

LOW EMISSIVITY COATING WITH LOW SOLAR HEAT GAIN COEFFICIENT,
ENHANCED CHEMICAL AND MECHANICAL PROPERTIES
AND METHOD OF MAKING THE SAME

FIELD OF THE INVENTION

[001] The present invention relates generally to low emissivity ("low-e") coatings, and more particularly to coatings with low solar heat gain coefficient (SHGC) ("low-g") and retained or enhanced mechanical and chemical durability.

BACKGROUND OF THE INVENTION

[002] All United States Patents and patent applications referred to herein, including copending U.S. Application No. 11/648,913, U.S. Application No. 11/431,915, U.S. Provisional Application No. 60/680,008, U.S. Provisional Application No. 60/736,876, and U.S. Provisional Application No. 60/750,782, are hereby incorporated by reference in their entireties. In the case of conflict, the present specification, including definitions, will control.

[003] Solar control coatings on transparent panels or substrates are designed to permit the passage of visible light while blocking infrared (IR) radiation. High visible transmittance, low emissivity coatings on, e.g., architectural glass and automobile windows can lead to substantial savings in costs associated with environmental control, such as heating and cooling costs.

[004] Generally speaking, coatings that provide for high visible transmittance and low emissivity are made up of a stack, which typically includes a transparent substrate and an optical coating. The stack includes one or more thin metallic layers, with high IR reflectance and low

transmissivity, disposed between anti-reflective dielectric layers. These systems reflect radiant heat and provide insulation from the cold as well as from solar radiation. Most low-e stacks in use today are based on transparent dielectrics. In general, the thickness of the dielectric layers are tuned in to reduce inside and outside reflectance so that the light transmittance is high (>60%). The IR reflective metallic layers may be virtually any reflective metal, such as silver, copper, or gold. Silver (Ag) is most frequently used for this application due to its relatively neutral color. The anti-reflective dielectric layers are generally transparent material selected to enhance visible transmittance.

[005] Conventional low emissivity coatings generally strive to maintain reflection relatively constant throughout the visible spectrum so that the coating has a "neutral" color; i.e., is essentially colorless. However, conventional low-emissivity coatings fail to provide the extremes of reflected color required for aesthetic and other reasons by certain applications.

[006] To achieve the desired properties in a coated substrate, the composition and thickness of each of the layers of a multilayer coating must be chosen carefully. For example, the thickness of an IR reflective layer, such as Ag, must be chosen carefully. It is well known that the emissivity of a Ag layer tends to decrease with decreasing Ag sheet resistance. Thus, to obtain a low emissivity Ag layer, the sheet resistance of the Ag layer should be as low as possible. However, increasing Ag layer thickness will also cause visible transmission to decrease and can result in colors that are generally undesirable. It would be desirable to be able to increase visible transmission by decreasing Ag layer thickness without increasing sheet resistance and emissivity.

[007] Thin, transparent metal layers of Ag are susceptible to corrosion when they are brought into contact, under moist or wet conditions, with various corrosive agents, such as atmosphere-carried chlorides, sulfides, sulfur dioxide and the like. To protect the Ag layers, various barrier layers can be deposited on the Ag. However, the protection provided by conventional barrier layers is frequently inadequate.

[008] Coated glass is used in a number of applications where the coating is exposed to elevated temperatures. For example, coatings on glass windows in self-cleaning kitchen ovens are repeatedly raised to cooking temperatures of 120-230 °C, with frequent excursions to, e.g., 480°C during cleaning cycles. In addition, when coated glass is tempered or bent, the coating is heated along with the glass to temperatures on the order of 600°C and above for periods of time up to several minutes. These thermal treatments can cause the optical properties of Ag coatings to deteriorate irreversibly. This deterioration can result from oxidation of the Ag by oxygen diffusing across layers above and below the Ag. The deterioration can also result from reaction of the Ag with alkaline ions, such as sodium (Na⁺), migrating from the glass. The diffusion of the oxygen or alkaline ions can be facilitated and amplified by the deterioration or structural modification of the dielectric layers above and below the Ag. Coatings must be able to withstand these elevated temperatures. However, previously known multilayer coatings employing Ag as an infrared reflective film frequently cannot withstand such temperatures without some deterioration of the Ag film.

[009] Low emissivity coatings are described in U.S. Patent Nos. 4,749,397 and 4,995,895. Vacuum deposited low emissivity coatings containing silver are presently sold in the fenestration marketplace.

[0010] U.S. Patent No. 4,995,895 teaches the use of oxidizable metals as haze reduction topcoats useful for protecting temperable low-e coatings. This patent is directed to methods of reducing haze resulting from exposure to temperatures over 600°C.

[0011] Metal, metal alloy and metal oxide coatings have been applied to low emissivity silver coatings to improve some properties of the coated object. U.S. Patent No. 4,995,895 describes a metal or metal alloy layer which is deposited as the outermost layer of the total layers applied to a glass base. The metal or metal alloy layer is oxidized and acts as an anti-reflection coating. U.S. Patent No. 4,749,397 describes a method where a metal oxide layer is deposited as an antireflection layer. Sandwiching the silver layer between anti-reflection layers optimizes light transmission.

[0012] Unfortunately, optical coatings are frequently damaged during shipping and handling, including by scratching and by exposure to corrosive environments. Silver based low-emissivity coatings are particularly susceptible to corrosion problems. Most low emissivity stacks in use today make use of barrier layers somewhere in or on the low emissivity thin layer stack to reduce these problems. Thin barriers typically function to reduce the corrosion of silver layers from water vapor, oxygen or other fluids. Some reduce damage from physical scratching of the low emissivity stack by virtue of their hardness or by lowering friction if they form the outer layer.

[0013] For sub-desert areas as well as regions with an intense sun load, the current high transmittance low-e products are already bringing advantages, but the heat and light load is still too high to maximize the thermal and visual comfort inside the houses and buildings in which such low-e products are being used.

[0014] A few low-e stacks with lower light transmittance are available, but such products usually exhibit at least one of the following draw backs: high reflectance, which makes them less aesthetically appealing, or high shading coefficient, which makes them inappropriate for controlling the heat load.

[0015] Very few commercially available low-e products combine the desired optical properties and shading coefficient. Those that do still require additional modifications to make them ideal for processing and production. Further, such low-e coatings are soft coatings that require extra attention during storage and processing into an insulating glass unit. It is desirable to improve the current mechanical and chemical durability of such coatings.

[0016] Producing different stack designs on the same coater also can often present a problem because the set-up requirements are not always compatible between the different designs. It would be desirable to provide different coatings that can be produced simultaneously on a coater without requiring down time and modification of the coater layout.

[0017] Furthermore, for safety reasons, more glass is now being heat treated to increase its mechanical strength and avoid laceration in case of breakage. This is especially true for low SHGC products. The increase in energy absorption of the coating increases the potential thermal stress on the lite when part of it is exposed to the sun's radiation and part of it is in the shade. Typical low-e coatings are not designed to withstand thermal strengthening or tempering. Such conditions can completely damage the coating, destroying its aesthetic appeal, thereby rendering it unusable.

[0018] There thus remains a need for low emissivity coating stacks (and methods of making them) that overcome the various problems seen in the prior art. In particular, there is a

need for low-e stacks having a low solar heat gain coefficient, which stacks exhibit retained or increased aesthetic appeal, and mechanical and/or chemical durability, and which can be tempered or heat strengthened, if desired. Moreover, there is a need for stacks that can be applied without need for a specific, nonstandard coater.

SUMMARY OF INVENTION

[0019] To overcome the problems associated with previous low emissivity coatings, the present invention provides improved coatings that yield stacks that have a low solar heat gain coefficient (i.e., low-g stacks), are aesthetically appealing, and exhibit equal or better chemical and mechanical durability than typical low emissivity stacks. Moreover, the invention provides products which are compatible with standard production methods. In particular, for example, shifting from a standard coater to a low-g coater would not require venting or other change in coater layout. Furthermore, glass substrates coated in accordance with the invention surprisingly can be tempered or heat strengthened without such tempering or heat strengthening causing degradation in the stack layers or in the optical qualities of the coated substrate and without causing the other drawbacks typically seen when such processes are used in connection with low emissivity coatings.

[0020] The present invention overcomes the disadvantages seen in low e stacks known in the art by increasing the absorption of such stacks, through the introduction of at least one thin absorbing layer, or by increasing the absorption of other layers, such as barrier layers. Such techniques for increasing the absorption of the stack decrease the overall light transmittance

without increasing the light reflectance. Such increased light reflectance is frequently a problem, particularly when it occurs on a pane facing the inside of a building.

[0021] The appropriate choice of absorbing material also enables one to control the transmittance color of the coated glass. In embodiments, an absorbing layer can be inserted between a barrier layer protecting an infrared reflecting layer, and an overlying dielectric. In alternate embodiments, a barrier layer itself can be made more absorbing to achieve a similar result. In such embodiments, the barrier layer thus serves both as a barrier layer and as an absorbing layer and is referred to herein as an "absorbing barrier" layer. The infrared reflecting layer is preferably silver (Ag), but may be any reflective material, such as, without limitation, copper or gold. Accordingly, in an aspect, the invention provides a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate, a first dielectric layer; a first infrared reflecting layer; a first absorbing barrier layer; a second dielectric layer; a second infrared reflecting layer; a second absorbing barrier layer; a third dielectric layer; and optionally, a topcoat layer. The optional topcoat layer is employed in embodiments which are to be subjected to tempering or heat treatment. In preferred embodiments, a nucleation layer underlies one or both of the infrared reflecting layers. While preferred embodiments include the above stack configurations, the invention also provides coatings having a single infrared reflecting layer, rather than two or more such layers. Such embodiments therefore would include a first dielectric layer; optionally, a nucleation layer; an infrared reflecting layer; an absorbing barrier layer; a second dielectric layer; and, optionally, a topcoat layer. The coatings of the present invention are formed by depositing the layers onto the substrate. A preferred method includes depositing by magnetron sputtering.

BRIEF DESCRIPTION OF THE DRAWINGS

[0022] **Figure 1** depicts an embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0023] **Figure 2** depicts an alternate embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability, which includes nucleation layers for improving the properties of the Ag layers, in accordance with the present invention.

[0024] **Figure 3** depicts a further embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0025] **Figure 4** depicts a still further embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0026] **Figure 5** depicts an embodiment of a low emissivity stack for use in an automotive or other vehicle, including two glass substrates, a PVB layer, and a coating in accordance with the present invention.

[0027] **Figures 6A and 6B** depict optical constant data for typical materials suitable for use as low-g absorbers in accordance with the invention. Figure 6A provides data relating to the index of refraction (n) and Figure 6B provides data relating to extinction coefficient (k).

[0028] **Figure 7** provides graphical data illustrating index of refraction and extinction coefficients for two stoichiometries of SiAlO_xN_y.

[0029] **Figure 8** provides graphical data illustrating preferred n & k values for SiAlO_xN_y in low-g stacks in accordance with the invention.

[0030] **Figure 9** depicts an alternate embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0031] **Figure 10** depicts a further embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0032] **Figure 11** depicts an embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0033] **Figure 12** depicts an alternate embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability, which includes nucleation layers for improving the properties of the Ag layers, in accordance with the present invention.

[0034] **Figure 13** depicts a further embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

[0035] **Figure 14** depicts a still further embodiment of an aesthetically appealing low-emissivity stack, exhibiting low SHGC and enhanced mechanical and/or chemical durability in accordance with the present invention.

DETAILED DESCRIPTION OF THE INVENTION

[0036] In the following detailed description, reference is made to various specific embodiments in which the invention may be practiced. These embodiments are described with sufficient detail to enable those skilled in the art to practice the invention, and it is to be understood that other embodiments may be employed, and that structural and logical changes may be made without departing from the spirit or scope of the present invention.

[0037] The present invention provides improved coatings that yield low emissivity stacks that have a low solar heat gain coefficient (SHGC), are aesthetically appealing, and exhibit equal or better chemical and mechanical durability than typical low emissivity stacks. Moreover, the invention provides products which are compatible with standard production methods. In particular, for example, shifting from a standard coater to a low-g coater would not require venting or other changes in coater layout. Furthermore, glass substrates coated in accordance with embodiments of the invention surprisingly can be tempered or heat strengthened without the drawbacks typically seen when such processes are used in connection with low emissivity coatings.

[0038] In embodiments, the present invention achieves the desired properties of low-e stacks by increasing the absorption of such stacks, through the introduction of at least one thin absorbing layer, or by increasing the absorption of other layers, such as barrier layers, (thereby

yielding “absorbing barrier” layers). Such techniques for increasing the absorption of the stack decrease the overall light transmittance without increasing the light reflectance. Such increased light reflectance is frequently a problem, particularly when it occurs on a pane facing the inside of a building. Tolerance for tempering can be enhanced by adjusting the thickness of the dielectric or absorbing barrier layers or the nature of the absorbing barrier layers.

[0039] In an aspect, the invention provides a low-emissivity stack, including a coating on a substrate, the coating comprising at least one absorbing layer. The absorbing layer can be a layer that is present in addition to a barrier layer. Alternatively, a barrier layer can be modified to also act as an absorbing layer, thus becoming an absorbing barrier layer and eliminating the need for separate absorbing and barrier layers. The low-emissivity stack is characterized by a solar heat gain coefficient (SHGC) that is less than about 0.34, preferably less than about 0.31. In some embodiments, the low-e stack is characterized by a SHGC of about 0.22 to about 0.25. In various embodiments, the stack has a light transmittance of about 42% to about 46%. In some embodiments described herein, the light transmittance can be up to about 62%. During tempering, the transmittance rises by about 1-8%. In some embodiments, the stack has a transmittance color with a negative a^* and a negative b^* . In alternate embodiments, the stack has a transmittance color with a negative a^* and a positive b^* .

[0040] In an aspect, the invention provides a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate, a first dielectric layer; a first infrared reflecting layer; a first absorbing barrier layer; a second dielectric layer; a second infrared reflecting layer; a second absorbing barrier layer; a third dielectric layer; and optionally, a topcoat layer. Either of the first or second absorbing barrier layers is optional, i.e., two such layers are

not required. The optional topcoat layer is employed in embodiments which are to be subjected to tempering or heat treatment. In preferred embodiments, a nucleation layer underlies one or more of the infrared reflecting layers.

[0041] The substrate is preferably glass. In preferred embodiments, the two infrared reflecting layers are Ag layers and are well balanced with a ratio Ag_1/Ag_2 of about 80% or higher. However, in alternate embodiments, the ratio may be as low as 50%. Having balanced Ag layers provides various advantages, in particular from a process point of view. Because the two targets erode at approximately the same rate, the length of a campaign can be maximized. When the second Ag layer (Ag_2) is much thicker than the first one (Ag_1), for example, the coater must be vented early in the campaign, which has a strong negative impact on production cost. As noted above, the invention also provides coatings having a single Ag layer, rather than two or more Ag layers.

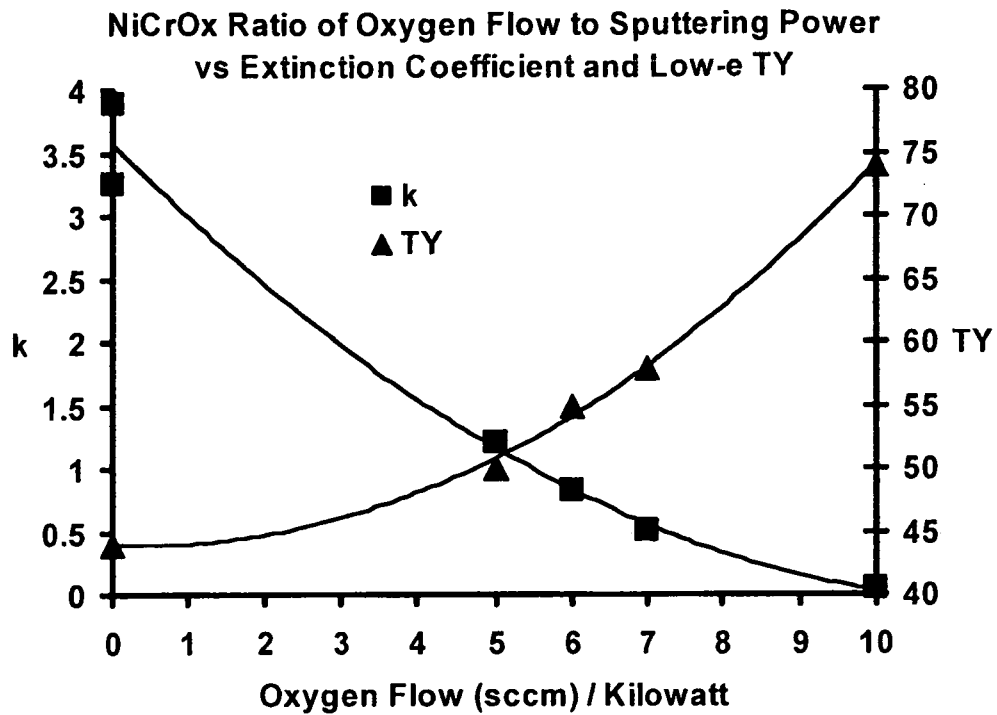
[0042] The absorbing layer, when present as a separate layer, is preferably inserted between the barrier protecting the Ag layer and the overlying dielectric. The absorbing material can include a metal, an alloy, a silicide, an absorbing oxide, an absorbing gray metal, a nitride, or any other suitable material that achieves the desired effect. Preferred materials include, without limitation, Ti, TiN, Si, NiCr, NiCrOx, Cr, Zr, Mo, W, and ZrSi, nickel or chromium alloys, and transition metals, nitrides, subnitrides, and suboxides thereof, as well as silicides and aluminides. In preferred temperable and non-temperable embodiments, the absorbing material comprises NiCr. In some embodiments which are not to be tempered, Ti also works well as an absorbing material.

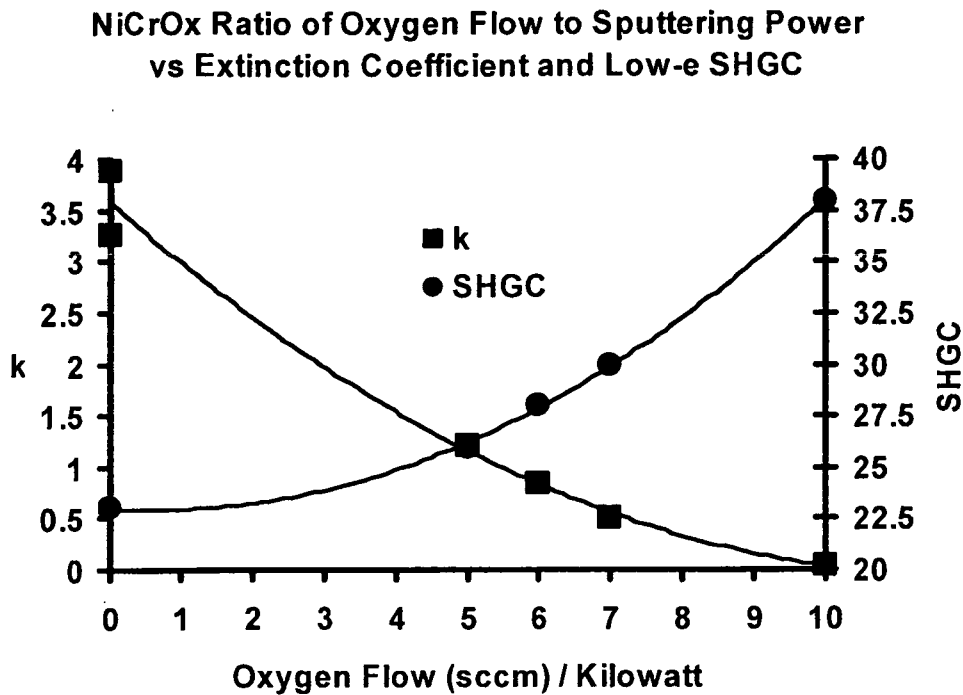
[0043] The appropriate choice of absorbing material also enables one of ordinary skill to control the transmittance color of the coated glass. A neutral color (a^* and b^* negative and well balanced are preferred--the minimal requirement being a negative a^* value and a b^* value that is lower than +2 for transmittance and glass side reflectance) is more aesthetically appealing than a stronger greenish or yellowish hue. A neutral transmittance is highly desirable because it maximizes the correct color rendering of the insulated glass unit (IGU) housing the glass. The present invention also makes it possible to obtain a bluish hue, if desirable.

[0044] Thus, certain materials in low-g designs have been found capable of lowering transmission of low-e coatings and allowing the stack color to be tuned to preferred colors. In the case of temperable coatings, the preferred materials also are thermally stable within the thin film stack. Many other materials can be used as alternatives to the absorbing materials recited above. Such materials are those which can be defined by a range of index of refraction (n) and extinction coefficients (k) that are suitable for performing this transmission lowering function. In a temperable low-g design, the absorbing layer will have the appropriate optical properties as well as additional thermal stability properties.

[0045] When a separate absorbing layer is not employed, one or more barrier layers can be modified to achieve increased absorption, thereby resulting in the same desirable optical properties described above. Such modification preferably includes altering gas levels in these layers, as represented in the graphs below. These graphs show the relationship between NiCrOx oxygen flow to sputter power (kilowatts) and NiCrOx extinction coefficient (k). The second y scale also shows TY or SHGC values when the given NiCrOx is used in a double silver low-e stack as described herein.

[0046] The NiCrOx ratio preferably is based on 2879 mm long sputtering targets run with DC power. Power is typically in the range from 15 to 45kw. Argon flow is 300sccm.





[0047] U.S. Pat. No. 6,416,872, incorporated into this application by reference in its entirety, refers to the use of a solar control design that contains a Fabry-Perot type thin film stack (metal/dielectric/metal). One of the metals is an infrared reflecting material (silver) and one is an optically absorbing material. The optically absorbing material is described in terms of a range of suitable optical constants. Embodiments of the present invention similarly include Fabry-Perot stacks but comprise a general layer structure of metal / metal / dielectric / metal / metal or, more specifically, metal / thin suboxide absorber (barrier) / metal / dielectric / metal / thin suboxide absorber (barrier) / metal. In each of these cases, one metal of the metal/metal pair is preferably an infrared reflecting metal and the other is preferably an absorbing metallic material. The low-g absorbing metallic material may be described by optical constant ranges similar to those set forth in U.S. Pat. No. 6,416,872. Optical constants for typical materials optically suitable as low-g absorbers are plotted in Figs. 6A and 6B. Based on the data presented in Fig. 6A, the preferred

index of refraction range at a wavelength of 550nm is from about 1 to about 5.5 for the metallic absorbers shown. Based on the data presented in Fig. 6B, the extinction coefficient range at a wavelength of 550nm is from about 1.75 to about 4.5 for the metallic absorbers shown. An additional parameter that may be used in helping to define the range of suitable materials is that of an index plot which has a positive slope at 550nm. This characteristic would distinguish the metallic materials from suboxides and nitrides which, when similarly plotted, typically have a negative slope at 550nm.

[0048] In an embodiment of the invention, the absorbing layer, when present as a separate layer, is introduced in a very specific location in the stack. This is to optimize the other properties which are important for the manufacturing and the processing of the coated glass, particularly the overall durability and the ease of production.

[0049] Each of the absorbing layers, when present, preferably has a thickness of about 0.1 nm to about 8 nm. If two absorbing layers are included, the first absorbing layer preferably is thicker than the second absorbing layer. The first absorbing layer preferably has a thickness of about 1 nm to about 6 nm, more preferably 1.5 nm to about 5 nm. The second absorbing layer preferably has a thickness of about 0.1 nm to about 5 nm, more preferably about 0.1 nm to about 4 nm. In an alternate embodiment, the first absorbing layer has a thickness of about 3 nm. In another alternate embodiment, the second absorbing layer has a thickness of about 0.5 nm. In another alternate embodiment, the first absorbing layer has a thickness of about 3.6 nm. In another alternate embodiment, the second absorbing layer has a thickness of about 0.1 nm. The above-noted thickness ranges are similarly suitable for absorbing barrier layers when such layers are used in lieu of separate absorbing and barrier layers.

[0050] The barrier layer (whether separate or an absorbing barrier layer) protects the Ag layer against attack of the plasma when sputtering the dielectric on top of it. It also improves the chemical durability by controlling the diffusion of aggressive species like O₂, O, H₂O, and Na⁺. In a preferred embodiment, the barrier is transparent. The barrier can comprise, without limitation, NiCr, NiCrOx, TiOx, NiCrNxOy, NiCrNx, Ti or other metal or metals, or subnitrides or suboxides thereof. A preferred barrier is NiCrOx. In such layers, particularly in the first (i.e., bottom) NiCrOx layer, it may comprise approximately 15 to 60 atomic percent oxygen. Preferably, the atomic percent oxygen is from 20% to 55%. Thermal durability for the temperable versions of this invention was improved when the first NiCrOx layer contained about 20 atomic percent oxygen. In preferred embodiments, (particularly when the barrier is modified to also have increased absorbing qualities), the barrier comprises NiCrOx and is a thin protective layer sputtered on silver and deposited from planar targets. It is preferably sputtered in an argon-oxygen mixture. The power to oxygen flow (sccm) is the preferred method used to estimate oxidation in sputtered NiCrOx. The ratio used for fully oxidized NiCrOx is 10:1. The ratio used in some coatings in accordance with the inventions preferably varies from 7.5:1 to 8.0:1.

[0051] In alternate preferred embodiments, an absorbing barrier of NiCr is employed. Similarly, this thin protective barrier layer is preferably sputtered on silver and deposited from DC planar targets. In such embodiments, the NiCr layer (or layers) are sputtered in argon only. Such NiCr layers can be fully metallic except for unintentional impurities, such as may be caused by gas crosstalk from neighboring cathodes.

[0052] In preferred embodiments, the dielectric layers each independently comprise an oxide, a nitride, or an oxy-nitride. When a dielectric layer comprises an oxide, the oxide is

preferably sputtered from a Ti, a Zn, an Sn, a ZnSn alloy, or a Bi target. The oxide may comprise Nb_2O_5 . The oxide may comprise up to about 20 wt%, preferably up to about 10 wt% of an element, such as Al or B, or similar such element. These dopants are commonly used to make silicon coater targets conductive. When a dielectric layer comprises a nitride or an oxy-nitride, the nitride or oxy-nitride can be a nitride or oxy-nitride of Si, SiAl, SiB, SiZr, or other suitable nitride or oxy-nitride that achieves the desired effect. Similarly, the nitride or oxy-nitride may comprise up to about 20 wt%, preferably up to about 10 wt% of an element, such as Al or B, or similar such element for making the coater target conductive. In preferred embodiments, the dielectric is SiAlOxNy and is reactively sputtered from a silicon /10 weight percent aluminum rotatable cathode. The reactive gas is preferably about 90% nitrogen flow and 10% oxygen. Although stoichiometry variations occur from layer to layer and from production run to production run, the material is preferably sub-stoichiometric. In preferred embodiments, insufficient nitrogen and oxygen are present in the sputtering gas for the SiAl to reach a fully reacted oxy-nitride. In some embodiments, atomic ratios in the layer are approximately $\text{Si}_4\text{O}_{0.4}\text{N}_5$.

[0053] In preferred embodiments that employ three primary dielectrics, at least one of the dielectric layers is in a substoichiometric state. More preferably, all three such dielectrics (e.g., SiAlOxNy) are in a substoichiometric state. Various advantages can be achieved using such substoichiometric layers. For example:

[0054] 1. The deposition rate from SiAl sputter targets is higher if the target surface chemistry is sub-stoichiometric. Sputter yield for a silicon rich surface is higher than for a

surface comprised of more nitrided silicon. The higher deposition rate is advantageous for running a coater at higher speeds, which is more economical.

[0055] 2. The higher index of the sub-stoichiometric nitrides allows for dielectric layers that have a lower physical thickness for the same optical thickness. Less target material is consumed when sub-stoichiometric layers are deposited and again, this allows the coater to run more efficiently.

[0056] 3. The higher index dielectrics allow for greater flexibility in the optical characteristics in the low-e stack design. Desirable colors for transmission and reflection may be more easily achieved using higher index dielectrics than can be achieved using lower index, stoichiometric materials.

[0057] 4. Sub-stoichiometric layers tend to have better chemical barrier properties than stoichiometric dielectrics. This allows for a more chemically stable and corrosion resistant low-e stack. Corrosive chemicals are less likely to reach the vulnerable silver layers.

[0058] 5. The optical absorption of the sub-stoichiometric dielectrics helps reduce the transmission and raise the solar heat gain coefficient of the low-g stack. Sub-stoichiometric dielectrics tend to be optically absorbing in the visible and more transparent in the infrared. Thus, these materials reduce visible transmission but do not tend to interfere with the infrared reflective properties of the silver layers.

[0059] Metal absorber layers are optically absorbing in both visible and infrared. When metallic materials are used to reduce transmission in a low-g product, both visible transmission and infrared reflection are reduced. It is desirable for low-e products to have as high an infrared reflection as possible.

[0060] These advantages tend to occur for sub-stoichiometric oxides, oxy-nitrides, and nitrides which might be used in a low-e stack.

[0061] The silicon to aluminum ratio used in the preferred dielectrics in stacks in accordance with the invention is 10 weight % Al. Other Si:Al ratios may be used. In some embodiments, the atomic ratio of Si, O, and N is approximately $\text{Si}_4\text{O}_{0.4}\text{N}_5$. The top silicon oxynitride dielectric has a primary function as an optical interference layer, which contributes to the antireflection of the silver. The material is chosen, however, in part for its barrier properties and hardness, and it contributes to the protection of the silver, both mechanically and chemically.

[0062] Figure 7 depicts Index and Extinction coefficients for silicon oxy-nitride. The indices and extinction coefficients plotted on the graph show two stoichiometries of SiAlOxNy . These represent the approximate SiAlOxNy stoichiometry upper and lower limits that would be suitable for low-g coatings. Stoichiometry for the preferred embodiments typically would fall between these two extremes. Figure 8 depicts approximate preferred n & k values for SiAlOxNy in low-g stacks.

[0063] In preferred embodiments, the dielectrics have indices of refraction at 550nm that are between about 1.8 and about 2.5, more preferably between about 2.1 and about 2.3. Specifically, in preferred embodiments, the top dielectric may have a lower index of refraction than the bottom or middle dielectrics. In such embodiments, the top dielectric has an index of refraction between about 1.8 and about 2.3 and the bottom or mid dielectrics have an index of refraction between about 2.0 and about 2.5. In preferred embodiments, the dielectrics have extinction coefficients at 550nm that are between about 0 and about 0.05, more preferably between about 0.01 and about 0.02.

[0064] In preferred embodiments, the coating further comprises a nucleation layer between the first dielectric layer and the first Ag layer. In an alternate preferred embodiment, the coating further comprises a second nucleation layer between the second dielectric layer and the second Ag layer. The nucleation layers improve the properties of the Ag layer, and are typically based on Zn oxide, with up to about 15 wt% of other elements, such as, without limitation, Al, Sn, or a combination thereof. In preferred embodiments, the sputtering targets used to deposit ZnO contain approximately 1.5% Al, yielding layers that are ZnAlOx. This material preferably is reactively sputtered from a zinc /1.5 weight percent aluminum rotatable or planar cathode. The sputtering gas preferably consists of argon and sufficient oxygen for the oxide to be deposited in a fully oxidized state. Nucleation layers for silver, such as those described herein, are commonly described in low-e patent literature. The nucleation layers in embodiments of the present invention are preferably between about 2 nm and 12 nm in thickness. In preferred embodiments, the bottom nucleation layer is thicker than the top nucleation layer, with the ratios between the two being about 1.2 to about 2.0. This configuration improves durability, particularly following heat treatment or tempering.

[0065] In preferred embodiments, the infrared reflecting layers comprise Ag and are sputtered in pure argon. Alternatively, a small amount of oxygen may be added. The oxygen helps with mechanical durability, particularly in embodiments subjected to heat treatment or tempering.

[0066] The optional topcoat, if included, can have a positive impact on the chemical and/or mechanical stability. It can comprise, without limitation, C, SiSn, ZrSi, SiSnO₂ or silicides. It should be noted that this nomenclature is not intended to refer to the stoichiometry or

atomic ratio of the different elements. For example, ZrSi is a sputtered material in which the Zr at% varies from 0 to 100% and the layer can be graded. This layer may oxidize upon heating. The topcoat typically has a contrasting nature compared to the underlying dielectric. If the dielectric is an oxide, the topcoat is preferably one of the above materials, or a nitride or an oxynitride, such as SiN or Si_xAl_yN_zO_c. Alternatively, when the dielectric is a nitride or an oxynitride, the top coat is chosen from the above list, or can be an oxide (for instance ZrO₂, ZrSiO₂, SnO₂, or, ZrO_xN_y, TiO₂ or other similar substance, but not limited to the precise stoichiometric ratios recited herein). A preferred topcoat is carbon, and is used preferably in a temperable product during production. Such a coating, which is typically sputtered, is preferably about 4-8nm thick and burns off in the tempering process. Preferred embodiments utilize an approximately 3-5nm thick sputtered carbon topcoat as the outermost layer. This material preferably is DC magnetron sputtered in argon.

[0067] In a preferred embodiment, the invention provides a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate a first dielectric layer having a thickness up to about 25 nm, preferably up to about 23 nm; a first Ag layer having a thickness of about 8 nm to about 15 nm; a first absorbing barrier layer having a thickness of about 0.1 nm to about 4 nm; a second dielectric layer having a thickness of about 40 nm to about 75 nm; a second Ag layer having a thickness of about 8 nm to about 15 nm; a second absorbing barrier layer having a thickness of about 0.1 nm to about 4 nm; a third dielectric layer having a thickness of about 10 nm to about 40 nm; and optionally, a topcoat layer. In a further embodiment, the coating comprises a nucleation layer between the first dielectric layer and the first Ag layer, the nucleation layer having a thickness of about 4 nm to about 12 nm. In a still

further embodiment, the coating comprises a second nucleation layer between the second dielectric layer and the second Ag layer, the second nucleation layer having a thickness of about 2 nm to about 8 nm. A stack having a first dielectric layer with a thickness of about 23 nm is particularly suitable for tempering.

[0068] In another preferred embodiment, the invention provides a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate a first dielectric layer comprising SiAlOxNy; a first nucleation layer comprising ZnAlOx; a first infrared reflecting layer comprising Ag; a first absorbing barrier layer comprising NiCr; a second dielectric layer comprising SiAlOxNy; a second nucleation layer comprising ZnAlOx; a second infrared reflecting layer comprising Ag; a second absorbing barrier layer comprising NiCr; a third dielectric layer comprising SiAlOxNy; and optionally, a topcoat layer. In alternate embodiments, the absorbing barrier layers comprise NiCrOx.

[0069] In another preferred embodiment, the invention provides a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate a first dielectric layer comprising SiAlOxNy and having a thickness up to about 25 nm, preferably up to about 23 nm; a first nucleation layer comprising ZnAlOx and having a thickness of about 4 nm to about 12 nm; a first Ag layer having a thickness of about 8 nm to about 15 nm; a first absorbing barrier layer comprising NiCr and having a thickness of about 0.1 nm to about 4 nm; a second dielectric layer comprising SiAlOxNy and having a thickness of about 40 nm to about 80 nm; a second nucleation layer comprising ZnAlOx and having a thickness of about 2 nm to about 8 nm; a second Ag layer having a thickness of about 8 nm to about 15 nm; a second absorbing barrier layer comprising NiCr and having a thickness of about 0.1 nm to about 4 nm; a third dielectric

layer comprising SiAlO_xNy and having a thickness of about 10 nm to about 40 nm; and optionally, a topcoat layer. In alternate embodiments, the absorbing barrier layers comprise NiCrO_x . A stack having a first dielectric layer with a thickness of about 23 nm is particularly suitable for tempering.

[0070] In an embodiment, the present invention provides a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate a first dielectric layer comprising $\text{SiAl}_x\text{N}_y\text{O}_w$ and having a thickness of about 3 nm to about 25 nm; a first nucleation layer comprising ZnAl_yO_x and having a thickness of about 4 nm to about 12 nm; a first Ag layer having a thickness of about 8 nm to about 12 nm; a first barrier layer comprising NiCrO_x and having a thickness of about 1 nm to about 4 nm; a first absorbing layer comprising NiCr and having a thickness of about 1.5 nm to about 4 nm; a second dielectric layer comprising $\text{SiAl}_x\text{N}_y\text{O}_w$ and having a thickness of about 55 nm to about 75 nm; a second nucleation layer comprising ZnAlO_x and having a thickness of about 3 nm to about 10 nm; a second Ag layer having a thickness of about 10 nm to about 15 nm; optionally, a second barrier layer comprising NiCrO_x and having a thickness of about 2 nm to about 4 nm; a second absorbing layer comprising NiCr and having a thickness of about 0.7 nm to about 2.2 nm; a third dielectric layer comprising $\text{SiAl}_x\text{N}_y\text{O}_w$ and having a thickness of about 24 nm to about 40 nm; and optionally, a topcoat layer. In embodiments, the second barrier layer comprising NiCrO_x is absent, so that the second absorbing layer is deposited directly on the second Ag layer. As an alternative to the NiCr metal in the second absorbing layer in this described embodiment, co-sputtered NiCr and Chromium, a NiCr/Cr bilayer, or any absorbing gray metal or alloy may be used. Further alternatives include, without limitation, a nichrome alloy comprising any Ni:Cr ratio, a NiCr

layer in which the Ni:Cr ratio is graded, a NiCr layer reacted with nitrogen to form NiCrN_x, and a dual layer optical absorber comprising NiCr/NiCr, wherein either metal may be any ratio of Ni and Cr.

[0071] In a further embodiment, the present invention provides, as illustrated in Figure 9, for example, a low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate a first dielectric layer; a first nucleation layer; a first Ag layer; a first barrier layer; a first optical absorbing layer; a second dielectric layer; a second nucleation layer; a second Ag layer; a second optical absorbing layer; a third dielectric layer; and optionally, a topcoat layer, preferably scratch resistant. Layer thicknesses are as described herein. In an alternate embodiment, as illustrated in Figure 10, for example, the coating comprises, in order outward from the substrate, SiAlOxNy / ZnO / Ag / NiCrOx / NiCr metal / SiAlOxNy / ZnO / Ag / NiCr metal / SiAlOxNy / optional topcoat. Therefore, in this embodiment, a second NiCr metal absorbing layer is deposited directly on the second Ag layer. This embodiment may be tempered or heat strengthened without such tempering or heat strengthening causing degradation in the stack layers or in the optical qualities of the coated substrate or causing the other drawbacks typically seen when such processes are used in connection with low emissivity coatings. In addition to improved temperability, this configuration (in which the second absorbing layer is directly deposited on the second Ag layer) exhibits improved mechanical durability. It has been noted also that color appears to be easier to tune to preferred setpoints with this embodiment. As an alternative to the NiCr metal in the second absorbing layer, co-sputtered NiCr and Chromium, a NiCr/Cr bilayer, or any absorbing gray metal, or alloy may be used. Further alternatives include, without limitation, a nichrome alloy comprising any Ni:Cr ratio, a NiCr layer in which

the Ni:Cr ratio is graded, a NiCr layer reacted with nitrogen to form NiCrN_x, and a dual layer optical absorber comprising NiCr/NiCr, wherein either metal may be any ratio of Ni and Cr.

[0072] The invention further provides low-emissivity stacks comprising at least one absorbing layer (which, as described, can be a separate layer, or a barrier layer modified to have increased absorption properties), the low-emissivity stack being characterized by a solar heat gain coefficient (SHGC) that is less than about 0.34, preferably less than about 0.31, and, in some preferred embodiments, about 0.22 to about 0.25. In embodiments, the stack includes a glass substrate having a thickness of about 1/8 inch and exhibiting a light transmittance of about 42% to about 46%. Embodiments also are provided which exhibit a light transmittance of about 50% to about 62%. In some embodiments, the stack has a transmittance color with a negative a* and a negative b*. In alternate embodiments, the stack has a transmittance color with a negative a* and a positive b*.

[0073] The invention further provides methods of making low-emissivity stacks having a low SHGC as described, the methods including depositing on a substrate the coatings described herein. The layers in the multilayer coatings of the present invention can be deposited by conventional physical and chemical vapor deposition techniques. The details of these techniques are well known in the art and will not be repeated here. Suitable deposition techniques include sputtering methods. Suitable sputtering methods include DC sputtering, using metallic targets, and AC and RF sputtering, using metallic and non-metallic targets. All can utilize magnetron sputtering. The sputtering can be in an inert gas, or can be carried out reactively in reactive gas. The total gas pressure can be maintained in a range from 5×10^{-4} to 8×10^{-2} mbar, preferably from 1×10^{-3} to 1×10^{-2} mbar. Sputtering voltages can be in a range from 200 to 1200 V, preferably 250

to 1000 V. Dynamic deposition rates can be in a range of from 25 to 4000 nm-mm²/W-sec, preferably 30 to 700 nm-mm²/W-sec. Coaters manufactured by Leybold Systems GmbH with model numbers Typ A 2540 Z 5 H/13-22 and Typ A 2540 Z 5 H/20-29 are suitable for sputter depositing the multilayer coatings of the present invention.

[0074] As indicated, the multiple layers of silver in the low emissivity coating of the present invention provide greater efficiency in reflecting IR radiation, and a sharper cut-off between transmitted and reflected wavelengths, than is possible with a single layer of silver.

[0075] The multilayer coating of the present invention is deposited on and is mechanically supported by the substrate. The substrate surface serves as a template for the coating, and influences the surface topography of the coating. To maximize transmission of visible light, preferably the surface of the substrate has a roughness less than the wavelength of the light. Such a smooth surface can be formed by, e.g., solidifying a melt of the substrate. The substrate can be any material having an emissivity that can be lowered by the multilayer coating of the present invention. For architectural and automotive applications, the substrate is preferably a material which has superior structural properties and minimum absorption in the visible and near-infrared spectra regions where the solar energy is concentrated. Crystalline quartz, fused silica, soda-lime silicate glass and plastics, e.g., polycarbonates and acrylates, are all preferred substrate materials.

[0076] As used in the present specification, the language "deposited onto" or "deposited on" means that the substance is directly or indirectly applied above the referenced layer. If applied indirectly, one or more layers may intervene. Furthermore, unless otherwise indicated, in describing coatings of the present invention by use of the format "[substance 1] / [substance 2] /

[substance 3] / . . ." or the format "a first [substance 1] layer; a first [substance 2] layer; a second [substance 1] layer; a second [substance 2] layer; . . .", or the like, it is meant that each successive substance is directly or indirectly deposited onto the preceding substance.

[0077] Coated articles according to different embodiments of this invention may be used in the context of architectural windows (e.g., IG units), automotive windows, or any other suitable application. Coated articles described herein may or may not be heat treated in different embodiments of this invention. Figure 5 depicts an embodiment of the invention suitable for use in an automotive or other vehicle application (such as a windshield or similar laminate). In the illustrated embodiment, a coating in accordance with the present invention is included in a stack which also comprises two glass substrates and a polyvinyl butyral (PVB) layer. The coating can be on the first sheet or the second sheet, provided it is facing the PVB.

[0078] Certain terms are prevalently used in the glass coating art, particularly when defining the properties and solar management characteristics of coated glass. Such terms are used herein in accordance with their well known meaning. For example, as used herein:

[0079] Intensity of reflected visible wavelength light, i.e. "reflectance" is defined by its percentage and is reported as $R_x Y$ or R_x (i.e. the RY value refers to photopic reflectance or in the case of TY photopic transmittance), wherein "X" is either "G" for glass side or "F" for film side. "Glass side" (e.g. "G") means, as viewed from the side of the glass substrate opposite that on which the coating resides, while "film side" (i.e. "F") means, as viewed from the side of the glass substrate on which the coating resides.

[0080] Color characteristics are measured and reported herein using the CIE LAB 1976 a^* , b^* coordinates and scale (i.e. the CIE 1976 a^*b^* diagram, D65 10 degree observer), wherein:

L^* is (CIE 1976) lightness units

a^* is (CIE 1976) red-green units

b^* is (CIE 1976) yellow-blue units.

[0081] Other similar coordinates may be equivalently used such as by the subscript "h" to signify the conventional use of the Hunter method (or units) Ill. C, 10^0 observer, or the CIE LUV u^*v^* coordinates. These scales are defined herein according to ASTM D-2244-93 "Standard Test Method for Calculation of Color Differences From Instrumentally Measured Color Coordinates" Sep. 15, 1993 as augmented by ASTM E-308-95, Annual Book of ASTM Standards, Vol. 06.01 "Standard Method for Computing the Colors of Objects by 10 Using the CIE System" and/or as reported in IES LIGHTING HANDBOOK 1981 Reference Volume.

[0082] The terms "emissivity" (or emittance) and "transmittance" are well understood in the art and are used herein according to their well known meaning. Thus, for example, the term "transmittance" herein means solar transmittance, which is made up of visible light transmittance (T_{vis}), infrared energy transmittance (T_{IR}), and ultraviolet light transmittance (T_{uv}) Total solar energy transmittance (T_S or T_{solar}) can be characterized as a weighted average of these other values. With respect to these transmittances, visible transmittance may be characterized for architectural purposes by the standard Ill. D65 10 degree technique; while visible transmittance may be characterized for automotive purposes by the standard Ill. A 2 degree technique (for these techniques, see for example ASTM E-308-95, incorporated herein by reference). For purposes of emissivity a particular infrared range (i.e. 2,500-40,000 nm) is employed.

[0083] "Emissivity" (or emittance) ("E" or "e") is a measure, or characteristic of both absorption and reflectance of light at given wavelengths. It is usually represented by the formula:

$E=1-\text{Reflectance}_{\text{film}}$. For architectural purposes, emissivity values become quite important in the so-called "mid-range", sometimes also called the "far range" of the infrared spectrum, i.e. about 2,500-40,000 nm., for example, as specified by the WINDOW 4.1 program, LBL-35298 (1994) by Lawrence Berkeley Laboratories, as referenced below. The term "emissivity" as used herein, is thus used to refer to emissivity values measured in this infrared range as specified by ASTM Standard E 1585-93 entitled "Standard Test Method for Measuring and Calculating Emittance of Architectural Flat Glass Products Using Radiometric Measurements". This Standard, and its provisions, are incorporated herein by reference. In this Standard, emissivity is reported as hemispherical emissivity (E_h) and normal emissivity (E_n).

[0084] The actual accumulation of data for measurement of such emissivity values is conventional and may be done by using, for example, a Beckman Model 4260 spectrophotometer with "VW" attachment (Beckman Scientific Inst. Corp.). This spectrophotometer measures reflectance versus wavelength, and from this, emissivity is calculated using the aforesaid ASTM Standard 1585-93.

[0085] The term R_{solar} refers to total solar energy reflectance (glass side herein), and is a weighted average of IR reflectance, visible reflectance, and UV reflectance. This term may be calculated in accordance with the known DIN 410 and ISO 13837 (December 1998) Table 1, p. 22 for automotive applications, and the known ASHRAE 142 standard for architectural applications, both of which are incorporated herein by reference.

[0086] "Haze" is defined as follows. Light diffused in many directions causes a loss in contrast. The term "haze" is defined herein in accordance with ASTM D 1003 which defines haze as that percentage of light which in passing through deviates from the incident beam greater than

2.5 degrees on the average. "Haze" may be measured herein by a Byk Gardner haze meter (all haze values herein are measured by such a haze meter and are given as a percentage of light scattered). Another term employed herein is "sheet resistance". Sheet resistance (R_s) is a well known term in the art and is used herein in accordance with its well known meaning. It is here reported in ohms per square units. Generally speaking, this term refers to the resistance in ohms for any square of a layer system on a glass substrate to an electric current passed through the layer system. Sheet resistance is an indication of how well the layer or layer system is reflecting infrared energy, and is thus often used along with emissivity as a measure of this characteristic. "Sheet resistance" may for example be conveniently measured by using a 4-point probe ohmmeter, such as a dispensable 4-point resistivity probe with a Magnetron Instruments Corp. head, Model M-800 produced by Signatone Corp. of Santa Clara, Calif.

[0087] "Chemical durability" or "chemically durable" is used herein synonymously with the term of art "chemically resistant" or "chemical stability". Chemical durability is determined by an immersion test wherein a 2" x 5" or 2" X 2" sample of a coated glass substrate is immersed in about 500 ml of a solution containing 4.05% NaCl and 1.5% H_2O_2 for 20 minutes at about 36°C. Chemical durability can also be determined by the Cleveland test or the climatic chamber test, as follows.

Cleveland Chamber Set Up

[0088] Samples are cut down to 4" x 12" or 6" x 12" for this test. The water is heated to 50°C +/- 2°C and the room temperature kept at 23°C +/- 3°C (73° F +/- 5°F). Samples are placed film side down over the heated water bath. Within a few minutes of exposure the samples

are covered with a thick layer of condensed water. As time progresses, the water drips down the face of the sample and new condensation forms on the sample. Condensed water is present on the samples for the entire duration of the test.

Climatic Chamber Set Up

[0089] Samples are cut down to 4" x 6" for this test. For the static humidity test, humidity is held at a 98% relative humidity (RH) while the temperature cycles between 45° and 55°C in one hour.

Measurements Performed

[0090] Samples are removed after 1, 3, and 7 days of exposure for measurements. Haze, emissivity, and film side reflection are measured.

To calculate delta haze:

Delta Haze = Post-Test Haze – Pre-Test Haze

To calculate delta E:

Delta E = $(\Delta L^2 + \Delta a^{*2} + \Delta b^{*2})^{1/2}$, where the ΔL , a^* , and b^* are pre-test minus post-test measurements.

[0091] To calculate percent change in emissivity use this formula:

Change in emissivity = $(E_{\text{post-test}} - E_{\text{pre-test}}) / (E_{\text{glass}} - E_{\text{pre-test}})$.

[0092] "Scratch durability," as used herein is defined by the following test. The test uses a Erichsen Model 494 brush tester and Scotch Brite 7448 abrasive (made from SiC grit adhered to fibers of a rectangular pad) wherein a standard weight brush or a modified brush holder is used to hold the abrasive against the sample. 100-500 dry or wet strokes are made using the brush or brush holder. Damage caused by scratching can be measured in three ways: variation of emissivity, haze and E for film side reflectance. This test can be combined with the immersion test or heat treatment to make the scratches more visible. Good results can be produced using 200 dry strokes with a 135g load on the sample. The number of strokes could be decreased or a less aggressive abrasive could be used if necessary. This is one of the advantages of this test, depending on the level of discrimination needed between the samples, the load and/or the number of strokes can be adjusted. A more aggressive test could be run for better ranking. The repeatability of the test can be checked by running multiple samples of the same film over a specified period.

[0093] The terms "heat treatment", "heat treated" and "heat treating" as used herein mean heating the article to a temperature sufficient to enable thermal tempering, bending, or heat strengthening of the glass inclusive article. This definition includes, for example, heating a coated article to a temperature of at least about 1100 degrees F. (e.g., to a temperature of from about 550 degrees C. to 700 degrees C.) for a sufficient period to enable tempering, heat strengthening, or bending.

[0094] The term "Solar Heat Gain Coefficient (or SHGC)" ("g") is well known in the art and refers to a measure of the total solar heat gain through a window system relative to the incident solar radiation.

[0095] Unless otherwise indicated, the additional terms listed below are intended to have the following meanings in this specification.

Ag	silver
TiO ₂	titanium dioxide
NiCrO _x	an alloy or mixture containing nickel oxide and chromium oxide. Oxidation states may vary from stoichiometric to substoichiometric.
NiCr	an alloy or mixture containing nickel and chromium.
SiAlN _x or SiN _x	reactively sputtered silicon aluminum nitride. Sputtering target typically contains 1-20 weight% Al. The sputtering gas is a mixture of Ar, N ₂ , and O ₂ . Dependant on the gas mixture and the sputtering power, the material is more or less absorbing.
SiAlN _x O _y or SiN _x O _y	reactively sputtered silicon aluminum oxy-nitride. Sputtering target typically contains 1-20 weight% Al. The sputtering gas typically is a mixture of Ar, N ₂ and O ₂ . Dependant on the gas mixture and the sputtering power, the material is more or less absorbing.
ZnAl _y O _x	reactively sputtered Zn aluminum oxide. Sputtering target typically contains 1-20 weight% Al. The sputtering gas is a mixture of Ar and O ₂ .
Zn _x Sn _y Al _z O _w	reactively sputtered zinc tin (aluminum) oxide. Sputtering target typically a zinc tin alloy with optional Al doping. The zinc tin alloy covers a wide range from zinc rich to tin rich alloys. The sputtering gas is a mixture of Ar and O ₂ .
Zr	zirconium

optical coating	one or more coatings applied to a substrate which together affect the optical properties of the substrate
low-e stack	transparent substrate with a low heat emissivity optical coating consisting of one or more layers
barrier	layer deposited to protect another layer during processing, especially a heat reflecting silver layer. May provide better adhesion of upper layers, may or may not be present after processing.
layer	a thickness of material having a function and chemical composition bounded on each side by an interface with another thickness of material having a different function and/or chemical composition. Deposited layers may or may not be present after processing due to reactions during processing. "Layer", as used herein, encompasses a thickness of material that may be bounded on a side by air or the atmosphere (such as, for example, the top layer or protective overcoat layer in a coating stack or surmounting the other layers in the stack).
co-sputtering	Simultaneous sputtering onto a substrate from two or more separate sputtering targets of two or more different materials. The resulting deposited coating may consist of a reaction product of the different materials, an un-reacted mixture of the two target materials or both.
Intermetallic compound	A certain phase in an alloy system composed of specific stoichiometric proportions of two or more metallic elements. The metal elements are electron or interstitial bonded rather existing in a solid solution typical of

standard alloys. Intermetallics often have distinctly different properties from the elemental constituents particularly increased hardness or brittleness. The increased hardness contributes to their superior scratch resistance over most standard metals or metal alloys.

Mechanical Durability

This term refers (unless otherwise noted) to a wet brush durability test carried out on an Erichsen brush tester (Model 494) using a nylon brush (Order number 0068.02.32. The brush weighs 450 grams. The individual bristle diameter is 0.3 mm. Bristles are arranged in groups with a diameter of 4 mm). The test is run for 1000 strokes (where one stroke is equal to a full cycle of one back and forth motion of the brush). The samples are brushed on the coated side and submerged in de-ionized water during the brushing procedure.

[0096] In various embodiments, the low emissivity stacks of the present invention exhibit the following independent characteristics: transmitted Y of about 30 to about 62, preferably about 35 to about 55 and most preferably about 40 to about 50; an transmitted a* value which is negative, most preferably about -1 to about -6; preferably a b* value which is negative, most preferably about 0 to about -6; RgY of about 8 to about 20, more preferably about 10 to about 18, most preferably about 11 to about 17; Rga* which is negative, most preferably about -1 to about -7; preferably an Rgb* value that is negative, most preferably -1 to about -7; Rf Y between about 2 and about 12, more preferably about 2 to about 10, and most preferably about 2 to about 8; Rfa* which is negative, most preferably about -2 to about -20; preferably an Rf b* of about -10 to

about +10, most preferably about -6 to about +6; and a SHGC of about .10 to .30, up to about .34, more preferably about .15 to about .28, most preferably about .20 to about .25.

[0097] To further illustrate the invention, the following non-limiting examples are also provided:

EXAMPLE 1

[0098] In the present example, depicted in Figure 4, a low-e coating is deposited on a glass substrate to form a stack having the following configuration: Glass/ 12 nm oxide/ 10nm Ag/ 2 nm NiCrOx/ 4nm NiCr/ 72nm oxide/ 13nm Ag/ 2nm NiCrOx/ 3nm NiCr/ 23nm oxide / 7nm SiN. The oxide can be sputtered from a Ti, Zn, Sn, ZnSn alloy, or Bi target. The oxide may comprise Nb₂O₅. The oxide may comprise up to about 20 wt%, preferably up to about 10 wt% of an element, such as Al or B, or similar such element to make the coater target conductive. The SiN topcoat is optional. This exemplified coating has an appealing transmittance color with a* and b* negative. The SHGC is below 0.30. The coating has an acceptable mechanical and chemical durability.

EXAMPLE 2

[0099] In the present example, a low-e coating is deposited on a glass substrate to form a stack having the following configuration: about 1/8 inch Glass/ 0-15 nm dielectric/ 2-10nm nucleation layer/ 8-15nmAg/ 0.1-4nm barrier/ 0.2-8nm Absorbing layer/ 40-75 nm dielectric/ 2-10nm nucleation layer/ 8-18nmAg/ 0.1-4nm barrier/ 0.2-8nm Absorbing layer/ 10-40 nm dielectric/ topcoat. The dielectric can be an oxide (as in example 1) or a nitride or an oxy-nitride

of Si, SiAl, SiB, SiZr and it may contain up to about 20 wt%, preferably up to about 10 wt% of an element, such as Al and B, to make the coater target conductive. The nucleation layer improves the properties of the Ag layer and is typically based on Zn oxide with up to 15 wt% of other elements such as Al, Sn or a combination thereof.

[00100] The barrier protects the Ag against the attack of the plasma when sputtering the dielectric atop. It also improves the chemical durability by controlling the diffusion of aggressive species such as O₂, O, H₂O, and Na⁺. Suitable barriers include, without limitation, NiCr, NiCrOx, NiCrNxOy, TiOx, Ti and other metals.

[00101] As indicated, the topcoat is optional. When included, it can have a positive impact on the chemical and mechanical stability. A suitable topcoat includes but is not limited to C, ZrSi, or silicides. Typically, the topcoat has a contrasting nature compared to the underlying dielectric. If the dielectric is an oxide, the topcoat will be one of the materials described above or a nitride or an oxy-nitride (for instance SiN or SixAlyNzOc). In the alternative, when the dielectric is a nitride or an oxynitride, the top coat can advantageously be an oxide, such as, without limitation, ZrO₂, ZrSiO₂, SnO₂, ZrOxNy, or TiO₂.

EXAMPLE 3

[00102] In the present example, a low-e coating is deposited on a glass substrate to form a stack having the following configuration: about 1/8 inch Glass/ 3-15 nm SiAlxNyOw / 3-10nm ZnAlyOx/ 8-12nm Ag/ 1-4nm NiCrOx/ 1.5-3.0 nm NiCr/55-65 nm SiAlxNyOw / 3-10nm ZnAlyOx/ 10-15nm Ag/ 1-4nm NiCrOx / 0.7-2.2 nm NiCr/ 24-32 nm SiAlxNyOw / optional top coat. The top coat, if included, can be chosen from, but is not limited to 1-5nm C, 1-10 nm of

ZrO₂, or ZrSiO₂. The coating in the present example exhibits a light transmittance of about 42% to about 46%, as measured on an IGU, a SHGC below about 0.30, and the transmittance color is gray and can be adjusted for a green to a blue hue. The IGU includes 1/8" coated glass, with the coating in position 2, and 1/8" clear class, with a 1/2" gap. The coating has improved chemical and mechanical durability. The double layer NiCrOx/NiCr in this example has a positive impact in achieving the sought after properties. Because of the specific location of the NiCr, the coating can be produced on an existing coater that is primarily dedicated to low-e coating. It does not require specific isolation of the NiCr sputtering target. A summary of the properties observed in the above exemplified stacks is provided in the table below:

	Example 1	Example 2	Example 3
Aesthetics	neutral	neutral	neutral
SHGC	below .30	below .30	below .30
Aesthetics	good	good	good
Angular stability	good	good	good
Humidity resistance	good	good	good
Chemical durability	good	good	good
Mechanical durability	good	good	good

EXAMPLE 4

[00103] The present Example represents a preferred non-tempered coating, with thickness data, in accordance with the invention. Thicknesses were measured with a DekTak Profilometer. In measuring the thicknesses, an initial thickness measurement was made on the entire stack. Subsequently, the top layer was turned off in the coater and the thickness of the stack minus the top SiAlOyNx layer was measured. This was repeated with layers turned off one at a time, until lastly, the bottom SiAlOyNx alone was measured. The accuracy of the measurements is approximately $\pm 0.5\text{nm}$.

LAYER	Individual layer
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	thickness (nm)
top SiAlOxNy	33.4
top NiCr	0.5
Ag	13.5
ZnAlOx	6.2
mid SiAlOxNy	68.2
bot NiCr	3.0
NiCrOx	1.3
Ag	10.6
ZnAlOx	9.0
bot SiAlOxNy	23.0

EXAMPLE 5

[00104] The present Example represents a preferred temperable coating, which includes a carbon topcoat, in accordance with embodiments of the invention. Thicknesses were measured with a Dektak Profilometer as in Example 4 above. In these measurements, the top SiAlOxNy and carbon topcoat thicknesses were not separated. The carbon is estimated to be approximately 5 nm thick, thereby making the top SiAlOxNy layer approximately 33 nm.

LAYER	Individual layer thickness (nm)
top SiAlOxNy and carbon topcoat	38.6
top NiCr	0.1

Ag	13.2
ZnAlOx	9.4
mid SiAlOxNy	67.4
bot NiCr	3.6
NiCrOx	1.0
Ag	9.8
ZnAlOx	10.7
bot SiAlOxNy	23.3

EXAMPLE 6

[00105] The table below represents optical and electrical measurements taken of coatings in accordance with embodiments of the invention. The "low-g A" product is an annealed product on which no heat treatment was carried out. The "low-g T" product is a temperable product, which includes a topcoat in accordance with the invention. "BB" represents measurements taken before tempering and "AB" represents measurements taken after tempering. "N/A" indicates no measurements were obtained during generation of this particular example.

	low-g A (no heat treatment done)	low-g T	
	BB only	BB	AB
Transmitted Y (monolithic on 1/8" glass)	44.7	42.9	45.37
a*t (transmissive): (monolithic on 1/8" glass)	-5.1	-.51	5.3
b*t (transmissive): (monolithic on 1/8" glass)	-4.3	1.59	-4.3
RtY (outside reflectance): (monolithic on 1/8" glass)	11.5	11.4	11.9
a*g (outside reflective): (monolithic on 1/8" glass)	-1.7	-4.8	-2.7
b*g (outside reflective): (monolithic on 1/8" glass)	-4.2	-6.7	-4.6

SHGC: (in IGU)	0.23	N/A	N/A
SC	0.26	N/A	N/A
T _{ultraviolet}	0.178	N/A	N/A
Rs	2.3	2.3	1.9
Transmitted ΔE^* ($\Delta L^*a^*b^*$) (monolithic on 1/8" glass)			12.1
Glass side reflection ΔE^* ($\Delta L^*a^*b^*$) (monolithic on 1/8" glass)			3.1

EXAMPLE 7

[00106] The present Example represents a summary of the specifications of various coatings in accordance with the present invention. Optical and electrical properties of non-tempered and temperable coatings in accordance with certain embodiments of the invention would fall within the specifications set forth in the table below.

Normal Incidence Color Specification for low-g coatings											
	Transmission			Glass Side R			Film Side R				
	TY	a*	b*	RGY	a*	b*	RFY	a*	b*	NC Rs	SHGC
Min	42.0	-6.0	-4.5	10.0	-3.0	-3.0	2.0	-18.0	-4.0	2.0	0.22
Max	46.0	-3.0	-1.5	12.0	-1.0	-6.0	6.0	-10.0	4.0	2.4	0.25

EXAMPLE 8

[00107] The present Example represents a substrate having a coating in accordance with the invention. As noted, an optional carbon topcoat (not depicted) can be employed in embodiments intended to be subjected to tempering or heat treatment and is preferably about 3 nm to about 5 nm in thickness. The optional topcoat is preferably not included in embodiments not intended to be tempered or heat treated. Such embodiments are referred to herein as “annealed.” Layer thicknesses for the exemplified embodiment shown below are approximate. Accuracy with respect to the dielectric and Ag layers is in the range of about $\pm 20\%$. The thickness of the NiCr layers can be plus 200% minus 20%. In annealed coatings, the ZnAlOx layers typically are thinner and may be as low as 60% of the values noted in the table below.

LAYER	Individual layer thickness (nm)
top SiAlOxNy	31
top NiCr	1.6

Ag	11.4
ZnAlOx	8.4
mid SiAlOxNy	79.7
bot NiCr	1.1
Ag	11.2
ZnAlOx	7.7
bot SiAlOxNy	24.2
Substrate	

[00108] The descriptions of the materials noted in the table are as follows:

SiAlOxNy - In embodiments represented by the present example, this material is reactively sputtered from a silicon /10 weight percent aluminum rotatable cathode. The reactive gas is about 90% nitrogen flow and 10% oxygen. This material is used for the bottom, middle, and top primary dielectric layers. Although stoichiometry variations can occur from layer to layer and from production run to production run, all of the SiAlOxNy in the present example is sub-stoichiometric. Insufficient nitrogen and oxygen are present in the sputtering gas for the SiAl to reach a fully reacted oxy-nitride. Atomic ratios in the layer are approximately $\text{Si}_4\text{O}_{0.4}\text{N}_5$.

ZnAlOx - In embodiments represented by the present example, this material is reactively sputtered from a zinc /1.5 weight percent aluminum rotatable or planar cathode. The sputtering gas consists of argon and sufficient oxygen for the oxide to be deposited in a fully oxidized state. This layer serves as a nucleation layer for the silver and is consistent with such layers commonly described in low-e patent literature.

Ag - In embodiments represented by the present example, the silver layers may be sputtered in pure argon or, alternatively, a small amount of oxygen may be added. The oxygen helps with mechanical durability in the tempered version, but is not always necessary.

NiCr - In embodiments represented by the present example, this thin, protective or barrier layer sputtered on silver is deposited from DC planar targets and is sputtered in argon only. In this example, these layers are fully metallic except for unintentional impurities such as gas crosstalk from neighboring cathodes.

Carbon - Temperable versions of the exemplified embodiment utilize a 3-5nm thick sputtered carbon topcoat as the outermost layer, which is DC magnetron sputtered in argon.

[00109] In the present example, gas distributions for all materials are symmetric in the machine direction. In the across machine direction, gas flows for reactive materials may be varied for tuning cross-machine uniformity.

[00110] It is preferable in the various embodiments described herein that the top Ag layer be thicker than the bottom Ag layer and the bottom absorbing barrier layer be thicker than the top absorbing barrier layer. (In the present example, the absorbing barrier layers are NiCr, but, as noted, alternate embodiments employ NiCrOx for such layers.) Such reverse thickness ratios are advantageous in achieving preferred colors of the stack. It is also preferable that the bottom dielectric layer (SiAlOxNy in the present example) be thicker than the middle and top dielectric

layers. Such a configuration similarly is advantageous in achieving preferred colors.

Furthermore, it is preferable that the bottom nucleation layer (ZnAlOx in the present example) be thicker than the top nucleation layer. Such a configuration provides for improved mechanical and chemical durability. In preferred embodiments, the stack layer ratios fall generally into the following ranges:

bottom Ag / top Ag: about 0.8 to about 1.0

bottom NiCr / top NiCr: about 1.2 to about 2.0

bottom ZnAlOx / top ZnAlOx: About 1.2 to about 2.0

bottom SiAlOxNy / top SiAlOxNy: about 0.4 to about 0.8

middle SiAlOxNy / top SiAlOxNy: about 1.5 to about 2.5.

[00111] It is further advantageous for the top dielectric to have a lower index of refraction than either the bottom or middle dielectric. Preferred ranges include:

top index: about 1.8 to about 2.3;

bottom or middle: about 2.0 to about 2.5.

[00112] The present Example exhibits the following color and solar performance.

Normal Incidence Color Specification for monolithic LowG on 1/8" glass

LowG A	Transmission			Reflection (uncoated side)			Reflection (coated Side)			NC Rs	SHGC
	TY	a*	b*	RGY	a*	b*	RFY	a*	b*		
Min	42.0	-6.0	-4.5	12.0	-3.0	-3.0	2.0	-12.0	-4.0	2.0	0.22
Max	46.0	-3.0	-1.5	16.0	-1.0	-6.0	6.0	-4.0	2.0	2.4	0.25

[00113] "NC Rs" refers to noncontact surface resistance and the measurement is in units of ohms/square.

In tempered embodiments, tempering color shift, or ΔE , is greater than 3 for the glass side reflection color. This is due to the burning off of the carbon layer.

EXAMPLE 9

Material	Annealed Stack (in nm)	Temperable Stack (in nm)
Carbon	n/a	0.14
Top SiAlOxNy	36.4	36.2
Top NiCrOx	5.7	4.7
Top Ag	10.2	11.6
Top ZnAlOx	6.5	5.3
Middle SiAlOxNy	71.0	71.1
Bottom NiCrOx	2.4	5.2
Bottom Ag	14.8	14.1
Bottom ZnAlOx	3.9	16.5
Bottom SiAlOxNy	22.4	24.3
Glass Substrate	3 mm	3 mm

[00114] The present Example represents a substrate having a coating in accordance with the invention. As noted, an optional carbon topcoat (not depicted) can be employed in embodiments intended to be subjected to tempering or heat treatment and is preferably about 3 nm to about 5 nm in thickness. The optional topcoat is preferably not included in embodiments not intended to be tempered or heat treated. Such embodiments are referred to herein as “annealed.” Layer thicknesses for the embodiment shown in the table below are approximate.

[00115] With respect to the exemplified embodiment, thickness measurements were made using a Dektak Profilometer. Slides with ink lines were coated with the full stack to achieve the total stack thickness. Additional samples were prepared by turning off the upper most material cathodes one layer at a time until only the bottom SiAlOxNy was present. The ink lines were removed with Isopropyl Alcohol and the resulting steps were measured with the Dek Tak. Individual layer thicknesses were calculated by subtracting the thickness of the remaining stack

underneath. Therefore the accuracy of the individual layers is affected by the accuracy of the layers underneath them. The accuracy of the dielectrics (SiAlOxNy) and the silvers (Ag) is in the range of +/-20%. The thickness range of the NiCrOx layer is +/-100%. Annealed embodiments in accordance with the inventions tend to have thinner bottom ZnAlOx than temperable versions.

[00116] The descriptions of the materials noted in the exemplified embodiment are as follows:

SiAlOxNy – In embodiments represented by the present example, this material is reactively sputtered from a silicon / 10 weight percent aluminum rotatable cathode. The reactive gas is about 90% nitrogen flow and 10% oxygen. This material is used for the bottom, middle, and top primary dielectric layers.

ZnAlOx - In embodiments represented by the present example, this material is reactively sputtered from a zinc / 1.5 weight percent aluminum rotatable or planar cathode. The sputtering gas consists of argon and sufficient oxygen for the oxide to be deposited in a fully oxidized state. This layer serves as a nucleation layer for the silver and is consistent with such layers commonly described in low-e patent literature.

Ag – In embodiments represented by the present example, the silver layers may be sputtered in pure argon or, as an alternative, a small amount of oxygen may be added. The oxygen helps with mechanical durability in the tempered version.

NiCrOx – In embodiments represented by the present example, this thin, protective or barrier layer sputtered on silver is deposited from planar targets and is sputtered in an argon oxygen mixture. The power to oxygen flow (sccm) is the method used to estimate oxidation in sputtered NiCrOx. The ratio used for fully oxidized NiCrOx is 10:1. The ratio used in preferred coatings in accordance with the presently exemplified embodiment varies from 7.5:1 to 8.0:1.

Carbon - Temperable versions of the exemplified embodiment utilize a 3-5nm thick sputtered carbon topcoat as the outermost layer. This material is DC magnetron sputtered in argon.

[00117] In the present example, gas distributions for all materials are symmetric in the machine direction. In the across machine direction, gas flows for reactive materials may be varied for tuning cross-machine uniformity.

[00118] The present Example exhibits the following optical characteristics:

Optical Properties	Annealed		Temperable	
	Monolithic	IGU	Monolithic	IGU
Tvis	65.5%	59.8%	69.3%	63.1%
a*t	-3.29	-3.73	-1.13	-1.87
b*t	3.67	3.66	1.95	2.08
Outside Reflection (glass side)	11.0%	14.4%	12.2%	15.9%
a*g	-1.56	-2.06	-1.48	-1.49
b*g	-7.41	-5.36	-3.56	-2.31
Inside Reflection (film side)	5.7%	12.4%	8.9%	15.0%
a*f	-13.3	-6.09	-15.9	-9.09
b*f	1.36	1.13	2.92	2.28
SHGC	0.346	0.305	0.371	0.329
SC	0.40	0.35	0.43	0.38
Tuv	0.27	0.23	0.30	0.25

The present Example exhibits the following color and solar performance:

Mid G	T Y	a*t	b*t	Rg Y	a*g	b*g	Rf Y	a*f	b*f	NS Rs	SHGC
Min	63%	-4	0	10%	-4	-7	5%	-16	0	1.5	0.25
Max	67%	0	4	12%	-1	-3	9%	-8	8	2.5	0.32

“NC Rs” refers to noncontact surface resistance and the measurement is in units of ohms/square.

In tempered embodiments, ΔE is as follows:

- 6 color units for transmission.
- 10 color units for glass side reflection.
- 14 color units for film side reflection.

The color shift is due to the burning off of the carbon layer.

EXAMPLE 10

[00119] The present Example includes a coating having the following structure, which employs a 2:1 oxygen:kw ratio in the NiCr layer.

LAYER
top SiAlOxNy
top NiCr
Ag
ZnAlOx
mid SiAlOxNy
bot NiCr
Ag
ZnAlOx
bot SiAlOxNy
Substrate

Process run data is provided in the table below:

Coater Set Up Temperable with 2:1 NiCrOx

Cathode	Target	Voltage (V)	I (amp)	P (kW)	Ar (sccm)	O2 (sccm)	N2 (sccm)	Pressure (x10 ⁻³ hPA)	Reactive Gas: kW ratio
1	SiAl	425.9	194.1	51.9	300	30	344	3.66	6.63
2	SiAl	601.3	149.7	51.9	300	30	344	4.22	6.63
5	ZnAl	431.1	179.3	39.3	150	420	0	2.65	0.00
7	ZnAl	328.7	178.4	39.4	150	420	0	1.88	10.66
10	Ag	436.3	29.8	13	100	20	0	1.12	1.54
20	NiCr	531.8	73.2	39	300	76.4	0		1.96
4	SiAl	604.2	193.5	67.8	300	35	482	1.29	7.11
12	SiAl	615.2	208.3	68.3	300	30	482	4.87	7.06
13	SiAl	581	202.1	68	300	30	482	4.25	7.09
15	SiAl	540.5	212.3	67.7	300	30	482		7.12
17	SiAl	549.8	207.5	67.8	300	30	482	4.45	7.11
17A	SiAl	505.8	213.7	67.5	300	30	482	4.59	7.14
21	ZnAl	392.9	133.3	39.5	150	500	0	1.66	0.00
23	Ag	565.4	14.6	8.2	100	20	0	1.62	0.00
19	NiCr	536.2	31.8	17.1	300	35.6	0	1.56	2.08
26	SiAl	471.6	130.7	35.1	300	30	254		0.85
27	SiAl	500.6	118.6	35.3	300	30	254		0.85
28	SiAl	484.4	121.9	35.2	300	30	254	4.58	7.22
30	SiAl	560.8	128.2	35.4	300	30	254		7.18
18	C	519.1	133.4	34.2	500	0	0	2.93	0.00

EXAMPLE 11

[00120] In the present Example, an annealed version of a coating in accordance with the invention is provided. Description of the stack configuration and characteristics are included in the tables below. In the exemplified embodiment, absorbing barrier layers comprising NiCrOx are employed.

	Material Thicknesses (in nm)		Annealed	-40%	+40%
	Preferred Range	More Preferred			
Layer			Example		
Bottom SiN	13 to 31 nm	18 to 27 nm	22.38	13	31
Bottom ZnOx	2 to 5 nm	3 to 5 nm	3.92	2	5
Bottom Ag	9 to 21 nm	12 to 18 nm	14.76	9	21
Bottom NiCrOx	1 to 3 nm	2 to 3 nm	2.42	1	3
Middle SiN	43 to 99 nm	57 to 85 nm	70.98	43	99
Top ZnOx	4 to 9 nm	5 to 8 nm	6.52	4	9
Top Ag	6 to 14 nm	8 to 12 nm	10.20	6	14
Top NiCrOx	3 to 8 nm	5 to 7 nm	5.68	3	8
Top SiN	22 to 51 nm	29 to 44 nm	36.42	22	51
Low-E Characteristics					
Characteristic	General	More Preferred	Most Preferred		
Rs (ohms/sq)	≤ 5.0	≤ 2.0	≤ 1.5		
En	≤ 0.07	≤ 0.04	≤ 0.03		
Monolithic Solar Characteristics					
Characteristic	General	More Preferred	example		
T Y (D65, 10°)	$\geq 64\%$	$\geq 66\%$	65.5%		
a* _i (D65, 10°)	-10 to 0.0	-4.0 to -2.0	-3.29		
b* _i (D65, 10°)	0 to 4.0	2.0 to 4.0	3.67		
Rg Y (D65, 10°)	4% to 14%	10% to 12%	11%		
a* _g (D65, 10°)	-10 to 0.0	-4.0 to -1.0	-1.56		
b* _g (D65, 10°)	-10 to 0.0	-7.0 to -3.0	-7.41		
Rf Y (D65, 10°)	4% to 14%	5% to 9%	5.7%		
a* _f (D65, 10°)	-20 to 0.0	-16 to -8.0	-13.3		
b* _f (D65, 10°)	0.0 to 10	0.0 to 8.0	1.36		
SHGC	≤ 0.40	≤ 0.35	0.346		
SC	≤ 0.49	≤ 0.46	0.40		
Tuv	≤ 0.35	≤ 0.30	0.27		
Tuv Damage Weighted (ISO)	≤ 0.49	≤ 0.46	0.514		

	IGU Solar Characteristics				
Characteristic	General		More Preferred		Example
T _Y (D65, 10°)	>=58%		>=60%		59.8%
a* _t (D65, 10°)	-10 to 0.0		-4.0 to -2.0		-3.73
b* _t (D65, 10°)	0 to 4.0		2.0 to 4.0		3.66
R _g Y (D65, 10°)	4% to 20%		10% to 15%		14.4%
a* _g (D65, 10°)	-10 to 0.0		-4.0 to -1.0		-2.06
b* _g (D65, 10°)	-10 to 0.0		-7.0 to -3.0		-5.36
R _f Y (D65, 10°)	4% to 20%		10% to 15%		12.4%
a* _f (D65, 10°)	-20 to 0.0		-16 to -8.0		-6.09
b* _f (D65, 10°)	0.0 to 10		0.0 to 8.0		1.33
SHGC	<=0.35		<=0.30		0.305
SC	<=0.43		<=0.40		0.35
U-value	0.20 to 0.30		0.22 to 0.25		0.24
T _{uv}	<=0.30		<=0.25		0.23
T _{uv} Damage Weighted (ISO)	<=0.49		<=0.46		0.464

Example Coater Set Up Annealed Test #24									
Cathode	Target	Voltage (V)	I (amp)	P (kW)	Ar (sccm)	O2 (sccm)	N2 (sccm)	Pressure (x10 ⁻³ hPA)	Reactive Gas: kW
1	SiAl	537.6	197.9	55.1	300	30	358	3.28	6.50
2	SiAl	494.2	206.6	55	300	30	358	3.44	6.51
6	SiAl	511.6	231.7	55.7	300	30	358	3.09	6.43
5	ZnAl	448.5	111.4	29.3	150	350	0	1.61	11.95
9	Ag	526	52.1	27.5	100	0	0	?	0.00
20	NiCr	574.7	41.4	23.8	100	185	0	?	7.77
11	SiAl	656.8	222.8	66.7	300	30	405	3.37	6.07
4	SiAl	495.9	247.1	66.1	300	35	405	2.93	6.13
12	SiAl	671.3	212.7	66.4	300	30	405	5.25	6.10
13	SiAl	579.9	217.5	66.1	300	30	405	4.74	6.13
14	SiAl	474	255.9	66	300	30	405	4.24	6.14
15	SiAl	531.8	222.6	65.9	300	30	405	1.03	6.15
16	SiAl	480.3	209.9	65.9	300	30	405	4.29	6.15
17	SiAl	583.3	211.8	65.9	300	30	405	4.57	6.15
17A	SiAl	545.7	229.1	65.8	300	30	405	4.43	6.16
18A	ZnAl	361.1	147.6	29.8	150	390	0	1.18	13.09
22	Ag	667.2	26.2	17.5	100	0	0	?	0.00
19	NiCr	612.6	38.1	23.3	100	192	0	?	8.24
25	SiAl	483.8	194.3	47.7	300	30	339	1.72	7.11
26	SiAl	443.9	195.8	47.9	300	30	339	4.99	7.08
27	SiAl	489	177.5	48	300	30	339	2.03	7.06
28	SiAl	384.3	186	47.8	300	30	339	5.1	7.09
29	SiAl	479.7	185.2	47.9	300	30	339	5.66	7.08
30	SiAl	524.9	177.7	48	300	30	339	3.83	7.06

Sample				
#505 AC31 Annealed	Monolithic & IGU Solar Characteristics			
Characteristic	Monolithic		IGU	
T Y (D65, 10°)	65.5%		59.8%	
a* _t (D65, 10°)	-3.29		-3.73	
b* _t (D65, 10°)	3.67		3.66	
Rg Y (D65, 10°)	11%		14.4%	
a* _g (D65, 10°)	-1.56		-2.06	
b* _g (D65, 10°)	-7.41		-5.36	
Rf Y (D65, 10°)	5.7%		12.4%	
a* _f (D65, 10°)	-13.3		-6.09	
b* _f (D65, 10°)	1.36		1.33	
SHGC	0.346		0.305	
SC	0.40		0.35	
Tuv	0.27		0.23	
Tuv Damage Weighted (ISO)	0.514		0.464	

EXAMPLE 12

[00121] In the present Example, a temperable version of a coating in accordance with the invention is provided. Description of the stack configuration and characteristics are included in the tables below. In the exemplified embodiment, absorbing barrier layers comprising NiCrOx are employed.

Material Thicknesses (in nm)					
				Temperable	-40% +40%
Layer	Preferred Range	More Preferred	Example		
Bottom SiN	15 to 34 nm	19 to 29 nm	24.32	15	34
Bottom ZnOx	10 to 23 nm	13 to 20 nm	16.50	10	23
Bottom Ag	8 to 20 nm	11 to 17 nm	14.06	8	20
Bottom NiCrOx	3 to 7 nm	4 to 6 nm	5.24	3	7
Middle SiN	43 to 100 nm	57 to 85 nm	71.10	43	100
Top ZnOx	3 to 7 nm	4 to 6 nm	5.34	3	7
Top Ag	7 to 16 nm	9 to 14 nm	11.60	7	16
Top NiCrOx	3 to 7 nm	4 to 6 nm	4.74	3	7
Top SiN	22 to 51 nm	29 to 43 nm	36.24	22	51
Top Carbon	1 to 10 nm	3 to 5 nm	0.14	0	0
Low-E Characteristics					
Characteristic	General	More Preferred	Most Preferred		
Rs (ohms/sq)	≤ 5.0	≤ 2.0	≤ 1.5		
En	≤ 0.07	≤ 0.04	≤ 0.03		
Monolithic Solar Characteristics					
Characteristic	General	More Preferred			
T Y (D65, 10°)	$\geq 64\%$	$\geq 66\%$	69.3%		
a^*_t (D65, 10°)	-10 to 0.0	-4.0 to -2.0	-1.13		
b^*_t (D65, 10°)	0 to 4.0	2.0 to 4.0	1.95		
Rg Y (D65, 10°)	4% to 14%	10% to 12%	12.2%		
a^*_g (D65, 10°)	-10 to 0.0	-4.0 to -1.0	-1.48		
b^*_g (D65, 10°)	-10 to 0.0	-7.0 to -3.0	-3.56		
Rf Y (D65, 10°)	4% to 14%	5% to 9%	8.9%		
a^*_f (D65, 10°)	-20 to 0.0	-16 to -8.0	-15.9		
b^*_f (D65, 10°)	0.0 to 10	0.0 to 8.0	2.92		
SHGC	≤ 0.40	≤ 0.35	0.371		
SC	≤ 0.49	≤ 0.46	0.43		
Tuv	≤ 0.35	≤ 0.30	0.297		
Tuv Damage Weighted (ISO)	≤ 0.49	≤ 0.46	0.559		

	IGU Solar Characteristics				
Characteristic	General	More Preferred			
T _Y (D65, 10°)	≥58%	≥60%		63.1%	
a* _i (D65, 10°)	-10 to 0.0	-4.0 to -2.0		-1.87	
b* _i (D65, 10°)	0 to 4.0	2.0 to 4.0		2.08	
R _g Y (D65, 10°)	4% to 20%	10% to 15%		15.9%	
a* _g (D65, 10°)	-10 to 0.0	-4.0 to -1.0		-1.49	
b* _g (D65, 10°)	-10 to 0.0	-7.0 to -3.0		-2.31	
R _f Y (D65, 10°)	4% to 20%	10% to 15%		15.0%	
a* _f (D65, 10°)	-20 to 0.0	-16 to -8.0		-9.09	
b* _f (D65, 10°)	0.0 to 10	0.0 to 8.0		2.28	
SHGC	≤0.35	≤0.30		0.329	
SC	≤0.43	≤0.40		0.38	
U-value	0.20 to 0.30	0.22 to 0.25		0.24	
T _{uv}	≤0.30	≤0.25		0.248	
T _{uv} Damage weighted	≤0.49	≤0.46		0.501	

Example Coater Set Up Temperable Test #38										
										Annealed
Cathode	Target	Voltage (V)	I (amp)	P (kW)	Ar (sccm)	O2 (sccm)	N2 (sccm)	Pressure (x10 ⁻³ hPA)	Reactive Gas: kW	
1	SiAl	458.9	179.8	43.2	300	30	328	0	7.59	6.50
2	SiAl	463	178.1	43.3	300	30	328	3.53	7.58	6.51
6	SiAl	436.9	195.8	43.7	300	30	328	3.45	7.51	6.43
5	ZnAl	439.8	129.2	34.2	150	330	0	2.02	9.65	11.95
7	ZnAl	325.8	160.6	34.6	150	330	0	1.1	9.54	0.00
10	Ag	527.8	44.1	23.3	100	40	0	0.644	1.72	7.77
20	NiCr	532.4	47.9	25.5	100	196	0	0.155	7.69	6.07
11	SiAl	558.4	161.8	39.1	300	30	264	3.86	6.75	6.13
4	SiAl	476.9	163.2	38.8	300	30	264	2.65	6.80	6.10
12	SiAl	519.7	162.6	39	300	30	264	5.09	6.77	6.13
13	SiAl	497.7	155.8	38.7	300	30	264	4.57	6.82	6.14
14	SiAl	410.9	182.6	38.6	300	30	264	4.07	6.84	6.15
15	SiAl	444.4	165.9	38.7	300	30	264	1.15	6.82	6.15
16	SiAl	449.7	151.9	38.7	300	30	264	4.93	6.82	6.15
17	SiAl	477.4	157.4	38.7	300	30	264	4.31	6.82	6.16
17A	SiAl	474	160.3	38.4	300	30	264	0	6.88	13.09
18A	ZnAl	366.9	168.5	34.8	150	440	0	1.42	12.64	0.00
23	Ag	486.7	21.4	10.4	100	40	0	0.661	3.85	8.24
19	NiCr	605.9	39.8	24.1	100	194	0	0.578	8.05	7.11
26	SiAl	461.2	141.3	32.8	300	30	257	3.46	7.84	7.08
27	SiAl	443.3	138.5	33	300	30	257	1.39	7.79	7.06
28	SiAl	445.6	136.8	32.8	300	30	257	5.38	7.84	7.09
29	SiAl	435.2	145.5	32.4	300	30	257	4.37	7.93	7.08
30	SiAl	474.5	138.6	33	300	30	257	4.14	7.79	7.06
18	C	506.9	123.7	30.9	500	0	0	3.78		

Sample				
#521 AC31 Temperable 3/16/07	Monolithic & IGU Solar Characteristics			
Characteristic	Monolithic		IGU	
T _Y (D65, 10°)	69.3%		63.1%	
a _t [*] (D65, 10°)	-1.13		-1.87	
b _t [*] (D65, 10°)	1.95		2.08	
R _g Y (D65, 10°)	12.2%		15.9%	
a _g [*] (D65, 10°)	-1.48		-1.49	
b _g [*] (D65, 10°)	-3.56		-2.31	
R _f Y (D65, 10°)	8.9%		15.0%	
a _f [*] (D65, 10°)	-15.9		-9.09	
b _f [*] (D65, 10°)	2.92		2.28	
SHGC	0.371		0.329	
SC	0.43		0.38	
T _{uv}	0.297		0.248	
T _{uv} Damage Weighted (ISO)	0.559		0.501	

While the present invention has been described with respect to specific embodiments, it is not confined to the specific details set forth, but includes various changes and modifications that may suggest themselves to those skilled in the art, all falling within the scope of the invention as defined by the following claims.

What is claimed is:

1. A low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate:
 - a first dielectric layer;
 - a first nucleation layer;
 - a first Ag layer;
 - a first barrier layer;
 - a second dielectric layer;
 - a second nucleation layer;
 - a second Ag layer;
 - a second barrier layer;
 - a third dielectric layer; and
 - optionally, a topcoat layer.
2. The low-emissivity coating of claim 1, wherein at least one of said first dielectric layer, said second dielectric layer or said third dielectric layer is in sub-stoichiometric state.
3. The low-emissivity coating of claim 1, wherein at least one of said first barrier layer or said second barrier layer is an absorbing barrier layer.

4. The low-emissivity coating of claim 1, wherein the first barrier layer and the second barrier layer each separately comprise a material selected from the group consisting of a metal, an alloy, a silicide, an absorbing oxide, and a nitride.
5. The low-emissivity coating of claim 4, wherein the first barrier layer and the second barrier layer each separately comprise a material selected from the group consisting of Ti, TiN, Si, NiCr, NiCrOx, Cr, Zr, Mo, W, and ZrSi.
6. The low-emissivity coating of claim 5, wherein at least one of the first barrier layer and the second barrier layer comprises NiCr.
7. The low-emissivity coating of claim 5, wherein at least one of the first barrier layer and the second barrier layer comprises NiCrOx.
8. The low-emissivity coating of claim 1, wherein at least one of the first or second barrier layers is capable of lowering transmission of the coating.
9. The low-emissivity coating of claim 1, wherein at least one of the first or second barrier layers is capable of increasing absorption of the coating.
10. The low emissivity coating of claim 1, wherein the second silver layer is thicker than the first silver layer.

11. The low emissivity coating of claim 1, wherein the first barrier layer is thicker than the second barrier layer.
12. The low emissivity coating of claim 10, wherein the ratio of the first silver layer thickness to the second silver layer thickness is about 0.8 to about 1.2.
13. The low emissivity coating of claim 11, wherein the ratio of the first barrier layer thickness to the second silver barrier thickness is about 1.2 to about 2.0.
14. The low emissivity coating of claim 1, wherein the first nucleation layer is thicker than the second nucleation layer.
15. The low emissivity coating of claim 14, wherein the ratio of the first nucleation layer thickness to the second nucleation layer thickness is about 1.2 to about 2.0.
16. The low emissivity coating of claim 1, wherein the third dielectric layer has an index of refraction that is lower than both the index of refraction of the second dielectric layer and the index of refraction of the first dielectric layer.
17. The low emissivity coating of claim 7, wherein each of said barrier layers comprises a 2:1 oxygen:kw ratio.

18. The low-emissivity coating of claim 1, wherein each of the first dielectric layer, the second dielectric layer, and the third dielectric layer independently comprises a material selected from an oxide, a nitride, and an oxy-nitride, or a combination thereof.
19. The low-emissivity coating of claim 18, wherein at least one of the first dielectric layer, the second dielectric layer, and the third dielectric layer comprises an oxide.
20. The low-emissivity coating of claim 19, wherein the oxide comprises up to about 20 wt% of an element selected from the group consisting of Al and B.
21. The low-emissivity coating of claim 20, wherein the oxide comprises up to about 10 wt% of an element selected from the group consisting of Al and B.
22. The low-emissivity coating of claim 15, wherein at least one of the first dielectric layer, the second dielectric layer, and the third dielectric layer comprises a nitride or an oxy-nitride.
23. The low-emissivity coating of claim 1, wherein at least one of the nucleation layers comprises ZnAlOx.

24. A low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate:
- a first dielectric layer comprising SiAlOxNy;
 - a first nucleation layer comprising ZnAlOx;
 - a first infrared reflecting layer comprising Ag;
 - a first absorbing barrier layer comprising NiCr;
 - a second dielectric layer comprising SiAlOxNy;
 - a second nucleation layer comprising ZnAlOx;
 - a second infrared reflecting layer comprising Ag;
 - a second absorbing barrier layer comprising NiCr;
 - a third dielectric layer comprising SiAlOxNy; and
 - optionally, a topcoat layer.
25. A low-emissivity coating on a substrate, the coating comprising, in order outward from the substrate:
- a first dielectric layer comprising SiAlOxNy;
 - a first nucleation layer comprising ZnAlOx;
 - a first infrared reflecting layer comprising Ag;
 - a first absorbing barrier layer comprising NiCrOx;
 - a second dielectric layer comprising SiAlOxNy;
 - a second nucleation layer comprising ZnAlOx;
 - a second infrared reflecting layer comprising Ag;

a second absorbing barrier layer comprising NiCrOx;
a third dielectric layer comprising SiAlOxNy; and
optionally, a topcoat layer.

26. The low emissivity coating of claim 1, wherein the substrate is glass.
27. A low-emissivity stack comprising at least one absorbing barrier layer, said low-emissivity stack characterized by a solar heat gain coefficient (SHGC) that is less than about 0.31.
28. The low-emissivity stack of claim 27, wherein the stack is characterized by a solar heat gain coefficient (SHGC) that is about 0.22 to about 0.25.
29. The low emissivity stack of claim 27, wherein the stack has a light transmittance of about 42% to about 46%, as measured on an IGU.
30. The low emissivity stack of claim 27, wherein the stack has a light transmittance of about 58% to about 62%, as measured on an IGU.
31. The low-emissivity stack of claim 27, characterized by improved mechanical or chemical stability.

32. A method of making a low-emissivity stack having a low solar heat gain coefficient (SHGC), said method comprising depositing on a substrate the coating of claim 1.
33. The method of claim 32, wherein the depositing comprises magnetron sputtering.
34. The low emissivity stack of claim 1, characterized by a tolerance for tempering or heat strengthening.
35. The low emissivity stack of claim 34, wherein optical qualities of the stack are not degraded following tempering or heat strengthening.
36. The low emissivity stack of claim 27, wherein the stack has a transmittance color with a negative a^* and a negative b^* .
37. The low emissivity stack of claim 27, wherein the stack has a transmittance color with a negative a^* and a positive b^* .
38. An automotive window comprising the low emissivity coating of claim 1.