

- [54] Title: TETRAHALOPHTHALATE ESTERS AS FLAME RETARDANTS FOR STYRENE MALEIC ANHYDRIDE COPOLYMER (SMA) RESINS
- [75] Inventor (s): JOSEPH MICHAEL BOHEM, of King of Prussia, Pennsylvania, U. S. A.
- [73] Assignee (s): PERMUTAL CORPORATION, of Philadelphia, Pennsylvania, a corporation of Pennsylvania, U. S. A.
- [22] Filed: April 3, 1990

- [21] Application Serial No: 40519 - A divisional application of application SN-37760 filed on November 2, 1988.

FOREIGN APPLICATION PRIORITY DATA

- [31] Number (s) : 173,691
- [32] Date (s) : March 25, 1988
- [33] Country (ies) : U. S. A.
- [52] PH Class 524/288; 524/411
- [51] Int. Class COSEK 5/12
- [58] Field of Search 524/288; 524/411

- [56] Reference (s) Cited and/or Considered:
- | | | | |
|-----------------|-----------|---------|------------------|
| U. S. Pat. Nos. | 3,766,249 | 10/1973 | Howell et al. |
| | 3,772,542 | 11/1973 | Foley |
| | 3,956,845 | 6/1976 | Finberg |
| | 4,052,401 | 6/1977 | Fillar |
| [57] | 4,032,509 | 6/1977 | Lee |
| | 4,058,245 | 7/1977 | Reineke |
| | 4,051,311 | 9/1977 | Lee |
| | 4,093,704 | 7/1978 | Candler |
| | 4,108,945 | 8/1978 | Lee |
| | 4,115,672 | 9/1978 | Fillar |
| | 4,125,753 | 11/1978 | Candler |
| | 4,132,748 | 1/1979 | Arthur et al. |
| | 4,156,155 | 1/1979 | Lee |
| | 4,151,213 | 4/1979 | Lee |
| | 4,304,874 | 12/1981 | De Giulio et al. |
| | 4,323,655 | 4/1982 | -do- |
| | 4,329,272 | 5/1982 | Dufour |
| | 4,361,666 | 11/1982 | -do- |
| | 4,376,337 | 3/1983 | Jenkner et al. |
| | 3,397,977 | 8/1983 | Sandler |
| | 4,762,861 | 8/1988 | Schen et al. |
| | 4,764,550 | 8/1988 | Lovenguth |

(See abstract next page)

via patches
37856

BAD ORIGINAL

26837

'91 OCT 11 P343

ABSTRACT

Tetrahalophthalate esters are disclosed herein as flame retardant processing aids for styrene-maleic anhydride (SMA) resins.

26837

TETRAHALOPHTHALATE ESTERS AS FLAME
RETARDANTS FOR STYRENE-MALEIC
ANHYDRIDE COPOLYMER (SMA) RESINS

BACKGROUND OF THE INVENTION

5 This invention relates to flame retardant compositions containing at least one tetrahalophthalate ester and an SMA resin. Additionally, this composition may also contain one or more brominated and/or chlorinated compounds in an amount to provide additional flame retardancy to the SMA resin. This invention also comprehends the method of improving the flame retardancy and processability of the SMA resins by using these tetrahalophthalate esters alone or in combination with one or more bromine and/or chlorine compounds.

10

15

 Styrene-Maleic Anhydride (SMA) copolymers find extensive use in the manufacture of molded articles and foamed products. In general, they are prepared by copolymerizing styrene and maleic anhydride in the proper ratio and under the appropriate conditions. The preparation and

20

description of SMA copolymers are described
in U.S. Pat. Nos. 2,769,804; 2,971,939; 3,336,267;
and 3,966,843, the teachings of which are incor-
porated herein by reference.

5 SMA polymers burn rapidly and are generally
not used in applications which require fire
retardant polymers such as radio and television
cabinets, tables, chairs, appliance housings and
the like. (See U.S. Pat. No. 4,151,218 which is
10 incorporated by reference).

 The use of brominated and/or chlorinated
compounds by themselves or in combination with
other materials such as organic phosphates, anti-
mony compounds, etc., as flame retardants for
15 SMA resin compositions are well known in the art
and are exemplified by U.S. Pat. Nos. 3,766,249;
3,966,843; 4,032,481; 4,038,245; 4,089,912;
4,113,672; 4,136,135; 4,151,218; and 4,323,655.
The aforesaid patents are incorporated herein
20 by reference.

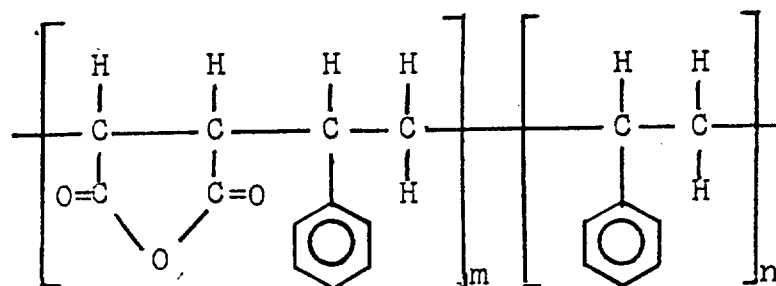
 Tetrahalophthalate esters have been used
as flameproofing materials. For example, U.S.

Pat. No. 4,098,704 describes the use of these materials as textile finishing agents. U.S. Pat. Nos. 4,298,517 and 4,397,977 disclose these compounds as flame retardants for halogenated resins. However, no teachings have been found which show the use of these compounds as flame retardants or processing aids for SMA resins.

SUMMARY OF THE INVENTION

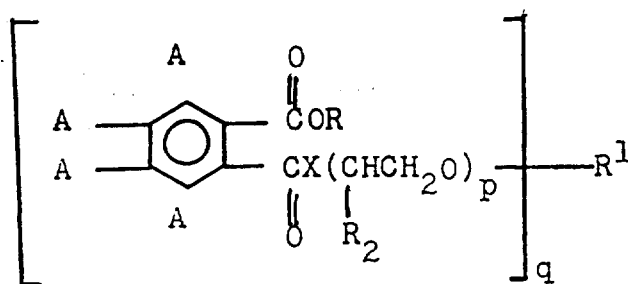
The present invention is directed to a composition of a styrene-maleic anhydride (SMA) resin and a flame retardant processing aid comprising:

(i) a styrene-maleic anhydride (SMA) resin having the following general formula:



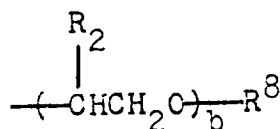
wherein m is a number from 1 to about 100 and
n is a number from zero to about 100; and

(ii) a flame retarding effective amount
of a tetrahalophthalate ester flame retardant
processing aid of the formula:



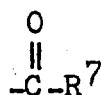
wherein

(a) R is selected from the group consisting of hydrogen, an alkyl or substituted alkyl of 1 to 30 carbons, hydroxyalkyl of 2 to 20 carbons, polyhydroxyalkyl of 3 to 10 carbons, and

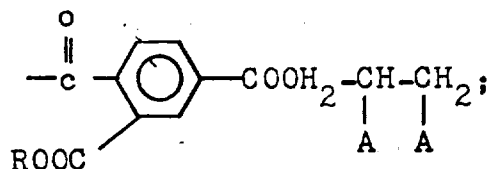
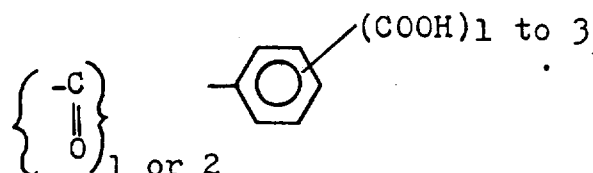


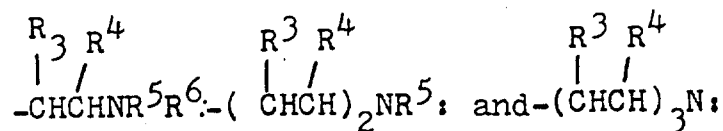
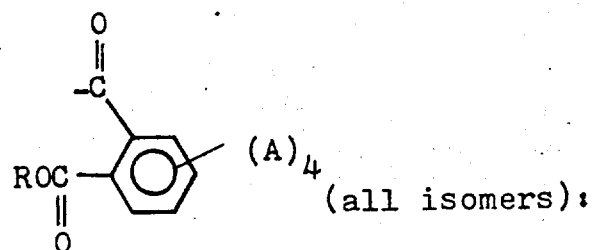
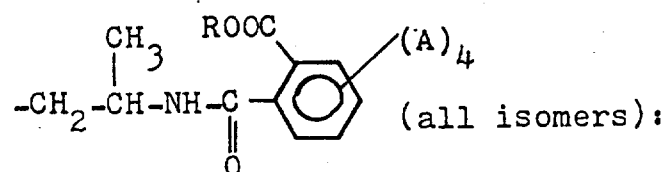
where R^8 is an alkyl or substituted alkyl of 1 to 18 carbons, and b is 1 to 50;

5 (b) R^1 is selected from the group consisting of hydrogen, an alkyl or substituted alkyl of 1 to 30 carbons, alkenyl or substituted alkenyl of 2 to 22 carbons,



where R^7 is an alkyl of 1 to 18 carbons; a polyhydroxyalkyl of 3 to 12 carbons;





5 with the proviso that the valence of R^1 is equal to q;

(c) R^2 is independently selected from the group consisting of H and CH_3 ;

10 (d) R^3 , R^4 , R^5 , and R^6 are independently selected from the group consisting of H and alkyl of 1 to 18 carbons;

(e) p is an integer of 0 to 50;

(f) q is an integer of 1 to 6;

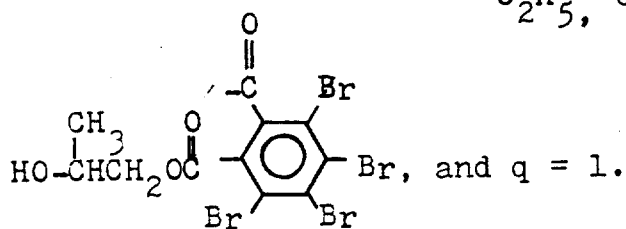
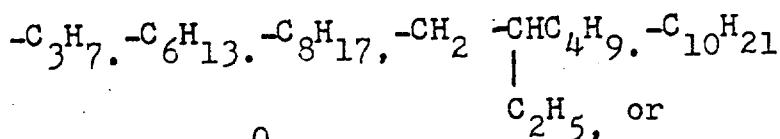
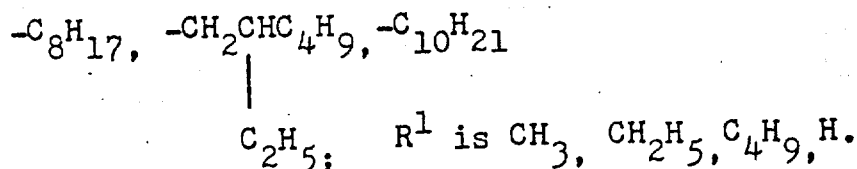
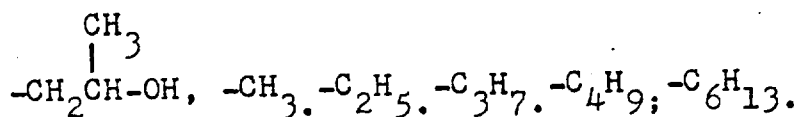
15 (g) X is selected from the group consisting of O or NH;

(h) A is selected from the group consisting of Cl or Br; and

(i) provided further that when p is zero and X is oxygen that R and R¹ are other than a neopentyl group.

Preferably, the weight ratio of (i) to (ii) is within the range of about 100:1 to about 2:1.

It is preferred that in the above tetrahalophthalate ester (ii), R is an alkyl or substituted alkyl of 1 to 10 carbons, A is Br, X is oxygen, p is 0 to 20, and q is 1 to 6. More preferably R is



In the tetrahalophthalate ester of ii, preferably p is zero, q is one, and x is oxygen. Even more preferred is when also R and R¹ are alkyl groups and A is Br. Most preferably, the ester is di-2-ethylhexyl tetrahalophthalate.

Another aspect of this invention is that the composition may optionally also contain other bromine and/or chlorine compounds such as those that are well known in the art.

This invention also comprehends the method of improving the flame retardancy and processability of the SMA resins by incorporating in the resin the tetrahalophthalate compound as described above alone or in combination with other bromine and/or chlorine flame retardants.

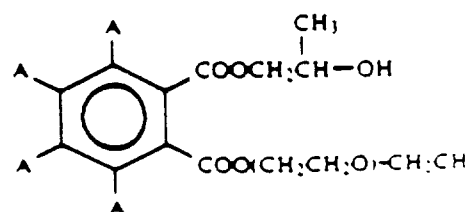
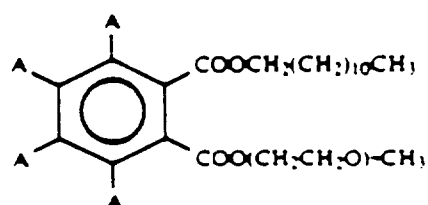
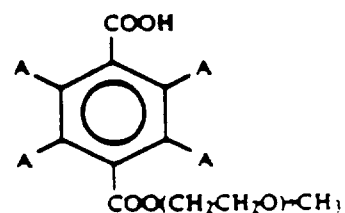
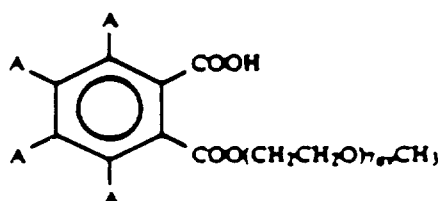
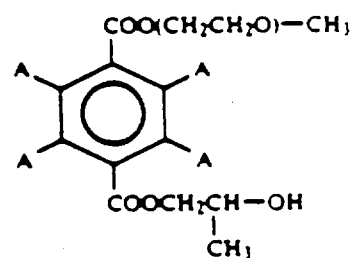
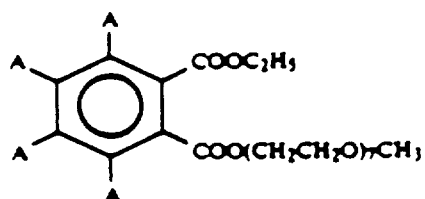
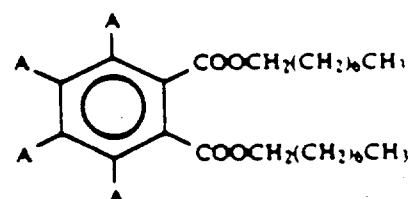
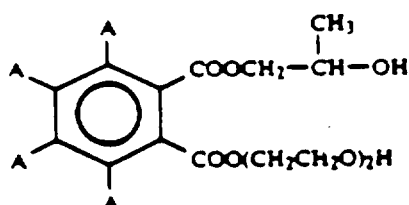
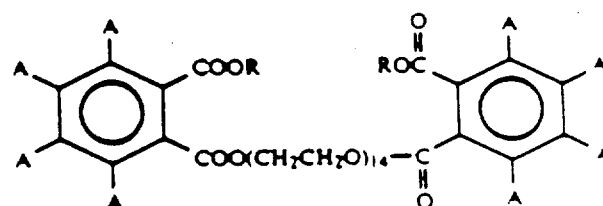
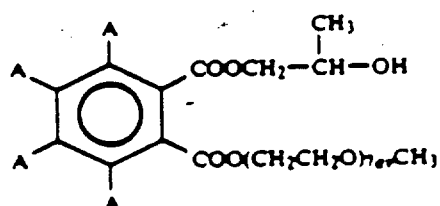
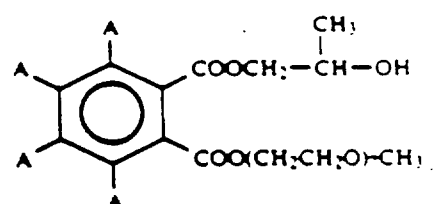
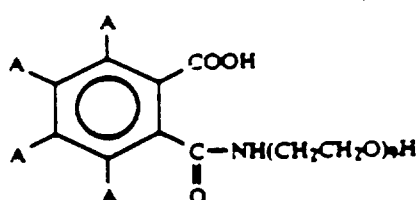
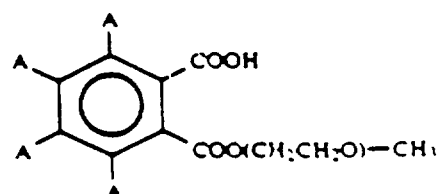
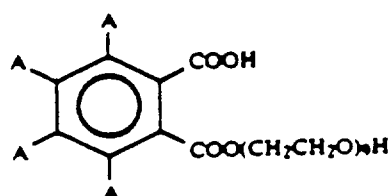
In practicing this invention, the tetrahalophthalate by itself or additionally with other brominated and/or chlorinated flame retardants is added to the SMA resin in any convenient manner, such as blending or extruding in order to get a uniform composition. Flame retardant synergists such as antimony oxide (Sb_2O_3) may also be

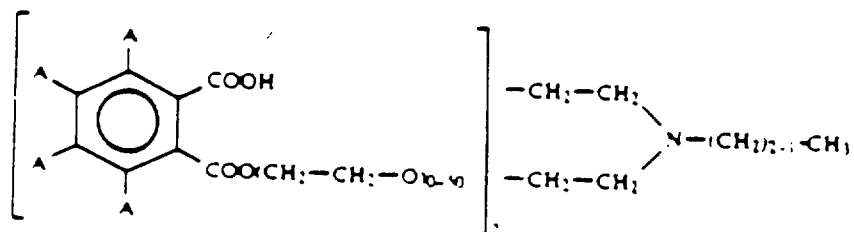
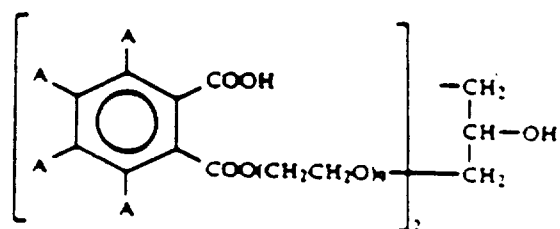
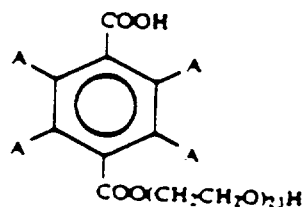
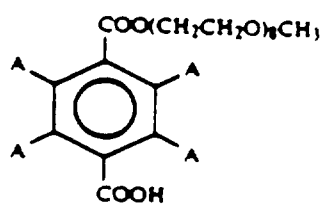
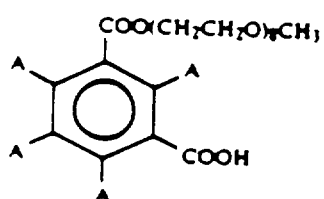
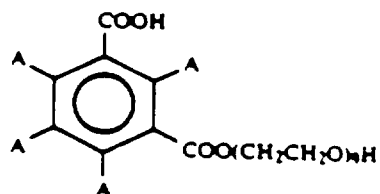
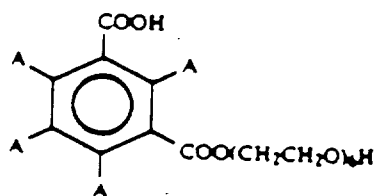
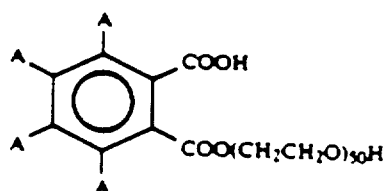
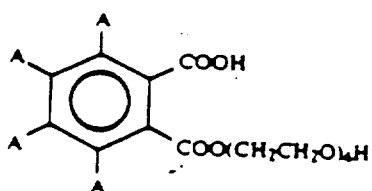
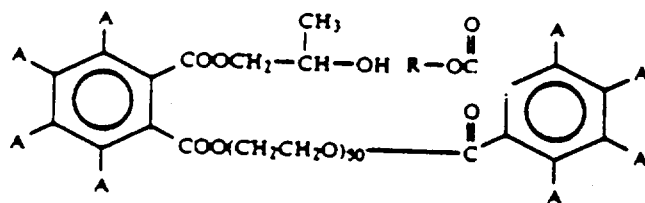
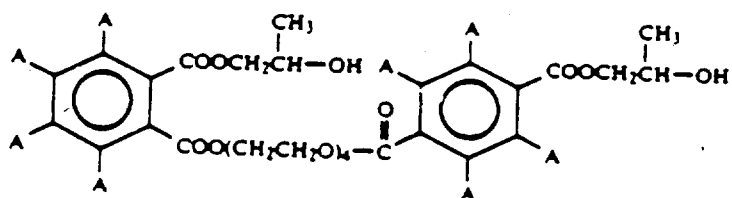
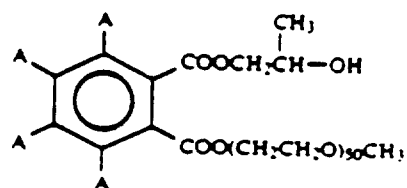
added if desired. In addition, other additives such as thermal stabilizers, ultraviolet stabilizers, reinforcing agents, organic polymers, mold release agents, blowing agents, colorants, and the like may also be optionally included.

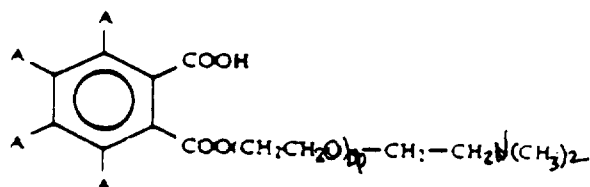
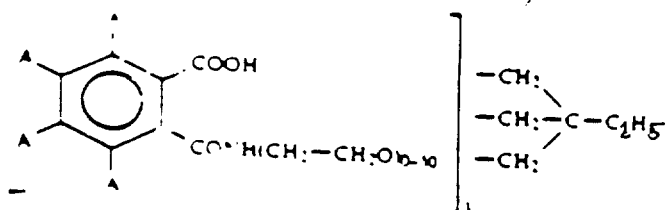
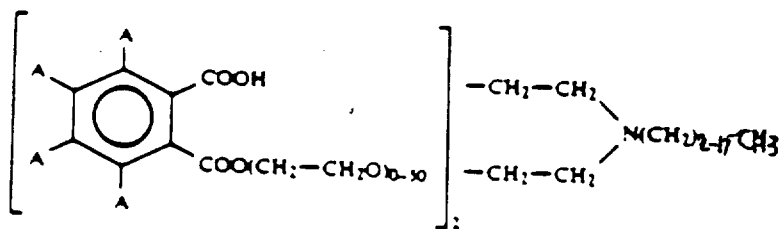
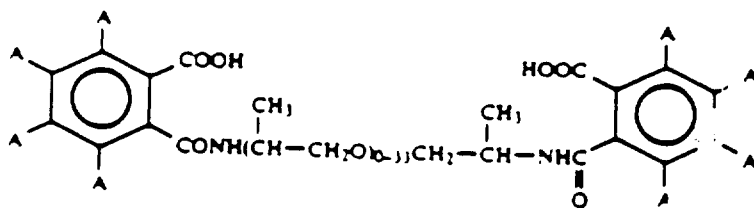
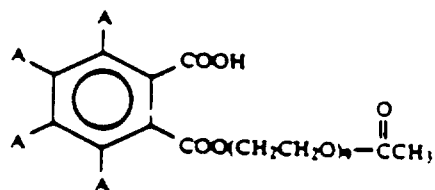
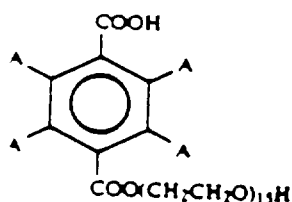
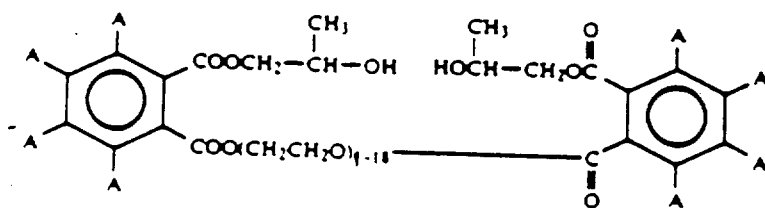
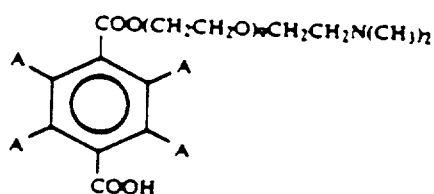
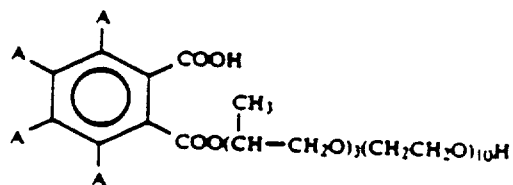
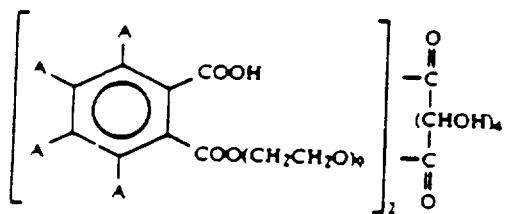
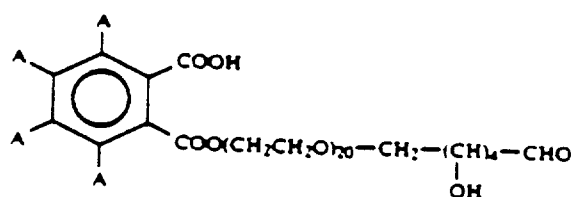
A further advantage of the polyoxyalkylene tetrahalophthalates alone or in combination with other brominated and/or chlorinated compounds as used in this invention is their improved compatibility with SMA resins.

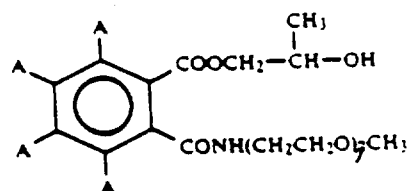
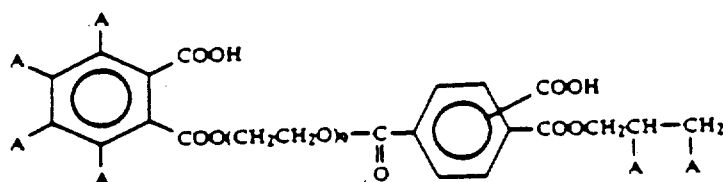
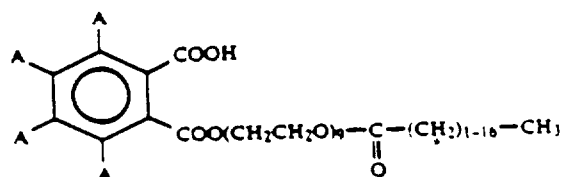
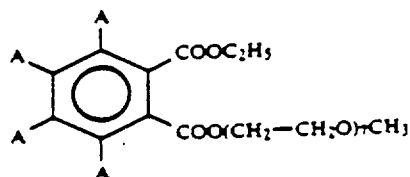
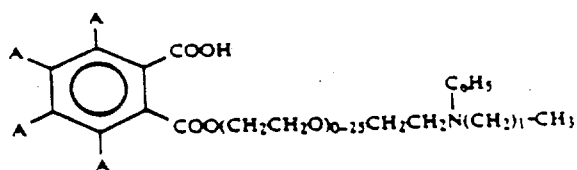
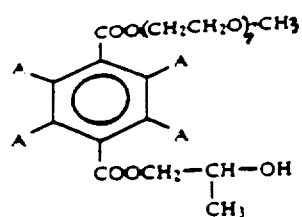
Representative tetrahalophthalate compounds useful in practicing this invention are as follows (where A is Br or Cl):

Chemical structures of various polymeric compounds are shown in following figures A to Z of 211:

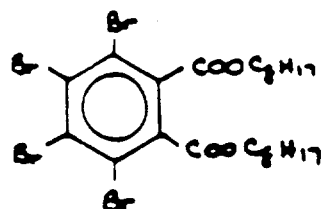
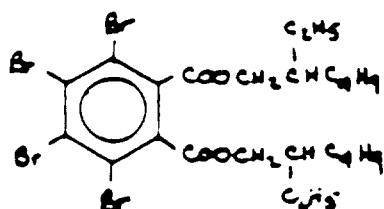
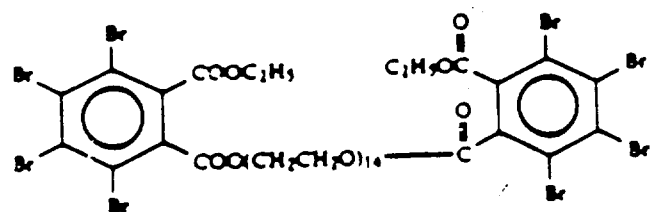
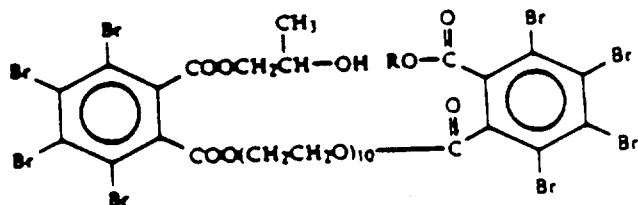
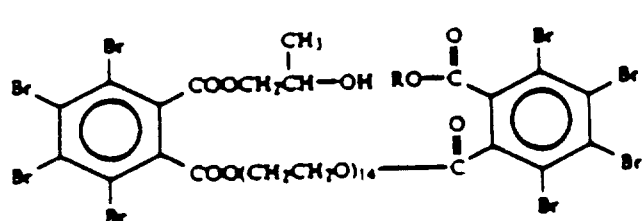
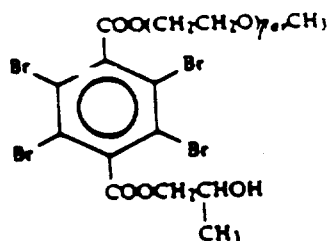
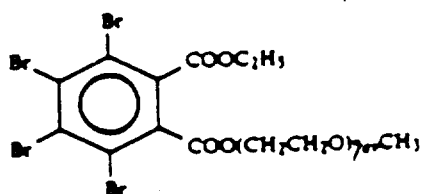
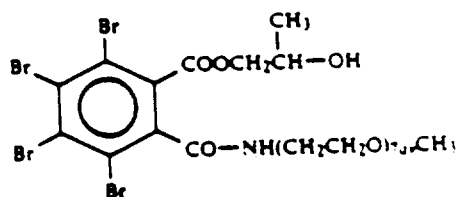
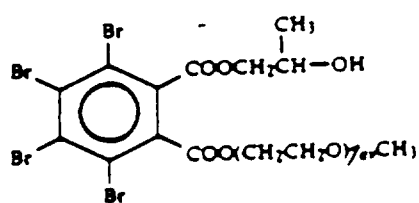


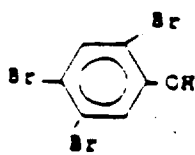
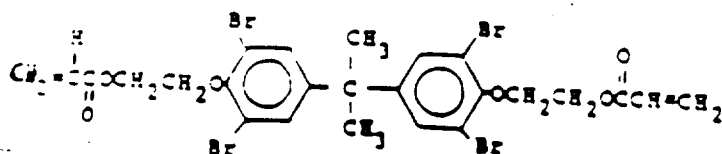
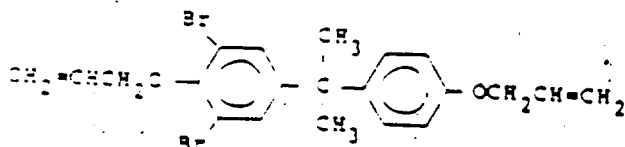
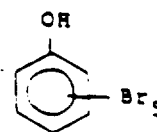
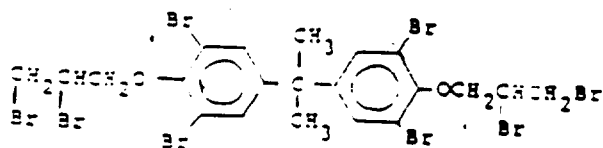
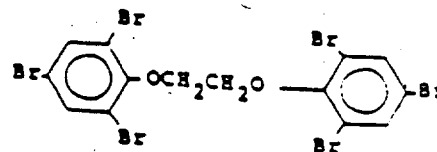
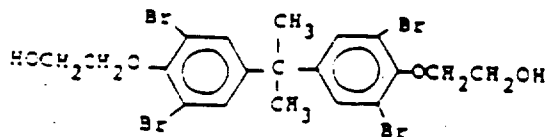
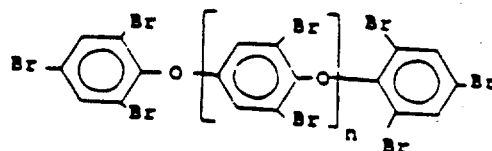
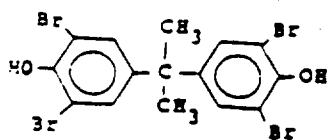




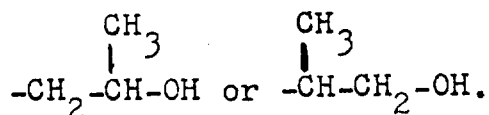


The preferred compounds are:

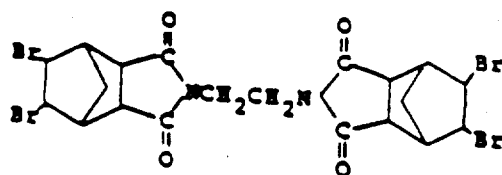
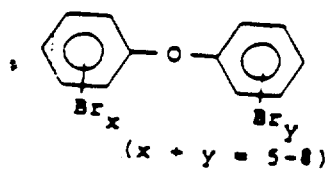
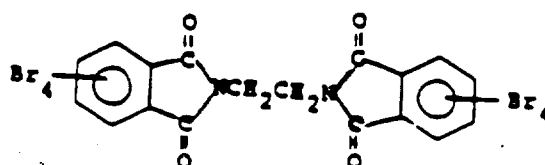
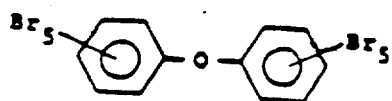


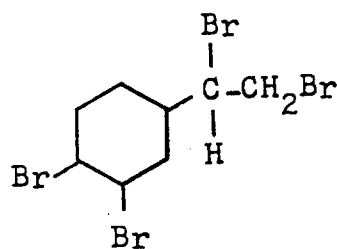
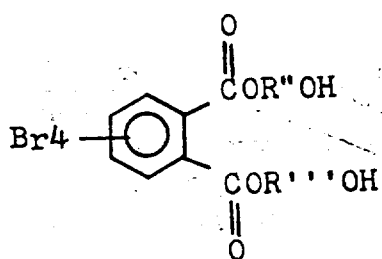
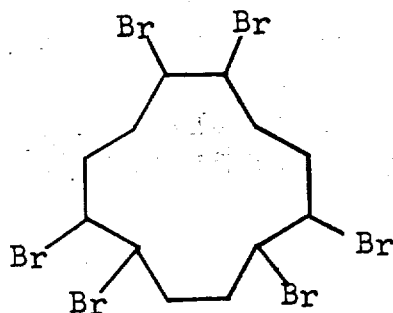
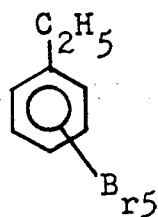
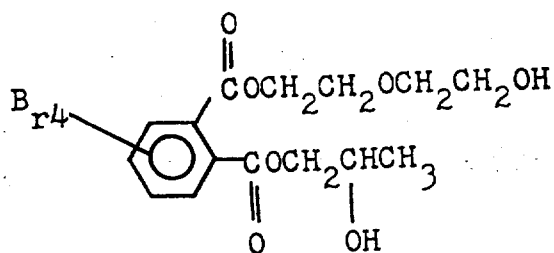


The R in the above formulas is



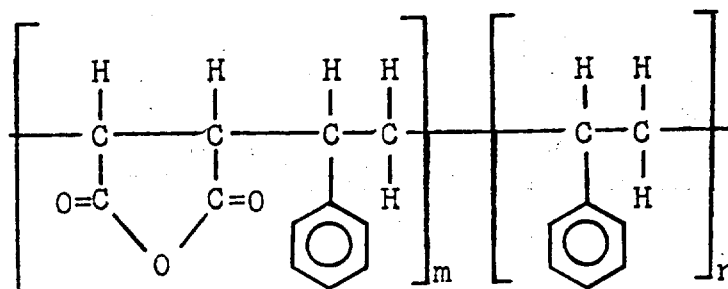
5 The brominated and/or chlorinated compounds
that may be used in combination with the tetrahaloph-
thalates are any of those that are well known in
the art. Preferred halogenated flame retardant
examples are





where R'' and R''' are
alkylene or substituted alkylene

The SMA resins that may be used in the present invention usually have the following structural formula:



5 wherein m=1 to about 100 and n=0 to about 100.
The weight ratio of styrene to maleic anhydride
may vary from about 50:50 to about 95:5.

10 The ratio of tetrahalophthalate or a mixture of tetrahalophthalate and one or more bor-
minated and/or chlorinated compounds to SMA
resins that will impart flame retardancy to the
latter may vary from 1:100 to about 1:2 depending
on the application. In addition, the ratio of
tetrahalophthalate to other brominated and/or
15 chlorinated compounds may vary from 100:0 to
about 1:99.

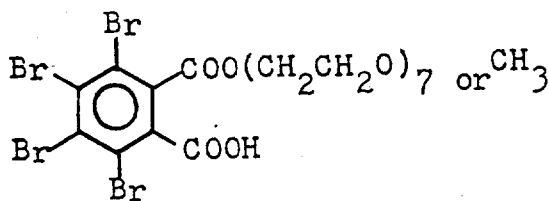
The compositions of this invention may also
include other additives such as thermal stabilizers,

ultraviolet stabilizers, reinforcing agents,
organic polymers, mold release agents, blowing
agents, colorants, etc.

In order to illustrate the present inven-
tion, the following examples are presented. These
are not to be construed as limiting the scope of
the invention.

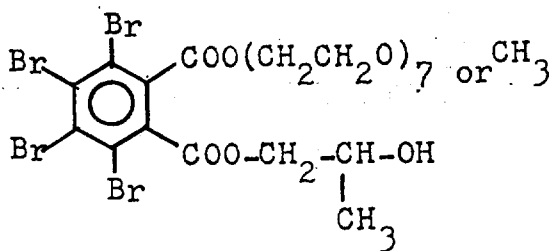
EXAMPLE 1

To 1,392 g (3.0 moles) of tetrabromophthalic
anhydride were added 1,050 g (3.0 moles) of Methoxy
Carbowax 350 in the presence of 22.0 g of sodium
acetate. The mixture was heated at 90°C. for 8
hours in a nitrogen atmosphere. The reaction
mixture was filtered hot to remove the sodium
acetate. The analytical data were consistent
with the assigned structure.



EXAMPLE 2

To the compound of Example 1 were added 348.0 g (6.0 moles) of propylene oxide and 2.0 liters of toluene. The mixture was heated at 60°C.-100°C. The solvent and residual propylene oxide were removed to give the product in almost quantitative yield. The analytical data were consistent with the assigned structure.

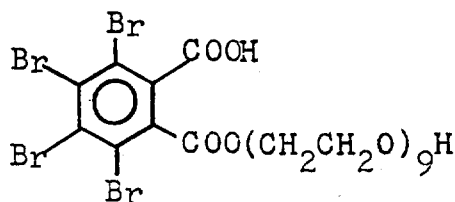


EXAMPLE 3

To 92.8 g (0.2 mole) of tetrabromophthalic anhydride is added all at once 90 g (0.2 mole) of Carbowax 400 and the mixture heated to 120° - 130° C. for 2.5 hours. The desired product is isolated in essentially quantitative yield as a clear yellow viscous liquid. Calcd. Mol. Wt.,

864; found 865. Calcd. % Br, 37.1; found 38.5.

The analytical data are consistent with the assigned structure.



av.

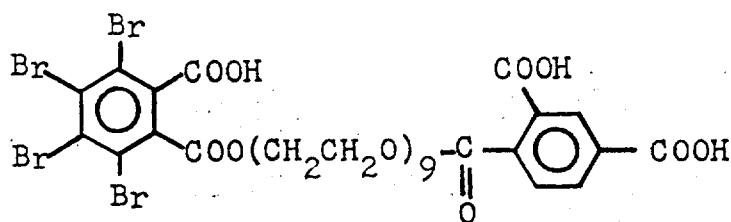
5

EXAMPLE 4

10

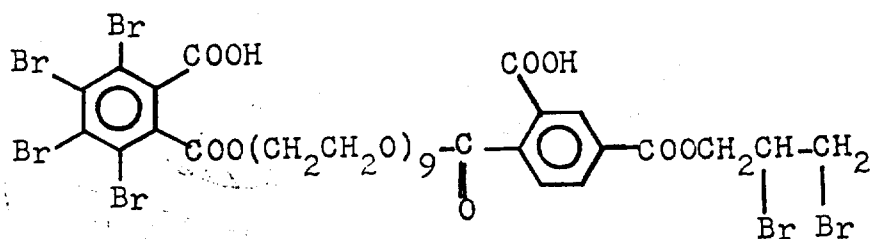
15

To 240 g (0.24 mole) of the compound of Example 3 is added 45.3 g (0.24 mole) of trimellitic anhydride and the mixture was heated at 155° C. under nitrogen for about 7 hours. The infrared spectrum indicated the completion of the reaction by the substantial disappearance of the anhydride absorption band at 5.65u. The product was isolated in essentially quantitative yield. Analy. Calcd.; % Br, 29.4; Mol. Wt., 1,014; neutralization equivalent, 351. The spectral data was consistent with the structure.



EXAMPLE 5

To 156.3 g (0.18 mole) of the compound of Example 3 is added 70.9 g (0.18 mole) 2,3-dibromopropyl trimellitate. The mixture is heated at 130° - 140° C. for 6 hours with stirring to give the product as a brown opaque oil. Isolation afforded the product in essentially quantitative yield and the analysis was consistent with the structure being:

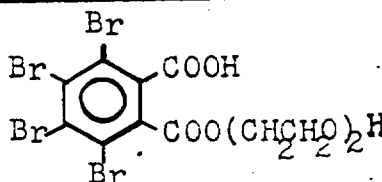
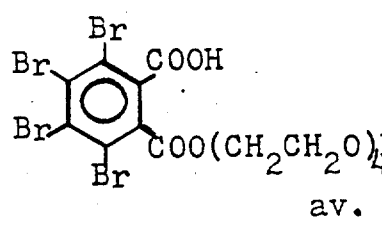
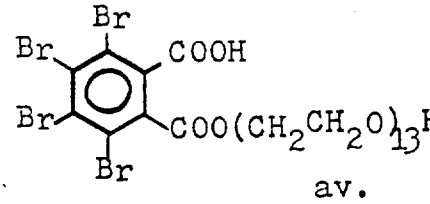
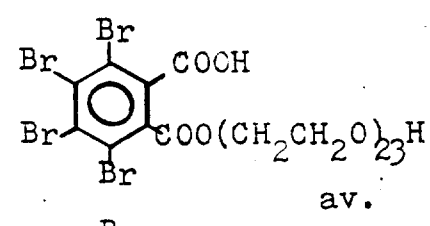
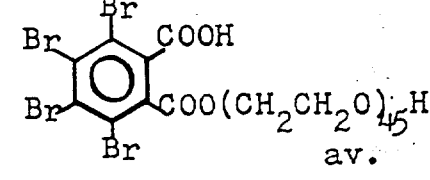
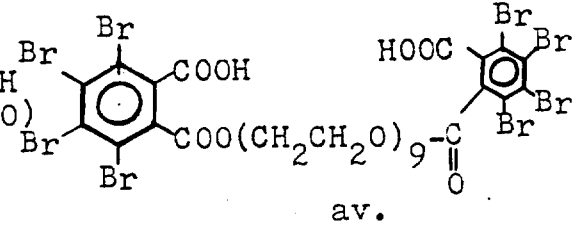


(and isomers)

EXAMPLES 6 to 11

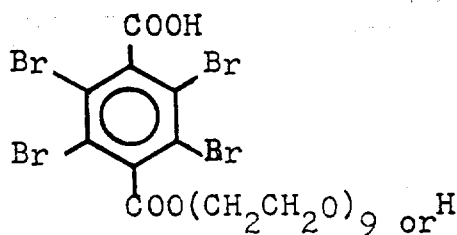
The following preparations were carried out as in Example 3 using the reactants set forth below.

5

Example No.	Tetrabromo phthalic Anhydride	Hydroxy Compound	Product Structure
6	1.0 mole	$\text{HOCH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{OH}$	
7	1.0 mole	$\text{HO}(\text{CH}_2\text{CH}_2\text{O})_4\text{H}$ (Carbowax 200) 1.0 mole	
8	1.0 mole	$\text{HO}(\text{CH}_2\text{CH}_2\text{O})_{13}\text{H}$ (Carbowax 600) 1.0 mole	
9	1.0 mole	$\text{HO}(\text{CH}_2\text{CH}_2\text{O})_{23}\text{H}$ (Carbowax 1600) 1.0 mole	
10	1.0 mole	$\text{HO}(\text{CH}_2\text{CH}_2\text{O})_{45}\text{H}$ (Polyglycol E-2000) 1.0 mole	
11	2.0 mole	$\text{HO}(\text{CH}_2\text{CH}_2\text{O})_9\text{H}$ (Carbowax 400) 1.0 mole	

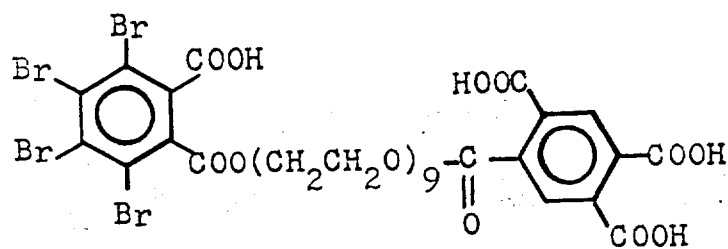
EXAMPLE 12

To 96.4 g (0.2 mole) of tetrabromoter-phthalic acid is added all at once 160 g (0.2 mole) of Carbowax 400 and 300 g of toluene containing 1.0 g P-toluene sulfonic acid. The mixture is heated to reflux until 3.6 g (0.2 mole) water was collected. The toluene is removed under reduced pressure to give a clear viscous liquid in essentially quantitative yield.



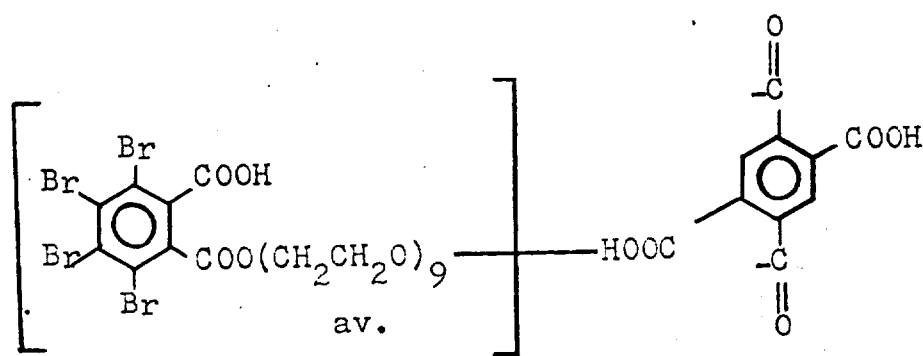
EXAMPLE 13

To 86.4 g (0.1 mole) of the compound of Example 3 is added all at once 21.8 g (0.1 mole) pyromellitic dianhydride and the mixture to 120° - 130° C. for 2.5 hours to give the desired product. Water, 1.8 g (0.1 mole), is added to open the remaining anhydride group and the analytical data are consistent with the assigned structure.



EXAMPLE 14

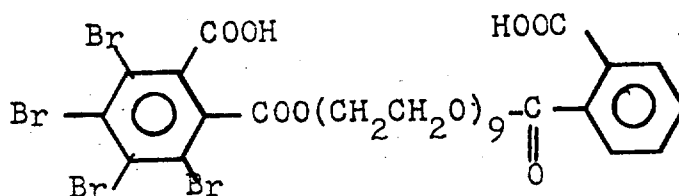
5 To 86.4 g (0.1 mole) of the compound of Example 3 is added all at once 10.9 g (0.05 mole) of pyromellitic dianhydride and the mixture heated to 120° - 130° C. for 2.5 hours to give the desired product. The analytical data are consistent with the assigned structure.



(and isomers)

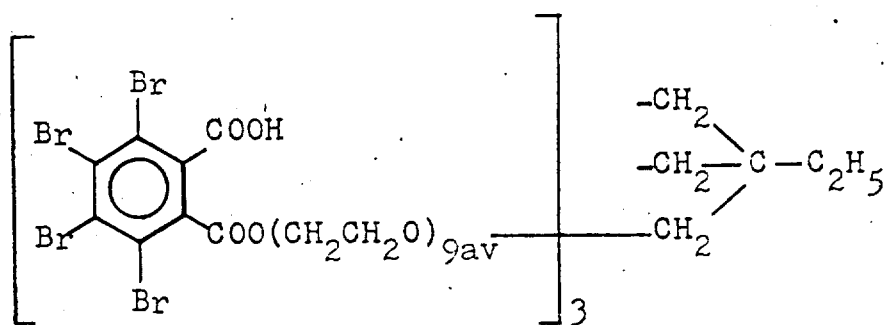
EXAMPLE 15

To 86.4 g (0.1 mole) of the compound of Example 3 is added all at once 21.8 g (0.1 mole) of phthalic anhydride and the mixture heated to 120° - 130° C. for 2.5 hours to give the desired product. The analytical data are consistent with the assigned structure.



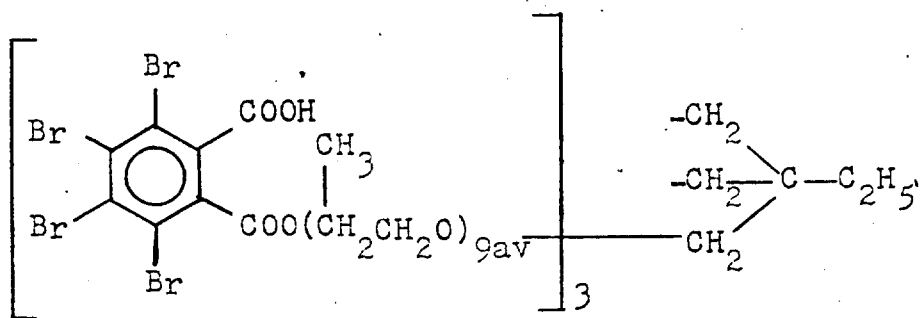
EXAMPLE 16

To 139.2 g (0.3 mole) of tetrabromophthalic anhydride is added all at once 122.9 g (0.1 mole) polyoxyethylated trimethylol propane of molecular weight 1229 and the mixture heated to 120° - 130°C. for 2.5 hours to give the desired product. The analytical data are consistent with the assigned structure.



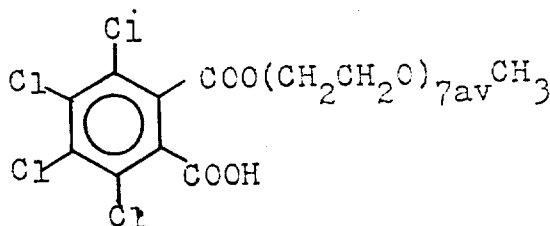
EXAMPLE 17

5 To 139.2 g (0.3 mole) of tetrabromophthalic anhydride is added all at once 156.8 g (0.1 mole) polyoxypropylated trimethylol propane of molecular weight 1568 and the mixture heated to 120° - 130° C. for 2.5 hours to give the desired product. The analytical data are consistent with the assigned structure.



EXAMPLE 18

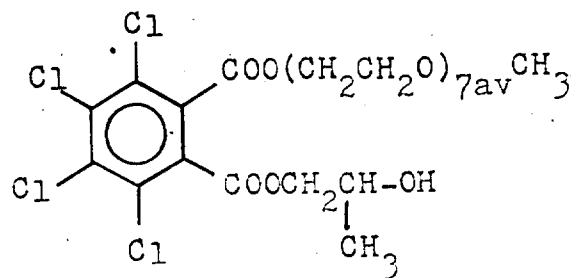
To 284.0 g (1.0 mole) of tetrachlorophthalic anhydride is added 350.0 g (1.0 mole) of Methoxy Carbowax 350 in presence of 7.0 g of sodium acetate. The mixture is heated at 90°C. for 8 hours in a nitrogen atmosphere. The reaction mixture is filtered hot to remove sodium acetate to give the expected product in nearly quantitative yield. The analytical data are consistent with the assigned structure.



EXAMPLE 19

To 634.0 g (1.0 mole) of the composition of Example 13 is added 116 g (2.0 moles) of propylene oxide in 200 ml of toluene. The reaction mixture is heated from 60°-100°C. for

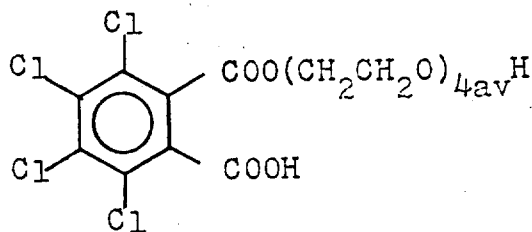
3-5 hours, and then concentrated to give the product in nearly quantitative yield. The analytical data are consistent with the assigned structure.



EXAMPLE 20

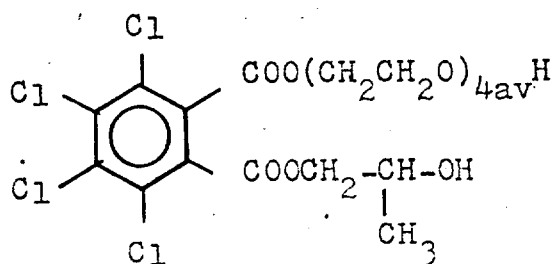
To 284.0 g (1.0 mole) of tetrachlorophthalic anhydride is added 200.9 g (1.0 mole) of Carbowax 200 in the presence of 7.0 g of sodium acetate. The mixture is heated at 90°C. for 8 hours in a nitrogen atmosphere. The reaction mixture is filtered hot to remove sodium acetate to generate the expected product in nearly quantitative yield. The analytical data are consistent with the assigned structure.

10



EXAMPLE 21

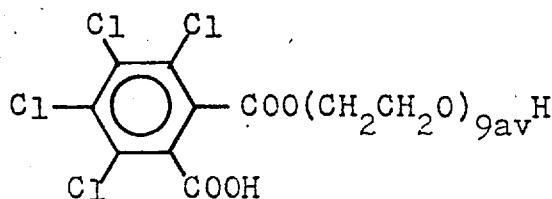
To 484.0 g (1.0 mole) of the product of Example 20 is added 116.0 g (2.0 moles) of propylene oxide in 200 ml of toluene. The reaction mixture is warmed at 60°-100°C. for 3-5 hours, and then concentrated to give the product in nearly quantitative yield. The analytical data are consistent with the assigned structure.



EXAMPLE 22

To 284.0 g (1.0 mole) of tetrachlorophthalic anhydride is added 400.0 g (1.0 mole) of Carbowax 400 in the presence of 7.0 g of sodium acetate. The mixture is heated at 90°C. for 8 hours in a nitrogen atmosphere. The reaction mixture is filtered hot to remove sodium acetate to generate

the expected product in nearly quantitative yield. The analytical data are consistent with the assigned structure.

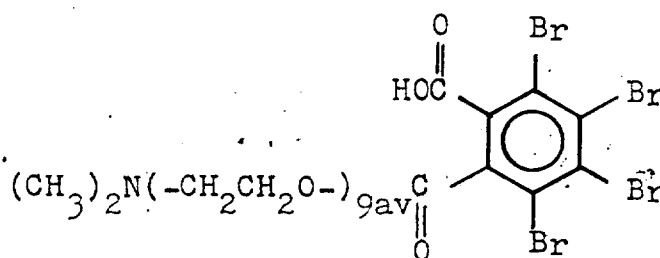


5

EXAMPLE 23

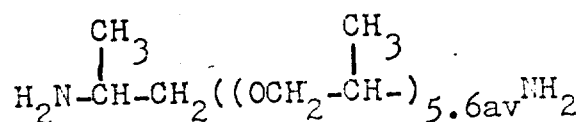
To 46.4 g (0.1 mole) of tetrabromophthalic anhydride is added all at once 44.1 g (0.1 mole) of polyoxyethylated dimethylamine $(\text{CH}_3)_2\text{N}(\text{CH}_2\text{CH}_2\text{O})_{9-\text{av H}}$ dissolved in 100 ml of toluene. The mixture was heated at $100^\circ\text{--}110^\circ\text{C}$. for 4-5 hours and then concentrated to give the desired product in essentially quantitative yield. The analytical data are consistent with the assigned structure,

10

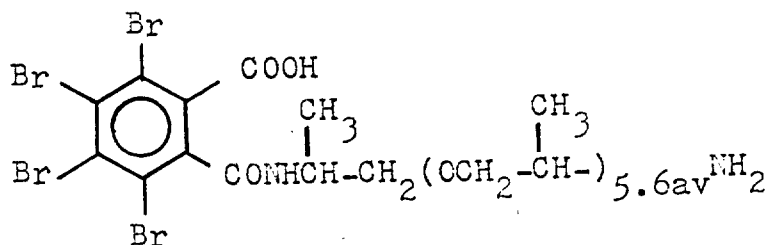


EXAMPLE 24

To 92.8 g (0.2 mole) of tetrabromophthalic anhydride is added 80.0 g (0.2 mole) of



5 (Jeffamine D-400) and the mixture heated to about 120°C. The final product is obtained in almost quantitative yield. The analytical data are consistent with the assigned structure.

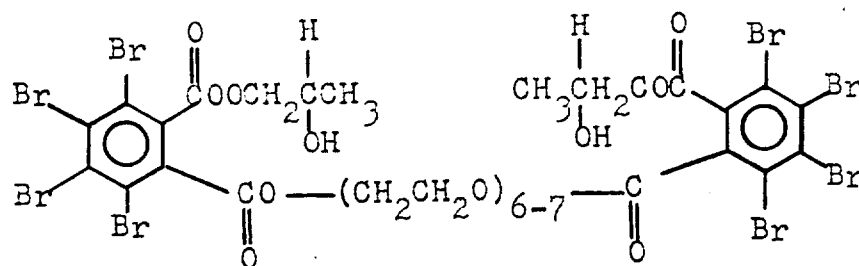


EXAMPLE 25

Poly(ethylene glycol 300), 204.5 g (0.67 mole) was refluxed (T=117°C.) with 600 ml of

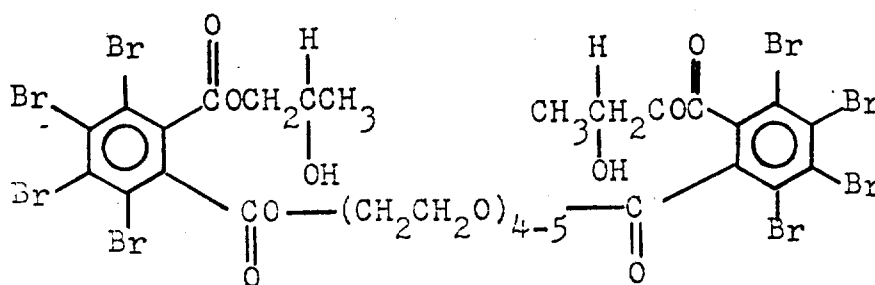
5 toluene for 1.5 hours in order to remove a small
 amount of water present in the glycol. The mix-
 ture was cooled to about 100°C. and tetrabromoph-
 thalic anhydride, 614.5 g (1.35 moles) and sodium
 acetate, 1.62 g were added and the mixture was
 reheated to reflux and held for 25 hours. After
 the mixture was cooled to 50°C., propylene oxide,
 (156.4 g, 2.69 moles, 100% excess) was added and
 the mixture heated to and held at 100°C. for 2.5
 10 hours. When the solution cooled to about 50°C.
 it was filtered through a bed of diatomaceous earth
 and decolorizing charcoal. The filtrate was dis-
 tilled to remove the solvent to give 904.1 g of
 product as a viscous liquid.

15 Calcd. % Br, 47.4. Found % Br, 46.5. Analy-
 tical data is consistent with the assigned structure.



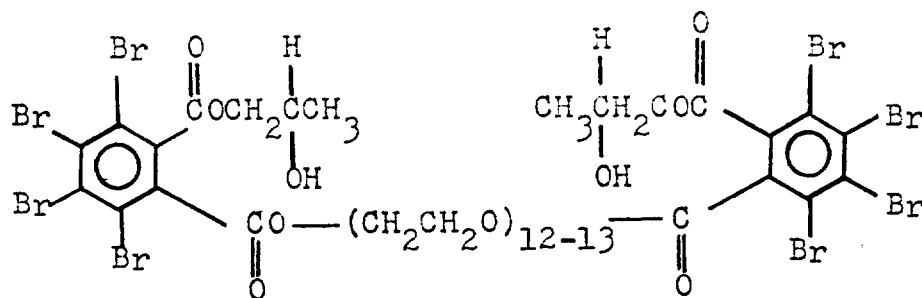
5

Calcd. % Br, 51.0. Found % Br, 49.3. Analytical data was consistent with the assigned structure.



10

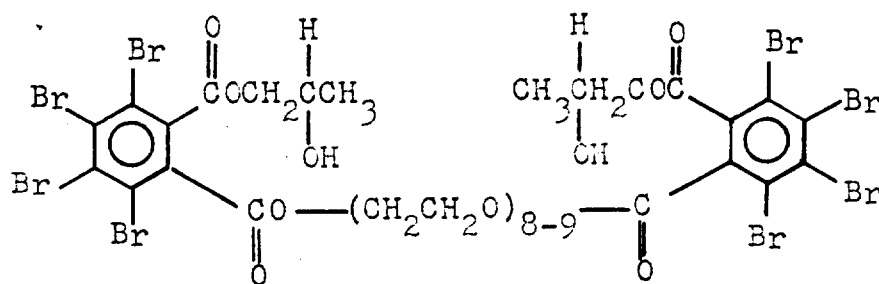
Calcd. % Br, 39.5. Found % Br, 39.3. Analytical data is consistent with the assigned structure.



EXAMPLE 28

5 This compound was prepared by the procedure described in Example 25 except that poly(ethylene glycol 400) was used in place of poly(ethylene glycol 300). Product is a viscous liquid.

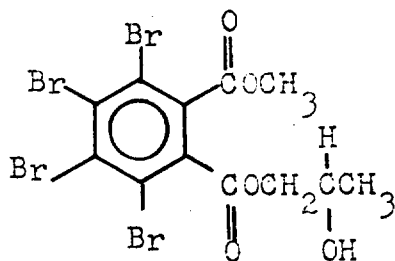
Calcd. % Br, 44.2. Found % Br, 44.0. Analytical data is consistent with the assigned structure.



EXAMPLE 29

5 Methanol (54.1 g, 1.5 mole), tetrabromo-
phthalic anhydride (695.6 g, 1.6 moles), and
potassium acetate, 2.73 g were refluxed for 4
hours with 500 ml of toluene. After cooling
the reaction mixture to room temperature, pro-
pylene oxide (87.12 g, 1.3 moles) were added
and the mixture reacted at 80°C. for 2.5 hours.
Product was obtained as a viscous liquid after
10 distilling out the toluene.

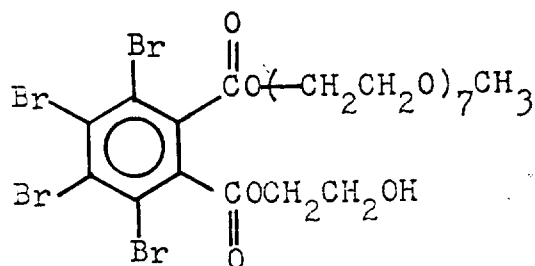
Calcd. % Br, 57.7. Found % Br, 57.2. Analy-
tical data is consistent with assigned structure.



EXAMPLE 30

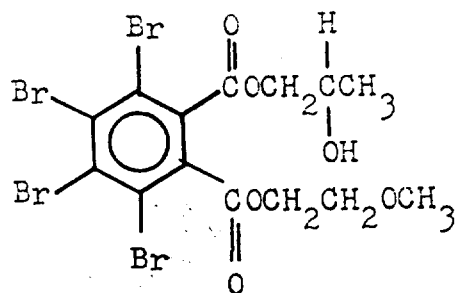
This compound was prepared by the procedure
similar to that described in Example 29 except
that methoxycarbonyl 350 was used in place of

Calcd. % Br, 37.8. Found % Br, 37.2. Analytical data is consistent with assigned structure.



5

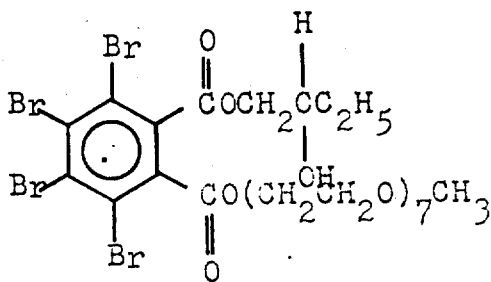
Calcd. % Br, 53.6. Found % Br, 52.0. Analytical data is consistent with the assigned structure.



EXAMPLE 32

This compound was prepared by the procedure outline in Example 29 except that methoxycarbowax 350 was used in place of methanol and epoxybutane in place of propylene oxide. Product is a viscous liquid.

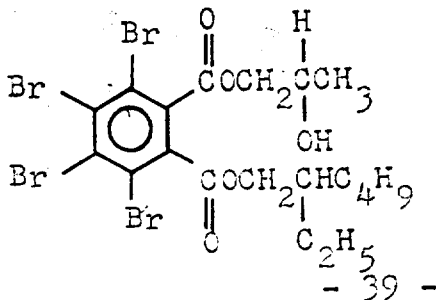
Calcd. % Br, 36.5. Found % Br, 37.2. Analytical data is consistent with the assigned structure.



EXAMPLE 33

This compound was prepared by the procedure outlined in Example 29 except that 2-ethylhexanol-1 was used in place of methanol. Product is a viscous liquid.

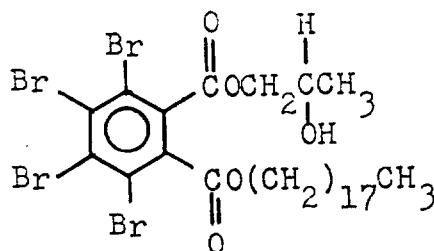
Calcd. % Br, 50.0. Found 52.7. Analytical data is consistent with the assigned structure.



EXAMPLE 34

This compound was prepared by the procedure described in Example 29 except that stearyl alcohol was used in place of methanol. Product is a viscous liquid.

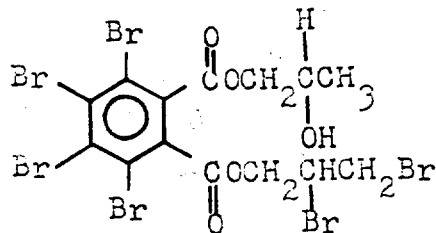
Calcd. % Br, 41.0. Found % Br, 43.0. Analytical data is consistent with the assigned structure.



EXAMPLE 35

This compound was prepared by the procedure described in Example 29 except that 2,3-dibromopropanol-1 was used in place of methanol. Product is a viscous liquid.

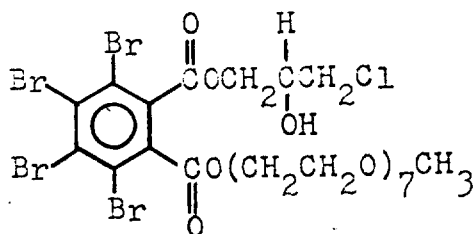
Calcd. % Br, 64.8. Found % Br, 61.9. Analytical data is consistent with the assigned structure.



EXAMPLE 36

This compound was prepared by the procedure outlined in Example 29 except that epichlorohydrin was used in place of propylene oxide.

Calcd. % Br, 35.7. Found % 35.4. Analytical data is consistent with the assigned structure.



EXAMPLE 37

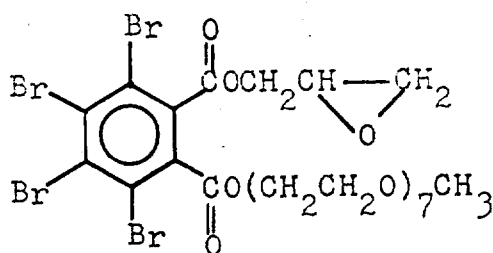
To a solution of methoxycarbonywax 350 (300.0 g, 0.89 mole) in dry toluene (184 ml) was added sodium methoxide (48.0 g, 0.90 mole) in methanol. The methanol was then distilled off atmospherically. Tetrabromophthalic anhydride was then added (442.2 g, 0.89 mole) along with an additional 50 ml of toluene. The reaction mixture was refluxed for 2 hours and after cooling to room temperature, epichlorohydrin (106.94

g, 1.16 moles) was added. The mixture was refluxed for 20 hours. After the solvent and excess epichlorohydrin were distilled, a viscous dark product was obtained.

5

Calcd. % Br, 37.2. Found % Br, 40.4.

Analytical data is consistent with assigned structure.



EXAMPLE 38

10

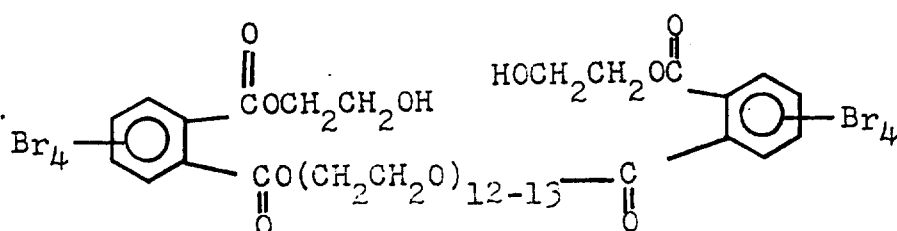
Methoxycarbonyl wax 350 and toluene were refluxed for 1 hour in order to distill out a small amount of water. Tetrabromophthalic anhydride (1:1 mole ratio with methoxycarbonyl wax 350) and sodium acetate were added and the mixture ~~refl~~uxed for 17 hours. After cooling to room temperature, an excess of diazomethane (prepared from the decomposition of N-methyl-N-nitroso-p-toluene sulfonamide by sodium hydroxide)

15

EXAMPLE 40

Poly(ethylene glycol 600) 885.4 g (1.40 moles), tetrabromophthalic anhydride, 1298.4 g (2.80 moles), potassium acetate, 1.35 g, and toluene (1000 g) were charged into a one-gallon glass-lined reactor and heated to 120° C. After 4 hours at this temperature, ethylene oxide, 246.68 g (5.60 moles) was pumped into the reactor in 3/4 hour while maintaining the temperature at 120°C. After one hour longer of heating, the mixture was cooled to room temperature, the excess ethylene oxide was then vented, and the product collected. After stripping off the toluene, 2250 g of the product was isolated in 99% yield as a viscous liquid.

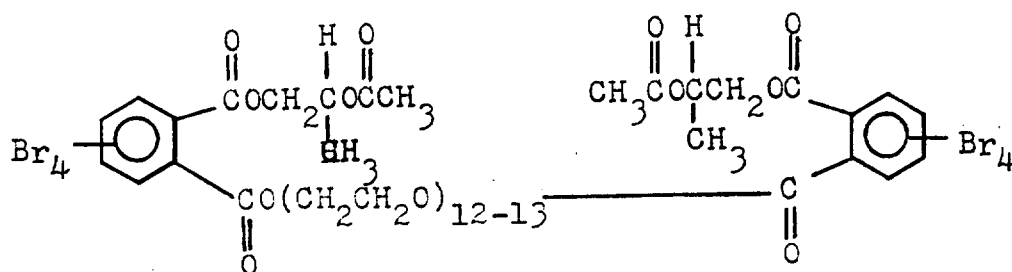
Calcd. % Br, 39.2. Found % Br, 38.8. Analytical data is consistent with the assigned structure.



EXAMPLE 41

To the product of Example 3, 453.8 g (0.27 mole), acetic anhydride, 83.4 g (0.82 mole), potassium acetate, 1.0 g, and toluene, 400 ml, were refluxed for 8 hours. After cooling to room temperature, the reaction mixture was transferred to a separatory funnel and extracted first with 100 ml of a 16% potassium bicarbonate solution and then with 100 ml of water. After distilling off the solvent, 335.0 g (64% yield) of product was obtained as a viscous liquid.

Calcd. % Br, 36.8. Found % Br, 32.9. Analytical data is consistent with the assigned structure.



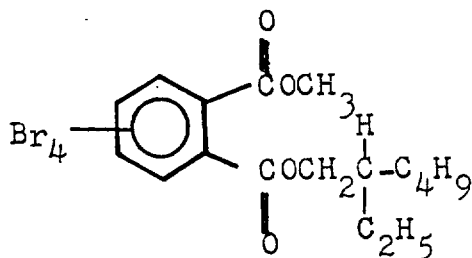
EXAMPLE 42

Tetrabromophthalic anhydride, 231.9 g (0.50 mole), 2-ethylhexanol, 130.2 g (1.0 mole),

and potassium acetate, 0.24 g were heated to and kept at 120°C. for 4 hours. The mixture was cooled to 60°C. and potassium carbonate, 35.9 g (0.26 mole), was added. Reheated mixture to 80°C. and kept it at this temperature for 2 hours. Cooled mixture to 60°C. and added triethylamine, 14.2 g (0.14 mole). Reheated mixture to 70°C. and added methyl iodide, 113.6 g (0.8 mole) in 20 minutes. Heated mixture to 70°-75°C. and kept it at this temperature for 2 1/2 hours. Cooled mixture to room temperature and filtered it in order to remove by-product potassium iodide. The filtrate was distilled to remove toluene and 290 g of crude product was collected as a pale yellow liquid. Extracted this product with 3 times 100 ml of a 6.5% potassium carbonate solution followed by 2 times 100 ml of water and once with a 30% sodium chloride solution. Dried the organic phase over anhydrous magnesium sulfate overnight. Filtered off magnesium sulfate and after removing the solvent from filtrate by distillation, 204 g of

product was obtained in 67% yield as a pale yellow liquid.

Calcd. % Br, 52.6. Found % Br, 52.2. Analytical data is consistent with the assigned structure.



EXAMPLE 43

Tetrabromophthalic anhydride, 231.9 g (0.5 mole), 2-(2-methoxyethoxy)-ethanol, 360.5 g (3.0 moles), stannous oxalate; 2.32 g, and xylene, 200 ml, were refluxed (temp. 160°C.) for 18 hours during which time, theory water was collected. The xylene and excess 2-(2-methoxyethoxy)-ethanol were distilled under reduced pressure to give 332 g of crude product as a wet white solid. Redissolved 256 g of this material in toluene (1000 ml) and extracted it with 3 times

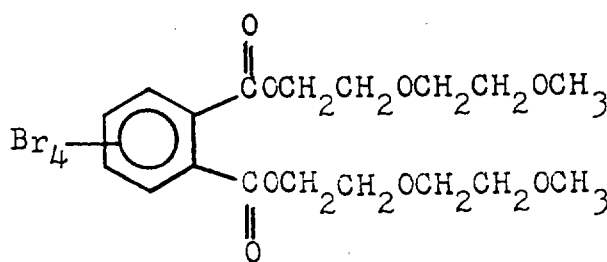
10

15

200 ml of a 7.5% potassium bicarbonate solution followed by one extraction with 200 ml of water. Dried the organic phase with anhydrous magnesium sulfate overnight. After removing the magnesium sulfate by filtration, toluene was removed by distillation to give 45 g of a yellow liquid product. Overall yield is 17%.

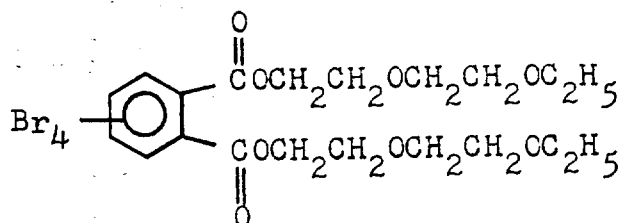
Calcd. % Br, 46.6. Found % Br, 45.7.

Analytical data is consistent with the assigned structure.



EXAMPLE 44

This compound was prepared by the procedure outlined in Example 43 except that 2-(2-methoxyethoxy)ethanol.

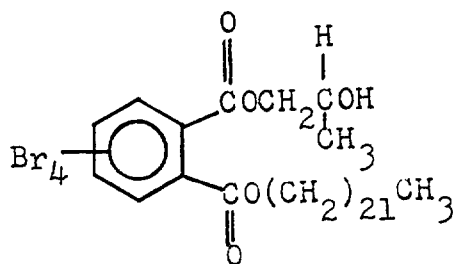


EXAMPLE 45

This compound was prepared by the procedure outlined in Example 1 except that docosyl alcohol (behenyl alcohol) was used in place of poly(ethylene glycol 600) and propylene oxide in place of ethylene oxide. Product is a viscous liquid.

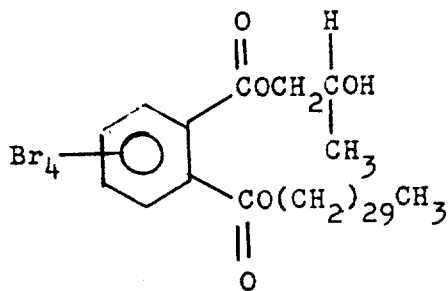
Calcd. % Br, 37.7. Found % Br, 36.5.

Analytical data is consistent with the assigned structure.



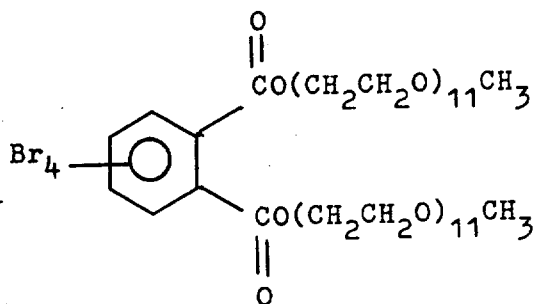
EXAMPLE 46

This compound was prepared by the procedure outlined in Example 1 except that tricontyl alcohol was used in place poly(ethylene glycol 600) and propylene oxide in place of ethylene oxide. Product is a viscous liquid.



EXAMPLE 47

This compound was prepared by the procedure outlined in Example 4 except that methoxycarbowax 550 was used in place of 2-(2-methoxyethoxy)-ethanol.



EXAMPLES 48-52

In the following examples, the flame retardancy of the compounds of this invention are demonstrated. The compositions were prepared by mixing together the the flame retardants, antimony oxide, and SMA on a roller until the compounds were blended thoroughly. The compounds were pelletized at 95°-245°C. and then injection molded into test specimens at 190°-204°C. The

UL-94 vertical burn test was run and compared to a control consisting of SMA itself. Melt flow of the various materials were determined according to ASTM D-1238.

- 5 SMA- Styrene-Maleic Anhydride Polymer
 DBDPO- Decabromodiphenyl Oxide (83% Bromine)
 DOTBP- Dioctyl Tetrabromophthalate (45% Bromine)
 AO- Antimony Oxide

10

TABLE I					
	Example No.				
	48	49	50	51	52
SMA ^(a)	100.0	82.7	81.5	80.4	76.8
DBDPO	-	13.8	12.4	11.0	6.9
DOTBP	-	-	2.6	5.1	12.8
Antimony Oxide	-	3.5	3.5	3.5	3.5
<u>UL .94 Rating</u>					
@ 0.0125"	Failed	V-0	V-0	V-0	V-0
@ 0.63"	Failed	V-0	V-0	V-0	V-0
Melt Flow	1.16	1.84	2.08	3.32	6.76
(g/10 min.)					
(@)Arco Chemicals Dylark R 250					

15

- 20 The above clearly demonstrates the flame retardancy of the composition of this invention relative to the control.

These composition have at least equal flame retardancy to a common commercial conventional flame retardant, DBDPO.

Example 49-52 are all run at equal bromine levels.

- 5 Partial replacement of DBDPO with the compositions of this invention results in enhanced flow characteristics as shown by the improved melt flow properties measured according to ASTM D-1238.

EXAMPLES 53-56

- 10 The following tests were performed on the various materials according to the appropriate ASTM method.

1. Impact Strength-ASTM D-256
2. Tensile Strength-ASTM D-638
3. Heat Deflection Temperature (HDT)-ASTM
15 D-648
4. Melt Flow-ASTM D-1238

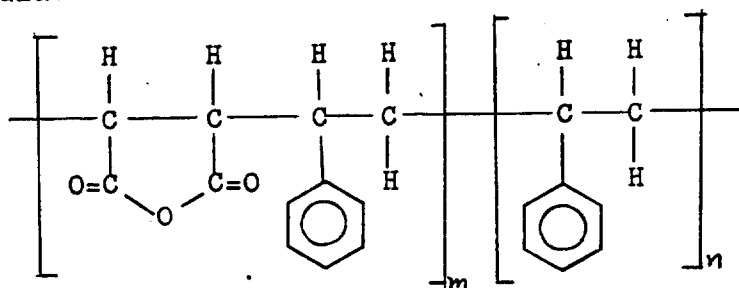
TABLE II

		Example No.			
		53	54	55	56
	SMA ^(a)	100.0	82.7	81.5	80.4
	DBDPO	-	13.8	12.4	11.0
5	DOTBP	-	-	2.6	5.1
	Antimony Oxide	-	3.5	3.5	3.5
	LOI	18.7	27.6	28.6	23.1
<u>UL/94 Rating</u>					
	@0.0125"	Failed	V.0	V.0	V.0
10	@ 0.063"	Failed	V.0	V.0	V.0
	Notched Izod	2.3	1.02	1.56	1.96
	(lbs./inch)				
	Tensile Strength (Yield)	3950	3880	3830	3700
	(PSI)				
15	% Elongation	8.7	7.4	7.7	8.1
	HDT (°F.)	197	197	191	192
	Melt Flow	1.16	1.84	2.08	3.32
	(g/10min)				
^(a) Arco Chemicals Dylark @ 230					

As can be seen from the data above, compositions containing the flame retardants of this invention greatly improve the impact strenght relative to the commercial flame retardant, DBDPO, while maintaining both tensile
5 strenght and percent elongation properties. Also the heat distortion temperature (HDT) of the compositions of this invention are comparable to both the control and to DBDPO.

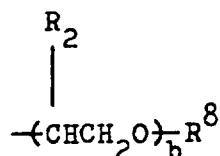
The data above clearly demonstrates the improved
10 processability of the compositions containing the materials of this invention.

1. A uniform flame retardant composition comprising
(i) a resin consisting essentially of styrene-
maleic anhydride having the following general
formula:


$$\left[\begin{array}{c} \text{A} \\ | \\ \text{A} - \text{C}_6\text{H}_2 - \text{A} \\ | \\ \text{A} \end{array} \begin{array}{l} \text{O} \\ || \\ \text{COR} \end{array} \begin{array}{l} \text{CX}(\text{CHCH}_2\text{O})_p \\ || \\ \text{O} \end{array} \begin{array}{l} | \\ \text{R}^2 \end{array} \begin{array}{l} - \\ | \\ \text{R}^1 \end{array} \right]_q$$

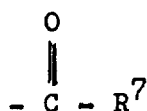
wherein

- (a) R is selected from the group consisting of hydrogen, an alkyl or substituted alkyl of 1 to 9 carbons, hydroxyalkyl of 2 to 20 carbons, polyhydroxyalkyl of 3 to 10 carbons, and



where R^8 is an alkyl or substituted alkyl of 1 to 18 carbons, and b is 1 to 50;

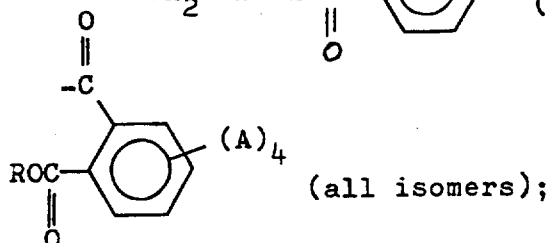
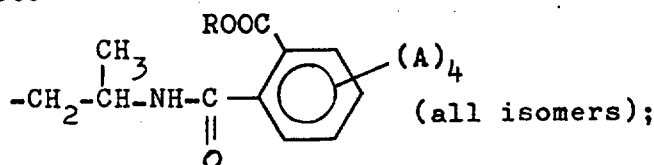
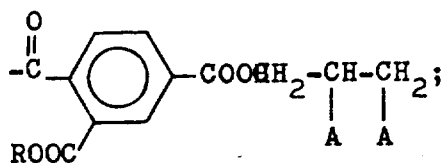
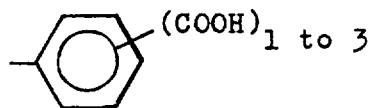
- (b) R^1 is selected from the group consisting of hydrogen, an alkyl or substituted alkyl of 1 to 9 carbons, alkenyl or substituted alkenyl of 2 to 22 carbons,



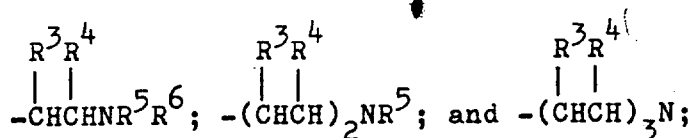
where R^7 is an alkyl of 1 to 18 carbons; a polyhydroxyalkyl of 3 to 12 carbons;



1 or 2



5



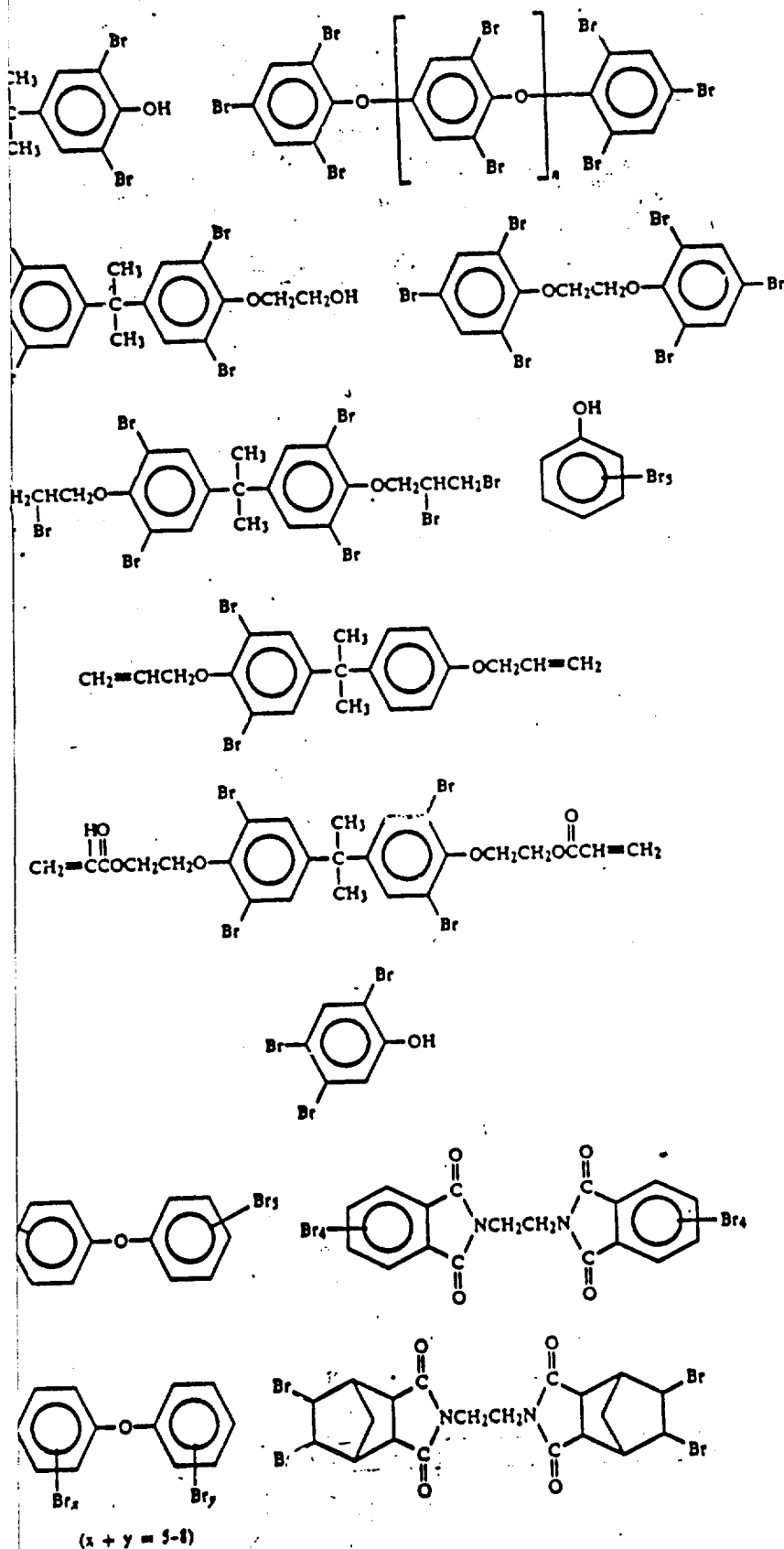
with the proviso that the valence of R^1 is equal to q ;

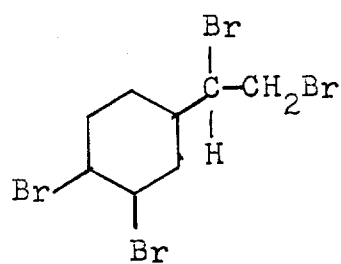
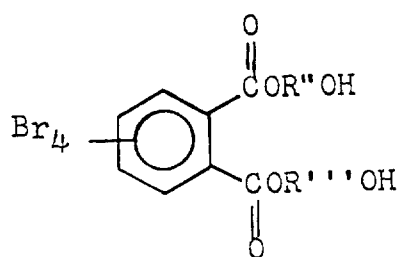
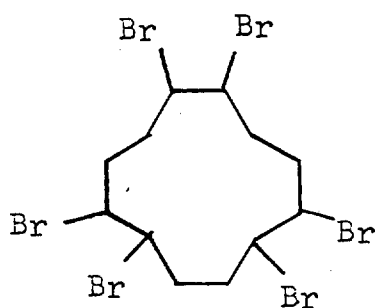
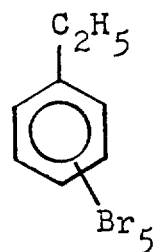
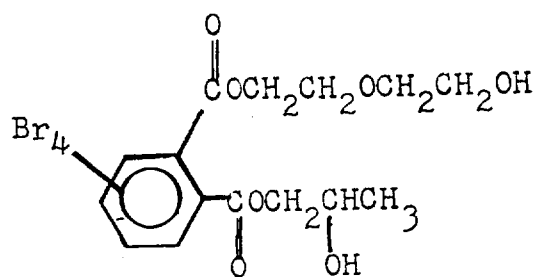
(c) R^2 is independently selected from the group consisting of H and CH_3 ;

10 (d) R^3 , R^4 , R^5 , and R^6 are independently selected from the group consisting of H and an alkyl of 1 to 18 carbons;

(e) p is an integer of 0 to 50;

- (f) q is an integer of 1 to ;
- (g) X is selected from the group consisting of O or NH;
- (h) A is selected from the group consisting of Clor
Br; and
- 5 (i) provided further that when p is zero and X is
oxygen that R and R¹ are other than a neopentyl
group.
2. The composition of claim 1 wherein p is zero, and q is
one and X is oxygen.
- 10 3. The composition of claim 2 wherein R and R¹ are alkyl
groups and A is Br.
4. The composition of claim 3, di-2-ethylhexyl tetra-
bromophthalate.
5. The composition of claim 1 wherein the weight ratio
15 of (i) to (ii) is within the range of about 100:1 to
about 2:1.
6. The composition of claim 1 wherein said tetrahalophthalate
ester of (ii) R is an alkyl or substituted alkyl of 1 to 9
carbons, A is Br, X is oxygen, p is 0 to 20, and q is 1 to 6.
- 20 7. The composition of claim 6 wherein R is selected from the
group consisting of





where R'' and R''' are
alkylene or substituted alkylene

5 10. A method for preparing a flame retardant composition having enhanced processability properties which comprises incorporating a flame retarding effective amount of the tetrahalophthalate ester of claim 1 (ii) in a resin consisting essentially of styrene-maleic anhydride.

10 11. The method of claim 10 wherein the weight ratio of styrene-maleic anhydride resin to the tetrahalophthalate ester is within the range of 100:1 to about 2:1.

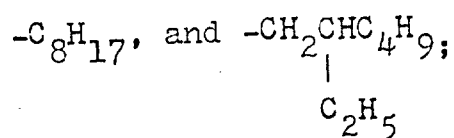
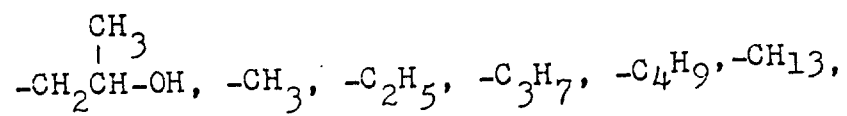
15 12. The method of claim 10 wherein in said tetrahalophthalate ester of claim 1(ii) R is an alkyl or substituted alkyl of 1 to 9 carbons, A is Br, X is oxygen, p is 0 to 20, and q is 1 to 6.

13. The method of claim 10 wherein in said tetrahalophthalate ester of claim 1(ii) p is zero, and q is one and X is oxygen.

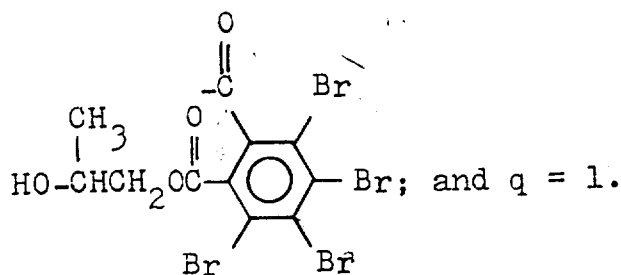
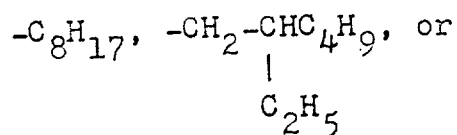
20 14. The method of claim 10 wherein in said tetrahalophthalate ester of claim 1 (ii) R and R¹ are alkyl groups and A is Br.

15. The method of claim 10 wherein said ester is di-2-ethylhexyltetrabromophthalate.

16. The method of claim 12 wherein R is selected from the group consisting of



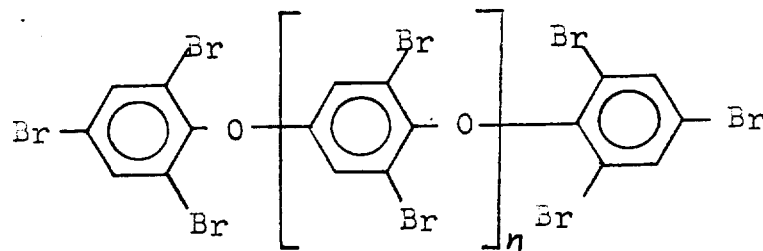
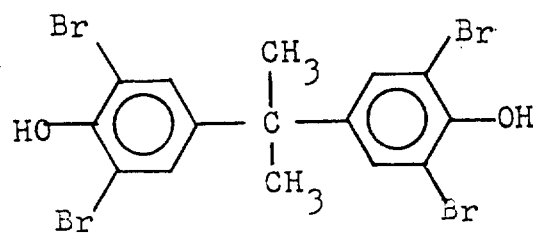
R_1 is CH_3 , C_2H_5 , C_4H_9 , H , $-\text{C}_3\text{H}_7$, $-\text{C}_6\text{H}_{13}$,

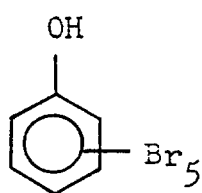
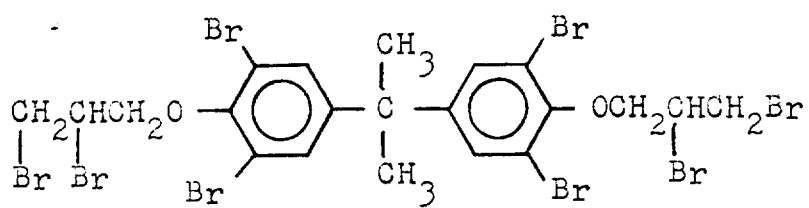
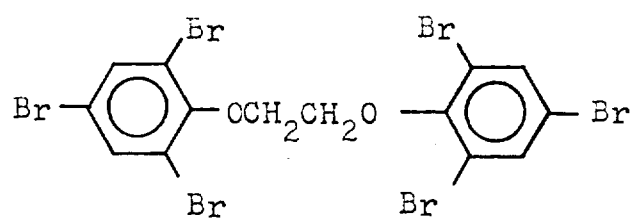
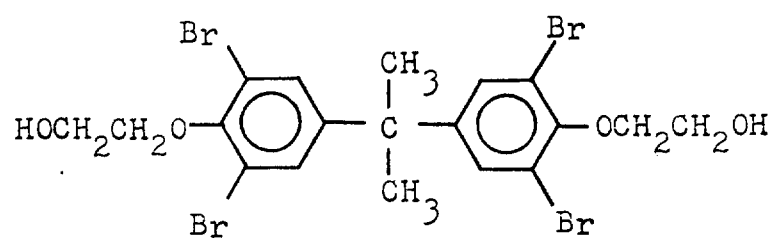


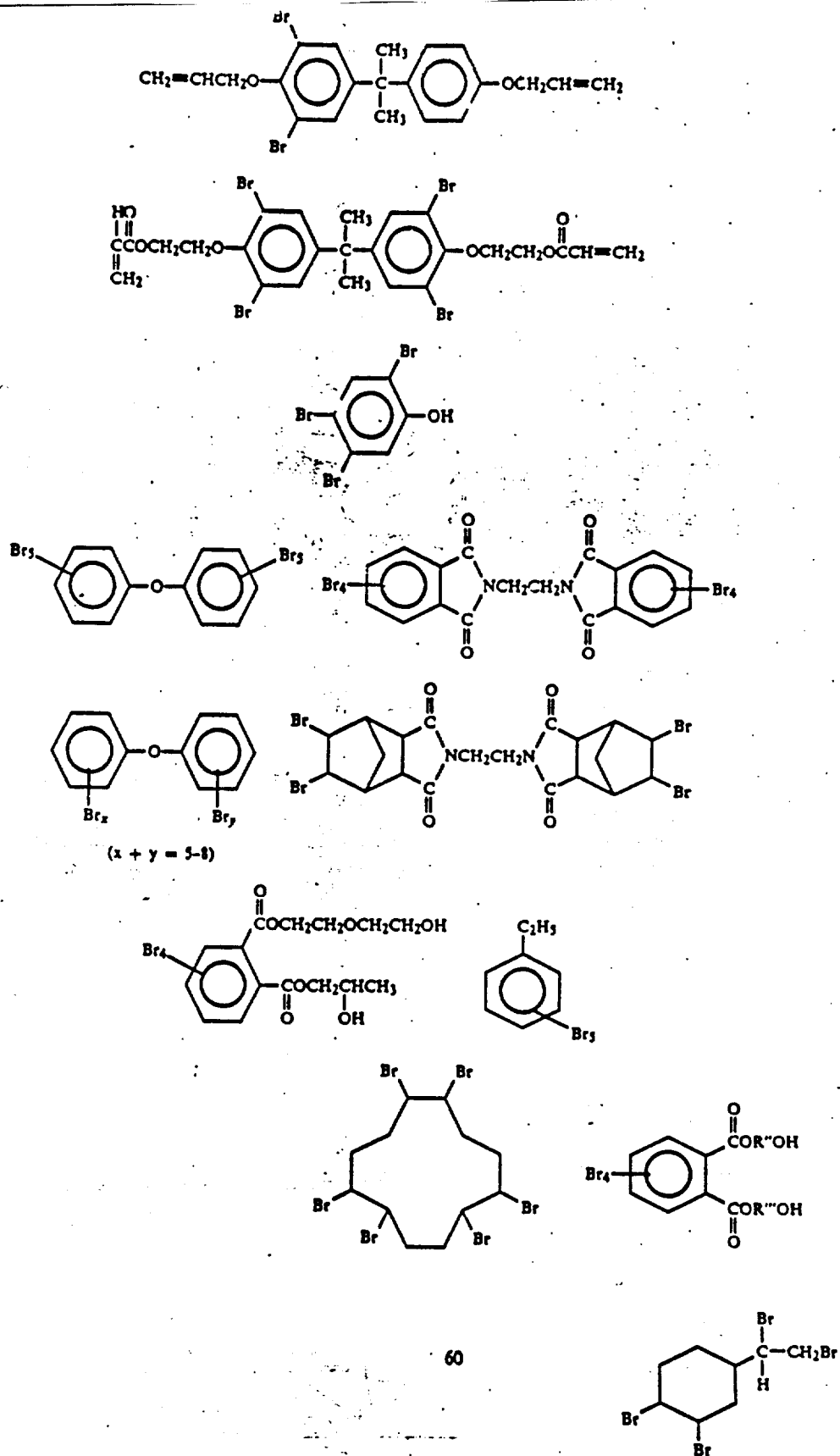
17. The method of claim 10 wherein the resin includes other brominated or chlorinated flame retardants or mixtures thereof.

18. The method of claim 17 wherein said brominated flame retardants are selected from the group consisting essentially of

5







60

where R'' and R''' are alkylene or substituted alkylene, 65
and