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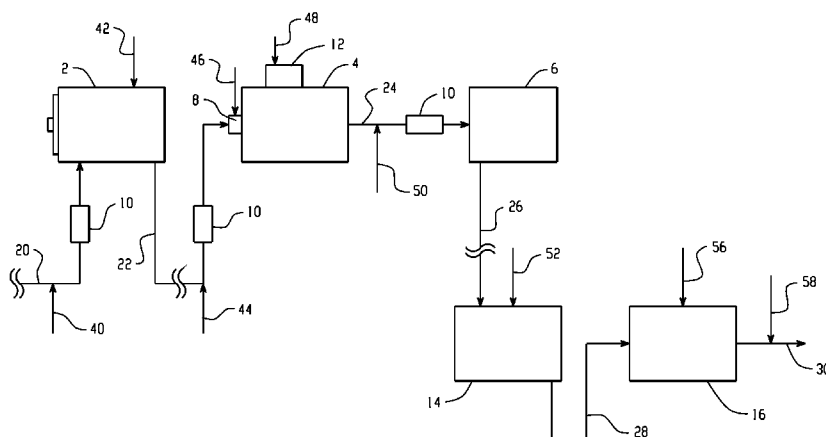
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(54) Title: MELT POLYMERIZATION POLYCARBONATE QUENCHING



(57) Abstract: In an embodiment, a melt polymerization process comprising: melt polymerizing reactants in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprising a catalyst; adding a quencher composition to the polycarbonate, wherein the quencher composition comprises a quencher; directing the polycarbonate to an extruder.

MELT POLYMERIZATION POLYCARBONATE QUENCHING

TECHNICAL FIELD

[0001] This application relates to quenching and quenchers in a melt polymerization processes.

BACKGROUND

[0002] In melt polymerization processes of polymerizing polycarbonate, a quencher can be added to reduce the activity of a melt catalyst.

[0003] EP 2 540 758 B1 is directed to a melt polymerization reactor system and method of producing polycarbonate using a late-addition catalyst formulation having a melt transesterification catalyst dispersed in a liquid carrier system which preferably includes less than 10 wt% water. The formulation also preferably includes a liquid carrier system having phenol and a cosolvent. The melt transesterification catalyst can be present in the formulation in a range of 50 ppm to 60,000 ppm

[0004] EP 0 955 768 A2 is directed to a process for the production of aromatic polycarbonate resin. Disclosed is the production of an aromatic polycarbonate resin “under the conditions that the flow velocity of the reaction mixture in a pipe through which a molten reaction mixture passes is a specific value or over, the viscosity-average molecular weight of the reaction mixture is 1,000 or over, the sum of the average retention times of the reaction mixture is no longer than 3 hours, the wall temperature of the pipe through which a molten reaction mixture passes is set to be higher than the temperature of the reaction mixture in the pipe, the catalyst deactivation agent is added within 2 hours after the completion of the melt polycondensation reaction, and the filtration is carried out by using a filter having a specific retained particle size under a specific pressure difference...”

[0005] JP 2003 335853 A is directed to an aromatic/aliphatic copolycarbonate resin composition manufactured by subjecting an aromatic carbonic diester, an aliphatic dihydroxy compound and an aromatic dihydroxy compound to melt polymerization in the presence of a catalyst to produce an aromatic/aliphatic copolycarbonate (A), and melting and kneading the copolycarbonate (A) with at least one other resin (B) in an extrusion step after the catalyst is deactivated.

[0006] Improved methods of adding the quencher are desired.

BRIEF DESCRIPTION

[0007] Disclosed herein are methods for adding a quencher.

[0008] In an embodiment: a melt polymerization process comprising: melt polymerizing reactants in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprising a catalyst; adding a quencher composition to the polycarbonate, wherein the quencher composition comprises a quencher; directing the polycarbonate to an extruder.

[0009] In an embodiment, a melt polymerization process comprises: melt polymerizing reactants in at least two polymerization units, in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises an alpha catalyst, wherein the alpha catalyst comprises a source of alkali and/or alkaline earth ions; combining a liquid carrier and a quencher in a quencher vessel to form a quencher composition; adding the quencher composition to the polycarbonate at a pressure of greater than or equal to 2 bars; mixing the quencher composition with the polycarbonate for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any additives having a reactive OH group or reactive ester group; filtering the polycarbonate; and directing the polycarbonate to an extruder.

[0010] In an embodiment, a melt polymerization process comprises: melt polymerizing reactants in at least two polymerization units, in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises an alpha catalyst, wherein the alpha catalyst comprises a source of alkali and/or alkaline earth ions; melting a quencher to form a quencher composition, wherein the quencher composition is free of a carrier; adding the quencher composition to the polycarbonate; filtering the polycarbonate; and directing the polycarbonate to an extruder.

[0011] In an embodiment, a melt polymerization process comprises: melt polymerizing reactants in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises only a beta catalyst, wherein the beta catalyst comprises a quaternary ammonium compound, a quaternary phosphonium compound, or a combination comprising at least one of the foregoing; adding a quencher composition to the polycarbonate, wherein the quencher composition comprises a quencher; and directing the polycarbonate to an extruder.

[0012] In an embodiment, a process of adding a solid quencher composition comprises: feeding a polycarbonate to an extruder; adding a quencher composition to the polycarbonate, wherein the quencher composition is a solid quencher composition; and mixing the quencher composition with the polycarbonate for a period of time of greater than

or equal to 5 seconds prior to the addition to the polycarbonate of any reactive additive, wherein the reactive additive has a reactive OH group or reactive ester group; wherein the polycarbonate is a melt polycarbonate.

[0013] The above described and other features are exemplified by the following figure and detailed description.

BRIEF DESCRIPTION OF THE DRAWINGS

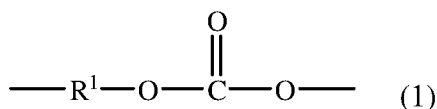
[0014] Refer now to the figures, which are exemplary embodiments, and wherein the like elements are numbered alike.

[0015] FIG. 1 illustrates a process of adding a quencher composition.

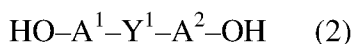
DETAILED DESCRIPTION

[0016] The Applicants developed an improved method of adding a quencher in a quencher composition in a liquid and/or a solid form into a melt polymerization process of polycarbonate.

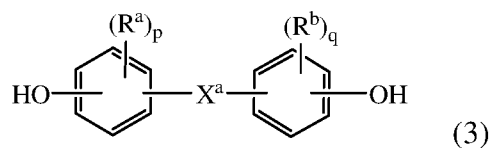
[0017] “Polycarbonate” as used herein means a polymer having repeating structural carbonate units of formula (1)



in which at least 60 percent of the total number of R^1 groups contain aromatic moieties and the balance thereof are aliphatic, alicyclic, or aromatic. Each R^1 can be a C_{6-30} aromatic group, that is, contains at least one aromatic moiety. R^1 can be derived from an aromatic dihydroxy compound of the formula $\text{HO-R}^1\text{-OH}$, in particular of formula (2)



wherein each of A^1 and A^2 is a monocyclic divalent aromatic group and Y^1 is a single bond or a bridging group having one or more atoms that separate A^1 from A^2 . One atom can separate A^1 from A^2 . Specifically, each R^1 can be derived from a bisphenol of formula (3)

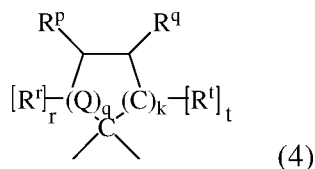


wherein R^a and R^b are each independently a halogen, C_{1-12} alkoxy, or C_{1-12} alkyl; and p and q are each independently integers of 0 to 4. It will be understood that when p or q is less than 4, the valence of each carbon of the ring is filled by hydrogen. Also in formula (3), X^a is a bridging group connecting the two hydroxy-substituted aromatic groups, where the bridging group and the hydroxy substituent of each C_6 arylene group are disposed ortho, meta, or para

(specifically para) to each other on the C₆ arylene group. The bridging group X^a can be a single bond, -O-, -S-, -S(O)-, -S(O)₂-, -C(O)-, or a C₁₋₁₈ organic group. The C₁₋₁₈ organic bridging group can be cyclic or acyclic, aromatic or non-aromatic, and can further comprise heteroatoms such as halogens, oxygen, nitrogen, sulfur, silicon, or phosphorous. The C₁₋₁₈ organic group can be disposed such that the C₆ arylene groups connected thereto are each connected to a common alkylidene carbon or to different carbons of the C₁₋₁₈ organic bridging group. Each p and q can be 1, and R^a and R^b can each be a C₁₋₃ alkyl group, specifically methyl, disposed meta to the hydroxy group on each arylene group.

[0018] X^a can be a substituted or unsubstituted C₃₋₁₈ cycloalkylidene, a C₁₋₂₅ alkylidene of formula -C(R^c)(R^d)- wherein R^c and R^d are each independently hydrogen, C₁₋₁₂ alkyl, C₁₋₁₂ cycloalkyl, C₇₋₁₂ arylalkyl, C₁₋₁₂ heteroalkyl, or cyclic C₇₋₁₂ heteroarylalkyl, or a group of the formula -C(=R^e)- wherein R^e is a divalent C₁₋₁₂ hydrocarbon group. Groups of this type include methylene, cyclohexylmethylene, ethylidene, neopentylidene, and isopropylidene, as well as 2-[2.2.1]-bicycloheptylidene, cyclohexylidene, cyclopentylidene, cyclododecylidene, and adamantylidene.

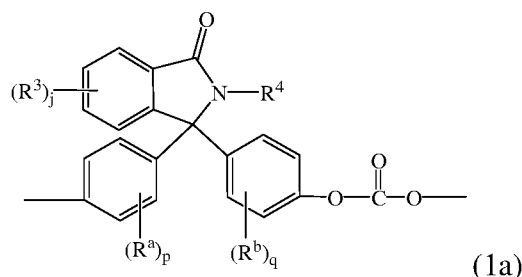
[0019] X^a can be a C₁₋₁₈ alkylene, a C₃₋₁₈ cycloalkylene, a fused C₆₋₁₈ cycloalkylene, or a group of the formula -B¹-G-B²- wherein B¹ and B² are the same or different C₁₋₆ alkylene and G is a C₃₋₁₂ cycloalkylidene or a C₆₋₁₆ arylene. For example, X^a can be a substituted C₃₋₁₈ cycloalkylidene of formula (4)



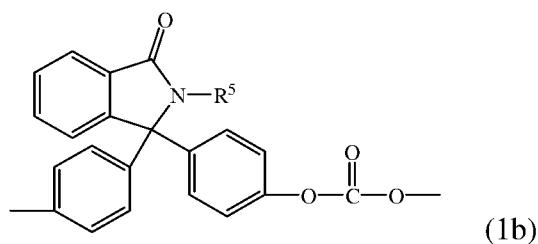
wherein R^r, R^p, R^q, and R^t are each independently hydrogen, halogen, oxygen, or C₁₋₁₂ hydrocarbon groups; Q is a direct bond, a carbon, or a divalent oxygen, sulfur, or -N(Z)- where Z is hydrogen, halogen, hydroxy, C₁₋₁₂ alkyl, C₁₋₁₂ alkoxy, or C₁₋₁₂ acyl; r is 0 to 2, t is 1 or 2, q is 0 or 1, and k is 0 to 3, with the proviso that at least two of R^r, R^p, R^q, and R^t taken together are a fused cycloaliphatic, aromatic, or heteroaromatic ring. It will be understood that where the fused ring is aromatic, the ring as shown in formula (4) will have an unsaturated carbon-carbon linkage where the ring is fused. When k is one and i is 0, the ring as shown in formula (4) contains 4 carbon atoms, when k is 2, the ring as shown in formula (4) contains 5 carbon atoms, and when k is 3, the ring contains 6 carbon atoms. Two adjacent groups (e.g., R^q and R^t taken together) can form an aromatic group, and R^q and R^t taken together can form one aromatic group and R^r and R^p taken together can form a second

aromatic group. When R^q and R^t taken together form an aromatic group, R^p can be a double-bonded oxygen atom, i.e., a ketone.

[0020] Bisphenols wherein X^a is a cycloalkylidene of formula (4) can be used in the manufacture of polycarbonates containing phthalimidine carbonate units of formula (1a)

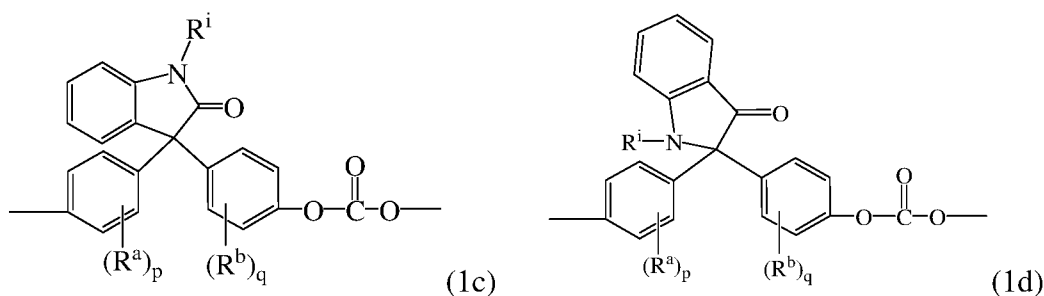


wherein R^a , R^b , p , and q are as in formula (3), R^3 is each independently a C_{1-6} alkyl, j is 0 to 4, and R^4 is hydrogen, C_{1-6} alkyl, or a substituted or unsubstituted phenyl, for example a phenyl substituted with up to five C_{1-6} alkyls. For example, the phthalimidine carbonate units are of formula (1b)



wherein R^5 is hydrogen, phenyl optionally substituted with up to five C_{1-6} alkyls, or C_{1-4} alkyl. In formula (1b), R^5 can be hydrogen, methyl, or phenyl, specifically phenyl. Carbonate units (1b) wherein R^5 is phenyl can be derived from 2-phenyl-3,3'-bis(4-hydroxyphenyl)phthalimidine (also known as 3,3-bis(4-hydroxyphenyl)-2-phenylisoindolin-1-one, or N-phenyl phenolphthalein bisphenol ("PPPBP")).

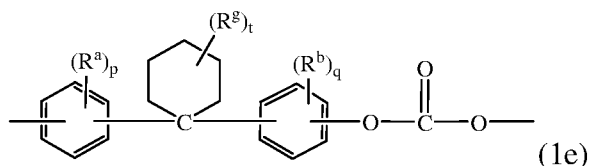
[0021] Other bisphenol carbonate repeating units of this type are the isatin carbonate units of formula (1c) and (1d)



wherein R^a and R^b are each independently C_{1-12} alkyl, p and q are each independently 0 to 4, and R^i is C_{1-12} alkyl, phenyl, optionally substituted with 1 to 5 C_{1-10} alkyl, or benzyl

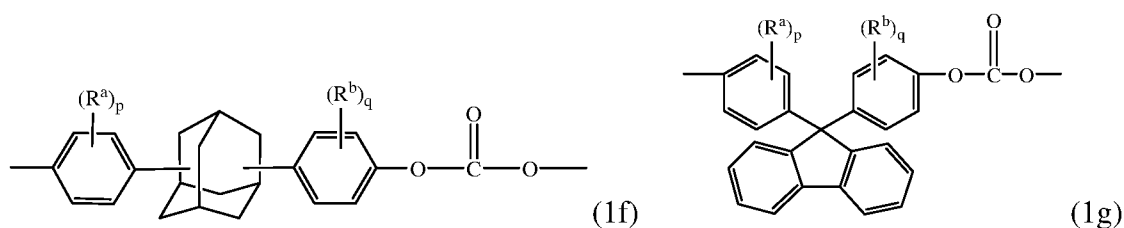
optionally substituted with 1 to 5 C₁₋₁₀ alkyl. Each R^a and R^b can be methyl, p and q can each independently be 0 or 1, and Rⁱ is C₁₋₄ alkyl or phenyl.

[0022] Other examples of bisphenol carbonate units derived from bisphenols (3) wherein X^a is a substituted or unsubstituted C₃₋₁₈ cycloalkylidene (4) include the cyclohexylidene-bridged, alkyl-substituted bisphenol of formula (1e)



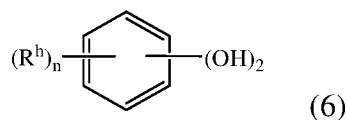
wherein R^a and R^b are each independently C₁₋₁₂ alkyl, R^g is C₁₋₁₂ alkyl, p and q are each independently 0 to 4, and t is 0 to 10. At least one of each of R^a and R^b can be disposed meta to the cyclohexylidene bridging group. Each R^a and R^b can independently be C₁₋₄ alkyl, R^g is C₁₋₄ alkyl, p and q are each 0 or 1, and t is 0 to 5. R^a, R^b, and R^g can each be methyl, p and q can each be 0 or 1, and t can be 0 or 3, specifically 0.

[0023] Examples of other bisphenol carbonate units derived from bisphenol (3) wherein X^a is a substituted or unsubstituted C₃₋₁₈ cycloalkylidene include adamantyl units of formula (1f) and fluorenyl units of formula (1g)



wherein R^a and R^b are each independently C₁₋₁₂ alkyl, and p and q are each independently 1 to 4. At least one of each of R^a and R^b can be disposed meta to the cycloalkylidene bridging group. R^a and R^b can each be independently C₁₋₃ alkyl, and p and q can be each 0 or 1; specifically, R^a, R^b can each be methyl, p and q are each 0 or 1, and when p and q are 1, the methyl group can be disposed meta to the cycloalkylidene bridging group. Carbonates containing units (1a) to (1g) are useful for making polycarbonates with high glass transition temperatures (T_g) and high heat distortion temperatures.

[0024] Other useful dihydroxy compounds of the formula HO-R¹-OH include aromatic dihydroxy compounds of formula (6)



wherein each R^h is independently a halogen atom, C₁₋₁₀ hydrocarbyl group such as a C₁₋₁₀ alkyl, a halogen-substituted C₁₋₁₀ alkyl, a C₆₋₁₀ aryl, or a halogen-substituted C₆₋₁₀ aryl, and n is 0 to 4. The halogen is usually bromine.

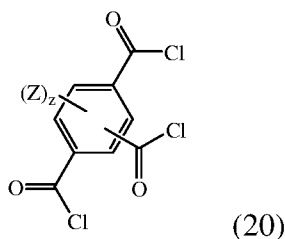
[0025] Some illustrative examples of specific dihydroxy compounds include the following: 4,4'-dihydroxybiphenyl, 1,6-dihydroxynaphthalene, 2,6-dihydroxynaphthalene, bis(4-hydroxyphenyl)methane, bis(4-hydroxyphenyl)diphenylmethane, bis(4-hydroxyphenyl)-1-naphthylmethane, 1,2-bis(4-hydroxyphenyl)ethane, 1,1-bis(4-hydroxyphenyl)-1-phenylethane, 2-(4-hydroxyphenyl)-2-(3-hydroxyphenyl)propane, bis(4-hydroxyphenyl)phenylmethane, 2,2-bis(4-hydroxy-3-bromophenyl)propane, 1,1-bis(hydroxyphenyl)cyclopentane, 1,1-bis(4-hydroxyphenyl)cyclohexane, 1,1-bis(4-hydroxyphenyl)isobutene, 1,1-bis(4-hydroxyphenyl)cyclododecane, trans-2,3-bis(4-hydroxyphenyl)-2-butene, 2,2-bis(4-hydroxyphenyl)adamantane, alpha, alpha'-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, 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, 2,2-bis(3-methoxy-4-hydroxyphenyl)propane, 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, 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, bis(4-hydroxyphenyl)sulfoxide, bis(4-hydroxyphenyl)sulfone, 9,9-bis(4-hydroxyphenyl)fluorine, 2,7-dihydroxypyrene, 6,6'-dihydroxy-3,3,3',3'-tetramethylspiro(bis)indane ("spirobiindane bisphenol"), 3,3-bis(4-hydroxyphenyl)phthalimide, 2,6-dihydroxydibenzo-p-dioxin, 2,6-dihydroxythianthrene, 2,7-dihydroxyphenoxathin, 2,7-dihydroxy-9,10-dimethylphenazine, 3,6-dihydroxydibenzofuran, 3,6-dihydroxydibenzothiophene, and 2,7-dihydroxycarbazole, resorcinol, substituted resorcinol compounds such as 5-methyl resorcinol, 5-ethyl resorcinol, 5-propyl resorcinol, 5-butyl resorcinol, 5-t-butyl resorcinol, 5-phenyl resorcinol, 5-cumyl resorcinol, 2,4,5,6-tetrafluoro resorcinol, 2,4,5,6-tetrabromo resorcinol, or the like; catechol; hydroquinone; substituted hydroquinones such as 2-methyl hydroquinone, 2-ethyl hydroquinone, 2-propyl hydroquinone, 2-butyl hydroquinone, 2-t-butyl hydroquinone, 2-phenyl hydroquinone, 2-cumyl hydroquinone, 2,3,5,6-tetramethyl hydroquinone, 2,3,5,6-

tetra-*t*-butyl hydroquinone, 2,3,5,6-tetrafluoro hydroquinone, 2,3,5,6-tetrabromo hydroquinone, or the like, or combinations comprising at least one of the foregoing dihydroxy compounds.

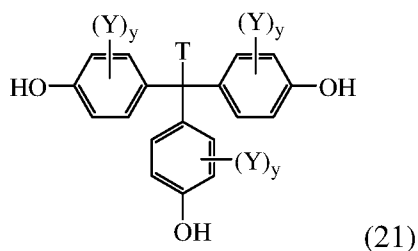
[0026] Specific examples of bisphenol compounds of formula (3) include 1,1-bis(4-hydroxyphenyl) methane, 1,1-bis(4-hydroxyphenyl) ethane, 2,2-bis(4-hydroxyphenyl) propane (hereinafter “bisphenol A” or “BPA”), 2,2-bis(4-hydroxyphenyl) butane, 2,2-bis(4-hydroxyphenyl) octane, 1,1-bis(4-hydroxyphenyl) propane, 1,1-bis(4-hydroxyphenyl) *n*-butane, 2,2-bis(4-hydroxy-2-methylphenyl) propane, 1,1-bis(4-hydroxy-*t*-butylphenyl) propane, 3,3-bis(4-hydroxyphenyl) phthalimidine, 2-phenyl-3,3-bis(4-hydroxyphenyl) phthalimidine (PPPBP), and 1,1-bis(4-hydroxy-3-methylphenyl)cyclohexane (DMBPC). Combinations comprising at least one of the foregoing dihydroxy compounds can also be used. The polycarbonate can be a linear homopolymer derived from bisphenol A, in which each of A¹ and A² is *p*-phenylene and Y¹ is isopropylidene in formula (3).

[0027] The polycarbonate herein is prepared via the melt polymerization of a bisphenol and a carbonate precursor. Exemplary carbonate precursors include a carbonyl halide such as carbonyl bromide or carbonyl chloride (phosgene) a bis(halo)formate of a dihydroxy compound (e.g., the bis(chloro)formate of bisphenol A, hydroquinone ethylene glycol, neopentyl glycol, or the like), and diaryl carbonates. Combinations comprising at least one of the foregoing types of carbonate precursors can also be used. The diaryl carbonate ester can be diphenyl carbonate, or an activated diphenyl carbonate having electron-withdrawing substituents on each aryl, such as bis(4-nitrophenyl)carbonate, bis(2-chlorophenyl)carbonate, bis(4-chlorophenyl)carbonate, bis(methyl salicyl)carbonate, bis(4-methylcarboxylphenyl) carbonate, bis(2-acetylphenyl) carboxylate, bis(4-acetylphenyl) carboxylate, or a combination comprising at least one of the foregoing.

[0028] The present polymerization can occur in the presence of a branching agent. Examples of branching agents include polyfunctional organic compounds containing at least three functional groups selected from hydroxyl, carboxyl, carboxylic anhydride, haloformyl, and mixtures of the foregoing functional groups. Such branching agents include aromatic triacyl halides, for example triacyl chlorides of formula (20)

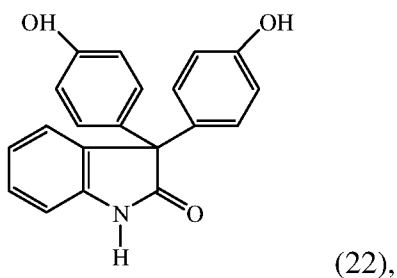


wherein Z is a halogen, C₁₋₃ alkyl, C₁₋₃ alkoxy, C₇₋₁₂ arylalkylene, C₇₋₁₂ alkylarylene, or nitro, and z is 0 to 3; a tri-substituted phenol of formula (21)



wherein T is a C₁₋₂₀ alkyl, C₁₋₂₀ alkoxy, C₇₋₁₂ arylalkyl, or C₇₋₁₂ alkylaryl, Y is a halogen, C₁₋₃ alkyl, C₁₋₃ alkoxy, C₇₋₁₂ arylalkyl, C₇₋₁₂ alkylaryl, or nitro, s is 0 to 4.

[0029] Specific examples of branching agents include trimellitic acid, trimellitic anhydride, trimellitic trichloride, tris-p-hydroxyphenylethane, isatin-bis-phenol of formula (22)



tris-phenol TC (1,3,5-tris((p-hydroxyphenyl)isopropyl)benzene), tris-phenol PA (4(4(1,1-bis(p-hydroxyphenyl)-ethyl) alpha, alpha-dimethyl benzyl)phenol), 4-chloroformyl phthalic anhydride, trimesic acid, and benzophenone tetracarboxylic acid.

[0030] In the melt polymerization process, the polycarbonate can be prepared by co-reacting, in a molten state, a dihydroxy reactant and a carbonate precursor in the presence of a transesterification catalyst. The reaction can be carried out in typical polymerization equipment, such as a continuously stirred reactor (CSTR), plug flow reactor, wire wetting fall polymerizers, free fall polymerizers, horizontal polymerizers, wiped film polymerizers, BANBURY mixers, single or twin screw extruders, or a combination comprising one or more of the foregoing. Volatile monohydric phenol is removed from the molten reactants by distillation and the polymer is isolated as a molten residue. Melt polymerization can be conducted as a batch process or as a continuous process. In either case, the melt polymerization conditions used can comprise two or more distinct reaction stages. For example, the polymerization can comprise an oligomerization stage in which the starting dihydroxy aromatic compound and diaryl carbonate are converted into an oligomeric polycarbonate and a second reaction stage also referred to a polymerization stage wherein the

oligomeric polycarbonate formed in the oligomerization stage is converted to high molecular weight polycarbonate. The oligomerization stage can comprise 1 or more, specifically, 2 or more, more specifically, 2 to 4 oligomerization units (for example 2 to 4 continuously stirred tanks). When 2 or more oligomerization units are present in series, one or both of an increase in temperature or a decrease in pressure can occur from one unit to the next. The polymerization stage can comprise 1 or more, specifically, 2 or more, more specifically, 2 polymerization units (for example 2 horizontal or wire wetting fall polymerizers). The polymerization stage can comprise one or more polymerization units that can polymerize the polycarbonate to a molecular weight of, for example, 20,000 to 50,000 Daltons. After formation of a polycarbonate, the polycarbonate composition can then be optionally quenched and devolatilized in a devolatilization unit, where the molecular weight of the polycarbonate does not significantly increase (for example, the molecular weight does not increase by greater than 10 weight percent (wt%)) and a temperature, a pressure, and a residence time are used to reduce the concentration of low molecular weight components (such as those with a molecular weight of less than 1,000 Daltons). The oligomerization unit is herein defined as a oligomerization unit that results in polycarbonates oligomers with a number average molecular weight of less than or equal to 8,000 Daltons and a polymerization unit is herein defined as a polymerization unit that produces polycarbonate with a number average molecular weight of greater than 8,000 Daltons. It is noted that while less than or equal to 8,000 Daltons is used here to define a molecular weight achieved in the oligomerization stage, one skilled in the art readily understands that said molecular weight is used to define an oligomerization stage, where the oligomer molecular weight could be greater than 8,000 Daltons. A "staged" polymerization reaction condition can be used in continuous polymerization systems, wherein the starting monomers are oligomerized in a first reaction vessel and the oligomeric polycarbonate formed therein is continuously transferred to one or more downstream reactors in which the oligomeric polycarbonate is converted to high molecular weight polycarbonate. Typically, in the oligomerization stage the oligomeric polycarbonate produced has a number average molecular weight of 1,000 to 7,500 Daltons. In one or more subsequent polymerization stages the number average molecular weight (M_n) of the polycarbonate can be increased to, for example, 8,000 and 25,000 Daltons (using polycarbonate standard), specifically, 13,000 to 18,000 Daltons.

[0031] Typically, solvents are not used in the process, and the reactants dihydroxy aromatic compound and the diaryl carbonate are in a molten state. The reaction temperature

can be 100 to 350 degrees Celsius (°C), specifically, 180 to 310°C. The pressure can be at atmospheric pressure, supra-atmospheric pressure, or a range of pressures from atmospheric pressure to 15 torr in the initial stages of the reaction, and at a reduced pressure at later stages, for example, 0.2 to 15 torr. Likewise, the polymerization can occur in a series of polymerization vessels that can each individually have increasing temperature and/or vacuum. For example, an oligomerization stage can occur at a temperature of 100 to 280°C, specifically, 140 to 240°C and a polymerization stage can occur at a temperature of 240 to 350°C, specifically, 280 to 300°C or 240 to 270°C or 250 to 310°C, where the temperature in the polymerization stage is greater than the temperature in the oligomerization stage. The reaction time from the initial oligomerization unit to the final polymerization unit is generally 0.1 to 15 hours. A final polymerization unit as used herein refers to a final polymerization unit in the melt polymerization where the last increase in molecular weight occurs. For example, the quenching agent can be added to the polycarbonate resin after a final polymerization (e.g., after a point where the weight average molecular weight (Mw) of the polycarbonate will increase by less than or equal to 10%), and optionally, before any melt filtering.

[0032] Likewise, an oligomerization can occur at a pressure of greater than or equal to 100 millibars absolute (mbara) or the oligomerization can comprise at least two oligomerization units where a first oligomerization unit can have a pressure of greater than or equal to 100 mbara and a second oligomerization can have a pressure of 15 to 90 mbara, where the first oligomerization unit is upstream of the second oligomerization unit, where one or more oligomerization units can be located before, in between, or after said polymerization units.

[0033] The polymerization stage following the oligomerization stage can comprise polymerizing in one or two polymerization units. The first polymerization unit can be at a temperature of 240 to 350°C, specifically, 260 to 310°C and a pressure of 1 to 10 mbar. The second polymerization unit can be at a temperature of 240 to 350°C, specifically, 260 to 300°C and a pressure of less than or equal to 5 mbar. The polycarbonate can be devolatilized after a final polymerization.

[0034] After a final polymerization vessel (also referred to as a final polymerization unit), the polymer can be introduced to a reactor, extruded, subjected to filtration in a melt filter, or a combination comprising one or more of the foregoing. It is noted that the melt filter can be located before or after the extruder. For example, the melt polymerization

process for the manufacture of a polycarbonate composition can comprise: melt polymerizing a dihydroxy reactant and a carbonate compound to produce a molten reaction product; quenching the molten reaction product; filtering the molten reaction product in a melt filter upstream of any extruders; optionally, introducing an additive to form a mixture; and extruding the mixture to form the polycarbonate composition. Likewise, the melt polymerization process for the manufacture of a polycarbonate composition can comprise: melt polymerizing a dihydroxy reactant and a carbonate compound to produce a molten reaction product; introducing a quencher composition and optionally an additive for form a mixture; and extruding the mixture to form the polycarbonate composition.

[0035] Catalysts used in the melt transesterification polymerization production of polycarbonates can include alpha and/or beta catalysts. Beta catalysts are transesterification catalysts that are typically volatile and degrade at elevated temperatures. Beta catalysts can therefore be used at early low-temperature polymerization stages (e.g., during oligomerization). Alpha catalysts are transesterification catalysts that are typically more thermally stable and less volatile than beta catalysts, and therefore can be used throughout transesterification, including during oligomerization, and after oligomerization, e.g., in the polymerization vessels, during polymerization.

[0036] The alpha catalyst can comprise a source of alkali and/or alkaline earth ions, e.g., is a catalyst that provides a source of alkali and/or alkaline earth ions. The sources of these ions include alkali metal hydroxides such as lithium hydroxide, sodium hydroxide, and potassium hydroxide, as well as alkaline earth hydroxides such as magnesium hydroxide and calcium hydroxide. Other possible sources of alkali and alkaline earth metal ions include the corresponding salts of carboxylic acids (such as sodium acetate) and derivatives of ethylene diamine tetraacetic acid (EDTA) (such as EDTA tetrasodium salt, and EDTA magnesium disodium salt). Other alpha transesterification catalysts include alkali or alkaline earth metal salts of carbonate, such as Cs_2CO_3 , NaHCO_3 , and Na_2CO_3 , and the like, non-volatile inorganic acid such as NaH_2PO_3 , NaH_2PO_4 , Na_2HPO_3 , KH_2PO_4 , CsH_2PO_4 , Cs_2HPO_4 , and the like, or mixed salts of phosphoric acid, such as NaKHPO_4 , CsNaHPO_4 , CsKHPO_4 , and the like. Combinations comprising at least one of any of the foregoing catalysts can be used.

[0037] Possible beta catalysts can comprise a quaternary ammonium compound, a quaternary phosphonium compound, or a combination comprising at least one of the foregoing. The quaternary ammonium compound can be a compound of the structure $(\text{R}^4)_4\text{N}^+\text{X}^-$, wherein each R^4 is the same or different, and is a C_{1-20} alkyl, a C_{4-20} cycloalkyl, or

a C₄₋₂₀ aryl; and X⁻ is an organic or inorganic anion, for example a hydroxide, halide, carboxylate, sulfonate, sulfate, formate, carbonate, or bicarbonate. Examples of organic quaternary ammonium compounds include tetramethyl ammonium hydroxide, tetrabutyl ammonium hydroxide, tetramethyl ammonium acetate, tetramethyl ammonium formate, tetrabutyl ammonium acetate, and combinations comprising at least one of the foregoing. Tetramethyl ammonium hydroxide is often used. The quaternary phosphonium compound can be a compound of the structure (R⁵)₄P⁺X⁻, wherein each R⁵ is the same or different, and is a C₁₋₂₀ alkyl, a C₄₋₂₀ cycloalkyl, or a C₄₋₂₀ aryl; and X⁻ is an organic or inorganic anion, for example a hydroxide, phenoxide, halide, carboxylate such as acetate or formate, sulfonate, sulfate, formate, carbonate, or bicarbonate. Where X⁻ is a polyvalent anion such as carbonate or sulfate it is understood that the positive and negative charges in the quaternary ammonium and phosphonium structures are properly balanced. For example, where R²⁰ to R²³ are each methyls and X⁻ is carbonate, it is understood that X⁻ represents 2(CO₃⁻²). Examples of organic quaternary phosphonium compounds include tetramethyl phosphonium hydroxide, tetramethyl phosphonium acetate, tetramethyl phosphonium formate, tetrabutyl phosphonium hydroxide, tetrabutyl phosphonium acetate (TBPA), tetraphenyl phosphonium acetate (TPPA), tetraphenyl phosphonium phenoxide (TPPP), and combinations comprising at least one of the foregoing. The catalyst can comprise TBPA. The catalyst can comprise TPPP.

[0038] The amount of alpha and beta catalyst used can be based upon the total number of moles of dihydroxy compound used in the polymerization reaction. When referring to the ratio of beta catalyst, for example, a phosphonium salt, to all dihydroxy compounds used in the polymerization reaction, it is convenient to refer to moles of catalyst per mole of the dihydroxy compound, meaning the number of moles of catalyst divided by the sum of the moles of each individual dihydroxy compound present in the reaction mixture. The transesterification catalyst can be used in an amount sufficient to provide 1 x 10⁻⁸ to 1 x 10⁻⁵, specifically, 1 x 10⁻⁷ to 8 x 10⁻⁶, more specifically, 3 x 10⁻⁷ to 2 x 10⁻⁶ moles of catalyst per mole of aromatic dihydroxy compound used. The alpha catalyst can be used in an amount sufficient to provide 1 x 10⁻² to 1 x 10⁻⁸ moles, specifically, 1 x 10⁻⁴ to 1 x 10⁻⁷ moles of metal per mole of the dihydroxy compound used. The amount of beta catalyst (e.g., organic ammonium or phosphonium salts) can be 1 x 10⁻² to 1 x 10⁻⁵, specifically 1 x 10⁻³ to 1 x 10⁻⁴ moles per total mole of the dihydroxy compound in the reaction mixture. The amount of alpha catalyst can be less than the amount of beta catalyst added to the polymerization. Quenching of the transesterification catalysts and any reactive catalyst residues with an acidic

compound after polymerization is completed can also be useful in some melt polymerization processes. Removal of catalyst residues and/or quenching agent and other volatile residues from the melt polymerization reaction after polymerization can also be useful in some melt polymerization processes.

[0039] The polycarbonate can be, for example, a bisphenol A polycarbonate with a weight average molecular weight of 21800 Daltons with a melt flow of 24 to 32 g/10 min (ASTM D1238, 300°C, 2.16 kg).

[0040] The polycarbonate can have a melt flow of 4 to 40 g/10 min, for example, 4.5 to 15 g/10 min or 15 to 35 g/10 min as determined by ASTM D1238 at 300°C, 1.5 kg. The polycarbonate can have a melt flow of 5 to 15 g/10 min as determined by ASTM D1238 at 250°C, 1.5 kg.

[0041] A quencher composition can be added at one or more locations in the present melt preparation of the polycarbonate to reduce the activity of the catalyst, e.g., to reduce or suppress the activity of the alpha catalyst. The quencher composition comprises a quenching agent (also referred to herein as a quencher). For example, the quenching agent can comprise a sulfonic acid ester such as an alkyl sulfonic ester of the formula $R_1SO_3R_2$ wherein R_1 is hydrogen, C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl, and R_2 is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl. Examples of alkyl sulfonic esters include benzenesulfonate, p-toluenesulfonate, methylbenzene sulfonate, ethylbenzene sulfonate, n-butyl benzenesulfonate, octyl benzenesulfonate and phenyl benzenesulfonate, methyl p-toluenesulfonate, ethyl p-toluenesulfonate, n-butyl p-toluene sulfonate, octyl p-toluenesulfonate and phenyl p-toluenesulfonate. The sulfonic acid ester can comprise alkyl tosylates such as n-butyl tosylate. The sulfonic acid ester can be present in the quencher composition in an amount of 0.1 to 10 volume percent (vol%), specifically, 0.1 to 5 vol%, more specifically, 0.5 to 2 vol% based on the total volume of the quencher composition.

[0042] The quenching agent can comprise boric acid esters (e.g., $B(OCH_3)_3$, $B(OCH_2CH_3)_3$, and $B(OC_6H_5)_3$), zinc borate, boron phosphate, aluminum stearate, aluminum silicate, zirconium carbonate, zirconium C_1 - C_{12} alkoxides, zirconium hydroxycarboxylates, gallium phosphide, gallium antimonide, germanium oxide, C_1 - C_{32} organogermanium compounds, C_4 - C_{32} tetraorganotin tin compound, C_6 - C_{32} hexaorganotin compound (e.g., $[(C_6H_5O)Sn(CH_2CH_2CH_2CH_3)_2]_2O$), Sb_2O_3 , antimony oxide, C_1 - C_{32} alkylantimony, bismuth oxide, C_1 - C_{12} alkylbismuth, zinc acetate, zinc stearate, C_1 - C_{32} alkoxytitanium, and titanium oxide, phosphoric acid, phosphorous acid, hypophosphorous acid, pyrophosphoric acid,

polyphosphoric acid, boric acid, hydrochloric acid, hydrobromic acid, sulfuric acid, sulfurous acid, adipic acid, azelaic acid, dodecanoic acid, L-ascorbic acid, aspartic acid, benzoic acid, formic acid, acetic acid, citric acid, glutamic acid, salicylic acid, nicotinic acid, fumaric acid, maleic acid, oxalic acid, benzenesulfonic acid, C₁-C₁₂ dialkyl sulfates (e.g., dimethyl sulfate and dibutyl sulfate), sulfonic acid phosphonium salts of the formula (R^aSO₃⁻)(PR^b₄)⁺ wherein R^a is hydrogen, C₁-C₁₂ alkyl, C₆-C₁₈ aryl, or C₇-C₁₉ alkylaryl, and each R^b is independently hydrogen, C₁-C₁₂ alkyl or C₆-C₁₈ aryl, sulfonic acid derivatives of the formula A¹-(Y¹-SO₃X¹)_m wherein A¹ is a C₁-C₄₀ hydrocarbon group having a valence of m, Y¹ is a single bond or an oxygen atom, X¹ is a secondary or tertiary alkyl group of the formula -CR¹⁵R¹⁶R¹⁷, a metal cation of one equivalent, an ammonium cation (e.g., NR^b₃⁺ wherein each R^b is independently hydrogen, C₁-C₁₂ alkyl or C₆-C₁₈ aryl), or a phosphonium (e.g., PR^b₄⁺ wherein each R^b is independently hydrogen, C₁-C₁₂ alkyl or C₆-C₁₈ aryl) wherein R¹⁵ is a hydrogen atom or an alkyl group having 1 to 5 carbon atoms, R¹⁶ is a hydrogen atom, a phenyl group or an alkyl group having 1 to 5 carbon atoms, and R¹⁷ is the same as or different from R¹⁵ and has the same definition as R¹⁵, provided that two of R¹⁵, R¹⁶, and R¹⁷ cannot be hydrogen atoms, and m is an integer of 1 to 4, provided that when Y¹ is a single bond, all of X¹ in an amount of m cannot be metal cations of one equivalent, a compound of the formula ⁺X²-A²-Y¹-SO₃⁻ wherein A² is a divalent hydrocarbon group, ⁺X² is a secondary, tertiary or quaternary ammonium cation or a secondary (e.g., , tertiary or quaternary phosphonium cation, and Y¹ is a single bond or an oxygen atom, a compound of the formula A³-(⁺X³)_n·(R-Y¹-SO₃⁻)_n wherein A³ is a C₁-C₄₀ hydrocarbon group having a valence of n, ⁺X³ is a secondary, tertiary or quaternary ammonium cation (e.g., NR^b₃⁺ wherein each R^b is independently hydrogen, C₁-C₁₂ alkyl or C₆-C₁₈ aryl), or a secondary, tertiary or quaternary phosphonium cation (e.g., PR^b₄⁺ wherein each R^b is independently hydrogen, C₁-C₁₂ alkyl or C₆-C₁₈ aryl), R is a monovalent C₁-C₄₀ hydrocarbon group, n is an integer of 2 to 4, and Y¹ is a single bond or an oxygen atom, a compound of the formula A⁵-Ad¹-A⁴-(Ad²-A⁵)_ℓ wherein A⁵ is a monovalent or divalent C₁-C₄₀ hydrocarbon group, A⁴ is a divalent C₁-C₄₀ hydrocarbon group, each of Ad¹ and Ad² is independently an acid anhydride group selected from -SO₂-O-SO₂-, -SO₂-O-CO-, and -CO-O-SO₂-, and ℓ is 0 or 1, provided that when ℓ is 0, -(Ad²-A⁵)_ℓ is a hydrogen atom or a bond between A⁴ and A⁵, in which A⁵ is a divalent hydrocarbon group or a single bond, aminosulfonic esters having the formula R_aR_bN-A-SO₃R_c, wherein R_a and R_b are each independently hydrogen, C₁-C₁₂ alkyl, C₆-C₂₂ aryl, C₇-C₁₉ alkylaryl, or R_a and R_b, either singly or in combination, form an aromatic or non-aromatic

heterocyclic compound with N (e.g., pyrrolyl, pyridinyl, pyrimidyl, pyrazinyl, carbazolyl, quinolinyl, imidazolyl, piperazinyl, oxazolyl, thiazolyl, pyrazolyl, pyrrolinyl, indolyl, purinyl, pyrrolydinyl, or the like), R_c is hydrogen, and A is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_{17} - C_{19} alkylaryl (e.g., compounds such as N-(2-hydroxyethyl) piperazine-N'-3-propanesulfonic acid, 1,4,-piperazinebis (ethanesulfonic acid), and 5-dimethylamino-1-naphthalenesulfonic acid), ammonium sulfonic esters of the formula $R_aR_bR_cN^+—A—SO_3^-$, wherein R_a , R_b , are each independently hydrogen, C_1 - C_{12} alkyl, C_1 - C_{12} aryl, C_7 - C_{19} alkylaryl, or R_a and R_b , either singly or in combination, form an aromatic or non-aromatic heterocyclic compound with N (e.g., pyrrolyl, pyridinyl, pyrimidyl, pyrazinyl, carbazolyl, quinolinyl, imidazolyl, piperazinyl, oxazolyl, thiazolyl, pyrazolyl, pyrrolinyl, indolyl, purinyl, pyrrolydinyl, or the like), R_c is a hydrogen, and A is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl, sulfonated polystyrene, methyl acrylate-sulfonated styrene copolymer, and combinations comprising at least one of the foregoing.

[0043] The quencher composition can be added in a solid or liquid form. When in the liquid form, the quencher composition can be added, for example, via an addition system. The addition system can comprise a first drum; a buffer drum; a dosing pump; a filter; an injector or a combination comprising one or more of the foregoing, where one or both of the first drum and the buffer drum can comprise an agitator and/or a heating system. For example, the quencher and a liquid carrier can be added to the first drum and then added to a buffer drum. From the buffer drum, the liquid quencher composition can be injected to the polymerization system via an injector located in one or more of a polymerization unit, a reactor, a transfer line, a mixer, and an extruder. The pumping of the quencher composition to a dosing pump can be controlled by a main distribution loop, where the addition of the quencher composition can be monitored with a flow meter, either continuously or intermittently. The pumping can further comprise a controller for automated monitoring of the flow meter and adjustment of the amount of the quencher composition to the polymerization unit. The liquid quencher composition can be added to the polycarbonate at a pressure of greater than or equal to 2 bars, specifically, greater than or equal to 3 bars, more specifically, 3 to 100 bar. The liquid quencher composition can likewise be added by spraying the liquid onto a solid polycarbonate substrate. The liquid quencher composition can be filtered before it is added to the polymerization system.

[0044] When in the solid form, the quencher composition can comprise a quencher and, optionally, a solid carrier, for example, a polycarbonate powder, where the

polycarbonate powder can comprise, for example, a melt polycarbonate as herein described in a powder form and/or an interfacial polycarbonate. When in the solid form, the solid quencher composition can be added only directly to and/or downstream of an extruder, for example, in a masterbatch or by spraying onto a solid polycarbonate substrate. Likewise, the solid quencher composition can be added via a feeder, for example, a screw feeder. Specifically, a process for adding a solid quencher composition can comprise pelletizing a melt polycarbonate to form a polycarbonate; feeding the polycarbonate to an extruder; adding a solid quencher composition to the polycarbonate; and mixing the quencher composition with the polycarbonate for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any reactive additive, wherein the reactive additive has a reactive OH group or reactive ester group. The polycarbonate can be melted prior to adding the solid quencher composition.

[0045] The solid quencher composition can comprise 0.1 to 100 wt%, specifically, 10 to 99 wt% quencher, based on the total weight of the solid quencher composition.

[0046] When in the liquid form, the quencher composition can comprise a liquid carrier. The liquid carrier can comprise a low boiling point solvent such that the boiling point of the low boiling point solvent is less than that of a quenching agent present in the quenching composition. For example, if the quenching agent comprises butyl tosylate, then the low boiling point solvent can have a boiling point of less than 140°C. The low boiling point solvent can be essentially unreactive with the polycarbonate at the temperature and pressure conditions in the extruder, for example, at high temperatures under vacuum. The low boiling point solvent can be capable of solubilizing the quenching agent. The low boiling point solvent can comprise xylene, toluene, benzene, ethylbenzene, anisole, chlorobenzene, and combinations comprising one or more of the foregoing. The low boiling point solvent can comprise water, an organic solvent (such as acetone), or a combination comprising one or both of the foregoing.

[0047] The liquid carrier can comprise a high boiling point solvent such that the boiling point of the high boiling point solvent is greater than or equal to that of a quenching agent present in the quenching composition. For example, if the quenching agent comprises butyl tosylate, then the low boiling point solvent can have a boiling point of greater than or equal to 140°C. The high boiling point solvent can comprise a compound present in the melt polymerization. For example, in the melt polymerization of a bisphenol A polycarbonate, the high boiling point solvent can comprise diphenylcarbonate, phenol, bisphenol A, the

polycarbonate oligomers, bisphenol A derivatives, propylene carbonate, or a combination comprising one or more of the foregoing.

[0048] If both a low boiling point solvent and the high boiling point solvent are present, then they can be soluble in each other. A ratio of the low boiling point solvent and the high boiling point solvent in the quencher composition can be 4:1 to 1:4, specifically, 2:1 to 1:2, more specifically 1.5:1 to 1:1.5. Likewise, the quencher composition can be free of a liquid carrier.

[0049] The liquid quencher composition can comprise 0.1 to 99 wt%, specifically, 1 to 50 wt%, more specifically, 1 to 20 wt% quencher based on the total weight of the liquid quencher composition.

[0050] Likewise, the quencher composition can be free of a carrier. For example, the quencher composition can include the quencher, additive(s), and no carrier; e.g., can consist of the quencher and an optional additive. The quencher can be added as a molten (i.e. a melted) quencher. When the quencher composition is free of a carrier, the quencher composition can comprise 0.1 to 100 wt% quencher, based on the total weight of the carrier free quencher composition.

[0051] The quencher can be added in an amount of greater than or equal to 5 parts per million by weight (ppm), specifically, greater than or equal to 10 ppm based on the total amount of the polycarbonate. The quencher can be added in an amount of less than or equal to 5 ppm, specifically, less than or equal to 10 ppm based on the total amount of the polycarbonate. The quencher composition can be added to the polymerization unit such that the quencher is added in an amount of 0.5 to 15 ppm, specifically, 1 to 10 ppm, more specifically, 1.5 to 5 ppm, even more specifically, 1.5 to 3 ppm based on the total weight of the polycarbonate. Likewise, the quencher composition can be added to the polymerization unit such that the quencher is added in an amount of 5 to 10 ppm, specifically, 6 to 8 ppm based on the total weight of the polycarbonate. Likewise, the quencher can be added such that the quencher or derivatives thereof are present in an amount of 0.1 to 50 times, specifically, 0.5 to 30 times, per the neutralization equivalent of the catalyst used.

[0052] The quencher composition can be added at one or more locations in the melt preparation of the polycarbonate. For example, the quencher composition can be added upstream of a polymerization unit, directly into a polymerization unit (for example, at an inlet, in a side feeder, in an outlet, or a combination comprising one or more of the foregoing), downstream of a polymerization unit, in a reactor that is not polymerizing

polycarbonate, upstream of an extruder, directly into an extruder (for example, at the throat of the extruder, in a side feeder, in an outlet, or a combination comprising one or more of the foregoing), downstream of an extruder, or a combination comprising one or more of the foregoing. When added upstream of an extruder, the quencher composition can be added upstream of a final polymerization unit and/or into a final polymerization unit and/or after a final polymerization unit. The quencher composition can be added into a final polymerization unit. The quencher composition can be added in the outlet of a first polymerization unit, in the outlet of a second polymerization unit, in a reactor located in between a final polymerization unit and an extruder, in an extruder, or a combination comprising one or more of the foregoing. Likewise, an amount of the quencher composition can be added into and/or after one or more of the staged polymerization units and/or into a finishing extruder. For example, the quencher composition can be added after an initial polymerization unit, fresh catalyst can then be added, and after further polymerization, additional quencher can be added.

[0053] The polymerization process can comprise a section of parallel polymerization, where parallel polymerization refers to the splitting of a polycarbonate stream into two or more streams that may or may not experience the same polymerization conditions thereafter (i.e. they can attain different molecular weights, have different additives added thereto, etc.). For example, polycarbonate can be prepared in a first portion of the polymerization process; a stream comprising polycarbonate can be split into two or more streams and directed to 2 or more parallel operating lines. For example, a process can comprise polymerizing polycarbonate in a series of oligomerization polymerization units; a stream exiting the oligomerization stage can be split into two streams: A and B, where stream A is directed to polymerization unit A and stream B is directed to polymerization unit B. Likewise, a process can comprise polymerizing polycarbonate in a series of oligomerization units followed by polymerizing in a series of polymerization units; a stream exiting the polymerization stage can be split into two streams: A and B, where stream A is directed to extruder A and stream B is directed to extruder B. Likewise, a process can comprise polymerizing polycarbonate in a series of oligomerization units followed by polymerizing in a series of two polymerization units; a stream exiting the first polymerization unit can be split into two streams: A and B, where stream A is directed to second polymerization unit A and stream B is directed to second polymerization unit B. In any of the aforementioned scenarios, a quencher composition can be added to one or both of streams A and B, where the quencher

composition can be the same or different. One skilled in the art can readily envision other embodiments comprising more than 2 parallel streams and embodiments where the streams are split at different locations.

[0054] When the quencher composition is added to a polymerization unit and/or to an extruder, the quencher composition can optionally be mixed, for example, by means of a Henschel mixer, and introduced to a feeder, such as a gravimetric feeder, and then fed to a polymerization unit and/or to an extruder through a feeder, such as a side feeder and/or directly into a throat of the extruder.

[0055] When the quencher composition is added to a connecting stream that connects a first unit to a second unit, then the connecting stream comprising the added quencher composition can be mixed via, for example, the establishment of a turbulent flow, an in-line mixer, for example, a static mixer located in a pipe that contains the connecting stream and/or in a mixer unit that houses a rotating paddle, for example a continuously stirred tank. Mixing can occur for 0.3 to 5 minutes, for example, 0.5 to 3 minutes, for example, 1 to 2 minutes. Likewise, the quencher composition can be added to the connecting stream without mixing.

[0056] The quencher composition can be added after the formation of the polycarbonate composition, i.e. after extruding and/or melt filtering. For example, after the polycarbonate composition is prepared, the polycarbonate composition can be mixed with a quencher composition, for example, in an in-line mixer, a twin barrel mixer, or the like, and then pelletized. Likewise, the polycarbonate composition can first be pelletized and then the quencher composition can be introduced. The quencher composition can be added, for example, by flowing or spraying, in the solid or liquid form onto polycarbonate pellets and can optionally be mixed with the pellets in, for example, a melt kneader. In this scenario, an additive can be introduced after the introduction of the quencher composition. For example, a pelletized polycarbonate, for example, one that is free of an additive, can be combined with a quencher composition and an antioxidant and/or a release agent can then be added.

[0057] The polycarbonate composition can be devolatilized to remove low molecular weight (such as those with a molecular weight of less than or equal to 1,000 Daltons). Devolatilization can occur in a polymerization unit (for example, in a polymerization unit), in a reactor, in an extruder, in a mixer, or in a combination comprising one or more of the foregoing. The polycarbonate can be quenched prior to devolatilization. For example, a quencher can be added upstream of and/or directly to an extruder, the extruder can be devolatilized, and an additive can be added.

[0058] It is noted that an amount of water can be added to extruder 4 to devolatilize the polycarbonate composition. The amount of water that can be introduced can be 0.1 to 10 wt%, specifically, 0.3 to 5 wt% based on the total weight of the polycarbonate composition.

[0059] FIG. 1 illustrates a method of adding the quencher composition to a polymerization system. Specifically, FIG. 1 shows that the quencher composition can be added via one or more of quencher streams 40 - 50, where quencher streams 40-50 can be liquid quencher streams and quencher streams 46-50 can be solid quencher streams. For example, quencher stream 40 can be added to stream 20 and stream 20 can then optionally be mixed in mixer 10; quencher stream 42 can be added to reactor unit 2, where reactor unit 2 can be one or more of a first polymerization vessel, a middle polymerization vessel(s), a final polymerization vessel, and a reactor located after a final polymerization vessel; quencher stream 44 can be added to polymerized stream 22, and polymerized stream 22 can then be optionally mixed in mixer 10; quencher stream 46 can be added to the extruder 4 via the extruder throat 8; quencher stream 48 can be added to the extruder 4 via side feeder 12; and quencher stream 50 can be added to extruded stream 24 and can be optionally mixed in mixer 10. Extruded stream 24 can be fed to melt filter 6 to form polycarbonate composition stream 26. Mixer 10 can be, for example, an in-line mixer, a turbulent flow, or a continuously stirred unit. It is noted that melt filter 6 can likewise be located upstream of extruder 4 and that a quencher composition can be added before and/or after the melt filter. It is further noted that while streams 42, 56, and 58 are illustrated as entering a side of the respective vessels, it is readily understood that these streams can enter the vessel at any appropriate location.

[0060] FIG. 1 further illustrates a method of adding a quencher composition to a polycarbonate composition that is further pelletized. Specifically, FIG. 1 shows that the quencher composition can be added via one or more of quencher streams 52 - 58, where quencher streams 52-58 can be solid quencher streams or liquid quencher streams. For example, quencher stream 52 can be added to optional mixer 14, where optional mixer 14 can be, for example, an in-line mixer, a turbulent flow, or a continuously stirred unit (such as a twin barrel extruder); quencher stream 56 can be added to pelletizer 16, for example at a throat of the pelletizer; quencher stream 58 can be added to pelletized stream 30, for example by spraying the quencher composition on the formed pellets. It is noted that while quencher streams 56 and 58 are illustrated as entering a side of the respective vessels, it is readily understood that these streams can enter the vessel at any appropriate location. As is noted in the figure, streams 40, 44, and 26 include an indication of locations for potential other

processes, such as, polymerization units, transportation steps, and purifications steps can occur.

[0061] An additive can further be added at one or more locations in the present melt preparation of the polycarbonate. For example, the additive can be added upstream of a polymerization unit, directly into a polymerization unit (for example, at an inlet, in a side feeder, in an outlet, or a combination comprising one or more of the foregoing), downstream of a polymerization unit, in a reactor that is not polymerizing polycarbonate, upstream of an extruder, directly into an extruder (for example, at the throat of the extruder, in a side feeder, in an outlet, or a combination comprising one or more of the foregoing), downstream of an extruder, or a combination comprising one or more of the foregoing. The additive can be added as part of the quencher composition and/or can be added separately. For example, quencher composition comprising a heat stabilizer can be added to the polycarbonate and an additive composition comprising a release agent and a UV agent can be added to the quenched composition. The additive can be added in a molten state or can be added after an extruded polycarbonate is re-melted. The additive can be filtered prior to being added into the polymerization unit.

[0062] The additive can comprise, for example, an impact modifier, a flow modifier, a filler (e.g., a particulate polytetrafluoroethylene (PTFE), glass, carbon, a mineral, or metal), a reinforcing agent (e.g., glass fibers), an antioxidant, a heat stabilizer, a light stabilizer, an ultraviolet (UV) agent (such as a UV light stabilizer and a UV absorbing additive), a plasticizer, a lubricant, a release agent (such as a mold release agent (such as glycerol monostearate, pentaerythritol stearate, glycerol tristearate, stearyl stearate, and the like)), an antistatic agent, an antifog agent, an antifrost agent, an antimicrobial agent, a colorant (e.g. a dye or pigment), a surface effect additive, a radiation stabilizer, a flame retardant, an anti-drip agent (e.g., a PTFE-encapsulated styrene-acrylonitrile copolymer (TSAN)), or a combination comprising one or more of the foregoing. For example, a combination of a heat stabilizer, mold release agent, and ultraviolet light stabilizer can be used. In general, the additives are used in the amounts generally known to be effective. For example, the total amount of the additive composition (other than any impact modifier, filler, or reinforcing agent) can be 0.001 to 10.0 weight percent (wt%), or 0.01 to 5 wt%, each based on the total weight of the polymer in the polymerized composition.

[0063] Heat stabilizer additives include organophosphites (e.g. triphenyl phosphite, tris-(2,6-dimethylphenyl)phosphite, tris-(mixed mono-and di-nonylphenyl)phosphite or the

like), phosphonates (e.g., dimethylbenzene phosphonate or the like), phosphates (e.g., trimethyl phosphate, or the like), or combinations comprising at least one of the foregoing heat stabilizers. The heat stabilizer can comprise tris(2,4-di-*t*-butylphenyl) phosphate available as IRGAPHOSTM 168. The heat stabilizer can comprise IRGAPHOSTM 205. Heat stabilizers are generally used in amounts of 0.01 to 5 wt%, based on the total weight of polymer in the composition.

[0064] The term “antistatic agent” refers to monomeric, oligomeric, or polymeric materials that can be processed into polymers and/or sprayed onto materials or articles to improve conductive properties and overall physical performance. Examples of monomeric antistatic agents include ethoxylated amines, primary, secondary and tertiary amines, ethoxylated alcohols, alkyl sulfates, alkylarylsulfates, alkylphosphates, alkylaminesulfates, alkyl sulfonate salts such as sodium stearyl sulfonate, sodium dodecylbenzenesulfonate or the like, quaternary ammonium salts, quaternary ammonium polymers, imidazoline derivatives, sorbitan esters, ethanolamides, betaines, or the like, or combinations comprising at least one of the foregoing monomeric antistatic agents.

[0065] Polymeric antistatic agents include certain polyesteramides, polyether-polyamide (polyetheramide) block copolymers, polyetheresteramide block copolymers, polyetheresters, or polyurethanes, each containing polyalkylene glycol moieties polyalkylene oxide units such as polyethylene glycol, polypropylene glycol, polytetramethylene glycol, and the like. Such polymeric antistatic agents are commercially available, for example PELESTATTM 6321 (Sanyo) or PEBAXTM MH1657 (Atofina), IRGASTATTM P18 and P22 (Ciba-Geigy). Other polymeric materials that can be used as antistatic agents are inherently conducting polymers such as polyaniline (commercially available as PANIPOLTMEB from Panipol), polypyrrole and polythiophene (commercially available from Bayer), which retain some of their intrinsic conductivity after melt processing at elevated temperatures. In an embodiment, carbon fibers, carbon nanofibers, carbon nanotubes, carbon black, or a combination comprising at least one of the foregoing can be used in a polymer composition containing chemical antistatic agents to render the composition electrostatically dissipative.

[0066] Radiation stabilizers can also be present, specifically gamma-radiation stabilizers. gamma-radiation stabilizers include alkylene polyols such as ethylene glycol, propylene glycol, 1,3-propanediol, 1,2-butanediol, 1,4-butanediol, meso-2,3-butanediol, 1,2-pentanediol, 2,3-pentanediol, 1,4-pentanediol, 1,4-hexandiol, and the like; cycloalkylene polyols such as 1,2-cyclopentanediol, 1,2-cyclohexanediol, and the like; branched

alkylenepolyols such as 2,3-dimethyl-2,3-butanediol (pinacol), and the like, as well as alkoxy-substituted cyclic or acyclic alkanes. Unsaturated alkenols are also useful, examples of which include 4-methyl-4-penten-2-ol, 3-methyl-pentene-3-ol, 2-methyl-4-penten-2-ol, 2,4-dimethyl-4-pene-2-ol, and 9-decen-1-ol, as well as tertiary alcohols that have at least one hydroxy substituted tertiary carbon, for example 2-methyl-2,4-pentanediol (hexylene glycol), 2-phenyl-2-butanol, 3-hydroxy-3-methyl-2-butanone, 2-phenyl-2-butanol, and the like, and cyclic tertiary alcohols such as 1-hydroxy-1-methyl-cyclohexane. Certain hydroxymethyl aromatic compounds that have hydroxy substitution on a saturated carbon attached to an unsaturated carbon in an aromatic ring can also be used. The hydroxy-substituted saturated carbon can be a methylol group ($-\text{CH}_2\text{OH}$) or it can be a member of a more complex hydrocarbon group such as $-\text{CR}^4\text{HOH}$ or $-\text{CR}_2^4\text{OH}$ wherein R^4 is a complex or a simple hydrocarbon. Specific hydroxy methyl aromatic compounds include benzhydrol, 1,3-benzenedimethanol, benzyl alcohol, 4-benzyloxy benzyl alcohol and benzyl benzyl alcohol. 2-Methyl-2,4-pentanediol, polyethylene glycol, and polypropylene glycol are often used for gamma-radiation stabilization.

[0067] Colorants such as pigment and/or dye additives can also be present. Useful pigments can include, for example, inorganic pigments such as metal oxides and mixed metal oxides such as zinc oxide, titanium dioxides, iron oxides, or the like; sulfides such as zinc sulfides, or the like; aluminates; sodium sulfo-silicates sulfates, chromates, or the like; carbon blacks; zinc ferrites; ultramarine blue; organic pigments such as azos, di-azos, quinacridones, perylenes, naphthalene tetracarboxylic acids, flavanthrones, isoindolinones, tetrachloroisoindolinones, anthraquinones, enthrone, dioxazines, phthalocyanines, and azo lakes; Pigment Red 101, Pigment Red 122, Pigment Red 149, Pigment Red 177, Pigment Red 179, Pigment Red 202, Pigment Violet 29, Pigment Blue 15, Pigment Blue 60, Pigment Green 7, Pigment Yellow 119, Pigment Yellow 147, Pigment Yellow 150, and Pigment Brown 24; or combinations comprising at least one of the foregoing pigments.

[0068] Dyes are generally organic materials and include coumarin dyes such as coumarin 460 (blue), coumarin 6 (green), Nile red or the like; lanthanide complexes; hydrocarbon and substituted hydrocarbon dyes; polycyclic aromatic hydrocarbon dyes; scintillation dyes such as oxazole or oxadiazole dyes; aryl- or heteroaryl-substituted poly (C_{2-8}) olefin dyes; carbocyanine dyes; indanthrone dyes; phthalocyanine dyes; oxazine dyes; carbostyryl dyes; naphthalenetetracarboxylic acid dyes; porphyrin dyes; bis(styryl)biphenyl dyes; acridine dyes; anthraquinone dyes; cyanine dyes; methine dyes; arylmethane dyes; azo

dyes; indigoid dyes, thioindigoid dyes, diazonium dyes; nitro dyes; quinone imine dyes; aminoketone dyes; tetrazolium dyes; thiazole dyes; perylene dyes, perinone dyes; bis-benzoxazolylthiophene (BBOT); triarylmethane dyes; xanthene dyes; thioxanthene dyes; naphthalimide dyes; lactone dyes; fluorophores such as anti-stokes shift dyes which absorb in the near infrared wavelength and emit in the visible wavelength, or the like; luminescent dyes such as 7-amino-4-methylcoumarin; 3-(2'-benzothiazolyl)-7-diethylaminocoumarin; 2-(4-biphenyl)-5-(4-t-butylphenyl)-1,3,4-oxadiazole; 2,5-bis-(4-biphenyl)-oxazole; 2,2'-dimethyl-p-quaterphenyl; 2,2-dimethyl-p-terphenyl; 3,5,3''',5'''-tetra-t-butyl-p-quinquephenyl; 2,5-diphenylfuran; 2,5-diphenyloxazole; 4,4'-diphenylstilbene; 4-dicyanomethylene-2-methyl-6-(p-dimethylaminostyryl)-4H-pyran; 1,1'-diethyl-2,2'-carbocyanine iodide; 3,3'-diethyl-4,4',5,5'-dibenzothiatricarbocyanine iodide; 7-dimethylamino-1-methyl-4-methoxy-8-azaquinolone-2; 7-dimethylamino-4-methylquinolone-2; 2-(4-(4-dimethylaminophenyl)-1,3-butadienyl)-3-ethylbenzothiazolium perchlorate; 3-diethylamino-7-diethyliminophenoxazonium perchlorate; 2-(1-naphthyl)-5-phenyloxazole; 2,2'-p-phenylene-bis(5-phenyloxazole); rhodamine 700; rhodamine 800; pyrene, chrysene, rubrene, coronene, or the like; or combinations comprising at least one of the foregoing dyes.

[0069] Possible fillers or reinforcing agents include, for example, mica, clay, feldspar, quartz, quartzite, perlite, tripoli, diatomaceous earth, aluminum silicate (mullite), synthetic calcium silicate, fused silica, fumed silica, sand, boron-nitride powder, boron-silicate powder, calcium sulfate, calcium carbonates (such as chalk, limestone, marble, and synthetic precipitated calcium carbonates) talc (including fibrous, modular, needle shaped, and lamellar talc), wollastonite, hollow or solid glass spheres, silicate spheres, cenospheres, aluminosilicate or (armospheres), kaolin, whiskers of silicon carbide, alumina, boron carbide, iron, nickel, or copper, continuous and chopped carbon fibers or glass fibers, molybdenum sulfide, zinc sulfide, barium titanate, barium ferrite, barium sulfate, heavy spar, TiO₂, aluminum oxide, magnesium oxide, particulate or fibrous aluminum, bronze, zinc, copper, or nickel, glass flakes, flaked silicon carbide, flaked aluminum diboride, flaked aluminum, steel flakes, natural fillers such as wood flour, fibrous cellulose, cotton, sisal, jute, starch, lignin, ground nut shells, or rice grain husks, reinforcing organic fibrous fillers such as poly(ether ketone), polyimide, polybenzoxazole, poly(phenylene sulfide), polyesters, polyethylene, aromatic polyamides, aromatic polyimides, polyetherimides, polytetrafluoroethylene, and poly(vinyl alcohol), as well combinations comprising at least one of the foregoing fillers or

reinforcing agents. The fillers and reinforcing agents can be coated with a layer of metallic material to facilitate conductivity, or surface treated with silanes to improve adhesion and dispersion with the polymer matrix. Fillers are used in amounts of 1 to 200 parts by weight, based on 100 parts by weight of based on 100 parts by weight of the total composition.

[0070] Antioxidant additives include organophosphites such as tris(nonyl phenyl)phosphite, tris(2,4-di-*t*-butylphenyl)phosphite, bis(2,4-di-*t*-butylphenyl)pentaerythritol diphosphite, distearyl pentaerythritol diphosphite; alkylated monophenols or polyphenols; alkylated reaction products of polyphenols with dienes, such as tetrakis[methylene(3,5-di-*tert*-butyl-4-hydroxyhydrocinnamate)] methane; butylated reaction products of para-cresol or dicyclopentadiene; alkylated hydroquinones; hydroxylated thiodiphenyl ethers; alkylidene-bisphenols; benzyl compounds; esters of beta-(3,5-di-*tert*-butyl-4-hydroxyphenyl)-propionic acid with monohydric or polyhydric alcohols; esters of beta-(5-*tert*-butyl-4-hydroxy-3-methylphenyl)-propionic acid with monohydric or polyhydric alcohols; esters of thioalkyl or thioaryl compounds such as distearylthiopropionate, dilaurylthiopropionate, ditridecylthiodipropionate, octadecyl-3-(3,5-di-*tert*-butyl-4-hydroxyphenyl)propionate, pentaerythrityl-tetrakis[3-(3,5-di-*tert*-butyl-4-hydroxyphenyl)propionate; amides of beta-(3,5-di-*tert*-butyl-4-hydroxyphenyl)-propionic acid, or combinations comprising at least one of the foregoing antioxidants. Antioxidants can be used in amounts of 0.01 to 0.1 parts by weight, based on 100 parts by weight of the total composition, excluding any filler.

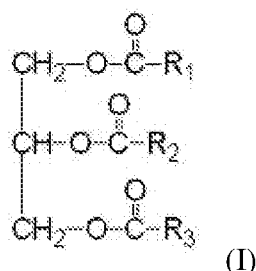
[0071] UV absorbing additives include hydroxybenzophenones; hydroxybenzotriazoles; hydroxybenzotriazines; cyanoacrylates; oxanilides; benzoxazinones; aryl salicylates; monoesters of diphenols such as resorcinol monobenzoate; 2-(2H-benzotriazol-2-yl)-4-(1,1,3,3-tetramethylbutyl)-phenol (CYASORBTM 5411); 2-hydroxy-4-n-octyloxybenzophenone (CYASORBTM 531); 2-[4,6-bis(2,4-dimethylphenyl)-1,3,5-triazin-2-yl]-5-(octyloxy)-phenol (CYASORBTM 1164); 2,2'-(1,4-phenylene)bis(4H-3,1-benzoxazin-4-one) (CYASORBTM UV-3638); poly[(6-morpholino-s-triazine-2,4-diyl)[2,2,6,6-tetramethyl-4-piperidyl]imino]-hexamethylene[(2,2,6,6-tetramethyl-4-piperidyl)imino], 2-hydroxy-4-octyloxybenzophenone (UVINULTM3008), 6-*tert*-butyl-2-(5-chloro-2H-benzotriazole-2-yl)-4-methylphenyl (UVINULTM3026), 2,4-di-*tert*-butyl-6-(5-chloro-2H-benzotriazole-2-yl)-phenol (UVINULTM3027), 2-(2H-benzotriazole-2-yl)-4,6-di-*tert*-pentylphenol (UVINULTM3028), 2-(2H-benzotriazole-2-yl)-4-(1,1,3,3-tetramethylbutyl)-phenol (UVINULTM3029), 1,3-bis[(2'-cyano-3',3'-diphenylacryloyl)oxy]-2,2-bis-[(2'-cyano-

3',3'-diphenylacryloyl)oxy)methyl}-propane (UVINULTM3030), 2-(2H-benzotriazole-2-yl)-4-methylphenol (UVINULTM3033), 2-(2H-benzotriazole-2-yl)-4,6-bis(1-methyl-1-phenylethyl)phenol (UVINULTM3034), ethyl-2-cyano-3,3-diphenylacrylate (UVINULTM3035), (2-ethylhexyl)-2-cyano-3,3-diphenylacrylate (UVINULTM3039), N,N'-bisformyl-N,N'-bis(2,2,6,6-tetramethyl-4-piperidyl)hexamethyldiamine (UVINULTM4050H), bis-(2,2,6,6-tetramethyl-4-piperidyl)-sebacate (UVINULTM4077H), bis-(1,2,2,6,6-pentamethyl-4-piperidyl)-sebacate + methyl-(1,2,2,6,6-pentamethyl-4-piperidyl)-sebacate (UVINULTM4092H) 1,3-bis[(2-cyano-3,3-diphenylacryloyl)oxy]-2,2-bis[[2-cyano-3,3-diphenylacryloyl)oxy)methyl]propane (UVINULTM3030); 2,2'-(1,4-phenylene) bis(4H-3,1-benzoxazin-4-one); 1,3-bis[(2-cyano-3,3-diphenylacryloyl)oxy]-2,2-bis[[2-cyano-3,3-diphenylacryloyl)oxy)methyl]propane; TINUVINTM 234; nano-size inorganic materials such as titanium oxide, cerium oxide, and zinc oxide, all with particle size less than or equal to 100 nanometers; or the like, or combinations comprising at least one of the foregoing UV absorbers. UV absorbers can be used in amounts of 0.01 to 1 part by weight, based on 100 parts by weight of polycarbonate and impact modifier. UV absorbers that can be particularly useful with the polycarbonate compositions disclosed herein include 2-(2H-benzotriazole-2-yl)-4-(1,1,3,3-tetramethylbutyl)-phenol (e.g., CYASORBTM 5411 commercially available from Cytec Industries, Inc., Woodland Park, New Jersey) and 2,2'-(1,4-phenylene)bis(4H-3,1-benzoxazin-4-one) (e.g., CYASORBTM UV-3638, commercially available from Cytec Industries, Inc., Woodland Park, New Jersey), and combinations comprising at least one of the foregoing. The UV stabilizers can be present in an amount of 0.01 to 1 wt%, specifically, 0.1 to 0.5 wt%, and more specifically, 0.15 to 0.4 wt%, based upon the total weight of the polycarbonate composition.

[0072] Plasticizers, lubricants, and/or mold release agents can also be used. There is considerable overlap among these types of materials, which include, for example, phthalic acid esters such as dioctyl-4,5-epoxy-hexahydrophthalate; tris-(octoxycarbonyl)ethyl isocyanurate; tristearin; di- or polyfunctional aromatic phosphates such as resorcinol tetraphenyl diphosphate (RDP), the bis(diphenyl) phosphate of hydroquinone and the bis(diphenyl) phosphate of bisphenol A; poly- α -olefins; epoxidized soybean oil; silicones, including silicone oils; esters, for example, fatty acid esters such as alkyl stearyl esters, e.g., methyl stearate, stearyl stearate, pentaerythritol tetrastearate, and the like; combinations of methyl stearate and hydrophilic and hydrophobic nonionic surfactants comprising polyethylene glycol polymers, polypropylene glycol polymers, poly(ethylene

glycol-co-propylene glycol) copolymers, or a combination comprising at least one of the foregoing glycol polymers, e.g., methyl stearate and polyethylene-polypropylene glycol copolymer in a suitable solvent; waxes such as beeswax, montan wax, paraffin wax, or the like.

[0073] The plasticizers, lubricants, and/or mold release agent can comprise compound of formula (I)



wherein R_1 , R_2 , and R_3 can be the same or different hydrocarbon chains with 8 to 20 carbon atoms and 0 to 6 unsaturations, wherein R_1 , R_2 , and R_3 are each independently selected from C_8 - C_{20} alkyl, C_8 - C_{20} haloalkyl, C_8 - C_{20} polyhaloalkyl, C_8 - C_{20} alkene, and C_8 - C_{20} alkoxy. R_1 , R_2 , and R_3 can each independently be from $\text{C}_{17}\text{H}_{35}$ or all R_1 , R_2 , and R_3 can be $\text{C}_{17}\text{H}_{35}$. The plasticizers, lubricants, and/or mold release agent can comprise glycerol monostearate, glycerol monopalmitate, glycerol tristearate, glycerol tristearate, stearyl stearate, or a combination comprising one or more of the foregoing. One or more of the aforementioned can have an acid value of 2 to 20 milligrams (mg) KOH as determined by: adding 100 milliliters (ml) of isopropanol to 2.5 grams (g) of a partial ester to thereby dissolve the partial ester; phenolphthalein is added to the resultant solution as an indicator; titrating the resultant mixture using a 0.1 moles per liter (mol/L) standard solution of potassium hydroxide to thereby obtain the acid value (mg KOH). In the measurement of the acid value, when it is expected that the partial ester has an acid value of 1 or less, the amount of the partial ester subjected to measurement is changed to 20 g; when it is expected that the partial ester has an acid value of from 1 to 4, the amount of the partial ester subjected to measurement is changed to 10 g; and when it is expected that the partial ester has an acid value of 15 or more, the amount of the partial ester subjected to measurement is changed to 0.5 g.

[0074] The plasticizers, lubricants, and/or mold release agent can be present in an amount of 0.01 to 5 parts by weight, specifically, 0.01 to 0.1 parts by weight, based on 100 parts by weight of polycarbonate and impact modifier.

[0075] Useful flame retardants include organic compounds that include phosphorus, bromine, and/or chlorine. Non-brominated and non-chlorinated phosphorus-containing flame

retardants can be preferred in certain applications for regulatory reasons, for example organic phosphates and organic compounds containing phosphorus-nitrogen bonds.

[0076] Flame retardant aromatic phosphates include triphenyl phosphate, tricresyl phosphate, isopropylated triphenyl phosphate, phenyl bis(dodecyl) phosphate, phenyl bis(neopentyl) phosphate, phenyl bis(3,5,5'-trimethylhexyl) phosphate, ethyl diphenyl phosphate, 2-ethylhexyl di(p-tolyl) phosphate, bis(2-ethylhexyl) p-tolyl phosphate, tritolyl phosphate, bis(2-ethylhexyl) phenyl phosphate, tri(nonylphenyl) phosphate, bis(dodecyl) p-tolyl phosphate, dibutyl phenyl phosphate, 2-chloroethyl diphenyl phosphate, p-tolyl bis(2,5,5'-trimethylhexyl) phosphate, and 2-ethylhexyl diphenyl phosphate. Di- or polyfunctional aromatic phosphorus-containing compounds are also useful, for example resorcinol tetraphenyl diphosphate (RDP), the bis(diphenyl) phosphate of hydroquinone and the bis(diphenyl) phosphate of bisphenol A, respectively, and their oligomeric and polymeric counterparts. Flame retardant compounds containing phosphorus-nitrogen bonds include phosphonitrilic chloride, phosphorus ester amides, phosphoric acid amides, phosphonic acid amides, phosphinic acid amides, and tris(aziridiny) phosphine oxide. When used, phosphorus-containing flame retardants are present in amounts of 0.1 to 30 parts by weight, more specifically 1 to 20 parts by weight, based on 100 parts by weight of the total composition, excluding any filler.

[0077] Halogenated materials can also be used as flame retardants, for example bisphenols of which the following are representative: 2,2-bis-(3,5-dichlorophenyl)-propane; bis-(2-chlorophenyl)-methane; bis(2,6-dibromophenyl)-methane; 1,1-bis-(4-iodophenyl)-ethane; 1,2-bis-(2,6-dichlorophenyl)-ethane; 1,1-bis-(2-chloro-4-iodophenyl)ethane; 1,1-bis-(2-chloro-4-methylphenyl)-ethane; 1,1-bis-(3,5-dichlorophenyl)-ethane; 2,2-bis-(3-phenyl-4-bromophenyl)-ethane; 2,6-bis-(4,6-dichloronaphthyl)-propane; and 2,2-bis-(3,5-dichloro-4-hydroxyphenyl)-propane 2,2 bis-(3-bromo-4-hydroxyphenyl)-propane. Other halogenated materials include 1,3-dichlorobenzene, 1,4-dibromobenzene, 1,3-dichloro-4-hydroxybenzene, and biphenyls such as 2,2'-dichlorobiphenyl, polybrominated 1,4-diphenoxybenzene, 2,4'-dibromobiphenyl, and 2,4'-dichlorobiphenyl as well as decabromo diphenyl oxide, as well as oligomeric and polymeric halogenated aromatic compounds, such as a copolycarbonate of bisphenol A and tetrabromobisphenol A and a carbonate precursor, e.g., phosgene. Metal synergists, e.g., antimony oxide, can also be used with the flame retardant. When present, halogen containing flame retardants are present in amounts of 1 to 25 parts by weight, more

specifically 2 to 20 parts by weight, based on 100 parts by weight of the total composition, excluding any filler.

[0078] Inorganic flame retardants can also be used, for example salts of C₁₋₁₆ alkyl sulfonate salts such as potassium perfluorobutane sulfonate (Rimar salt), potassium perfluorooctane sulfonate, tetraethylammonium perfluorohexane sulfonate, and potassium diphenylsulfone sulfonate; salts such as Na₂CO₃, K₂CO₃, MgCO₃, CaCO₃, and BaCO₃, or fluoro-anion complexes such as Li₃AlF₆, BaSiF₆, KBF₄, K₃AlF₆, KAlF₄, K₂SiF₆, and/or Na₃AlF₆. When present, inorganic flame retardant salts are present in amounts of 0.01 to 10 parts by weight, more specifically 0.02 to 1 parts by weight, based on 100 parts by weight of the total composition, excluding any filler.

[0079] Anti-drip agents can also be used in the composition, for example a fibril forming or non-fibril forming fluoropolymer such as polytetrafluoroethylene (PTFE). The anti-drip agent can be encapsulated by a rigid copolymer, for example styrene-acrylonitrile copolymer (SAN). PTFE encapsulated in SAN is known as TSAN. A TSAN comprises 50 wt% PTFE and 50 wt% SAN, based on the total weight of the encapsulated fluoropolymer. The SAN can comprise, for example, 75 wt% styrene and 25 wt% acrylonitrile based on the total weight of the copolymer. Antidrip agents can be used in amounts of 0.1 to 10 parts by weight, based on 100 parts by weight of the total composition, excluding any filler.

[0080] The quenched composition can be essentially free of chlorine and bromine. “Essentially free of chlorine and bromine” is defined as having a bromine and/or chlorine content of less than or equal to 100 parts per million by weight (ppm), less than or equal to 75 ppm, or less than or equal to 50 ppm, based on the total parts by weight of the composition, excluding any filler.

[0081] The quenched composition can have a light transparency of greater than 90% as determined using 3.2 mm thick samples using ASTM D1003-00, Procedure B using CIE standard illuminant C, with unidirectional viewing. Accordingly, when the quenched composition has such a light transparency, it is herein referred to as an “optical grade” composition.

[0082] Embodiment 1: A melt polymerization process comprising: melt polymerizing reactants in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises a catalyst; adding a quencher composition to the polycarbonate, wherein the quencher composition comprises a quencher; and directing the polycarbonate to an extruder.

[0083] Embodiment 2: A melt polymerization process comprising: melt polymerizing reactants in at least two polymerization units, in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises an alpha catalyst; combining a liquid carrier and a quencher in a quencher vessel to form a quencher composition; adding the quencher composition to the polycarbonate at a pressure of greater than or equal to 2 bars; mixing the quencher composition with the polycarbonate for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any additives having a reactive OH group or reactive ester group; filtering the polycarbonate; and directing the polycarbonate to an extruder.

[0084] Embodiment 3: The process of any of Embodiments 1 - 2, wherein the quencher composition comprises diphenyl carbonate.

[0085] Embodiment 4: The process of Embodiment 3, wherein the liquid carrier comprises a low boiling point solvent and/or a high boiling point solvent.

[0086] Embodiment 5: The process of Embodiment 4, wherein the liquid carrier comprises the low boiling point solvent and the high boiling point solvent, and a ratio of the low boiling point solvent and the high boiling point solvent is 4:1 to 1:4.

[0087] Embodiment 6: The process of any of Embodiments 3 - 5, wherein the liquid carrier comprises a compound present in the melt polymerization.

[0088] Embodiment 7: The process of any of Embodiments 3 - 6, wherein the liquid carrier comprises diarylcarbonate, phenol, bisphenol A, polycarbonate oligomers, bisphenol A derivatives, propylene carbonate, or a combination comprising one or more of the foregoing.

[0089] Embodiment 8: The process of any of Embodiments 3 - 7, wherein the liquid carrier comprises xylene, toluene, benzene, ethylbenzene, anisole, chlorobenzene, or a combination comprising one or more of the foregoing.

[0090] Embodiment 9: The process of any of Embodiments 3 - 8, wherein the liquid carrier comprises toluene.

[0091] Embodiment 10: The process of any of Embodiments 3 - 9, wherein the liquid carrier comprises water, acetone, or a combination comprising one or more of the foregoing.

[0092] Embodiment 11: A melt polymerization process comprising: melt polymerizing reactants in at least two polymerization units, in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises an alpha catalyst; melting a quencher to form a quencher composition, wherein the quencher

composition is free of a carrier; adding the quencher composition to the polycarbonate; filtering the polycarbonate; and directing the polycarbonate to an extruder.

[0093] Embodiment 12: The process of any of Embodiments 1 - 11, wherein the filtering occurs after directing the polycarbonate to the extruder.

[0094] Embodiment 13: The process of any of Embodiments 1 - 12, wherein the process is a batch process.

[0095] Embodiment 14: The process of any of Embodiments 1 - 13, wherein the quencher composition comprises a polycarbonate and/or an additive.

[0096] Embodiment 15: The process of any of Embodiments 1 - 14, wherein the adding of the quencher composition occurs before and/or after the directing of the polycarbonate to the extruder.

[0097] Embodiment 16: The process of any of Embodiments 1 - 15, wherein the melt polymerizing comprises polymerizing the polycarbonate in a series of polymerization units and wherein the process further comprises adding the quencher composition after one or more of the polymerization units.

[0098] Embodiment 17: The process of any of Embodiments 1 - 16, wherein the quencher composition comprises a sulfonic acid ester.

[0099] Embodiment 18: The process of any of Embodiments 1 - 17, wherein the quencher composition is added directly to the extruder after a final polymerization unit.

[0100] Embodiment 19: The process of Embodiment 18, wherein the quencher composition is added to the throat of the extruder.

[0101] Embodiment 20: The process of any of Embodiments 18 - 19, wherein the quencher composition is side injected into the extruder downstream of the throat of the extruder.

[0102] Embodiment 21: The process of any of Embodiments 1 - 20, wherein the catalyst composition comprises a beta catalyst.

[0103] Embodiment 22: The process of Embodiment 21, wherein the beta catalyst comprises a tetraphenyl phosphonium acetate.

[0104] Embodiment 23: The process of any of Embodiments 21 - 22, wherein the melt polymerizing comprises using a greater amount of beta catalyst than alpha catalyst.

[0105] Embodiment 24: The process of any of Embodiments 1 - 20, wherein the melt polymerization uses only the alpha catalyst.

[0106] Embodiment 25: A melt polymerization process comprising: melt polymerizing reactants in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises only a beta catalyst; adding a quencher composition to the polycarbonate, wherein the quencher composition comprises a quencher; and directing the polycarbonate to an extruder.

[0107] Embodiment 26: The process of any of Embodiments 1 – 25, wherein the quencher composition comprises 1 to 10 ppm alkyl tosylate, based upon 100 parts of the polycarbonate.

[0108] Embodiment 27: The process of any of Embodiments 1 – 26, wherein the quencher composition comprises 1 to 10 ppm phosphorous acid, based upon 100 parts of the polycarbonate.

[0109] Embodiment 28: The process of any of Embodiments 1 – 27, wherein the quencher composition comprises 2 to 5 ppm alkyl tosylate and 2 to 5 ppm phosphorous acid, based upon 100 parts of the polycarbonate.

[0110] Embodiment 29: The process of any of Embodiments 1 – 28, wherein the quencher composition comprises n-butyl tosylate.

[0111] Embodiment 30: The process of any of Embodiments 1 – 27, wherein the quencher composition comprises 1 to 7 ppm quencher, based upon 100 parts of the polycarbonate.

[0112] Embodiment 31: The process of any of Embodiments 1 – 27, wherein the quencher composition comprises 1.5 to 3 ppm quencher, based upon 100 parts of the polycarbonate.

[0113] Embodiment 32: The process of any of Embodiments 1 – 31, wherein the quencher comprises a difunctional compound having an acid or acid ester moiety and an amine moiety.

[0114] Embodiment 33: The process of any of Embodiments 1 – 32, wherein the quenching composition includes a compound of formula: $R_a R_b R_c N^+ - A - SO_3^-$ wherein R_a and R_b are each independently hydrogen, C_1 - C_{12} alkyl, C_1 - C_{12} aryl, or C_1 - C_{18} alkylaryl; R_c is a hydrogen; R_a , R_b , singly or in combination form a heterocyclic ring structure with N; and A is C_1 - C_{12} alkyl, C_1 - C_{12} aryl, or C_1 - C_{18} alkylaryl.

[0115] Embodiment 34: The process of any of Embodiments 1 – 33, wherein an amount of quencher is added to reduce branching to less than or equal to 100 ppm.

[0116] Embodiment 35: The process of any of Embodiments 1 – 34, wherein the quencher has a pKa of less than or equal to 5.

[0117] Embodiment 36: The process of any of Embodiments 1 – 35, wherein the quencher has a pKa of less than or equal to 3.

[0118] Embodiment 37: The process of any of Embodiments 1 – 36, wherein the melt polymerizing comprises reacting the reactants in a wire-wetting fall polymerizer.

[0119] Embodiment 38: The process of any of Embodiments 1 – 37, wherein the melt polymerizing comprises reacting the reactants in the presence of the catalyst composition, adding additional catalyst and further melt polymerizing the reactants.

[0120] Embodiment 39: The process of Embodiment 38, further comprising adding the quencher before adding the additional catalyst.

[0121] Embodiment 40: The process of any of Embodiments 38 - 39, further comprising adding the quencher after the further melt polymerizing of the reactants.

[0122] Embodiment 41: The process of any of Embodiments 1 – 40, further comprising introducing an additive to the polycarbonate.

[0123] Embodiment 42: The process of any of Embodiments 1 – 41, wherein the quencher composition comprises a heat stabilizer and introducing the additive occurs after adding of the quencher composition, and wherein the additive comprises a release agent and a UV agent.

[0124] Embodiment 43: The process of any of Embodiments 41 - 42, wherein the additive is introduced to at least one of a reaction vessel, the extruder, and a mixer.

[0125] Embodiment 44: The process of any of Embodiments 41 – 43, further comprising filtering the additive prior to introducing the additive to the polycarbonate.

[0126] Embodiment 45: The process of any of Embodiments 1 – 44, further comprising filtering the quencher composition prior to adding the quencher composition.

[0127] Embodiment 46: The process of any of Embodiments 1 – 45, further comprising, prior to the adding of the quencher composition, pumping quencher composition to a dosing pump controlled by a main distribution loop.

[0128] Embodiment 47: The process of Embodiment 46, wherein the dosing pump has a rate of 300 to 1,550 rpm.

[0129] Embodiment 48: The process of any of Embodiments 46 - 47, further comprising monitoring the addition of the quencher composition to the polycarbonate with a flow meter, either continuously or intermittently.

[0130] Embodiment 49: The process of Embodiment 48, further comprising a controller for automated monitoring of the flow meter and adjustment of the amount of the quencher composition to the polycarbonate.

[0131] Embodiment 50: The process of Embodiment 49, wherein the rate is 500 to 1,450 rpm.

[0132] Embodiment 51: The process of any of Embodiments 1 – 26 and 28 – 48, wherein the quencher composition comprises 1 to 10 ppm phosphorous acid, based upon 100 parts of the polycarbonate, and wherein the adding of the quencher composition is at a flow rate of 1 to 5 kg/hr.

[0133] Embodiment 52: The process of Embodiment 50, wherein the flow rate is 2.2 to 2.7 kg/hr.

[0134] Embodiment 53: The process of any of Embodiments 1 – 52, wherein the melt polymerizing comprises oligomerizing at an oligomerization temperature of 100°C to 280°C, and polymerizing at a polymerization temperature of 250°C to 310°C, and wherein the oligomerization temperature is less than the polymerization temperature.

[0135] Embodiment 54: The process of Embodiment 53, wherein the oligomerizing is at an oligomerization pressure of greater than 100 mbara.

[0136] Embodiment 55: The process of any of Embodiments 53 – 54, wherein the oligomerizing comprises a first oligomerization at a first oligomerization temperature of 150°C to 260°C at a first oligomerization pressure of greater than or equal to 100 mbara; and a subsequent oligomerization at a second oligomerization temperature of 230°C to 280°C, and a second oligomerization pressure of 15 to 90 mbara.

[0137] Embodiment 56: The process of any of Embodiments 53 – 55, wherein the polymerizing comprises a first polymerization at a first polymerization temperature of 260°C to 310°C at a polymerization pressure of 1 to 10 mbara; and a subsequent polymerization at a second polymerization temperature of 260°C to 300°C, and a second polymerization pressure of less than or equal to 5 mbara.

[0138] Embodiment 57: The process of Embodiment 56, wherein the first polymerization temperature is 260°C to 285°C; and the second polymerization temperature is 260°C to 285°C.

[0139] Embodiment 58: The process of any of Embodiments 56 – 57, wherein the first polymerization temperature is 270°C to 280°C; and the second polymerization temperature is 270°C to 280°C.

[0140] Embodiment 59: The process of any of Embodiments 56 – 58, wherein the adding of the quencher composition comprises adding the quenching composition before the second polymerization.

[0141] Embodiment 60: The process of any of Embodiments 56 – 59, wherein the adding of the quencher composition comprises adding the quenching composition after the second polymerization.

[0142] Embodiment 61: The process of any of Embodiments 53 – 54, wherein the polymerizing is in one or more wire wetting polymerizers and the polymerization temperature is 200°C to 300°C, and the polymerization pressure is less than or equal to 4 mbara.

[0143] Embodiment 62: The process of Embodiment 61, wherein the polymerization temperature is 250°C to 280°C.

[0144] Embodiment 63: The process of any of Embodiments 53 - 62, wherein the polymerizing comprises a first polymerization unit and a second unit, wherein a polycarbonate produced in the first polymerization unit has a number average molecular weight of 20,000 to 50,000 Daltons.

[0145] Embodiment 64: The process of Embodiment 63, wherein the polycarbonate increases its molecular weight by less than or equal to 10 wt% in the second unit and wherein the process further comprises devolatizing in the second unit.

[0146] Embodiment 65: The process of any of Embodiments 1 – 64, wherein the extruder is a counter rotating twin screw extruder.

[0147] Embodiment 66: The process of any of Embodiments 20 – 65, wherein the beta catalyst comprises tetraphenyl phosphonium acetate.

[0148] Embodiment 67: The process of any of Embodiments 1 – 66, wherein a ratio of quencher to catalyst is 3:1 to 2:1.

[0149] Embodiment 68: The process of any of Embodiments 1 - 67, wherein, before the melt polymerizing, further comprising introducing a first reactant to a mixer; melting the first reactant; then adding a second reactant and the catalyst composition to the mixer.

[0150] Embodiment 69: The process of Embodiment 68, wherein the first reactant is selected from diaryl carbonate and dihydroxy compound.

[0151] Embodiment 70: The process of any of Embodiments 68 - 69, wherein the second reactant is selected from diaryl carbonate and dihydroxy compound.

[0152] Embodiment 71: The process of any of Embodiments 1 – 70, further comprising devolatizing the polycarbonate composition.

[0153] Embodiment 72: The process of Embodiment 71, wherein the devolatizing occurs in the extruder and/or in a polymerization unit.

[0154] Embodiment 73: The process of any of Embodiments 71 – 72, wherein the devolatizing occurs after quenching.

[0155] Embodiment 74: The process of any of Embodiments 1 - 73, wherein the process comprises a section of parallel polymerization.

[0156] Embodiment 75: The process of Embodiment 74, wherein the section of parallel polymerization comprises: polymerizing polycarbonate in a series of oligomerization units; splitting a stream exiting an oligomerization unit into a stream A and a stream B, directing stream A to a polymerization unit A and directing stream B to a polymerization unit B.

[0157] Embodiment 76: The process of Embodiment 74, wherein the section of parallel polymerization oligomerization units, then polymerizing in a series of polymerization units, splitting a stream exiting a final polymerization unit into a stream A and a stream B, directing stream A to an extruder A and directing stream B to an extruder B.

[0158] Embodiment 77: The process of Embodiment 74, wherein the section of parallel polymerization comprises: polymerizing polycarbonate in a series of oligomerization units, then polymerizing in a series of two polymerization units; splitting a stream exiting a first polymerization unit into a stream A and a stream B, directing stream A to a second polymerization unit A and directing stream B to a second polymerization unit B.

[0159] Embodiment 78: The process of any of Embodiments 1 - 77, wherein adding the quencher composition comprises spraying the quencher composition onto pelletized polycarbonate.

[0160] Embodiment 79: A melt polymerization process comprising: melt polymerizing a polycarbonate wherein the melt polymerization comprises reacting reactants in the presence of a catalyst composition; directing the polycarbonate to an extruder; selecting a quencher composition based upon a balance of color stability, retention of a UV agent, and hydrolytic stability; and adding the quencher composition upstream of and/or directly into the extruder, wherein the quencher composition comprises a quencher.

[0161] Embodiment 80: A melt polycarbonate made by the process of any of Embodiments 1 – 79.

[0162] Embodiment 81: The process of any of Embodiments 1 – 80, wherein the polycarbonate is a bisphenol A polycarbonate.

[0163] Embodiment 82: The process of any of Embodiments 1 – 81, wherein the pressure is greater than or equal to 3 bars.

[0164] Embodiment 83: The process of any of Embodiments 1 – 82, wherein the pressure is 3 bars to 100 bars.

[0165] Embodiment 84: The process of Embodiment 11, wherein adding the quencher composition to the polycarbonate occurs at a pressure of greater than or equal to 2 bars and/or wherein mixing the quencher composition with the polycarbonate occurs for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any additives having a reactive OH group or reactive ester group.

[0166] Embodiment 85: a process of adding a quencher composition comprising: feeding a polycarbonate to an extruder; adding the quencher composition to the polycarbonate, wherein the quencher composition is a solid quencher composition; and mixing the quencher composition with the polycarbonate for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any reactive additive, wherein the reactive additive has a reactive OH group or reactive ester group; wherein the polycarbonate is a melt polycarbonate.

[0167] Embodiment 86: The process of Embodiment 85, further comprising pelletizing the polymerized polycarbonate prior to feeding.

[0168] Embodiment 87: The process of any of Embodiment 85-86, further comprising melting the polymerized polycarbonate prior to adding the solid quencher composition.

[0169] Embodiment 88: The process of any of Embodiment 85-87, wherein the solid quencher composition comprises a polycarbonate powder.

[0170] Embodiment 89: The process of Embodiment 85-88, wherein the quencher composition is free of a carrier.

[0171] Embodiment 90: The process of any of Embodiments 1, 3, 11-84, wherein the quencher composition is a solid quencher composition.

[0172] Embodiment 91: The process of any of Embodiments 1-90, wherein the quencher reduces the activity of the catalyst.

[0173] As used herein, when referring to “reactive” or a “reactive group”, e.g., having a reactive OH group or a reactive ester group, the reactivity is with respect to polycarbonate.

[0174] In general, the invention may alternately comprise, consist of, or consist essentially of, any appropriate components herein disclosed. The invention may additionally,

or alternatively, be formulated so as to be devoid, or substantially free, of any components, materials, ingredients, adjuvants or species used in the prior art compositions or that are otherwise not necessary to the achievement of the function and/or objectives of the present invention.

[0175] All ranges disclosed herein are inclusive of the endpoints, and the endpoints are independently combinable with each other (e.g., ranges of “up to 25 wt%, or, more specifically, 5 to 20 wt%”, is inclusive of the endpoints and all intermediate values of the ranges of “5 to 25 wt%,” etc.). “Combination” is inclusive of blends, mixtures, alloys, reaction products, and the like. Furthermore, the terms “first,” “second,” and the like, herein do not denote any order, quantity, or importance, but rather are used to denote one element from another. The terms “a” and “an” and “the” herein do not denote a limitation of quantity, and are to be construed to cover both the singular and the plural, unless otherwise indicated herein or clearly contradicted by context. The suffix “(s)” as used herein is intended to include both the singular and the plural of the term that it modifies, thereby including one or more of that term (e.g., the film(s) includes one or more films). Reference throughout the specification to “one embodiment,” “another embodiment,” “an embodiment,” and so forth, means that a particular element (e.g., feature, structure, and/or characteristic) described in connection with the embodiment is included in at least one embodiment described herein, and may or may not be present in other embodiments. “Or” means “and/or.” In addition, it is to be understood that the described elements may be combined in any suitable manner in the various embodiments. Disclosure of a narrower range or more specific group in addition to a broader range is not a disclaimer of the broader range or larger group. This application claims priority to European Patent Applications 13382423.5 and EP 13382419.3 both filed October 23, 2013, which are incorporated herein by reference in their entirety.

[0176] While particular embodiments have been described, alternatives, modifications, variations, improvements, and substantial equivalents that are or may be presently unforeseen may arise to applicants or others skilled in the art. Accordingly, the appended claims as filed and as they may be amended are intended to embrace all such alternatives, modifications variations, improvements, and substantial equivalents.

[0177] I/we claim:

CLAIMS

1. A melt polymerization process comprising:

melt polymerizing reactants in at least two polymerization units, in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises an alpha catalyst, wherein the alpha catalyst comprises a source of alkali and/or alkaline earth ions;

combining a liquid carrier and a quencher in a quencher vessel to form a quencher composition;

adding the quencher composition to the polycarbonate at a pressure of greater than or equal to 2 bars;

mixing the quencher composition with the polycarbonate for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any additives having a reactive OH group or reactive ester group;

filtering the polycarbonate; and

directing the polycarbonate to an extruder.

2. The process of Claim 1, wherein the liquid carrier comprises diarylcarbonate, phenol, bisphenol A, polycarbonate oligomers, bisphenol A derivatives, propylene carbonate, xylene, toluene, benzene, ethylbenzene, anisole, chlorobenzene, water, acetone, or a combination comprising one or more of the foregoing.

3. A melt polymerization process comprising:

melt polymerizing reactants in at least two polymerization units, in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises an alpha catalyst, wherein the alpha catalyst comprises a source of alkali and/or alkaline earth ions;

melting a quencher to form a quencher composition, wherein the quencher composition is free of a carrier;

adding the quencher composition to the polycarbonate;

filtering the polycarbonate; and

directing the polycarbonate to an extruder.

4. A melt polymerization process comprising:
melt polymerizing reactants in the presence of a catalyst composition to form polycarbonate, wherein the catalyst composition comprises only a beta catalyst, wherein the beta catalyst comprises a quaternary ammonium compound, a quaternary phosphonium compound, or a combination comprising at least one of the foregoing;
adding a quencher composition to the polycarbonate, wherein the quencher composition comprises a quencher; and
directing the polycarbonate to an extruder.
5. The process of Claim 4, wherein the beta catalyst comprises tetraphenyl phosphonium acetate.
6. A process of adding a quencher composition comprising:
feeding a polycarbonate to an extruder;
adding a quencher composition to the polycarbonate, wherein the quencher composition is a solid quencher composition; and
mixing the quencher composition with the polycarbonate for a period of time of greater than or equal to 5 seconds prior to the addition to the polycarbonate of any reactive additive, wherein the reactive additive has a reactive OH group or reactive ester group;
wherein the polycarbonate is a melt polycarbonate.
7. The process of Claim 6, further comprising pelletizing the polymerized polycarbonate prior to feeding.
8. The process of any of Claims 6-7, further comprising melting the polymerized polycarbonate prior to adding the solid quencher composition.
9. The process of any of Claims 6-8, wherein the solid quencher composition comprises a polycarbonate powder.
10. The process of Claims 4-8, wherein the quencher composition is free of a carrier.
11. The process of any of the preceding claims, wherein the quencher composition comprises 1 to 10 ppm alkyl tosylate, based upon 100 parts of the polycarbonate.
12. The process of any of the preceding claims, wherein the quencher composition comprises 1 to 10 ppm phosphorous acid, based upon 100 parts of the polycarbonate.
13. The process of any of the preceding claims, wherein the quencher composition comprises n-butyl tosylate.

14. The process of any of the preceding claims, wherein the melt polymerizing comprises reacting the reactants in a wire-wetting fall polymerizer.
15. The process of any of the preceding claims, further comprising filtering the quencher composition prior to adding the quencher composition.
16. The process of any of the preceding claims, wherein the melt polymerizing comprises oligomerizing at a oligomerization temperature of 100 to 280°C, and wherein the polymerizing comprises a first polymerization that occurs at a first polymerization temperature of 260 to 310°C and at a first polymerization pressure of 1 to 10 mbara; and a second polymerization that occurs at a second polymerization temperature of 260 to 300°C and a second polymerization pressure of less than or equal to 5 mbara.
17. The process of any of the preceding claims, wherein a ratio of quencher to catalyst is 3:1 to 2:1.
18. The process of any of the preceding claims, further comprising devolatilizing the polymerized polycarbonate for greater than or equal to 5 seconds after adding the quencher composition.
19. The process of any of the preceding claims, wherein adding the quencher composition comprises spraying the quencher composition onto pelletized polycarbonate.
20. The process of any of the preceding claims, wherein the catalyst composition comprises tetraphenyl phosphonium acetate.
21. The process of Claims 1-3 and 5-23, wherein the melt polymerization uses only the alpha catalyst.
22. The process of any of the preceding claims, wherein the melt polymerizing comprises reacting the reactants in the presence of the catalyst composition, adding additional catalyst and further melt polymerizing the reactants; and further comprising adding a first liquid quencher before adding the additional catalyst.

