

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
18 July 2002 (18.07.2002)

PCT

(10) International Publication Number
WO 02/055582 A2

(51) International Patent Classification⁷: **C08G 64/00**

(21) International Application Number: PCT/US01/48818

(22) International Filing Date:
17 December 2001 (17.12.2001)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
09/760,101 12 January 2001 (12.01.2001) US

(71) Applicant: **GENERAL ELECTRIC COMPANY**
[US/US]; 1 River Road, Schenectady, NY 12345 (US).

(72) Inventors: **LEMMON, John, Patrick**; 615 Barton Hill Road, Delanson, NY 12053 (US). **MCCLOSKEY, Patrick, Joseph**; 10 Meadowbrook Road, Watervliet, NY 12189 (US). **WROCZYNSKI, Ronald, James**; 209 Vincenza Lane, Schenectady, NY 12303 (US).

(74) Agents: **SNYDER, Bernard** et al.; General Electric Company, 3135 Easton Turnpike W3C, Fairfield, CT 06431 (US).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW.

(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— without international search report and to be republished upon receipt of that report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: MELT POLYCARBONATE CATALYST SYSTEMS

(57) Abstract: This invention provides a method for preparing polycarbonates, which utilizes polycondensation catalysts which are salts of certain phenanthroline compounds. We have found that this new class of catalysts provide excellent polymerization rates for the preparation of Bisphenol A polycarbonate from the melt polymerization of diphenyl carbonate and Bisphenol A. Moreover, the catalysts of the invention were found to be very selective in substantially reducing the level of branching side reaction, i.e., formation of Fries product, normally associated with the melt polycarbonate process.



WO 02/055582 A2

MELT POLYCARBONATE CATALYST SYSTEMS

BACKGROUND OF THE INVENTION

The present invention relates to a method for preparing polycarbonates by a transesterification reaction between, for example, diaryl carbonate and aromatic bis hydroxy compounds. In particular, this invention relates to the melt polymerization reaction for the preparation of polycarbonates and novel polycarbonate catalysts
5 comprised of certain phenanthroline compounds.

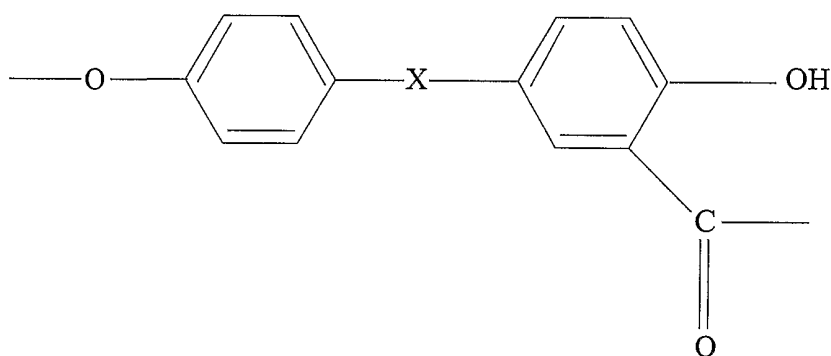
A large number of catalyst systems have been examined for application to the melt polymerization of polycarbonates. Most of these methods require either a variety of co-catalysts or the subsequent addition of a catalyst quencher to ensure polymer stability. The need for high purity, high quality thermoplastic resins requires
10 the reduction of residual contaminants in the final resin. This need for very low residual impurities is particularly acute in optical quality (OQ) grade polycarbonate resins. One approach towards elimination of residual solvent contamination, particularly methylene chloride, is through the implementation of a solventless (*i.e.*, melt) process.

The melt process generally involves a base catalyzed condensation polymerization of, for example, diphenyl carbonate, and a dihydroxy compound such as Bisphenol A. The reaction is conducted at high enough temperatures for the starting monomers and product to remain molten, while the reactor pressure is staged in order to effectively remove phenol, the by-product of the polycondensation
15 reaction.
20

Most current melt technology programs employ a two component catalyst system. The first component is a tetralkylammonium hydroxide (TMAH) co-catalyst which is used to initiate oligomer formation in the melt. The second catalyst is an alkali metal hydroxide (*i.e.*, the “ α -catalyst”) which is the second part of the overall
25 catalyst system. Due to its intrinsic thermal stability, the alkali metal salt must be quenched at the end of the polymerization. This quenching process requires the

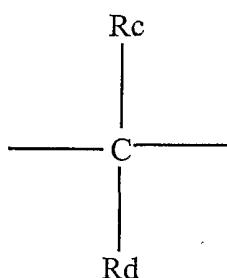
addition of yet another component to the polymer formation. All materials from the quenching process remain in the final resin, further compromising the final properties.

Although the alkali metal hydroxides in general are excellent melt polymerization catalysts they tend to generate substantial amounts of an additional undesired by-product which is a branched polycarbonate species typically referred to as Fries product which has the repeat unit as set forth below. The formation of Fries product during melt polycarbonate polymerization leads to changes in ductility and in general rheological properties of the polymer. Polycarbonates produced by the melt process typically have higher Fries content than polycarbonates produced by the interfacial method. As used herein the term "Fries" or "fries" refers to a repeating unit in polycarbonate having the following formula:



wherein the X variable represents

wherein variables R_c and R_d each independently represent a hydrogen atom or



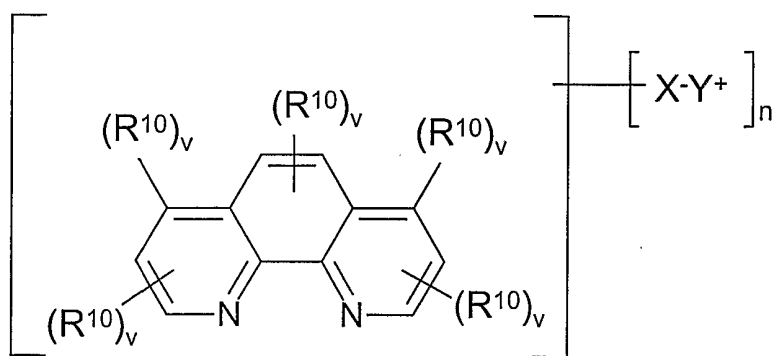
a monovalent hydrocarbon group and may form a ring structure. Thus, a need exists for the development of alternative melt polycarbonate polymerization catalysts which produce less Fries product than conventional catalyst systems.

SUMMARY OF THE INVENTION

This invention provides a method for preparing polycarbonates, which utilizes polycondensation catalysts which are salts of certain phenanthroline compounds. We have found that this new class of catalysts provides excellent polymerization rates for the preparation of Bisphenol A polycarbonate from the melt polymerization of diphenyl carbonate and Bisphenol A. Moreover, the catalysts of the invention were found to be very selective in substantially reducing the level of branching side reaction, *i.e.*, formation of Fries product, normally associated with the melt polycarbonate procedure. Examples of preferred catalysts include bathophenanthroline sulfonated sodium salt and bathocupproine disulfonate sodium salt.

DETAILED DESCRIPTION OF THE INVENTION

The present invention provides a method for preparing polycarbonates, which comprises contacting a diaryloxy compound with a dihydric phenol compound in the presence of a compound of Formula (I):



(I)

wherein each X is independently selected from a sulfate, carboxylate or a phosphonate group;

Y is an alkali metal cation;

each R^{10} is independently selected from the group consisting of C_1 - C_6 alkyl;

C₁-C₆ alkoxy; halo; aryl; and aryl substituted by one or two of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, aryl, or C₁-C₆ alkylaryl; and

v is 0, 1, or 2; and

n is 1, 2, 3 or 4;

5 optionally in the presence of a co-catalyst selected from tetraalkyl ammonium and tetraalkyl phosphonium salts; under polycarbonate melt polymerization conditions.

10 It should be understood that in the above Formula (I), the sulfate, carboxylate, and/or phosphonate groups are covalently bound to available sites on the aromatic carbon atoms of the phenanthroline ring structure.

As used herein, the term "aryl" preferably refers to a phenyl or naphthyl group.

Especially preferred compounds of Formula (I) include the following:

Bathophenanthroline sulfonated sodium salt;

15 Bathophenanthroline sulfonated potassium salt;

Bathophenanthroline sulfonated lithium salt;

Bathocupproine disulfonate sodium salt;

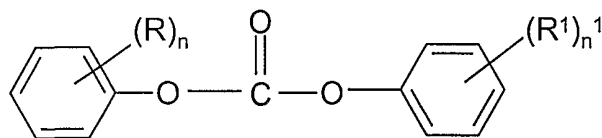
Bathocupproine disulfonate potassium salt;

Bathocupproine disulfonate lithium salt;

20 Bathophenanthroline sulfonated cesium salt; and;

Bathocupproine disulfonate cesium salt; and mixed potassium, sodium, lithium, and cesium salts thereof, *i.e.*, wherein each metal salt is independently selected from potassium, sodium, lithium, and cesium salts.

In the method of the present invention, certain diaryloxy compounds which are useful in preparing the polycarbonates of the invention may be represented by the general formula



wherein:

5 R is independently selected from halogen, monovalent hydrocarbon, and monovalent hydrocarbonoxy radicals;

 R¹ is independently selected from halogen, monovalent hydrocarbon, and monovalent hydrocarbonoxy radicals; and

 wherein n and n¹ are independently selected from integers having a value of
10 from 0 to 4 inclusive.

 The monovalent hydrocarbon radicals represented by R and R¹ include the alkyl, cycloalkyl, aryl, aralkyl and alkaryl radicals. The preferred alkyl radicals are those containing from 1 to about 12 carbon atoms. The preferred cycloalkyl radicals are those containing from 4 to about 8 ring carbon atoms. The preferred aryl radicals
15 are those containing from 6 to 12 ring carbon atoms, *i.e.*, phenyl, naphthyl, and biphenyl. The preferred alkaryl and aralkyl radicals are those containing from 7 to about 14 carbon atoms.

 The preferred halogen radicals represented by R and R¹ are chlorine and bromine.

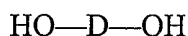
20 The divalent hydrocarbon radicals represented by include the alkylene, alkylidene, cycloalkylene and cycloalkylidene radicals. The preferred alkylene radicals are those containing from 2 to about 30 carbon atoms. The preferred alkylidene radicals are those containing from 1 to about 30 carbon atoms. The preferred cycloalkylene and cycloalkylidene radicals are those containing from 6 to

about 16 ring carbon atoms.

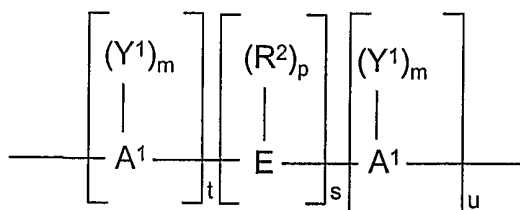
The monovalent hydrocarboxy radicals represented by R and R¹ may be represented by the formula —OR^{1'} wherein R^{1'} is a monovalent hydrocarbon radical of the type described herein. Preferred monovalent hydrocarboxy radicals are the alkoxy and aryloxy radicals.

Especially preferred diesters are the diesters of carbonic acid. As the diester of carbonic acid, various compounds may be used, including, but not limited to diaryl carbonate compounds, dialkyl carbonate compounds and alkylaryl carbonate compounds. Preferred diesters of carbonic acid include, but are not limited to, diphenyl carbonate; bis(4-*t*-butylphenyl)carbonate; bis(2,4-dichlorophenyl)carbonate; bis(2,4,6-trichlorophenyl)carbonate; bis(2-cyanophenyl)carbonate; bis(*o*-nitrophenyl)carbonate; bis(*o*-methoxycarbonylphenyl) carbonate; ditolyl carbonate; *m*-cresol carbonate; dinaphthyl carbonate; bis(diphenyl)carbonate; diethylcarbonate; dimethyl carbonate; dibutyl carbonate; dicyclohexyl carbonate; and mixtures thereof. Of these, diphenyl carbonate is preferred. If two or more of these compound are utilized, it is preferable that at least one is diphenyl carbonate.

Preferred dihydric phenols include those represented by the formula



wherein D is a divalent aromatic radical. Preferably, D has the formula:



wherein A¹ represents an aromatic group such as phenylene, biphenylene, naphthalene and the like; E represents an alkylene or alkylidene group such as methylene, ethylene, ethylidene, propylene, propylidene, isopropylidene, butylene, isobutylene, amylene, isoamylidene, and the like. Where E is an alkylene or

alkylidene group, it may also consist of two or more alkylene or alkylidene groups connected by a moiety different from alkylene or alkylidene, such as an aromatic linkage; a tertiary amino linkage; an ether linkage; a carbonyl linkage; a silicon-containing linkage; or a sulfur-containing linkage such as sulfide, sulfoxide, sulfone, *etc.*; or a phosphorus-containing linkage such as phosphinyl, phosphonyl, *etc.* In addition, E may be a cycloaliphatic group (e.g., cyclopentylidene, cyclohexylidene, 3,3,5-trimethylcyclohexylidene, methylcyclohexylidene, 2-[2.2.1]-bicycloheptylidene, neopentylidene, cyclopentadecylidene, cyclodecylidene, adamantylidene, and the like); a sulfur-containing linkage, such as sulfide, sulfoxide or sulfone; a phosphorus-containing linkage, such as phosphinyl, phosphonyl; an ether linkage; a carbonyl group; a tertiary nitrogen group; or a silicon-containing linkage such as silane or siloxy. R^2 represents hydrogen or a monovalent hydrocarbon group such as alkyl, aryl, aralkyl, alkaryl, or cycloalkyl. Y^1 may be an inorganic atom such as halogen (fluorine, bromine, chlorine, or iodine); an inorganic group such as nitro; an organic group such as R^2 above, or an oxy group such as $-OR^2$. It is only necessary that Y^1 be inert to and unaffected by reactants and reaction conditions used to prepare the polycarbonate. The letter m represents any integer from and including zero through the number of positions on A^1 available for substitution; p represents an integer from and including zero through the number of positions on E available for substitution; t represents an integer equal to at least one; s is either zero or one; and u represents zero or any integer.

In the dihydric phenol compound in which D is represented by the formula above, when more than one Y substituent is present, they may be the same or different. The same holds true for the R^2 substituent. Where s is zero in the above formula and u is not zero, the aromatic rings are directly joined with no intervening alkylidene or other bridging group or bond. The positions of the hydroxyl groups and Y^1 on the aromatic nuclear residues A^1 can be varied in the ortho, meta or para positions and the groupings can be vicinal, asymmetrical or symmetrical relationship, where two or more ring carbon atoms of the hydrocarbon residue are substituted with Y^1 and hydroxyl groups.

Further illustrative examples of dihydric phenols include the dihydroxy-

substituted aromatic hydrocarbons disclosed in U.S. Patent No. 4,217,438, incorporated herein by reference.

Further preferred dihydric phenols include the following:

resorcinol

5 4-bromoresorcinol

hydroquinone

4,4'-dihydroxybiphenyl ether

4,4'-thiodiphenol

1,6-dihydroxynaphthalene

10 2,6-dihydroxynaphthalene

bis(4-hydroxyphenyl)methane

bis(4-hydroxyphenyl)diphenylmethane

bis(4-hydroxyphenyl)-1-naphthylmethane

1,1-bis(4-hydroxyphenyl)ethane

15 1,1-bis(4-hydroxyphenyl)propane

1,2-bis(4-hydroxyphenyl)ethane

1,1-bis(4-hydroxyphenyl)-1-phenylethane

1,1-bis(3-methyl-4-hydroxyphenyl)-1-phenylethane 2,2-bis(4-hydroxyphenyl)propane ("Bisphenol A")

20 2-(4-hydroxyphenyl)-2-(3-hydroxyphenyl)propane

2,2-bis(4-hydroxyphenyl)butane

- 1,1-bis(4-hydroxyphenyl)isobutane
- 1,1-bis(4-hydroxyphenyl)decane
- 1,1-bis(3,5-dimethyl-4-hydroxyphenyl)cyclohexane
- 1,1-bis(3,5-dibromo-4-hydroxyphenyl)cyclohexane
- 5 1,1-bis(4-hydroxyphenyl)cyclohexane
- 1,1-bis(4-hydroxyphenyl)cyclododecane
- 1,1-bis(3,5-dimethyl-4-hydroxyphenyl)cyclododecane
- trans-2,3-bis(4-hydroxyphenyl)-2-butene
- 4,4-dihydroxy-3,3-dichlorodiphenyl ether
- 10 4,4-dihydroxy-2,5-dihydroxy diphenyl ether
- 2,2-bis(4-hydroxyphenyl)adamantane
- α , α' -bis(4-hydroxyphenyl)toluene
- bis(4-hydroxyphenyl)acetonitrile
- 2,2-bis(3-methyl-4-hydroxyphenyl)propane
- 15 2,2-bis(3-ethyl-4-hydroxyphenyl)propane
- 2,2-bis(3-n-propyl-4-hydroxyphenyl)propane
- 2,2-bis(3-isopropyl-4-hydroxyphenyl)propane
- 2,2-bis(3-sec-butyl-4-hydroxyphenyl)propane
- 2,2-bis(3-t-butyl-4-hydroxyphenyl)propane
- 20 2,2-bis(3-cyclohexyl-4-hydroxyphenyl)propane

- 2,2-bis(3-allyl-4-hydroxyphenyl)propane
- 2,2-bis(3-methoxy-4-hydroxyphenyl)propane
- 2,2-bis(3,5-dimethyl-4-hydroxyphenyl)propane
- 2,2-bis(2,3,5,6-tetramethyl-4-hydroxyphenyl)propane
- 5 2,2-bis(3,5-dichloro-4-hydroxyphenyl)propane
- 2,2-bis(3,5-dibromo-4-hydroxyphenyl)propane
- 2,2-bis(2,6-dibromo-3,5-dimethyl-4-hydroxyphenyl)propane
- α , α -bis(4-hydroxyphenyl)toluene
- α , α , α' , α' -Tetramethyl- α , α' -bis(4-hydroxyphenyl)-p-xylene
- 10 2,2-bis(4-hydroxyphenyl)hexafluoropropane
- 1,1-dichloro-2,2-bis(4-hydroxyphenyl)ethylene
- 1,1-dibromo-2,2-bis(4-hydroxyphenyl)ethylene
- 1,1-dichloro-2,2-bis(5-phenoxy-4-hydroxyphenyl)ethylene
- 4,4'-dihydroxybenzophenone
- 15 3,3-bis(4-hydroxyphenyl)-2-butanone
- 1,6-bis(4-hydroxyphenyl)-1,6-hexanedione
- ethylene glycol bis(4-hydroxyphenyl)ether
- bis(4-hydroxyphenyl)ether
- bis(4-hydroxyphenyl)sulfide
- 20 bis(4-hydroxyphenyl)sulfoxide

bis(4-hydroxyphenyl)sulfone

bis(3,5-dimethyl-4-hydroxyphenyl)sulfone

9,9-bis(4-hydroxyphenyl)fluorene

2,7-dihydroxypyrene

5 6,6'-dihydroxy-3,3,3',3'-tetramethylspiro(bis)indane("spirobiindane
Bisphenol") 3,3-bis(4-hydroxyphenyl)phthalide

2,6-dihydroxydibenzo-p-dioxin

2,6-dihydroxythianthrene

2,7-dihydroxyphenoxathiin

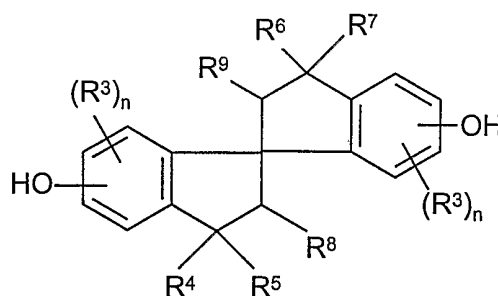
10 2,7-dihydroxy-9,10-dimethylphenazine

3,6-dihydroxydibenzofuran

3,6-dihydroxydibenzothiophene

2,7-dihydroxycarbazole

15 A further example of suitable dihydric phenols include those containing
spirobiindane structural units such as those represented by the formula:



wherein each R^3 is independently selected from monovalent hydrocarbon radicals and halogen radicals; each R^4 , R^5 , R^6 , and R^7 is independently C_1 - C_6 alkyl; each R^8 and R^9 is independently H or C_1 - C_6 alkyl; and each n is independently

selected from positive integers having a value of from 0 to 3, inclusive. The monovalent hydrocarbon radicals represented by R^3 are preferably those containing from 1 to about 12 carbon atoms, and include branched alkyl radicals and straight chain alkyl radicals. Some illustrative, non-limiting examples of these alkyl radicals include methyl, ethyl, propyl, isopropyl, butyl, tertiary-butyl, pentyl, neopentyl, and hexyl. Cycloalkyl radicals represented by R^3 are preferably those containing from about 3 to about 12 ring carbon atoms. Some illustrative non-limiting examples of these cycloalkyl radicals include cyclobutyl, cyclopentyl, cyclohexyl, methylcyclohexyl, and cycloheptyl. Aryl radicals represented by R^3 are preferably those containing from 6 to 12 ring carbon atoms. Some illustrative non-limiting examples of these aryl radicals include phenyl, biphenyl, and naphthyl. Preferred aralkyl and alkaryl radicals represented by R^3 are those containing from 7 to about 14 carbon atoms. These include, but are not limited to benzyl, ethylphenyl, phenylbutyl, phenylpropyl, propylphenyl, and phenylethyl. The preferred halogen radicals represented by R^3 are fluorine, chlorine and bromine.

In the dihydric phenols of the above formula, when more than one R^3 substituent is present, they may be the same or different. The relative positions of the hydroxyl groups and R^3 on the aromatic nuclear residues may be varied in the ortho or meta positions. The position of each hydroxy group is independently at any unsubstituted site on each of the aromatic rings. More preferably, each hydroxy group is independently in positions 5 or 6 and 5' and 6' of each aromatic ring.

The spirobiindane dihydric phenols of the above formula are compounds that are known in the art and are commercially available or may be readily prepared by known methods. Methods of preparation include those described in U.S. Patent No. 4,701,566; and by R.F. Curtis and K.O. Lewis in Journal of the Chemical Society (England), 1962, p. 420; and by R.F. Curtis in Journal of the Chemical Society (England), 1962, p. 417. In one illustrative, non-limiting example, these spiro dihydric phenols may be conveniently prepared by (i) reacting two moles of a phenolic compound with one mole of a carbonyl-containing compound such as acetone, and (ii) thereafter coreacting 3 moles of the product of (i) under acidic conditions to form the spiro dihydric phenol and 4 moles of a phenolic compound.

The acids which may be utilized in (ii) can include acids as anhydrous methanesulfonic acid, anhydrous hydrochloric acid, and the like.

The most preferred spiro dihydric phenol for forming polycarbonates is 6,6'-dihydroxy-3,3,3',3'-tetramethyl-1,1'-spirobiindane ("SBI"), in which n in the above
5 formula is 0 and the linkages with the rest of the polymer molecule are in a specific position on the aromatic rings.

The dihydric phenols set forth above may be used alone or as mixtures of two or more dihydric phenols. For reasons of availability and particular suitability for many end-uses, a preferred dihydric phenol is 2,2-bis(4-hydroxyphenyl)propane,
10 otherwise known as Bisphenol-A or "BPA".

Optionally, polyfunctional compounds may be utilized if the desired product is a branched polycarbonate. Such branched materials may be preferred in certain applications, for example in films for packaging applications. Suitable polyfunctional compounds used in the polymerization of branched polycarbonate include, but are not
15 limited to,

1,1,1-tris(4-hydroxyphenyl)ethane;

4-[4-[1,1-bis(4-hydroxyphenyl)-ethyl]-dimethylbenzyl];

trimellitic anhydride;

trimellitic acid, or its acid chloride derivatives;

20 trimethylolpropane; glycerol; and the like.

In the process of the present invention, an endcapping agent may optionally be used. Suitable endcapping agents include monovalent aromatic hydroxy compounds, haloformate derivatives of monovalent aromatic hydroxy compounds, monovalent carboxylic acids, halide derivatives of monovalent carboxylic acids, and mixtures
25 thereof.

Suitable endcapping agents include, but are not limited to phenol; *p*-tert-

butylphenol; *p*-cumylphenol; *p*-cumylphenolcarbonate; undecanoic acid; lauric acid; stearic acid; phenyl chloroformate; *t*-butyl phenyl chloroformate; *p*-cumyl chloroformate; chroman chloroformate; octyl phenyl; nonyl phenyl chloroformate; or a mixture thereof.

5 If present, the endcapping agent is preferably present in amounts of about 0.01 to about 0.20 moles, preferably about 0.02 to about 0.15 moles, even more preferably about 0.02 to about 0.10 moles per 1 mole of the dihydric phenol.

 It was found that catalyst systems comprising the phenanthroline compounds of Formula (I) provide polymerization rates comparable to alkali metal hydroxides, such as sodium hydroxide, while providing less branched side products. The
10 branched side products include, but are not limited to Fries products. In addition to the catalysts described above, the catalyst system may optionally comprise a quaternary ammonium salt and/or a phosphonium co-catalyst. Examples of suitable quaternary ammonium salts include, but are not limited to ammonium hydroxides
15 having alkyl groups, aryl groups and alkaryl groups, such as tetraamethylammonium hydroxide (TMAH) and tetrabutylammonium hydroxide (TBAH). Suitable phosphonium salts include, but are not limited to tetraethylphosphonium hydroxide and tetrabutylphosphonium hydroxide.

 In a preferred embodiment, a substantially equal molar mixture of the diester
20 and the dihydric phenol compound, preferably 1.0 to 1.2, most preferably 1.04-1.14 on a molar basis, is heated at atmospheric pressures in a substantially inert atmosphere at temperatures in the range of from 150° C to 210° C. Agitation of the mixture can be initiated as soon as the components start to melt. The system can be agitated slowly to promote better heat exchange. After the system has been allowed
25 to thermally equilibrate, an effective amount of the catalyst of the present invention can be added, optionally in the presence of co-catalyst as described above. The co-catalyst serves to catalyze the formation of polycarbonate oligomeric material, which later further undergoes polycondensation to form the polycarbonates of the present invention. In this regard, the catalyst of Formula (I) may be added at the beginning of
30 the polycondensation reaction, at later stages or during the polymerization step, either

in one portion or in multiple portions. An effective amount is at least about 1×10^{-6} mol ratio of the catalyst, per mole of BPA, preferably from about 1×10^{-6} to 1×10^{-5} mol ratio of the catalyst, per BPA.

The resulting solution can be stirred until the catalyst has been dispersed and
5 the reaction temperature of the mixture can be raised to 180°C to 210°C while the pressure can be lowered to 175 to 250 torr. Distillation of aromatic hydroxy compound (*i.e.*, the polycondensation by-product) can be effected and the pressure continuously reduced to further effect the separation of the aromatic hydroxy compound. The pressure of the reaction can be further reduced to 70 to 130 torr
10 while the temperature can be increased to 220°C to 250°C. The final stage of the reaction can be initiated by placing the condensation product under full vacuum at 0.1 to 5 torr at a temperature in the range of from 270°C to 350°C for 0.5 to 3 hours. Recovery of the final polycarbonate can be achieved after the theoretical amount of aromatic monohydroxy compound has been collected.

The reaction conditions of the melt polymerization are not particularly limited
15 and may be conducted in a wide range of operating conditions. Hence, the term "polycarbonate melt polymerization conditions" will be understood to mean those conditions necessary to effect reaction between the diaryloxy compound and the dihydric phenol compound. The reaction temperature is typically in the range of
20 about 100 to about 350°C, more preferably about 180 to about 310°C. The pressure may be at atmospheric, or at an added pressure of from atmospheric to about 15 torr in the initial stages of the reaction, and at a reduced pressure at later stages, for example in the range of about 0.2 to about 15 torr. The reaction time is generally about .1 hours to about 10 hours.

The melt polymerization may be accomplished in one or more stages, as is
25 known in the art with other catalysts. The catalysts of the present invention may be added in the same stage or different stages, if the melt polymerization is conducted in more than one stage. The optional co-catalyst may be added at any stage, although it is preferred that it be added early in the process. When utilized, the basic co-catalyst
30 is preferably utilized in a 1-500x molar equivalent, based on the moles of catalyst

utilized.

In a further preferred embodiment, the process is conducted as a two stage process. In the first stage of this embodiment, the catalyst of the present invention is introduced into the reaction system comprising the dihydric phenol compound and the diaryloxy compound. The first stage is conducted at a temperature of 270°C or lower, preferably 80 to 250°C, more preferably 100 to 230°C. The duration of the first stage is preferably 0 to 5 hours, even more preferably 0 to 3 hours at a pressure from atmospheric pressure to 100 torr, with a nitrogen atmosphere preferred.

In a second stage, the catalyst is introduced into the product from the first stage and further polycondensation is conducted. The catalyst may be added in its entire amount in the second stage, or it may be added in batches in the second and subsequent stages so that the total amount is within the aforementioned ranges.

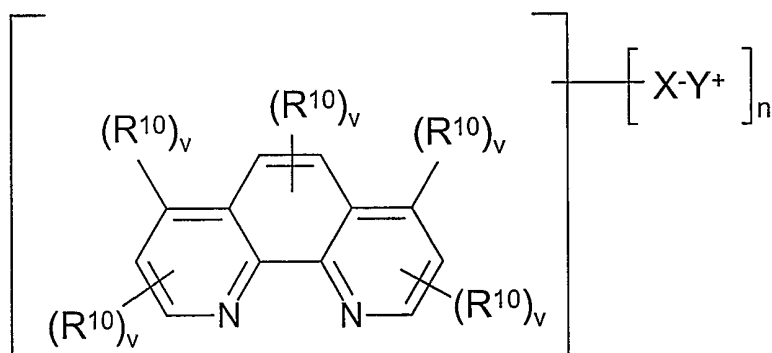
It is preferable in the second and subsequent stages of the polycondensation step for the reaction temperature to be raised while the reaction system is reduced in pressure compared to the first stage, thus bringing about a reaction between the dihydric phenol compound and the diaryloxy compound, and for the dihydric phenol and the diaryloxy compound finally to be subjected to a polycondensation reaction at 240 to 320°C under reduced pressure of 5 mm Hg or less, and preferably 1 mm Hg or less.

If the melt polymerization is conducted in more than one stage, as noted above, it is preferable to add a co-catalyst base, such as tetramethyl ammonium hydroxide in an earlier stage than the catalyst of the present invention. In particular, it is preferable to add the base to the reactor before the temperature reaches 220°C, preferably before it reaches 200°C.

Thus, in a further embodiment, the present invention provides a method for preparing polycarbonates, which comprises the steps of

(a) melting a dihydric phenol and a diaryloxy compound for a time and period sufficient to form a melt, and thereafter introducing a catalyst composition

comprising a catalytically effective amount of a compound of the formula



wherein each X is independently selected from a sulfate, carboxylate or a phosphonate group;

Y is an alkali metal cation;

5 each R^{10} is independently selected from the group consisting of $\text{C}_1\text{-C}_6$ alkyl; $\text{C}_1\text{-C}_6$ alkoxy; halo; aryl; and aryl substituted by one or two of $\text{C}_1\text{-C}_6$ alkyl, $\text{C}_1\text{-C}_6$ alkoxy, halo, aryl, or $\text{C}_1\text{-C}_6$ alkylaryl; and

v is 0, 1, or 2; and

10 n is 1, 2, 3 or 4; optionally in the presence of a co-catalyst selected from tetraalkyl ammonium and tetraalkyl phosphonium salts;

(b) oligomerizing the product from step (a) in a reaction system comprising at least one continuous reactor in series, wherein said reactor is operated at a temperature of about 210 C to about 290°C, and wherein the product from the reactor has a number average molecular weight of about 1000 to about 5500; and

15 (c) polymerizing the product from step (b) in a reaction system comprising at least one continuous polymerization reactor in series, wherein said reactor is operated at a temperature of about 280°C to 315°C, wherein the product from step (c) has a number average molecular weight of at least about 6500.

Additives may also be added to the polycarbonate product as long as they do

not adversely affect the properties of the product. These additives include a wide range of substances that are conventionally added to the polycarbonates for a variety of purposes. Specific examples include heat stabilizers, epoxy compounds, ultraviolet absorbers, mold release agents, colorants, antistatic agents, slipping agents, anti-
5 blocking agents, lubricants, antifogging agents, natural oils, synthetic oils, waxes, organic fillers, flame retardants, inorganic fillers and any other commonly known class of additives.

The reaction can be conducted as a batch or a continuous process. Any desired apparatus can be used for the reaction. The material and the structure of the reactor
10 used in the present invention is not particularly limited as long as the reactor has an ordinary capability of stirring. It is preferable that the reactor is capable of stirring in high viscosity conditions as the viscosity of the reaction system is increased in later stages of the reaction.

EXPERIMENTAL SECTION

We have discovered that the catalysts of the present invention significantly
15 enhance the selectivity towards reducing this side branching reaction product (commonly referred to as the Fries product).

Compared with sodium tosylate, the two bathophenanthrolines shown in Figure 1a and 1b demonstrate a significant increase in reaction rate as indicated by their molecular weight. The dependence of Fries and molecular weight on the anionic and structural variation within the catalyst molecule was dramatically observed when
20 2,2'-biquinoline-4, 4'-dicarboxylic acid disodium salt was used as the catalyst. Compared with results using NaOH, this catalyst produced polymer with a higher molecular weight and the Fries product was significantly higher. These results indicate a significant improvement in selectivity towards the formation of non-
25 branched polycarbonate while maintaining a slightly less than equivalent reaction rate to NaOH. Another attractive feature of these catalysts over NaOH is that they are neutral to slightly acidic in solution, thus avoiding the corrosive properties of NaOH. Comparisons of Fries and molecular weight for several catalysts are presented in

Table 1.

Table 1

<u>Salt added¹</u>	<u>Mn</u>	<u>Fries</u>
NaOH	8800	3200
Sodium Toylate	5938	240
Bathophenanthroline sulfonated sodium salt	6788	168
Bathocupproine disulfonate sodium salt	7619	510
2,2'-bisquinoline-4,4'-dicarboxylic acid disodium salt	9104	6297

¹ Catalyst level was 5.0×10^{-6} moles / mole BPA

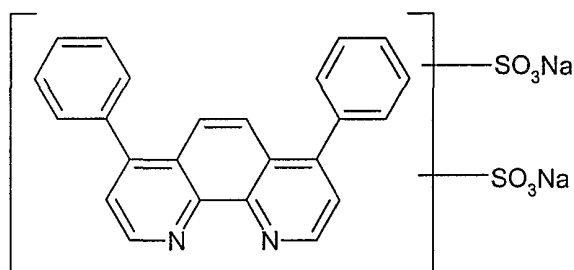


Figure 1a
Bathophenanthroline sulfonated sodium salt

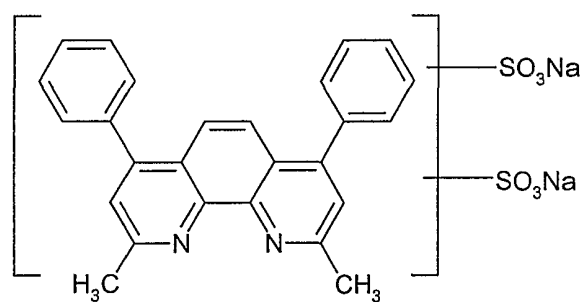


Figure 1b
Bathocupproine disulfonate sodium salt

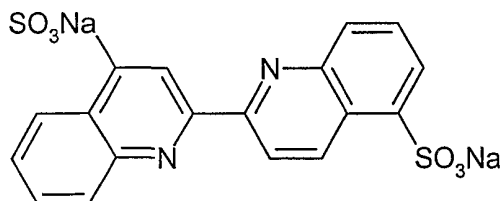


Figure 1c
2,2'-isoquinoline-4,4'-dicarboxylic acid disodium salt

As illustrated in Table 1 a significant level of Fries reduction can be achieved

by use of the catalysts of the present invention

General Procedure

To facilitate observations and for purity melt transesterification reactions were carried out in a 1 Liter glass batch reactor equipped with a solid nickel helical agitator. The reactor bottom had a breakaway glass nipple for removal of the final melt. To remove any sodium from the glass the reactor was soaked in 3N HCl for at least 12 hours followed by a soak in 18 Mohm water for at least 12 hours. The reactor was then dried in an oven overnight and stored covered until use. The temperature of the reactor was maintained using a fluidised sand bath with a PID controller and measured near the reactor and sand bath interface. The pressure over the reactor was controlled by a nitrogen bleed into the vacuum pump downstream of the distillate collection flasks and measured at higher pressures (760 mmHg - 40 mmHg) with a mercury barometer and at lower pressures (40 mmHg - 1 mmHg) with an Edwards pirani gauge.

The reactor was charged with solid Bisphenol-A (General Electric Plastics Japan Ltd., 0.6570 mol) and solid Diphenyl carbonate (General Electric Plastics Japan Ltd., 0.7096 mol) prior to assembly. The reactor was then assembled, sealed and the atmosphere was exchanged with nitrogen three times. With the final nitrogen exchange the reactor was brought to near atmospheric pressure and submerged into the fluidised bath which was at 180°C. After five minutes agitation was begun at 250 rpm. After an additional ten minutes the reactants were fully melted and a homogeneous mixture was assumed. Tetramethyl ammonium hydroxide (Sachem stock solution, 1.32×10^{-4} mol) and the catalyst of the invention were added sequentially after being diluted to the proper concentrations (Table 2).

Table 2. Reactant Amounts in 18M Ohm water

<u>Condition</u>	<u>TMAH</u>	<u>Catalyst of Invention</u>
Concentration / M	0.220	$1.0 - 5.0 \times 10^{-3}$
Volume added / ul	740	660
Catalyst / BPA	2.5×10^{-4}	$1.0 - 5.0 \times 10^{-6}$

After the final catalyst was added timing began and the temperature was ramped to 210°C in five minutes. Once at temperature the pressure was reduced to 180 mmHg and phenol distillate was immediately formed. After 25 minutes the pressure was again reduced to 100 mmHg and maintained for 45 minutes. The temperature was then ramped to 240°C in five minutes and the pressure was lowered to 15 mmHg. These conditions were maintained for 45 minutes. The temperature was then ramped to 270°C in five minutes and the pressure was lowered to 2 mmHg. These conditions were maintained for 10 minutes. The temperature was then ramped to the final finishing temperature in five minutes and the pressure was reduced to 1.1 mmHg. The finishing temperature was 310°C. After 30 minutes the reactor was removed from the sand bath and the melt was extruded into liquid nitrogen to quench the reaction.

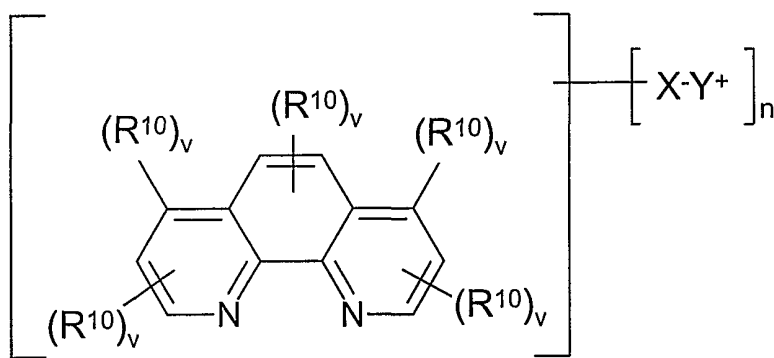
Fries determination (ppm) was obtained by the liquid chromatographic analysis of the KOH catalysed methanolysis of polycarbonate prepared by melt condensation.

Mn (Number average molecular weight) was obtained by GPC analysis of polycarbonate prepared by melt polymerization. Standards of polystyrene were used to construct a universal calibration against which polycarbonate could be measured using the Mark-Houwink equation. The temperature of the columns was 25°C and the mobile phase was chloroform

CLAIMS

We Claim:

1. A method for preparing polycarbonates which comprises contacting a diaryloxy compound with a dihydric phenol compound in the presence of a compound of Formula (I)



(I)

5 wherein each X is independently selected from a sulfate, carboxylate or a phosphonate group;

Y is an alkali metal cation;

each R^{10} is independently selected from the group consisting of C_1 - C_6 alkyl;
 10 C_1 - C_6 alkoxy; halo; aryl; and aryl substituted by one or two of C_1 - C_6 alkyl, C_1 - C_6
 alkoxy, halo, aryl, or C_1 - C_6 alkylaryl; and

v is 0, 1, or 2; and

n is 1, 2, 3 or 4;

optionally in the presence of a co-catalyst selected from tetraalkyl ammonium
 and tetraalkyl phosphonium salts; under polycarbonate melt polymerization
 15 conditions.

2. The method of claim 1, wherein the compound of Formula (I) is

selected from the group consisting Bathophenanthroline sulfonated sodium salt;

Bathophenanthroline sulfonated potassium salt;

Bathophenanthroline sulfonated lithium salt;

Bathocupproine disulfonate sodium salt;

5 Bathocupproine disulfonate potassium salt;

Bathocupproine disulfonate lithium salt;

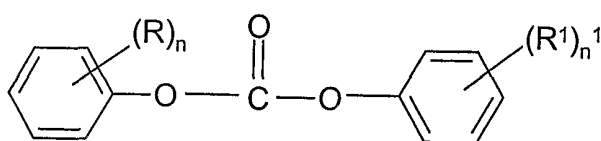
Bathophenanthroline sulfonated cesium salt; and;

Bathocupproine disulfonate cesium salt; and mixed potassium, sodium, lithium, and cesium salts thereof.

10 3. The method of claim 1, wherein the compound of Formula (I) is bathophenanthroline sulfonated sodium salt.

4. The method of claim 1, wherein the compound of Formula (I) is bathocupproine disulfonate sodium salt.

15 5. The method of claim 1, wherein the diaryloxy compound is a compound of the formula



wherein:

R is independently selected from halogen, monovalent hydrocarbon, and monovalent hydrocarbonoxy radicals;

20 R' is independently selected from halogen, monovalent hydrocarbon, and monovalent hydrocarbonoxy radicals; and

wherein n and n^1 are independently selected from integers having a value of from 0 to 4 inclusive.

6. The method of claim 5, wherein R and R^1 are selected from C_1 - C_{12} alkyl, C_4 - C_8 cycloalkyl, phenyl, naphthyl, and biphenyl.

5 7. The method of claim 5, wherein R and R^1 are selected from chlorine and bromine.

8. The method of claim 5, wherein the diaryloxy compound is selected from diaryl carbonate compounds, dialkyl carbonate compounds and alkylaryl carbonate compounds.

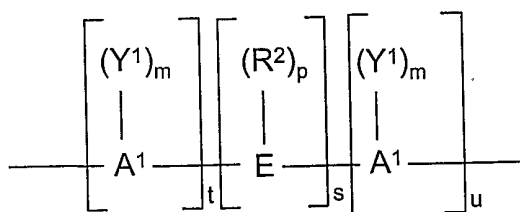
10 9. The method of claim 5, wherein the diaryloxy compound is selected from the group consisting of diphenyl carbonate; bis(4-*t*-butylphenyl)carbonate; bis(2,4-dichlorophenyl)carbonate; bis(2,4,6-trichlorophenyl)carbonate; bis(2-cyanophenyl)carbonate; bis(*o*-nitrophenyl)carbonate; bis(*o*-methoxycarbonylphenyl) carbonate; ditolyl carbonate; *m*-cresol carbonate; dinaphthyl carbonate; 15 bis(diphenyl)carbonate; diethylcarbonate; dimethyl carbonate; dibutyl carbonate; dicyclohexyl carbonate; and mixtures thereof.

10. The method of claim 1, wherein the dihydric phenol compound is a compound of the formula



20 wherein D is a divalent aromatic radical.

11. The method of claim 10, wherein D has the formula:



wherein A^1 represents an aromatic group selected from phenylene, biphenylene, and naphthalene; and

E represents an alkylene or alkylidene group selected from methylene, ethylene, ethylidene, propylene, propylidene, isopropylidene, butylene, isobutylene, amylene, and isoamylidene; a cycloaliphatic group selected from cyclopentylidene, cyclohexylidene, 3,3,5-trimethylcyclohexylidene, methylcyclohexylidene, 2-[2.2.1]-bicycloheptylidene, neopentylidene, cyclopentadecylidene, cyclodecylidene, and adamantylidene; a sulfur-containing linkage selected from sulfide, sulfoxide or sulfone; a phosphinyl or phosphonyl group; an ether linkage; a carbonyl group; a tertiary nitrogen group; or a silicon-containing linkage selected from silane or siloxy;

R^2 represents hydrogen or a monovalent hydrocarbon group selected from alkyl, aryl, aralkyl, alkaryl, or cycloalkyl; and

Y^1 is selected from halogen, nitro; R^2 as defined above, or a group of the formula $-OR^2$; and

s, t, and u are each independently zero or a positive integer.

12. The method of claim 10, wherein the dihydric phenol is selected from the group consisting of:

resorcinol;

4-bromoresorcinol;

hydroquinone;

4,4'-dihydroxybiphenyl ether;

- 4,4-thiodiphenol;
- 1,6-dihydroxynaphthalene;
- 2,6-dihydroxynaphthalene;
- bis(4-hydroxyphenyl)methane;
- 5 bis(4-hydroxyphenyl)diphenylmethane;
- bis(4-hydroxyphenyl)-1-naphthylmethane;
- 1,1-bis(4-hydroxyphenyl)ethane;
- 1,1-bis(4-hydroxyphenyl)propane;
- 1,2-bis(4-hydroxyphenyl)ethane;
- 10 1,1-bis(4-hydroxyphenyl)-1-phenylethane;
- 1,1-bis(3-methyl-4-hydroxyphenyl)-1-phenylethane; 2,2-bis(4-hydroxyphenyl)propane;
- 2-(4-hydroxyphenyl)-2-(3-hydroxyphenyl)propane;
- 2,2-bis(4-hydroxyphenyl)butane;
- 15 1,1-bis(4-hydroxyphenyl)isobutene;
- 1,1-bis(4-hydroxyphenyl)decane;
- 1,1-bis(3,5-dimethyl-4-hydroxyphenyl)cyclohexane;
- 1,1-bis(3,5-dibromo-4-hydroxyphenyl)cyclohexane;
- 1,1-bis(4-hydroxyphenyl)cyclohexane;
- 20 1,1-bis(4-hydroxyphenyl)cyclododecane;
- 1,1-bis(3,5-dimethyl-4-hydroxyphenyl)cyclododecane;

trans-2,3-bis(4-hydroxyphenyl)-2-butene;

4,4-dihydroxy-3,3-dichlorodiphenyl ether;

4,4-dihydroxy-2,5-dihydroxy diphenyl ether;

2,2-bis(4-hydroxyphenyl)adamantine;

5 α , α' -bis(4-hydroxyphenyl)toluene

bis(4-hydroxyphenyl)acetonitrile;

2,2-bis(3-methyl-4-hydroxyphenyl)propane;

2,2-bis(3-ethyl-4-hydroxyphenyl)propane;

2,2-bis(3-n-propyl-4-hydroxyphenyl)propane;

10 2,2-bis(3-isopropyl-4-hydroxyphenyl)propane;

2,2-bis(3-sec-butyl-4-hydroxyphenyl)propane;

2,2-bis(3-t-butyl-4-hydroxyphenyl)propane;

2,2-bis(3-cyclohexyl-4-hydroxyphenyl)propane;

2,2-bis(3-allyl-4-hydroxyphenyl)propane;

15 2,2-bis(3-methoxy-4-hydroxyphenyl)propane;

2,2-bis(3,5-dimethyl-4-hydroxyphenyl)propane;

2,2-bis(2,3,5,6-tetramethyl-4-hydroxyphenyl)propane;

2,2-bis(3,5-dichloro-4-hydroxyphenyl)propane;

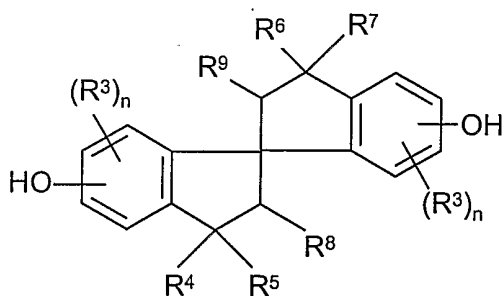
2,2-bis(3,5-dibromo-4-hydroxyphenyl)propane;

20 2,2-bis(2,6-dibromo-3,5-dimethyl-4-hydroxyphenyl)propane;

- α , α -bis(4-hydroxyphenyl)toluene;
- α , α , α' , α' -Tetramethyl- α , α' -bis(4-hydroxyphenyl)-*p*-xylene;
- 2,2-bis(4-hydroxyphenyl)hexafluoropropane;
- 1,1-dichloro-2,2-bis(4-hydroxyphenyl)ethylene;
- 5 1,1-dibromo-2,2-bis(4-hydroxyphenyl)ethylene;
- 1,1-dichloro-2,2-bis(5-phenoxy-4-hydroxyphenyl)ethylene;
- 4,4'-dihydroxybenzophenone;
- 3,3-bis(4-hydroxyphenyl)-2-butanone;
- 1,6-bis(4-hydroxyphenyl)-1,6-hexanedione;
- 10 ethylene glycol bis(4-hydroxyphenyl)ether;
- bis(4-hydroxyphenyl)ether;
- bis(4-hydroxyphenyl)sulfide;
- bis(4-hydroxyphenyl)sulfoxide;
- bis(4-hydroxyphenyl)sulfone;
- 15 bis(3,5-dimethyl-4-hydroxyphenyl)sulfone
- 9,9-bis(4-hydroxyphenyl)fluorine;
- 2,7-dihydroxypyrene;
- 6,6'-dihydroxy-3,3,3',3'-tetramethylspiro(bis)indane;
- 3,3-bis(4-hydroxyphenyl)phthalide;
- 20 2,6-dihydroxydibenzo-*p*-dioxin;

2,6-dihydroxythianthrene;
 2,7-dihydroxyphenoxathiin;
 2,7-dihydroxy-9,10-dimethylphenazine;
 3,6-dihydroxydibenzofuran;
 3,6-dihydroxydibenzothiophene; and
 2,7-dihydroxycarbazole.

13. The method of claim 10, wherein the dihydric phenol is selected from spirobiindane compounds of the formula:



wherein each R^3 is independently selected from monovalent hydrocarbon radicals and halogen radicals; each R^4 , R^5 , R^6 , and R^7 is independently C_1 - C_6 alkyl; each R^8 and R^9 is independently H or C_1 - C_6 alkyl; and each n is independently selected from positive integers having a value of from 0 to 3, inclusive.

14. The method of claim 10, wherein the dihydric phenol compound is 6,6'-dihydroxy-3,3',3'-tetramethyl-1.1'-spirobiindane.

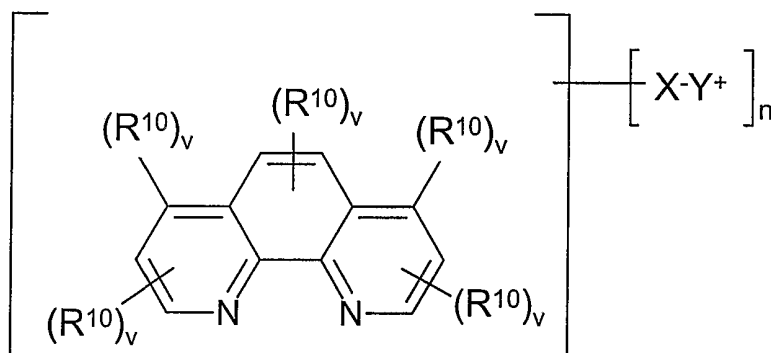
15. The method of claim 1, wherein the diaryloxy compound is diphenyl carbonate and the dihydric phenol compound is 2,2-bis(4-hydroxyphenyl)propane.

16. The method of claim 1, further comprising the use of one or more end capping monomers selected from the group consisting of phenol; *p*-tert-butylphenol; *p*-cumylphenol; *p*-cumylphenolcarbonate; undecanoic acid; lauric acid; stearic acid; phenyl chloroformate; *t*-butyl phenyl chloroformate; *p*-cumyl chloroformate; chroman

chloroformate; octyl phenyl; and nonyl phenyl chloroformate; or a mixture thereof

17. A method for preparing polycarbonates, which comprises the steps of

(a) melting a dihydric phenol and a diaryloxy compound for a time and period sufficient to form a melt, and thereafter introducing a catalyst composition comprising a catalytically effective amount of a compound of the formula



wherein each X is independently selected from a sulfate, carboxylate or a phosphonate group;

Y is an alkali metal cation;

each R¹⁰ is independently selected from the group consisting of C₁-C₆ alkyl; C₁-C₆ alkoxy; halo; aryl; and aryl substituted by one or two of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, aryl, or C₁-C₆ alkylaryl; and

v is 0, 1, or 2; and

n is 1, 2, 3 or 4; optionally in the presence of a co-catalyst selected from tetraalkyl ammonium and tetraalkyl phosphonium salts;

(b) oligomerizing the product from step (a) in a reaction system comprising at least one continuous reactor in series, wherein said reactor is operated at a temperature of about 210° C to about 290° C, and wherein the product from the reactor has a number average molecular weight of about 1000 to about 5500; and

(c) polymerizing the product from step (b) in a reaction system comprising at least one continuous polymerization reactor in series, wherein said reactor is operated at a temperature of about 280°C to 315°C, wherein the product from step (c) has a number average molecular weight of at least about 6500 .

5 18. The method of claim 17, wherein the compound of Formula (I) is selected from the group consisting of Bathophenanthroline sulfonated sodium salt;

Bathophenanthroline sulfonated potassium salt;

Bathophenanthroline sulfonated lithium salt;

Bathocupproine disulfonate sodium salt;

10 Bathocupproine disulfonate potassium salt;

Bathocupproine disulfonate lithium salt;

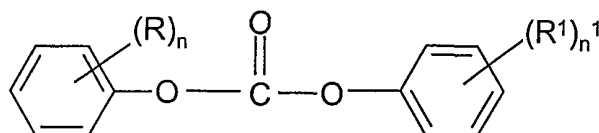
Bathophenanthroline sulfonated cesium salt; and;

Bathocupproine disulfonate cesium salt; and mixed potassium, sodium, lithium, and cesium salts thereof.

15 19. The method of claim 17, wherein the compound of Formula (I) is bathophenanthroline sulfonated sodium salt.

20. The method of claim 17, wherein the compound of Formula (I) is bathocupproine disulfonate sodium salt.

20 21. The method of claim 17, wherein the diaryloxy compound is a compound of the formula



wherein:

R is independently selected from halogen, monovalent hydrocarbon, and monovalent hydrocarboxy radicals;

R¹ is independently selected from halogen, monovalent hydrocarbon, and monovalent hydrocarboxy radicals; and

5 n and n¹ are independently selected from integers having a value of from 0 to 4 inclusive.

22. The method of claim 21, wherein R and R¹ are selected from C₁-C₁₂ alkyl,

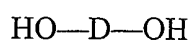
C₄-C₈ cycloalkyl, phenyl, naphthyl, and biphenyl.

10 23. The method of claim 21, wherein R and R¹ are selected from chlorine and bromine.

24. The method of claim 21, wherein the diaryloxy compound is selected from diaryl carbonate compounds, dialkyl carbonate compounds and alkylaryl carbonate compounds.

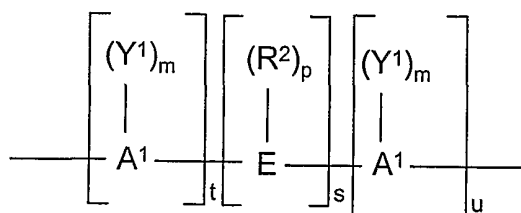
15 25. The method of claim 21, wherein the diaryloxy compound is selected from the group consisting of diphenyl carbonate; bis(4-*t*-butylphenyl)carbonate; bis(2,4-dichlorophenyl)carbonate; bis(2,4,6-trichlorophenyl)carbonate; bis(2-cyanophenyl)carbonate; bis(*o*-nitrophenyl)carbonate; bis(*o*-methoxycarbonylphenyl) carbonate; ditolyl carbonate; *m*-cresol carbonate; dinaphthyl carbonate;
20 bis(diphenyl)carbonate; diethylcarbonate; dimethyl carbonate; dibutyl carbonate; dicyclohexyl carbonate; and mixtures thereof.

26. The method of claim 21, wherein the dihydric phenol compound is a compound of the formula



25 wherein D is a divalent aromatic radical.

27. The method of claim 26, wherein D has the formula:



wherein A^1 represents an aromatic group selected from phenylene, biphenylene, and naphthalene; and

E represents an alkylene or alkylidene group selected from methylene, ethylene, ethylidene, propylene, propylidene, isopropylidene, butylene, isobutylene, amylene, and isoamylidene; a cycloaliphatic group selected from cyclopentylidene, cyclohexylidene, 3,3,5-trimethylcyclohexylidene, methylcyclohexylidene, 2-[2.2.1]-bicycloheptylidene, neopentylidene, cyclopentadecylidene, cyclodecylidene, and adamantylidene; a sulfur-containing linkage selected from sulfide, sulfoxide or sulfone; a phosphinyl or phosphonyl group; an ether linkage; a carbonyl group; a tertiary nitrogen group; or a silicon-containing linkage selected from silane or siloxy;

R^2 represents hydrogen or a monovalent hydrocarbon group selected from alkyl, aryl, aralkyl, alkaryl, or cycloalkyl; and

Y^1 is selected from halogen, nitro; R^2 as defined above, or a group of the formula $-OR^2$; and

s, t, and u are each independently zero or a positive integer.

28. The method of claim 26, wherein the dihydric phenols are selected from the group consisting of:

resorcinol;

4-bromoresorcinol;

hydroquinone;

- 4,4'-dihydroxybiphenyl ether;
- 4,4-thiodiphenol;
- 1,6-dihydroxynaphthalene;
- 2,6-dihydroxynaphthalene;
- 5 bis(4-hydroxyphenyl)methane;
- bis(4-hydroxyphenyl)diphenylmethane;
- bis(4-hydroxyphenyl)-1-naphthylmethane;
- 1,1-bis(4-hydroxyphenyl)ethane;
- 1,1-bis(4-hydroxyphenyl)propane;
- 10 1,2-bis(4-hydroxyphenyl)ethane;
- 1,1-bis(4-hydroxyphenyl)-1-phenylethane;
- 1,1-bis(3-methyl-4-hydroxyphenyl)-1-phenylethane; 2,2-bis(4-hydroxyphenyl)propane;
- 2-(4-hydroxyphenyl)-2-(3-hydroxyphenyl)propane;
- 15 2,2-bis(4-hydroxyphenyl)butane;
- 1,1-bis(4-hydroxyphenyl)isobutene;
- 1,1-bis(4-hydroxyphenyl)decane;
- 1,1-bis(3,5-dimethyl-4-hydroxyphenyl)cyclohexane;
- 1,1-bis(3,5-dibromo-4-hydroxyphenyl)cyclohexane;
- 20 1,1-bis(4-hydroxyphenyl)cyclohexane;
- 1,1-bis(4-hydroxyphenyl)cyclododecane;

- 1,1-bis(3,5-dimethyl-4-hydroxyphenyl)cyclododecane;
trans-2,3-bis(4-hydroxyphenyl)-2-butene;
4,4-dihydroxy-3,3-dichlorodiphenyl ether;
4,4-dihydroxy-2,5-dihydroxy diphenyl ether;
5 2,2-bis(4-hydroxyphenyl)adamantine;
 α , α' -bis(4-hydroxyphenyl)toluene
bis(4-hydroxyphenyl)acetonitrile;
2,2-bis(3-methyl-4-hydroxyphenyl)propane;
2,2-bis(3-ethyl-4-hydroxyphenyl)propane;
10 2,2-bis(3-n-propyl-4-hydroxyphenyl)propane;
2,2-bis(3-isopropyl-4-hydroxyphenyl)propane;
2,2-bis(3-sec-butyl-4-hydroxyphenyl)propane;
2,2-bis(3-t-butyl-4-hydroxyphenyl)propane;
2,2-bis(3-cyclohexyl-4-hydroxyphenyl)propane;
15 2,2-bis(3-allyl-4-hydroxyphenyl)propane;
2,2-bis(3-methoxy-4-hydroxyphenyl)propane;
2,2-bis(3,5-dimethyl-4-hydroxyphenyl)propane;
2,2-bis(2,3,5,6-tetramethyl-4-hydroxyphenyl)propane;
2,2-bis(3-5-dichloro-4-hydroxyphenyl)propane;
20 2,2-bis(3,5-dibromo-4-hydroxyphenyl)propane;

- 2,2-bis(2,6-dibromo-3,5-dimethyl-4-hydroxyphenyl)propane;
- α , α -bis(4-hydroxyphenyl)toluene;
- α , α , α' , α' -Tetramethyl- α , α' -bis(4-hydroxyphenyl)-*p*-xylene;
- 2,2-bis(4-hydroxyphenyl)hexafluoropropane;
- 5 1,1-dichloro-2,2-bis(4-hydroxyphenyl)ethylene;
- 1,1-dibromo-2,2-bis(4-hydroxyphenyl)ethylene;
- 1,1-dichloro-2,2-bis(5-phenoxy-4-hydroxyphenyl)ethylene;
- 4,4'-dihydroxybenzophenone;
- 3,3-bis(4-hydroxyphenyl)-2-butanone;
- 10 1,6-bis(4-hydroxyphenyl)-1,6-hexanedione;
- ethylene glycol bis(4-hydroxyphenyl)ether;
- bis(4-hydroxyphenyl)ether;
- bis(4-hydroxyphenyl)sulfide;
- bis(4-hydroxyphenyl)sulfoxide;
- 15 bis(4-hydroxyphenyl)sulfone;
- bis(3,5-dimethyl-4-hydroxyphenyl)sulfone
- 9,9-bis(4-hydroxyphenyl)fluorine;
- 2,7-dihydroxypyrene;
- 6,6'-dihydroxy-3,3,3',3'-tetramethylspiro(bis)indane;
- 20 3,3-bis(4-hydroxyphenyl)phthalide;

2,6-dihydroxydibenzo-p-dioxin;

2,6-dihydroxythianthrene;

2,7-dihydroxyphenoxathiin;

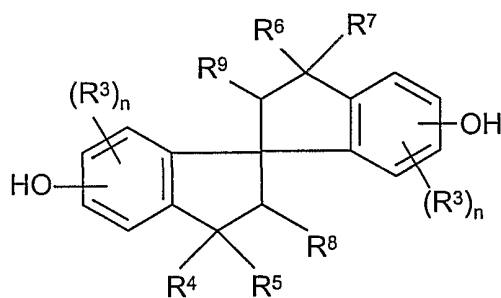
2,7-dihydroxy-9,10-dimethylphenazine;

5 3,6-dihydroxydibenzofuran;

3,6-dihydroxydibenzothiophene; and

2,7-dihydroxycarbazole.

29. The method of claim 26, wherein the dihydric phenols are spirobiindane compounds of the formula:



10 wherein each R^3 is independently selected from monovalent hydrocarbon radicals and halogen radicals; each R^4 , R^5 , R^6 , and R^7 is independently C_1 - C_6 alkyl; each R^8 and R^9 is independently H or C_1 - C_6 alkyl; and each n is independently selected from positive integers having a value of from 0 to 3, inclusive.

15 30. The method of claim 26, wherein the dihydric phenol compound is 6,6'-dihydroxy-3,3,3',3'-tetramethyl-1,1'-spirobiindane.

31. The method of claim 17, wherein the diaryloxy compound is diphenyl carbonate and the dihydric phenol compound is 2,2-bis(4-hydroxyphenyl)propane.

32. The method of claim 17, further comprising the use of one or more end capping monomers selected from the group consisting of phenol; *p*-tert-butylphenol;

p-cumylphenol; *p*-cumylphenolcarbonate; undecanoic acid; lauric acid; stearic acid; phenyl chloroformate; *t*-butyl phenyl chloroformate; *p*-cumyl chloroformate; chroman chloroformate; octyl phenyl; and nonyl phenyl chloroformate; or a mixture thereof