0.10	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.340	0.340	0.314	0.511	0.407	0.410
Strain Pt. (° C.)			483	473	474	473
Anneal Pt. (° C.)			525	515	517	515
Softening Pt. (° C.)			0.314	0.511	0.407	0.410
CTE (×10 <sup>-7</sup> /° C.)						
Density (g/cm <sup>3</sup> )			483	473	474	473
mol %	107YT	107YU	107YV	107AAC	107AAD	107AAE
SiO <sub>2</sub>	64.10	62.85	65.27	67.60	67.52	67.51
Al <sub>2</sub> O <sub>3</sub>	10.52	10.33	7.93	8.38	8.87	9.35
B <sub>2</sub> O <sub>3</sub>	1.89	3.70	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	7.65	7.56	8.86	8.03	8.09	8.16
Na <sub>2</sub> O	10.96	10.73	10.33	10.72	10.23	9.71
K <sub>2</sub> O	0.25	0.24	1.80	0.95	0.95	0.96
MgO	1.68	1.70	0.18	1.05	1.06	1.04
CaO	1.84	1.80	2.73	1.59	1.60	1.59
SnO <sub>2</sub>	0.09	0.09	0.09	0.10	0.09	0.10
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.406	0.408	0.422	0.408	0.420	0.434
Strain Pt. (° C.)	464	466				
Anneal Pt. (° C.)	504	503				
Softening Pt. (° C.)						
CTE (×10 <sup>-7</sup> /° C.)						
Density (g/cm <sup>3</sup> )	2.485	2.482		2.489	2.487	2.485
mol %	107AAF	107AAG	107AAH	107AAK	107AAL	107AAM
SiO <sub>2</sub>	67.45	67.08	67.52	67.73	67.55	67.40
Al <sub>2</sub> O <sub>3</sub>	8.85	8.87	8.87	8.69	8.63	8.64
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	8.18	8.06	8.59	9.89	10.04	10.20
Na <sub>2</sub> O	9.23	10.20	9.71	10.18	10.22	10.22
K <sub>2</sub> O	1.96	0.96	0.96	0.31	0.30	0.30
MgO	1.04	1.55	1.05	0.42	0.43	0.42
CaO	1.60	1.60	1.60	0.72	0.73	0.73
SnO <sub>2</sub>	0.10	0.09	0.09	0.00	0.00	0.00
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.422	0.419	0.446	0.485	0.488	0.492
Strain Pt. (° C.)						
Anneal Pt. (° C.)						
Softening Pt. (° C.)						
CTE (×10 <sup>-7</sup> /° C.)						

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.486	2.49	2.485			
mol %	107AAN	716HZE	716HZJ	716HZQ	716IBA	716IBS
SiO <sub>2</sub>	65.67	65.46	65.38	65.45	66.14	65.87
Al <sub>2</sub> O <sub>3</sub>	10.33	9.40	9.39	9.39	10.30	10.33
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	0.00	0.00	0.00	0.00
Li <sub>2</sub> O	7.85	6.17	6.13	6.12	7.68	7.71
Na <sub>2</sub> O	11.09	11.09	11.12	11.01	10.81	11.01
K <sub>2</sub> O	0.76	1.16	1.20	1.17	0.71	0.71
MgO	1.39	2.02	1.99	1.98	1.41	1.42
CaO	1.84	2.40	2.38	2.37	1.81	1.83
SnO <sub>2</sub>	0.00	0.08	0.05	0.05	0.05	0.03
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.398	0.335	0.332	0.334	0.400	0.397
Strain Pt. (° C.)	470	483.2	483.1	487.4	466.5	461.2
Anneal Pt. (° C.)	512	524.9	526.0	529.3	506.8	502.7
Softening Pt. (° C.)			735.4	742.3	711	703.3
CTE (×10 <sup>-7</sup> /° C.)		87.4	88.7		89.9	89.6
Density (g/cm <sup>3</sup> )	2.446		2.532	2.534	2.485	
mol %	716IBT	716IBU	196HLP	196HLQ	196HLR	196HLS
SiO <sub>2</sub>	65.92	65.96	60.22	60.03	59.88	59.96
Al <sub>2</sub> O <sub>3</sub>	10.32	10.32	16.94	14.90	16.84	16.85
B <sub>2</sub> O <sub>3</sub>	0.00	0.00	5.83	5.83	5.95	5.92
Li <sub>2</sub> O	7.72	7.72	0.00	0.00	4.98	7.00
Na <sub>2</sub> O	10.99	10.94	15.85	13.89	11.13	9.07
K <sub>2</sub> O	0.70	0.70	1.00	1.00	1.07	1.06
MgO	1.42	1.41	0.02	4.20	0.01	0.02
CaO	1.81	1.81	0.02	0.05	0.02	0.02
SnO <sub>2</sub>	0.03	0.03	0.08	0.08	0.08	0.08
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.398	0.399			0.290	0.409
Strain Pt. (° C.)	461.6	461.3	578.8	559.1	526.2	520.8
Anneal Pt. (° C.)	501.6	502.6	633.6	608.6	577.3	568.4
Softening Pt. (° C.)	702.5	703.1	906	858	820	814
CTE (×10 <sup>-7</sup> /° C.)	89	90.5	89.6	81.7	85.1	78.7
Density (g/cm <sup>3</sup> )			2.406	2.421	2.401	2.395
mol %	196HLT	196HLU	196HQB	196HQC	196HQD	196HQE
SiO <sub>2</sub>	59.87	59.98	60.432	60.351	60.627	60.462
Al <sub>2</sub> O <sub>3</sub>	15.89	14.88	15.212	16.250	16.612	15.760
B <sub>2</sub> O <sub>3</sub>	5.88	5.84	5.949	5.951	5.939	5.928
Li <sub>2</sub> O	6.49	5.98	5.860	5.884	6.080	6.995
Na <sub>2</sub> O	8.55	7.94	11.391	10.421	9.604	9.665
K <sub>2</sub> O	1.05	1.02	0.945	0.935	0.925	0.975
MgO	2.13	4.20	0.045	0.046	0.046	0.046
CaO	0.03	0.05	0.042	0.042	0.045	0.046
SnO <sub>2</sub>	0.08	0.08	0.081	0.081	0.081	0.082
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub> Li <sub>2</sub> O/(R <sub>2</sub> O)	0.19 0.403	0.06 0.400	2.98 0.322	0.99 0.341	0.00 0.366	1.87 0.397
Strain Pt. (° C.)	509.5	511.6	478.6	486.7	499.3	485.8
Anneal Pt. (° C.)	555.7	557.0	519.0	530.1	544.9	528.1
Softening Pt. (° C.)	784	784	720	775	815	738
CTE (×10 <sup>-7</sup> /° C.)	76	71	86.7	82.7	80.9	81.5

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.406	2.412	2.422	2.407	2.398	2.41
mol %	196HQF	196HQG	196HQH	196HQI	196HQP	196HQR
SiO <sub>2</sub>	60.462	60.393	60.136	59.979	59.867	60.099
Al <sub>2</sub> O <sub>3</sub>	14.902	14.918	16.000	16.066	14.972	17.064
B <sub>2</sub> O <sub>3</sub>	5.948	5.975	6.079	6.026	8.071	4.087
Li <sub>2</sub> O	7.350	5.828	5.851	5.969	5.724	6.228
Na <sub>2</sub> O	9.663	9.985	9.753	11.712	10.175	11.295
K <sub>2</sub> O	1.450	2.689	1.964	0.028	0.983	0.996
MgO	0.051	0.047	0.045	0.050	0.041	0.052
CaO	0.048	0.043	0.045	0.045	0.043	0.048
SnO <sub>2</sub>	0.084	0.083	0.083	0.083	0.082	0.083
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>	3.56	3.58	1.57	1.64	1.91	1.46
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.398	0.315	0.333	0.337	0.339	0.336
Strain Pt. (° C.)	470.3	471.0	485.5	491.9	481.0	500.5
Anneal Pt. (° C.)	510.7	510.9	529.4	536.3	523.6	546.1
Softening Pt. (° C.)	701	705	759	756	730	778
CTE (×10 <sup>-7</sup> /° C.)	85	86.6	84.1	82.2	82.1	88
Density (g/cm <sup>3</sup> )	2.42	2.425	2.411	2.413	2.397	2.428
mol %	196HQL	196HQM	196HVQ	196HVR	196HVS	196HVT
SiO <sub>2</sub>	60.140	60.048	60.452	60.473	60.373	62.560
Al <sub>2</sub> O <sub>3</sub>	16.090	15.056	16.842	16.335	15.823	15.855
B <sub>2</sub> O <sub>3</sub>	6.049	6.106	6.039	6.023	6.027	5.918
Li <sub>2</sub> O	5.803	5.815	6.683	6.492	6.303	6.325
Na <sub>2</sub> O	9.716	9.746	8.751	8.474	8.264	8.148
K <sub>2</sub> O	0.982	0.991	0.995	0.992	0.994	0.973
MgO	1.043	2.053	0.055	1.027	2.029	0.047
CaO	0.051	0.059	0.054	0.058	0.061	0.049
SnO <sub>2</sub>	0.082	0.081	0.081	0.079	0.080	0.081
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>	0.41	1.50	-0.41	-0.38	-0.26	-0.41
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.352	0.351	0.407	0.407	0.405	0.409
Strain Pt. (° C.)	500.8	485.7				
Anneal Pt. (° C.)	547.1	529.3				
Softening Pt. (° C.)	779	746				
CTE (×10 <sup>-7</sup> /° C.)	81	79.3				
Density (g/cm <sup>3</sup> )	2.407	2.416	2.395	2.401	2.405	2.385
mol %	196HVU	196HVV	196HVW	196HVX	196HVV	196HVZ
SiO <sub>2</sub>	64.405	62.473	64.869	64.742	64.860	59.773
Al <sub>2</sub> O <sub>3</sub>	14.859	15.816	13.272	13.276	13.287	14.728
B <sub>2</sub> O <sub>3</sub>	5.974	5.973	5.196	5.165	5.151	5.827
Li <sub>2</sub> O	5.825	6.272	4.659	5.790	6.667	5.666
Na <sub>2</sub> O	7.739	9.220	8.675	7.682	6.689	10.509
K <sub>2</sub> O	0.982	0.030	0.026	0.028	0.031	0.028
MgO	0.049	0.047	1.509	1.510	1.499	1.970
CaO	0.045	0.049	0.052	0.055	0.058	0.058
SnO <sub>2</sub>	0.080	0.079	0.006	0.009	0.008	0.005
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>	-0.31	-0.29	0.09	0.22	0.10	-0.31
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.400	0.404	0.349	0.429	0.498	0.400
Strain Pt. (° C.)						
Anneal Pt. (° C.)						
Softening Pt. (° C.)						
CTE (×10 <sup>-7</sup> /° C.)						

TABLE 2-continued

Compositions, densities, strain points, softening points, anneal points, and coefficients of thermal expansion (CTE) of selected lithium aluminosilicate glasses.						
Density (g/cm <sup>3</sup> )	2.375	2.386	2.408	2.406	2.403	2.375
mol %	196HVZ	196HWA	196HWB	196HXW	196HXX	196HXY
SiO <sub>2</sub>	59.773	59.271	58.890	60.00	60.00	60.00
Al <sub>2</sub> O <sub>3</sub>	14.728	14.635	14.544	16.75	16.25	15.75
B <sub>2</sub> O <sub>3</sub>	5.827	5.826	5.797	6.00	6.00	6.00
Li <sub>2</sub> O	5.666	5.626	5.587	6.25	6.00	5.75
Na <sub>2</sub> O	10.509	10.436	10.325	10.00	9.75	9.50
K <sub>2</sub> O	0.028	0.028	0.028	1.00	1.00	1.00
MgO	1.970	1.988	1.960	0.00	1.00	2.00
CaO	0.058	0.061	0.061			
SnO <sub>2</sub>	0.005	0.005	0.005	0.08	0.08	0.08
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>	1.47	1.46	1.40	0.50	0.50	0.50
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.350	0.350	0.351	0.362	0.358	0.354
Strain Pt. (° C.)				496		
Anneal Pt. (° C.)				541		
Softening Pt. (° C.)				796		
CTE (×10 <sup>-7</sup> /° C.)				81.1		
Density (g/cm <sup>3</sup> )	2.435	2.446	2.458	2.401		
mol %	196HXZ	196HYA	196HYB			
SiO <sub>2</sub>	60.00	60.00	62.00			
Al <sub>2</sub> O <sub>3</sub>	16.25	16.75	16.75			
B <sub>2</sub> O <sub>3</sub>	6.00	6.00	4.00			
Li <sub>2</sub> O	5.50	6.50	6.25			
Na <sub>2</sub> O	9.25	10.75	10.00			
K <sub>2</sub> O	1.00	0.00	1.00			
MgO	2.00	0.00	0.00			
CaO						
SnO <sub>2</sub>	0.08	0.08	0.08			
R <sub>2</sub> O—Al <sub>2</sub> O <sub>3</sub>	-0.50	0.50	0.50			
Li <sub>2</sub> O/(R <sub>2</sub> O)	0.349	0.377	0.362			
Strain Pt. (° C.)						
Anneal Pt. (° C.)						
Softening Pt. (° C.)						
CTE (×10 <sup>-7</sup> /° C.)						
Density (g/cm <sup>3</sup> )	2.435	2.446	2.458			

**[0069]** The lithium aluminosilicate glasses described herein, in some embodiments, may have an elastic modulus of at least about 68 gigaPascals (GPa).

**[0070]** In addition to exemplary compositions of lithium silicate glasses, physical properties, including strain, anneal, and softening points; CTE; and density of these example glasses are listed in Table 2. The strain point was determined using the beam bending viscosity method of ASTM C598-93 (2013). The annealing point was determined using the beam bending viscosity method of ASTM C598-93 (2013). The softening point was determined using the parallel plate viscosity method of ASTM C1351M-96 (2012). The linear coefficient of thermal expansion (CTE) over the temperature range 0-300° C. is expressed in terms of ppm/K and was determined using a push-rod dilatometer in accordance with ASTM E228-11. The density was determined using the buoyancy method of ASTM C693-93 (2013).

**[0071]** In some embodiments, the lithium aluminosilicate glasses described herein have a liquidus viscosity of greater than about 10,000 Poise (P) and, in certain embodiments, greater than 100,000 P. In some embodiments, these glasses are compatible with fusion processes, such as fusion draw processes or the like, and compatible with zircon hardware used in forming. However, in some embodiments (e.g., example 3 in Table 1) these glasses have low liquidus viscosities and are therefore not fusion-formable. In these instances, the glass may be formed by slot draw, float, rolling, and other sheet-forming processes known in the art.

**[0072]** The glasses described herein may be formed into articles such as, but not limited to, flat plates and three dimensional articles having thicknesses ranging from about 0.2 mm up to about 2 mm and, in some embodiments, from about 0.5 mm to about 1.5 mm.

**[0073]** The viscosity and mechanical performance are influenced by glass compositions. In the glass compositions

described herein,  $\text{SiO}_2$  serves as the primary glass-forming oxide and can serve to stabilize the networking structure. The concentration of  $\text{SiO}_2$  should be sufficiently high in order to provide the glass with sufficiently high chemical durability suitable for consumer applications. However, the melting temperature (200 poise temperature) of pure  $\text{SiO}_2$  or high content  $\text{SiO}_2$  glasses is too high to allow the glass to be processed by certain methods. Furthermore, the presence of  $\text{SiO}_2$  decreases the compressive stress created by ion exchange. In some embodiments, the lithium aluminosilicate glasses described herein comprise from about 55 mol % to about 75 mol %  $\text{SiO}_2$ , such as from about 57 mol % to about 73 mol %  $\text{SiO}_2$ ; from about 59 mol % to about 71 mol %  $\text{SiO}_2$ ; from about 61 mol % to about 69 mol %  $\text{SiO}_2$ ; from about 63 mol % to about 67 mol %  $\text{SiO}_2$ ; from about 55 mol % to about 60 mol %  $\text{SiO}_2$ ; from about 58 mol % to about 69 mol %  $\text{SiO}_2$ ; or any sub-ranges contained therein.

**[0074]**  $\text{Al}_2\text{O}_3$  may also serve as a glass former in these glasses. Like  $\text{SiO}_2$ , alumina generally increases the viscosity of the melt, and an increase in  $\text{Al}_2\text{O}_3$  relative to the alkalis or alkaline earths generally results in improved durability. The structural role of the aluminum ions depends on the glass composition. When the concentration of alkali metal oxides ( $\text{R}_2\text{O}$ ) is close to or greater than the concentration of alumina ( $\text{Al}_2\text{O}_3$ ), all aluminum is found in tetrahedral coordination with the alkali metal ions acting as charge-balancers. This is the case for all of the glasses described herein. In general,  $\text{Al}_2\text{O}_3$  also plays an important role in ion exchangeable glasses, as it enables a strong network backbone (i.e., high strain point) while allowing for the relatively fast diffusivity of alkali ions. However, high  $\text{Al}_2\text{O}_3$  concentrations generally lower the liquidus viscosity and thus  $\text{Al}_2\text{O}_3$  concentration needs to be controlled in a reasonable range. In some embodiments, the glasses described herein comprise from about 9 mol % to about 18 mol %  $\text{Al}_2\text{O}_3$ , such as from about 10 mol % to about 18 mol %  $\text{Al}_2\text{O}_3$ ; from about 12 mol % to about 16 mol %  $\text{Al}_2\text{O}_3$ ; from about 12 mol % to about 15 mol %  $\text{Al}_2\text{O}_3$ ; from about 9 mol % to about 17 mol %  $\text{Al}_2\text{O}_3$ ; or any sub-ranges contained therein.

**[0075]** Alkali oxides ( $\text{Li}_2\text{O}$ ,  $\text{Na}_2\text{O}$ ,  $\text{K}_2\text{O}$ ,  $\text{Rb}_2\text{O}$ , and  $\text{Cs}_2\text{O}$ ) serve as aids in achieving low melting temperature and low liquidus temperatures. On the other hand, the addition of alkali oxide dramatically increases the coefficient of thermal expansion (CTE) and lowers the chemical durability. Most importantly, to perform ion exchange, the presence of at least one small alkali oxide such as  $\text{Li}_2\text{O}$  and  $\text{Na}_2\text{O}$  is required to exchange with larger alkali ions (e.g.,  $\text{K}^+$ ) from an ion exchange medium, such as a salt bath. Three types of ion exchange can generally be carried out:  $\text{Na}^+$ -for- $\text{Li}^+$  exchange, which results in a deep depth of layer but low compressive stress;  $\text{K}^+$ -for- $\text{Li}^+$  exchange, which results in a small depth of layer but a relatively large compressive stress; and  $\text{K}^+$ -for- $\text{Na}^+$  exchange, which results in intermediate depth of layer and compressive stress. Because compressive stress is proportional to the number of alkali ions that are exchanged out of the glass, a sufficiently high concentration of the at least one small alkali oxide is needed to produce a large compressive stress in the glass. In some embodiments, the glasses described herein comprise from about 2.5 mol % to about 20 mol %  $\text{Li}_2\text{O}$ , such as from about 3 mol % to about 20 mol %  $\text{Li}_2\text{O}$ ; from about 4 mol % to about 18 mol %  $\text{Li}_2\text{O}$ ; from about 5 mol % to about 16 mol %  $\text{Li}_2\text{O}$ ; from about 6 mol % to about 14 mol %  $\text{Li}_2\text{O}$ ; from about 5 mol % to about 14 mol %  $\text{Li}_2\text{O}$ ; from about 7 mol % to about 10

mol %  $\text{Li}_2\text{O}$ ; from about 2.5 mol % to about 12 mol %  $\text{Li}_2\text{O}$ ; from about 4 mol % to about 10 mol %  $\text{Li}_2\text{O}$ ; or any sub-ranges contained therein. In some embodiments, these glasses comprise from 0 mol % to about 14 mol %  $\text{Na}_2\text{O}$ ; such as from 0 mol % to about 5 mol %  $\text{Na}_2\text{O}$ ; from about 0.2 mol % to about 12 mol %  $\text{Na}_2\text{O}$ ; from about 4 mol % to about 14 mol %  $\text{Na}_2\text{O}$ ; from 0.2 mol % to about 14 mol %  $\text{Na}_2\text{O}$ ; or any sub-ranges contained therein. The glasses described herein, in some embodiments, may comprise from 0 mol % to about 4 mol %  $\text{K}_2\text{O}$ , such as from 0 mol % to about 2.5 mol %  $\text{K}_2\text{O}$ ; from 0 mol % to about 1 mol %  $\text{K}_2\text{O}$ ; or any sub-ranges contained therein.

**[0076]** To achieve a high liquidus viscosity and thus make formation by down-draw techniques, particularly by the fusion draw method,  $\text{Li}_2\text{O}$  glass should account for less than half of the total alkali oxide content on a molar basis. When  $\text{Li}_2\text{O}/(\text{Li}_2\text{O}+\text{Na}_2\text{O}+\text{K}_2\text{O}+\text{Rb}_2\text{O}+\text{Cs}_2\text{O})$  exceeds 0.5, the spodumene liquidus increases and the glasses are no longer compatible with the fusion technique. Thus, in some embodiments,  $\text{Li}_2\text{O}/(\text{Li}_2\text{O}+\text{Na}_2\text{O}+\text{K}_2\text{O}+\text{Rb}_2\text{O}+\text{Cs}_2\text{O})$  is in a range from about 0.1 to about 0.5; such as  $0.1 \leq \text{Li}_2\text{O}/(\text{Li}_2\text{O}+\text{Na}_2\text{O}+\text{K}_2\text{O}+\text{Rb}_2\text{O}+\text{Cs}_2\text{O}) \leq 0.4$ ,  $0.2 \leq \text{Li}_2\text{O}/(\text{Li}_2\text{O}+\text{Na}_2\text{O}+\text{K}_2\text{O}+\text{Rb}_2\text{O}+\text{Cs}_2\text{O}) \leq 0.4$ , or any sub-ranges contained therein. To achieve high compressive stress at depth after ion exchange, however, it is desirable to maximize the  $\text{Li}_2\text{O}$  content. To achieve a compressive stress of greater than 100 MPa at depths greater than 40  $\mu\text{m}$ , the  $\text{Li}_2\text{O}$  content should therefore be greater than about 4 mol % and, in some embodiments, preferably greater than about 5 mol %, and should be less than about 10 mole %.

**[0077]** The presence of  $\text{K}_2\text{O}$  increases the rate of  $\text{K}^+$  for  $\text{Na}^+$  ion exchange but drastically decreases the compressive stress after ion exchange. In some embodiments, the glass should comprise less than about 2.5 mol %  $\text{K}_2\text{O}$  and, in certain embodiments, the  $\text{K}_2\text{O}$  concentration should not exceed 1 mole %.

**[0078]** Divalent cation oxides (such as alkaline earth oxides and zinc oxide) also improve the melting behavior of the glass. With respect to ion exchange performance, however, the presence of divalent cations acts to decrease alkali cation mobility. This negative effect on ion exchange performance is especially pronounced with the larger divalent cations. Furthermore, the smaller divalent cation oxides generally help enhance the compressive stress more than the larger divalent cation oxides. Hence,  $\text{MgO}$  offers several advantages with respect to improved stress relaxation while minimizing the adverse effects on alkali diffusivity. However, when the contents of  $\text{MgO}$  are high, the glasses are prone to form forsterite ( $\text{Mg}_2\text{SiO}_4$ ), which causes the liquidus temperature to rise very steeply as  $\text{MgO}$  concentration rises above a certain level. In some embodiments,  $\text{MgO}$  is the only divalent cation oxide present in the glass. In other embodiments, the glasses described herein may contain at least one of  $\text{MgO}$  and  $\text{ZnO}$ . Accordingly, these glasses, in some embodiments, may comprise from 0 mol % to about 8 mol %  $\text{MgO}$ , such as from 0 mol % to about 6 mol %  $\text{MgO}$ ; from 0 mol % to about 5 mol %  $\text{MgO}$ ; from 0 mol % to about 3 mol %  $\text{MgO}$ ; from 0 mol % to about 1 mol %  $\text{MgO}$ ; or any sub-ranges contained therein. In some embodiments, the glass may comprise from 0 mol % to about 4 mol %  $\text{ZnO}$ , such as from 0 mol % to about 3 mol %  $\text{ZnO}$ ; from 0 mol % to about 2 mol %  $\text{ZnO}$ ; from 0 mol % to about 1 mol %  $\text{ZnO}$ ; or any sub-ranges contained therein.

**[0079]** When boron is not charge balanced by alkali oxides or divalent cation oxides, it will be in a trigonal coordination state, and thus open up the glass structure. The network around the trigonally coordinated boron is not as rigid as those surrounding tetrahedrally coordinated boron; the bonds are “floppy (i.e. elastic, flexible, or capable of bending or stretching)” and therefore allow the glasses to tolerate some deformation before crack formation. Furthermore, boron decreases the melting viscosity and effectively helps suppress the zircon breakdown viscosity of the glass. In some embodiments, the glasses described herein contain from 0 mol % to about 20 mol %  $B_2O_3$ , such as from about 2.5 mol % to about 20 mol %  $B_2O_3$ ; from about 3 mol % to about 18 mol %  $B_2O_3$ ; from about 3.5 mol % to about 16 mol %  $B_2O_3$ ; from about 4 mol % to about 16 mol %  $B_2O_3$ ; from about 4.5 mol % to about 14 mol %  $B_2O_3$ ; from about 5 mol % to about 12 mol %  $B_2O_3$ ; from about 2.5 mol % to about 7.5 mol %  $B_2O_3$ ; from about 5 mol % to about 7 mol %  $B_2O_3$ ; from about 3.5 mol % to about 9.5 mol %  $B_2O_3$ ; from about 5 mol % to about 9 mol %  $B_2O_3$ ; or any sub-ranges contained therein.

**[0080]**  $P_2O_5$  improves damage resistance and does not impede ion exchange. In some embodiments, the addition of phosphorous to the glass creates a structure in which silica ( $SiO_2$  in the glass) is replaced by aluminum phosphate ( $AlPO_4$ ), which consists of tetrahedrally coordinated aluminum and phosphorus and/or boron phosphate ( $BPO_4$ ), which consists of tetrahedrally coordinated boron and phosphorus. In some embodiments, the glass comprises from 0 to about 4 mol %  $P_2O_5$ , such as from 0 mol % to about 3 mol %  $P_2O_5$ ; from 0 mol % to about 2.5 mol %  $P_2O_5$ ; from 0 mol % to about 1 mol %  $P_2O_5$ ; or any sub-ranges contained therein.

**[0081]**  $TiO_2$  serves as a nucleation agent to produce bulk nucleation if a glass-ceramic article is desired. If the concentration of  $TiO_2$  is too low, the precursor glass does not crystallize. If the concentration is too high, the devitrification, upon cooling during precursor glass forming, can be difficult to control. In some embodiments, the glasses described herein may comprise from 0 mol % to about 5 mol %  $TiO_2$ , such as from 0 mol % to about 4 mol %  $TiO_2$ ; from 0 mol % to about 3 mol %  $TiO_2$ ; from 0 mol % to about 2 mol %  $TiO_2$ ; from 0 mol % to about 1 mol %  $TiO_2$ ; or any sub-ranges contained therein.

**[0082]** In some embodiments, the glasses described herein may further include at least one fining agent such as, but not limited to,  $SnO_2$ ,  $As_2O_3$ ,  $Sb_2O_3$ , and the like. Due to environmental and toxicity concerns,  $As_2O_3$  and  $Sb_2O_3$  are typically not included in glasses. Accordingly, the glasses described herein are typically free of  $As_2O_3$  and  $Sb_2O_3$  and, in some embodiments, these glasses may comprise from about 0.05 mol % to about 0.5 mol %  $SnO_2$ .

**[0083]** Rare earth oxides may increase the hardness and elastic modulus of a glass, but they hamper ion exchange, increase the density and cost of the glass, and many impart color to the glass. It is therefore desirable to limit the total rare earth oxide content to less than 0.1 mol %.

**[0084]** In some aspects, the lithium aluminosilicate glasses described herein are strengthened by forming a compressive layer on the surfaces of the glass. In certain embodiments, these glasses are chemically strengthened, and in particular embodiments, are chemically strengthened by ion exchange.

**[0085]** Ion exchange is a process in which smaller cations in the glass are exchanged for larger cations that are present in an ion exchange medium such as a molten salt bath or a

paste. In a particular embodiment, ion exchange is carried out by immersing the glass in a molten salt bath substantially comprising a salt of the larger cation. The ion exchange bath may also comprise salts of the smaller cations that are present in the glass. As used herein, the term “substantially comprising” means that other components may be present in the molten salt bath. Such components may include, but are not limited to, compounds that act to reduce attack of the bath vessel or the glass article by the molten salt. Such additional components may include, but are not limited to, selected components of the glass, such as silicic acid, alumina in gel form, silica in gel form, or the like.

**[0086]** A cross-sectional schematic view of an ion exchanged glass article is shown in FIG. 1. Glass article **100** has a thickness  $t$ , first surface **110**, and second surface **112**. Glass article **100**, in some embodiments, has a thickness  $t$  of up to about 1 mm. While the embodiment shown in FIG. 1 depicts glass article **100** as a flat planar sheet or plate, glass article may have other configurations, such as three dimensional shapes or non-planar configurations. Glass article **100** has a first compressive layer **120** extending from first surface **110** to a depth of layer (DOL)  $d_1$  into the bulk of the glass article **100**. In the embodiment shown in FIG. 1, glass article **100** also has a second compressive layer **122** extending from second surface **112** to a second depth of layer  $d_2$ . First and second compressive layers **120**, **122** are each under a compressive stress CS. In some embodiments, first and second compressive layers **120**, **122** each have a maximum compressive stress at the first and second surfaces **110**, **112**, respectively. Glass article also has a central region **130** that extends from  $d_1$  to  $d_2$ . Central region **130** is under a tensile stress or central tension (CT), which balances or counteracts the compressive stresses of layers **120** and **122**. The depths of layer  $d_1$ ,  $d_2$  of first and second compressive layers **120**, **122** protects the glass article **100** from the propagation of flaws introduced by sharp impact to first and second surfaces **110**, **112** of glass article **100**, while the compressive stress of at least about 900 MPa minimizes the likelihood of a flaw penetrating through the depth  $d_1$ ,  $d_2$  of first and second compressive layers **120**, **122**.

**[0087]** When ion exchanged, the lithium aluminosilicate glasses described herein typically exhibit, relative to their sodium analogs, deep depths of layer and low central tension, thus enabling very thin (i.e., <0.5 mm) sheets of glass to be chemically strengthened while not being susceptible to frangible behavior.

**[0088]** Compressive stress (including surface CS) is measured by surface stress meter (FSM) using commercially available instruments such as the FSM-6000, manufactured by Orihara Industrial Co., Ltd. (Japan). Surface stress measurements rely upon the accurate measurement of the stress optical coefficient (SOC), which is related to the birefringence of the glass. SOC in turn is measured according to Procedure C (Glass Disc Method) described in ASTM standard C770-16, entitled “Standard Test Method for Measurement of Glass Stress-Optical Coefficient,” the contents of which are incorporated herein by reference in their entirety.

**[0089]** As used herein, DOL means the depth at which the stress in the chemically strengthened alkali aluminosilicate glass article described herein changes from compressive to tensile. DOL may be measured by FSM or a scattered light polariscope (SCALP) depending on the ion exchange treatment. Where the stress in the glass article is generated by

exchanging potassium ions into the glass article, FSM is used to measure DOL. Where the stress is generated by exchanging sodium ions into the glass article, SCALP is used to measure DOL. Where the stress in the glass article is generated by exchanging both potassium and sodium ions into the glass, the DOL is measured by SCALP, since it is believed the exchange depth of  $\text{Na}^+$  ions ("Potassium DOL") indicates the DOL and the exchange depth of potassium ions indicates a change in the magnitude of the compressive stress (but not the change in stress from compressive to tensile). The depth of penetration of  $\text{K}^+$  ions ("Potassium DOL") represents the depth of potassium penetration as a result of an ion exchange process. The Potassium DOL is typically less than the DOL for the articles described herein. Potassium DOL is measured using a surface stress meter such as the commercially available FSM-6000 surface stress meter, manufactured by Lucco Co., Ltd. (Tokyo, Japan), which relies on accurate measurement of the stress optical coefficient (SOC), as described above with reference to the CS measurement.

**[0090]** The lithium aluminosilicate glasses described herein may be subjected to an ion exchange process in at least one molten salt bath containing either sodium salts, potassium salts, or both sodium and potassium salts. The nitrate salts  $\text{NaNO}_3$  and  $\text{KNO}_3$  are typically used in the ion exchange process. The glasses are held in a salt bath for a time sufficient for ion exchange to occur on the surface and into some depth into the article. In one embodiment, the glass is chemically strengthened by immersion in a molten salt bath comprising  $\text{NaNO}_3$  for a predetermined time period to achieve a desired level of ion exchange. As a result of the ion exchange, a surface compressive layer is created caused by the substitution of Lit ions contained in a glass surface layer by  $\text{Na}^+$  or  $\text{K}^+$  ions, both of which have a larger ionic radius than Lit. In one embodiment, the temperature of the molten salt bath is about  $390^\circ\text{C}$ . and the predetermined time period is in a range from about one to four hours. In other embodiments, ion exchange is carried out in at least one molten salt bath at temperatures ranging from about  $370^\circ\text{C}$ . to about  $390^\circ\text{C}$ .

**[0091]** In some embodiments, the glasses described herein may undergo ion exchange with monovalent silver cations, thus providing the glass surface with antimicrobial properties. Since the ionic radius of  $\text{Ag}^+$  is greater than that of either  $\text{Li}^+$  or  $\text{Na}^+$ , silver ion exchange of these glasses results in a lower loss of compressive stress than observed in ion exchanged glasses that contain only sodium and potassium.

**[0092]** In some embodiments, the lithium aluminosilicate glasses described herein may be ion exchanged to achieve a depth of layer of at least about  $70\text{ }\mu\text{m}$  when ion exchanged for periods of less than about 7 hours. In addition, these glasses may be ion exchanged to achieve maximum compressive stresses at the surface of the glass of at least about  $500\text{ MPa}$  in a one-step ion exchange process, or at least about  $600\text{ MPa}$  in a two-step ion exchange process, with some glasses achieving maximum compressive stresses as high as  $840\text{ MPa}$  in a one-step ion exchange and as high as  $1000\text{ MPa}$  at the glass surface in a two-step ion exchange process. In some embodiments, a compressive stress of at least  $700\text{ MPa}$ , or at least about  $800\text{ MPa}$ , or at least about  $900\text{ MPa}$  may be achieved using either a one-step or a two-step ion exchange process. In some embodiments, the compressive stress in these ion exchanged glasses may be about  $50\text{ MPa}$  or greater at depths of  $100\text{ }\mu\text{m}$  or more below the surface.

**[0093]** The lithium aluminosilicate glasses described herein may be ion exchanged to achieve depths of compressive layer of at least about  $70\text{ }\mu\text{m}$ ; in some embodiment, at least about  $100\text{ }\mu\text{m}$ ; and in still other embodiment, at least about  $150\text{ }\mu\text{m}$  by either one-step or two-step ion exchange processes. The ion exchange time at temperatures ranging  $370^\circ\text{C}$ . to about  $390^\circ\text{C}$ . needed to achieve these depths of layer by either a one-step or two-step process is less than about 7 hours.

**[0094]** The profile and depth of the compressive layer may be determined from the concentration profile of the larger cations participating in the ion exchange process. The  $\text{Na}^+$  concentration profile from the surface of the glass to the inner portion of a 1) lithium aluminosilicate glass (example 3 in Table 1) and a glass ceramic (Corning Code 9667; nominal composition listed in Table 1) that had been cerammed at  $975^\circ\text{C}$ . for 4 hours) that were ion exchanged at  $390^\circ\text{C}$ . for 3.5 hours in a  $\text{NaNO}_3$  molten salt bath are shown in FIG. 2. In some embodiments, a depth of layer DOL of at least  $100\text{ }\mu\text{m}$ , determined from the  $\text{Na}_2\text{O}$  concentration profile, may be achieved for the lithium aluminosilicate glass (1 in FIG. 2).

**[0095]** Table 3 lists conditions for one-step ion exchange, CS, depth of  $\text{K}^+$  penetration into the glass, and depth of  $\text{Na}^+$  penetration into the glass for compositions selected from Table 2. Two-step ion exchange conditions, fictive temperature Tf, CS, and DOL for compositions selected from Table 2 are listed in Table 4.

TABLE 3

One-step ion exchange conditions, compressive stress (CS), and $\text{K}^+$ and $\text{Na}^+$ penetration for compositions selected from Table 2.						
	196HLP	196HLQ	196HLR	196HLS	196HLT	196HLU
Ion exchange in 100 wt % $\text{KNO}_3$ at $430^\circ\text{C}$ . for 2 hours						
CS (MPa)	998	861	876	860	905	881
$\text{K}^+$ DOL ( $\mu\text{m}$ )	40	25	22	19	14	11
Ion exchange in 90 wt % $\text{KNO}_3$ /10 wt % $\text{NaNO}_3$ at $390^\circ\text{C}$ . for 3 hours						
CS (MPa)	637	581	683	701	728	667
$\text{K}^+$ DOL ( $\mu\text{m}$ )	29.6	17.5	13.6	10.1	8.2	7.5
$\text{Na}^+$ DOL ( $\mu\text{m}$ )			244	267	237	247

TABLE 3-continued

One-step ion exchange conditions, compressive stress (CS), and K <sup>+</sup> and Na <sup>+</sup> penetration for compositions selected from Table 2.						
Ion exchange in 80 wt % KNO <sub>3</sub> /20 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	512	460	606	658	633	651
K <sup>+</sup> DOL (μm)	29.0	16.3	13.5	9.8	7.3	7.9
Na <sup>+</sup> DOL (μm)			280	273	237	224
Ion exchange in 60 wt % KNO <sub>3</sub> /40 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	348	302	505	542		
K <sup>+</sup> DOL (μm)	26.9	15.7	12.6	8.7		
Na <sup>+</sup> DOL (μm)			244	293	198	195
Ion exchange in 100 wt % NaNO <sub>3</sub> at 370° C. for 0.75 hour						
CS (MPa)						
Na <sup>+</sup> DOL (μm)			198	182	185	192
196HQB	196HQC	196HQD	196HQE	196HQF	196HQG	
Ion exchange in 95 wt % KNO <sub>3</sub> /5 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	722	780	822	779	721	651
K <sup>+</sup> DOL (μm)	8.3	9.8	10.7	7.9	7.1	10.4
Na <sup>+</sup> DOL (μm)	215	221	228	202	215	182
Ion exchange in 90 wt % KNO <sub>3</sub> /10 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	670	693	741	695	695	582
K <sup>+</sup> DOL (μm)	7.8	9.9	10.1	7.4	6.9	10.9
Na <sup>+</sup> DOL (μm)	224	228	250	224	234	195
Ion exchange in 80 wt % KNO <sub>3</sub> /20 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	568	604	639	599	579	486
K <sup>+</sup> DOL (μm)	7.6	9.8	10.0	7.5	7.1	8.9
Na <sup>+</sup> DOL (μm)	202	241	208	244	231	205
Ion exchange in 100 wt % NaNO <sub>3</sub> at 370° C. for 0.75 hour						
CS (MPa)						
Na <sup>+</sup> DOL (μm)	189	192	179	176	182	182
196HQH	196HQI	196HQJ	196HQK	196HQL	196HQM	
Ion exchange in 95 wt % KNO <sub>3</sub> /5 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	713	789	707	848	822	766
K <sup>+</sup> DOL (μm)	11.2	7.7	9.9	10.2	8.8	7.0
Na <sup>+</sup> DOL (μm)	182	241	202	250	228	224
Ion exchange in 80 wt % KNO <sub>3</sub> /20 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	539	629	613	652	611	602
K <sup>+</sup> DOL (μm)	10.5	5.4	5.3	9.1	8.1	7.2
Na <sup>+</sup> DOL (μm)	192	254	202	257	234	195
Ion exchange in 60 wt % KNO <sub>3</sub> /40 wt % NaNO <sub>3</sub> at 390° C. for 3 hours						
CS (MPa)	455	503	460	528	510	485
K <sup>+</sup> DOL (μm)	9.6	7.4	8.1	8.8	8.3	7.6
Na <sup>+</sup> DOL (μm)	205	260	185	244	237	205
Ion exchange in 100 wt % NaNO <sub>3</sub> at 370° C. for 0.75 hour						
CS (MPa)						
Na <sup>+</sup> DOL (μm)	172	169	169	169	172	172



TABLE 4

Two-step ion exchange conditions, fictive temperature $T_f$ , CS, and DOL for compositions selected from Table 2.				
	196HLR	196HLS	196HLT	196HLU
$T_f$ (° C.)	652	638 Bath 1	623	623
Temperature (° C.)	390	390	390	390
Time (hr)	0.75	0.75	0.75	0.75
Composition (wt %)	80% KNO <sub>3</sub> 20% NaNO <sub>3</sub>	80% KNO <sub>3</sub> 20% NaNO <sub>3</sub>	80% KNO <sub>3</sub> 20% NaNO <sub>3</sub>	80% KNO <sub>3</sub> 20% NaNO <sub>3</sub>
	Bath 2			
Temperature (° C.)	390	390	390	390
Time (hr)	0.75	0.75	0.75	0.75
Composition (wt %)	100% KNO <sub>3</sub>	100% KNO <sub>3</sub>	100% KNO <sub>3</sub>	100% KNO <sub>3</sub>
CS (MPa)	1041	1068	1042	
DOL (μm)	185	195	163	195

**[0096]** Vickers crack initiation thresholds described herein are determined by applying and then removing an indentation load to the glass surface at a rate of 0.2 mm/min. The maximum indentation load is held for 10 seconds. The indentation cracking threshold is defined at the indentation load at which 50% of 10 indents exhibit any number of radial/median cracks emanating from the corners of the indent impression. The maximum load is increased until the threshold is met for a given glass composition. All indentation measurements are performed at room temperature in 50% relative humidity. The test involved the use of a square-based pyramidal diamond indenter with an angle of 136° between faces, referred to as a Vickers indenter. The Vickers indenter was same as the one used in standard micro hardness testing (reference ASTM-E384-11).

**[0097]** As used herein, the term “Knoop Scratch Threshold” refers to the onset of lateral cracking. In Knoop threshold testing, a mechanical tester holds a Knoop diamond in which a glass is scratched at increasing loads to determine the onset of lateral cracking. As used herein, Knoop Scratch Threshold is the onset of lateral cracking (in 3 or more of 5 indentation events). In Knoop Scratch Lateral Cracking Threshold testing, samples of the glass articles and articles were first scratched with a Knoop indenter under a dynamic or ramped load to identify the lateral crack onset load range for the sample population. Once the applicable load range is identified, a series of increasing constant load scratches (3 minimum or more per load) are performed to identify the Knoop scratch threshold. The Knoop scratch threshold range can be determined by comparing the test specimen to one of the following 3 failure modes: 1) sustained lateral surface cracks that are more than two times the width of the groove, 2) damage is contained within the groove, but there are lateral surface cracks that are less than two times the width of groove and there is damage visible by naked eye, or 3) the presence of large subsurface lateral cracks which are greater than two times the width of groove and/or there is a median crack at the vertex of the scratch.

**[0098]** When ion exchanged in NaNO<sub>3</sub>, the glasses described herein exhibit high native damage resistance, and, in some embodiments, capable of achieving a Vickers crack initiation threshold of over 50 kilogram force (kgf). This level of damage resistance may be achieved, for example,

for the glasses described herein containing 6 mol % Li<sub>2</sub>O following ion exchange at 390° C. in a NaNO<sub>3</sub> bath for 3.5 hours. This Vickers crack initiation threshold value is comparable to—or greater than—those exhibited by analogous sodium aluminosilicate glasses having high levels of inherent damage resistance. FIG. 3 is a plot of indentation fracture thresholds (IFT) determined after ion exchange in KNO<sub>3</sub> for the present lithium aluminosilicate glass (example 3 in Table 1, ion exchanged at 390° C. in NaNO<sub>3</sub> for 3.5 hours) (C in FIG. 3), and in fusion-formed sodium aluminosilicate glasses A and E (nominal composition: 67.6 mol % SiO<sub>2</sub>; 3.7 mol % B<sub>2</sub>O<sub>3</sub>; 12.7 mol % Al<sub>2</sub>O<sub>3</sub>; 13.7 mol % Na<sub>2</sub>O; 0.01 mol % K<sub>2</sub>O; 2.3 mol % MgO; and 0.1 mol % SnO<sub>2</sub>) with IFT of 15-20 kgf; glass B (nominal composition: 64.7 mol % SiO<sub>2</sub>; 5.1 mol % B<sub>2</sub>O<sub>3</sub>; 13.9 mol % Al<sub>2</sub>O<sub>3</sub>; 13.7 mol % Na<sub>2</sub>O; 2.4 mol % MgO; and 0.08 mol % SnO<sub>2</sub>) with IFT of 30-40 kgf; and glass D (nominal composition: 64.7 mol % SiO<sub>2</sub>; 5.1 mol % B<sub>2</sub>O<sub>3</sub>; 13.9 mol % Al<sub>2</sub>O<sub>3</sub>; 13.7 mol % Na<sub>2</sub>O; 2.4 mol % MgO; and 0.08 mol % SnO<sub>2</sub>) with IFT of 15 kgf. Optical microscopic images of Vickers indentations in the ion exchanged lithium aluminosilicate glass plotted in FIG. 3 under indenter loads of 10 kgf (a in FIG. 4), 30 kgf (b), and 50 kgf (c) are shown in FIG. 4. The images in FIG. 4 show significant glass densification without formation of lateral cracking, indicating that the glass possesses a high level of inherent damage resistance.

**[0099]** In some embodiments, the glasses described herein, when ion exchanged as detailed above, may exhibit Vickers crack initiation thresholds (VIT) of at least 10 kgf; in some embodiments, at least 15 kgf; and in still other embodiments, at least about 20 kgf. In certain embodiments, the Vickers crack initiation threshold is in a range from about 10 kgf to about 35 kgf and Knoop scratch thresholds (KST) are in a range from about 10 Newtons (N) to about 20 N.

**[0100]** Vickers crack initiation thresholds (VIT) and Knoop scratch thresholds (KST) for glasses that were ion exchanged in one-step and two-step ion exchange processes are listed in Tables 3 and 4, respectively.

**[0101]** The articles disclosed herein may be incorporated into another article such as an article with a display (or display articles) (e.g., consumer electronics, including mobile phones, tablets, computers, navigation systems, and the like), architectural articles, transportation articles (e.g., automotive, trains, aircraft, sea craft, etc.), appliance articles, or any article that requires some transparency, scratch-resistance, abrasion resistance or a combination thereof. An exemplary article incorporating any of the strengthened articles disclosed herein is shown in FIGS. 5A and 5B. Specifically, FIGS. 5A and 5B show a consumer electronic device 200 including a housing 202 having front 204, back 206, and side surfaces 208; electrical components (not shown) that are at least partially inside or entirely within the housing and including at least a controller, a memory, and a display 210 at or adjacent to the front surface of the housing; and a cover substrate 212 at or over the front surface of the housing such that it is over the display. In some embodiments, the cover substrate 212 and/or housing may include any of the strengthened articles disclosed herein.

**[0102]** While typical embodiments have been set forth for the purpose of illustration, the foregoing description should not be deemed to be a limitation on the scope of the disclosure or appended claims. Accordingly, various modi-

fications, adaptations, and alternatives may occur to one skilled in the art without departing from the spirit and scope of the present disclosure and appended claims.

What is claimed:

1. A glass article, wherein the glass article is formed from a glass comprising:

from 55 mol % to 75 mol %  $\text{SiO}_2$ ;  
from 10 mol % to 18 mol %  $\text{Al}_2\text{O}_3$ ;  
from 5 mol % to 20 mol %  $\text{Li}_2\text{O}$ ;  
from 0 mol % to 1 mol %  $\text{K}_2\text{O}$ ;  
from 2.5 mol % to 20 mol %  $\text{B}_2\text{O}_3$ ;  
 $\text{Na}_2\text{O}$ , and  
 $\text{MgO}$ ,

wherein  $\text{R}_2\text{O}$  (mol %)+ $\text{R}'\text{O}$  (mol %)- $\text{Al}_2\text{O}_3$  (mol %)- $\text{B}_2\text{O}_3$  (mol %)- $\text{P}_2\text{O}_5$  (mol %) is in a range from -10.5 mol % to -0.11 mol %;

wherein  $\text{R}_2\text{O}$  (mol %)+ $\text{R}'\text{O}$  (mol %) is in a range from -2 mol % to 5.6 mol %; and

wherein  $\text{R}_2\text{O}=\text{Li}_2\text{O}+\text{Na}_2\text{O}+\text{K}_2\text{O}+\text{Rb}_2\text{O}+\text{Cs}_2\text{O}$ , and  $\text{R}'\text{O}=\text{MgO}+\text{CaO}+\text{SrO}+\text{BaO}$ .

2. The glass article of claim 1, wherein  $\text{Na}_2\text{O}$  is present in the glass in a range from 4 mol % to 14 mol %.

3. The glass article of claim 1, wherein  $\text{MgO}$  is present in the glass in a range from 1 mol % to 8 mol %.

4. The glass article of claim 1, wherein  $\text{MgO}$  is present in the glass in a range from 1 mol % to 5 mol %.

5. The glass article of claim 1, wherein  $(\text{Al}_2\text{O}_3 \text{ (mol \%)} + \text{B}_2\text{O}_3 \text{ (mol \%)})/\text{R}_2\text{O} \text{ (mol \%)}$  in the glass is in a range from 0.9 to 1.9.

6. The glass article of claim 1, wherein  $\text{SiO}_2$  is present in the glass in a range from 57 mol % to 67 mol %.

7. The glass article of claim 1, wherein  $\text{Al}_2\text{O}_3$  is present in the glass in a range from 12 mol % to 18 mol %.

8. The glass article of claim 1, wherein  $\text{Li}_2\text{O}$  is present in the glass in a range from 5 mol % to 16 mol %.

9. The glass article of claim 1, wherein  $\text{Li}_2\text{O}$  is present in the glass in a range from 6 mol % to 14 mol %.

10. The glass article of claim 1, wherein  $\text{B}_2\text{O}_3$  is present in the glass in a range from 3 mol % to 9 mol %.

11. The glass article of claim 1, wherein  $\text{B}_2\text{O}_3$  is present in the glass in a range from 3 mol % to 7 mol %.

12. The glass article of claim 1, wherein  $(\text{Al}_2\text{O}_3 \text{ (mol \%)} + \text{B}_2\text{O}_3 \text{ (mol \%)})/\text{R}_2\text{O} \text{ (mol \%)}$  in the glass is in a range from 1.13 to 1.9.

13. The glass article of claim 1, wherein  $\text{TiO}_2$  is present in the glass in a range from 0 mol % to 5 mol %.

14. The glass article of claim 1, wherein  $\text{P}_2\text{O}_5$  is present in the glass in a range from 0 mol % to 4 mol %.

15. The glass article of claim 1, wherein  $\text{ZnO}$  is present in the glass in a range from 0 mol % to 2 mol %.

16. The glass article of claim 1, wherein the glass is characterized by  $\text{Al}_2\text{O}_3 \text{ (mol \%)} > \text{B}_2\text{O}_3 \text{ (mol \%)}$ .

17. The glass article of claim 1, wherein the glass is ion exchanged and has a compressive stress layer with a maximum compressive stress of at least 600 MPa.

18. The glass article of claim 17, wherein the glass exhibits:

a Vickers crack initiation threshold of at least 10 kgf;  
a Knoop scratch threshold of at least 8 N; or  
both.

19. The glass article of claim 1, wherein the glass has a liquidus viscosity of at least 10 kP.

20. A consumer electronic product, comprising:

a housing having a front surface, a back surface and side surfaces;

electrical components provided at least partially within the housing, the electrical components including at least a controller, a memory, and a display, the display being provided at or adjacent the front surface of the housing; and

a cover glass disposed over the display,

wherein at least one of a portion of the housing or the cover glass comprises the glass article of claim 1.

\* \* \* \* \*