

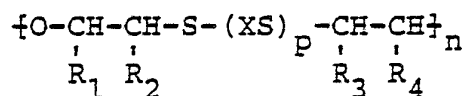


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(54) Title: LIQUID POLYTHIOETHERS**(57) Abstract**

A non-crystallizing, water, solvent, fuel and temperature resistant liquid polythioether having two to four terminating radicals which do not substantially reduce the water, solvent, fuel and temperature resistance and a water, solvent, fuel and temperature resistant polymeric backbone having repeating units of the formula:



wherein each of R_1 , R_2 , R_3 and R_4 is hydrogen or lower alkyl providing that a sufficient number of R_1 , R_2 , R_3 and/or R_4 are lower alkyl in said polymeric backbone to render said backbone non-crystallizing; X is a divalent organic radical selected from $-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{S}-\text{CH}_2-\text{CH}_2-$ or $-\text{CH}_2-\text{CH}_2-\text{O}-\text{CH}_2-\text{CH}_2-$; n is 8 to 200; and p is 0 or 1.

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LIQUID POLYTHIOETHERSCross-Reference to Related Applications:

This application is a continuation-in-part of
copending application Serial No. 213,173 filed on December
4, 1980 and copending application Serial No. 231,319 filed
5 on February 4, 1981.

Background of the Invention:

There are not many liquid polymers available in
the marketplace today which have good fuel, solvent, water
10 and temperature resistance. Of those liquid polymers available
in the marketplace, many are relatively expensive and the
remainder have other disadvantages.

Certain prior art workers have made hydroxyl
terminated polythioethers by condensing thiodiglycol in the
15 presence of certain etherifying catalysts as, for example,
shown in U.S. Patent 3,312,743 and 3,335,189. Compounds
produced by these patents give semi-crystalline waxy solids,
gums or low molecular weight liquids which have limited
commerical utility.

20 Copolymerization of thiodiglycol with dihydric
alcohols is disclosed in U.S. Patents 3,005,803; 3,985,708
and 4,093,599. Due to the fact that the hydroxyl groups on
the dihydric alcohols have lower activity towards condensa-
tion than the hydroxyl groups on thiodiglycol the condensa-
25 tion is irregular and/or incomplete which causes the reaction product
to have a very wide molecular weight distribution which is
undesirable. Just as importantly, the dihydric alcohols
are non-sulfur containing and therefore incorporation of
these non-sulfur containing monomers in the polymer backbone
30 significantly reduces the solvent and fuel resistance of the
resulting polymer.

In addition to the foregoing deficiencies with the
previously known polythioethers, the prior art polythio-
ethers are also crystallizing products which, even if liquid



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or semi-liquid at ambient temperatures, when they are cooled sufficiently to solidify will not return to their previous liquid state even when the temperature is raised to ambient.

5: Summary of the Invention:

It is therefore the primary object of the present invention to disclose and provide liquid, non-crystallizing polythioethers having a water, solvent, fuel and temperature resistant backbone.

10: It is a further object of the present invention to disclose and provide relatively high molecular weight liquid polythioethers which are water, solvent, fuel and temperature resistant.

It is still another object of the present invention
15: to embody liquid, non-crystallizing polythioethers which have a water, solvent, fuel and temperature resistant backbone with varying end groups which make them useful for a wide variety of applications.

Still a further object of the present invention is
20: to disclose liquid, non-crystallizing polythioethers which have a water, solvent, fuel and temperature resistant backbone and terminating chemically non-reactive radicals.

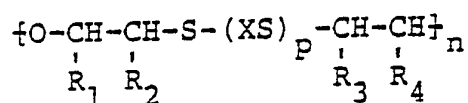
Another and further object of the present invention is to disclose and provide liquid, non-crystallizing poly-
25: thioethers which are vulcanizable to elastomers which are water, solvent, fuel and temperature resistant and exhibit elastomeric properties over a wide range of temperatures.

It is still another object of the present invention to disclose vulcanized solid elastomers which are water,
30: solvent, fuel and temperature resistant.

These and other objects of the present invention, which will be apparent to the art-skilled, are accomplished by providing a non-crystallizing, water, solvent, fuel and temperature resistant linear or branched polymeric backbone
35: having repeating units or groups of the formula



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wherein X is a radical consisting of $-\text{CH}_2-\text{CH}_2-\text{CH}_2-\text{CH}_2-$,

5 $-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{S}-\text{CH}_2-\text{CH}_2-$, or $-\text{CH}_2-\text{CH}_2-\text{O}-\text{CH}_2-\text{CH}_2-$;

n is from 8 to 200; p is 0 or 1; and each of R_1 , R_2 , R_3 and R_4 is hydrogen or lower alkyl (preferably methyl) with the provision that the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is
 10 sufficient to render said backbone non-crystallizing. In general it may be said that the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/5$,
 15 preferably $n/4$. In other words, in the case of $n/4$, when n is 8 at least two of R_1 , R_2 , R_3 or R_4 would be lower alkyl in the polymeric backbone. On the other hand when n is, for example, 200 at least about 50 of R_1 , R_2 , R_3 and/or R_4 would be lower alkyl in the polymeric backbone which could
 20 be accomplished (1) by having R_1 and R_4 both lower alkyl in at least about 12% to 13% of the units or groups or (2) by having R_1 lower alkyl in at least about 25% of the units or groups. In all of the foregoing exemplary cases the resulting polymeric backbone is non-crystallizing.

25 The polymeric backbone may be terminated with any type of terminating radical providing that said radical does not substantially reduce the water, solvent, fuel and temperature resistance of the liquid polythioether polymer. The number of such terminating radicals on the
 30 non-crystallizing liquid polythioether conveniently ranges from 2 to 4 but may be higher than 4 depending on the molecular weight and branching of the polymer. Such terminating radicals include vulcanizable radicals, for example room or low temperature vulcanizable radicals, as well as

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chemically non-reactive radicals. In the case of non-crystallizing liquid polythioethers having terminating vulcanizable radicals such liquid polythioethers may be cured or vulcanized to solid polythioether elastomers which are water, solvent, fuel and temperature resistant and exhibit elastomeric properties over a wide range of temperatures. In the case of those non-crystallizing liquid polythioethers having terminating chemically non-reactive radicals, such liquid polythioethers may be used as plasticizers, dielectric fluids, high temperature lubricants and non-curing sealants.

Whatever the use of the non-crystallizing liquid polythioethers of this invention, they will in general have a molecular weight of at least about 900 to as high as about 25,000, the particular molecular weight desired being a matter of choice.

It should be noted that by "non-crystallizing" we mean a polymer which is liquid at ambient and is not a semi-crystalline wax, gum or solid. Moreover, the non-crystallizing polymer, even when cooled to a sufficiently low temperature to become a solid, will be an amorphous solid which, when the temperature is raised to ambient, will return to the liquid state.

25 Description of the Preferred Embodiments:

In general the liquid polythioethers of the present invention will be made by condensing one or more beta-thioether diols. By "beta-thioether diol" we mean a thioether diol wherein each hydroxyl group in the diol is located beta to a sulfur atom, i.e. each hydroxyl group will be separated from a sulfur atom by two carbon atoms. A certain percentage, ranging up to 100 mole %, of the starting beta-thioether diols will have at least one (preferably one or two) branched lower alkyl, i.e. there will be a lower alkyl group (preferably a methyl group) attached to at least one of the two carbon atoms separating the



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sulfur and hydroxyl groups so that at least one of said hydroxyl groups will have a lower alkyl group located alpha or beta to said hydroxyl group. Hereinafter such beta-thioether diols will be referred to as "substituted beta-thioether diols".

The substituted beta-thioether diol may be the only beta-thioether diol used in the condensation reaction which produces the liquid polythioether backbone but there may also be used an "unsubstituted beta-thioether diol" by which we mean a beta-thioether diol wherein the two carbon atoms separating the sulfur and hydroxyl groups are unsubstituted, i.e. have the structure of $\text{HO}-\text{CH}_2-\text{CH}_2-\text{S}-$. The preferred unsubstituted beta-thioether diol is thio-diglycol, bis (beta-hydroxyethyl) sulfide.

As noted the amount of substituted beta-thioether diol in the condensation reaction may be 100% but may be less. However, the least amount of substituted beta-thioether diol which may be used must be sufficient to render the resulting liquid polythioether non-crystallizing. In general, the number of branched alkyls present in the liquid polythioether will be the quotient of $n/5$ or, preferably, $n/4$ where n has the same meaning as before. Therefore, where there is only one branched alkyl per substituted beta-thioether diol there should be present at least 20 or 25 mole % substituted beta-thioether diol in the condensation reaction and where there are two branched alkyls per substituted beta-thioether diol there should be present at least about 10 to 13 mole % of substituted beta-thioether diol in the condensation reaction.

As has been noted before, the liquid polythioethers of the present invention may be either linear or branched. In order to provide a linear polythioether all that is necessary is to condense the beta-thioether diols referred to above. In this case a non-crystallizing water, solvent, fuel and temperature resistant linear polymeric backbone



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is formed having two terminating hydroxyl groups or radicals thereon, such terminating hydroxyl groups being terminating vulcanizable groups. The resulting linear liquid polythioether having the two terminating hydroxyl radicals may be vulcanized to a solid elastomer at either low or high temperatures.

As will be explained in greater detail, if other terminating radicals, such as terminating vulcanizable radicals, are desired they may be added by including a condensable organic compound having a terminating radical in the initial condensation reaction with the beta-thioether diol. Alternatively, other terminating radicals, including terminating chemically non-reactive radicals as well as terminating vulcanizable radicals, may be added after formation of the hydroxyl terminated linear liquid polythioether by reacting such linear polythioether with an organic compound having the required terminating radicals as well as radicals reactive with hydroxyl groups.

To have a branched liquid polythioether there should also be used as a starting material in the condensation reaction of the beta-thioether diols an organic triol or tetrol of the formula $R(OH)_m$ where m is 3 or 4 and R is any tri- or tetravalent organic radical having no groups reactive with hydroxyl radicals. It is preferred that such triol or tetrol have a molecular weight less than 400 and more preferable that the molecular weight be less than 360. R is preferably aliphatic sulfide or hetero aliphatic sulfide and more preferably alkyl sulfide or hetero alkyl (e.g. oxyalkyl) sulfide, the number of sulfur atoms ranging from 2 to 6 and preferably from 2 to 4. R will, in general, also have from 6 to 16 carbon atoms. The amount of organic triol or tetrol used is not particularly critical. In general it may be said that the amount of organic triol or tetrol used will be between about .1 mole % to 5 mole % based on the total moles of beta-thioether diol.



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In order to have complete condensation between the beta-thioether diols and all of the hydroxyl groups on the organic triol or tetrol and thereby have a relatively high molecular weight branched liquid polythioether with substantially uniform chain lengths it is believed necessary that the organic triol or tetrol be a beta-thioether triol or tetrol, the term "beta-thioether" having the same meaning as previously defined for the term "beta-thioether diol". In other words, each hydroxyl group in the beta-thioether triol or tetrol should be separated from a sulfur atom by two carbon atoms so that the reactivity of the hydroxyl groups in the beta-thioether triol or tetrol is substantially the same as the reactivity of the hydroxyl groups in the beta-thioether diol. Additionally, since the beta-thioether triol or tetrol contains sulfur there is little, if any, loss of fuel and/or solvent resistance in the resulting branched or polyfunctional liquid polythioether of the present invention.

It should be noted that when we speak of a branched polymer having a functionality of 3 or 4, we mean the polymer per se and not the mixture of polymers formed by the condensation reaction. In practice, the condensation reaction between the beta-thioether diol and organic triol and/or tetrol will, depending on the relative amounts of the starting materials, produce a mixture of polymers, some having a functionality of 2 (i.e. linear polymers), and some having a functionality of greater than two. The resulting mixture, taken as a whole, may have a functionality of slightly greater than 2 (e.g. 2.05) to as high as about 4. One skilled in the art may vary the functionality of the mixture of polymers by varying the relative amounts of starting materials to produce a mixture having physical properties, etc. which are desired.

As noted above, the non-crystallizing liquid polythioethers formed by the condensation reactions referred to above have 2 to 4 terminating vulcanizable radicals, i.e. hydroxyl groups. In addition to having terminating vulcanizable radicals, the liquid polythioethers of the

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present invention may have other terminating radicals such as terminating chemically non-reactive radicals.

Such liquid, polythioethers having terminating chemically non-reactive radicals may be formed in situ by including in the condensation reaction an organic compound which is chemically non-reactive except for a condensable radical (e.g. a hydroxyl radical) which will react with the hydroxyl groups in the beta-thioether diols during the condensation reaction thereby forming a liquid polythioether which is terminated with the chemically non-reactive radical of said organic compound, which will hereinafter be referred to as a "condensable, non-reactive organic compound". Alternatively, the terminal chemically non-reactive radicals may be introduced after formation of the hydroxyl terminated liquid polythioether by reaction with an organic compound which has a radical reactive with said terminal hydroxyl groups (hereinafter referred to as hydroxyl reactive organic compound). This hydroxyl reactive organic compound may have, as the only reactive group, a group which is reactive with hydroxyl, the remainder of the compound being chemically non-reactive, in which event there is formed a liquid polythioether terminated with chemically non-reactive radicals. On the other hand, the hydroxyl reactive organic compound may be difunctional, i.e. contain a reactive functional group in addition to the hydroxyl reactive group, in which case there is formed a liquid polythioether terminated with reactive functional groups, to which may be added an organic compound which has, as the only reactive group, a group which will react with said reactive functional groups, the remainder of the compound being chemically non-reactive thereby forming a non-crystallizing reactive radical.

In any event, the non-crystallizing water, solvent, fuel and temperature resistant linear liquid polythioethers of the present invention will have 2 terminating radicals and the branched liquid polythioethers will have 3 to 4 terminating radicals, said terminating radicals not substantially reducing the water, solvent, fuel and temperature



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resistance of the liquid polythioether.

The terminating radicals will include, inter alia, chemically non-reactive radicals as well as vulcanizable radicals such as low temperature vulcanizable radicals. It
5 should be noted that by "low temperature" we mean a radical which is vulcanizable at a temperature of less than about 150°F. and preferably less than about 100°F..

In any event, the condensation of the beta-thioether diol, triol or tetrol and, if desired, the
10 aforesaid organic compound having a condensable group, is accomplished by methods known in the art and therefore, again, no detailed exemplification thereof is necessary to teach those skilled in the art how to accomplish the condensation reaction. As is known, the reactants are
15 mixed with a suitable etherifying catalyst and heated until water splits off which is then allowed to vaporize until such point in time as is necessary to pull a vacuum to remove the last traces of water. This is continued until the desired polymeric length is obtained which can be determined,
20 for example, by determining the hydroxyl number in the reaction mixture.

The temperature at which the condensation reaction takes place may vary widely but in general is between 150°C. and 200°C. but below the boiling point of the reaction
25 mixture. The etherification catalysts used in the present invention are esters or hemi-esters of phosphorous acid.

The preferred catalyst of the present invention is triphenyl phosphite. We have found that this catalyst produces excellent results, giving liquid polymers with
30 narrower molecular weight distributions and less by-products.

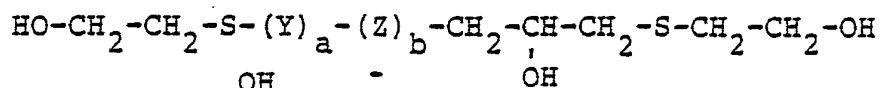
As has been noted, it is preferred in the present invention that the organic triol or tetrol be a beta-thioether triol or tetrol since if used it will be included in the initial condensation reaction. The preferred beta-
35 thioether triols and tetrols will have a molecular weight



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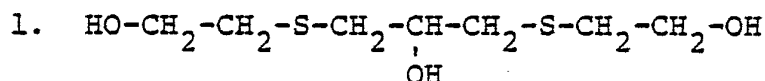
less than 360, have from 6 to 16 carbon atoms, have from 2 to 6 sulfur atoms, contain no groups or atoms which are reactive with hydroxyl groups (other than the three or four reactive hydroxyl groups) and have the formula:

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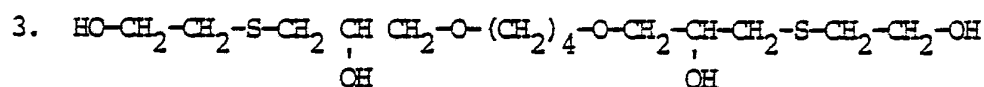
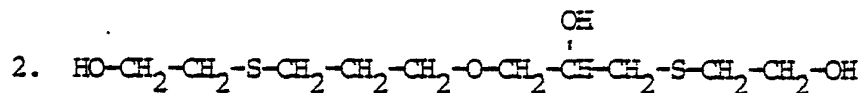


wherein Y is $-\text{CH}_2-\underset{\text{OH}}{\underset{|}{\text{CH}}}-$, each of a and b is 0 or 1 and Z is divalent hetero(lower) aliphatic such as oxy lower aliphatic.

10 Exemplary of such beta-thioether triols or tetrols useful in the present invention are:

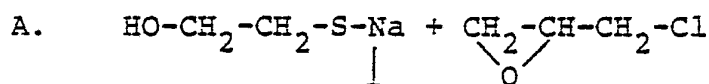


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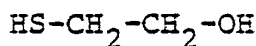
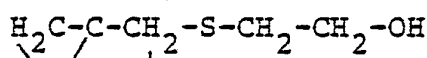


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Such beta-thioether triols and tetrols may be made, for example, by the following reactions:

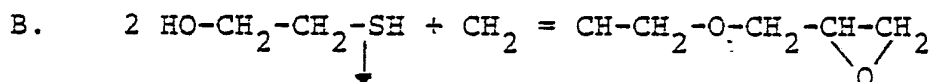


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(1) above.

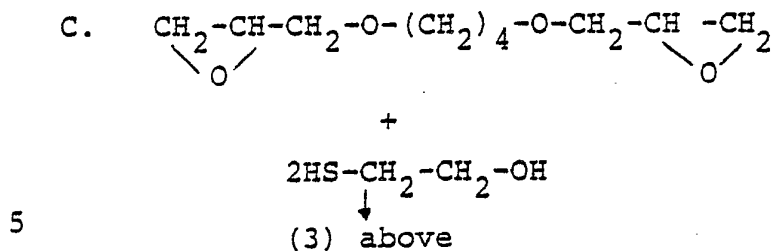
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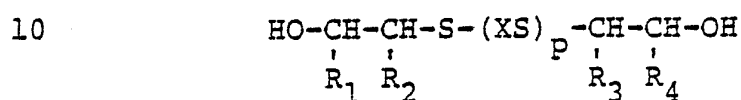
(2) above.



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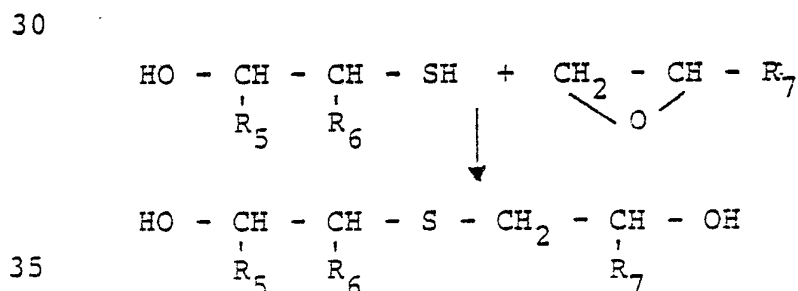
The beta-thioether diols are, in general, known in the art and will have the following formula:



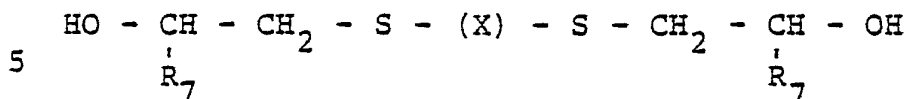
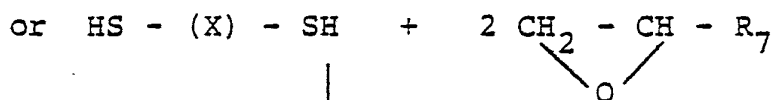
wherein R_1 , R_2 , R_3 , R_4 , X and p have the same meaning as indicated hereinbefore. In the case of the unsubstituted
15 beta-thioether diols each of R_1 , R_2 , R_3 and R_4 is hydrogen and in the case of the substituted beta-thioether diols at least one of R_1 , R_2 , R_3 and R_4 is lower alkyl and preferably methyl and more preferably one or both of R_1 or R_4 are lower alkyl (preferably methyl) and R_2 and R_3 are hydrogen.

20 The unsubstituted beta-thioether diols are known in the art and therefore no detailed exemplification thereof is necessary. An exemplary unsubstituted beta-thioether diol is thiodiglycol.

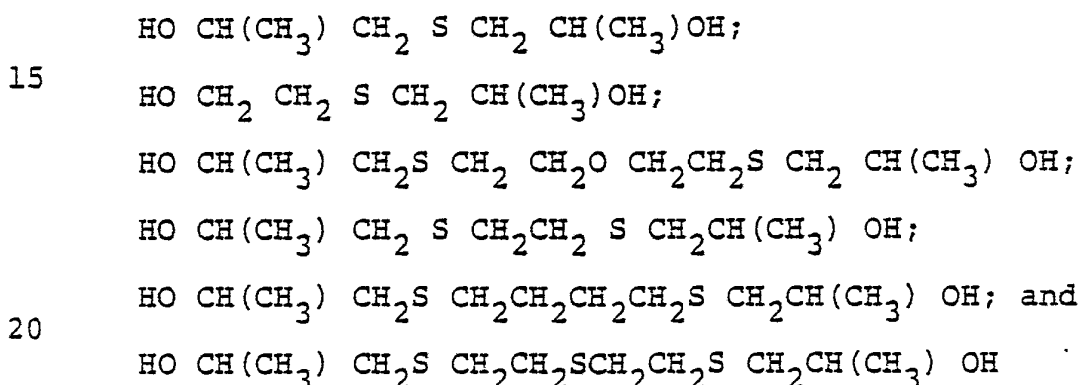
The substituted beta-thioether diols are not as well known in the art but either the substituted or unsubstituted beta-thioether diols may be prepared by reacting mercapto-alcohols or dimercaptans with ethylene oxide or lower alkyl substituted epioxides according to the following reactions:



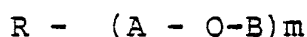
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wherein each of R_5 , R_6 and R_7 is hydrogen or lower alkyl, and X has the same meaning indicated hereinbefore. It should be noted that when R_5 , R_6 and R_7 is hydrogen, unsubstituted beta-thioether diols are formed and when R_5 , R_6 or R_7 is lower alkyl, substituted beta-thioether diols are formed. Exemplary substituted beta-thioether diols are



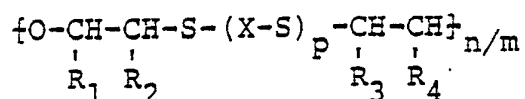
The branched chain liquid polythioethers of this invention will preferably have the formula



wherein R is the fragment or grouping of the organic triol or tetrol $\text{R} - (\text{OH})_m$ which has no chemically reactive groups other than hydroxyl groups and, in general will have a molecular weight of less than 400 and preferably less than 360 and, preferably, each hydroxyl is located beta to a sulfur atom. Also it is preferable if R has from 6 to 16 carbon atoms and 2 to 6 sulfur atoms. It is more preferable if R is aliphatic or hetero aliphatic sulfide, e.g. alkyl or heteroalkyl such as oxyalkyl and contains no reactive

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radical, and does not substantially reduce the water, solvent, fuel and temperature resistance of the polythioether. B is a terminating radical which preferably contains no more than twenty carbon atoms. A is a polymeric backbone or chain consisting of repeating units or groups of the formula

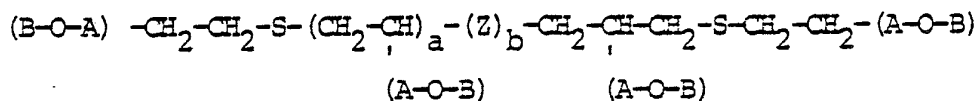


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wherein R_1 , R_2 , R_3 , R_4 , X, p, n and m have the same meaning as indicated hereinbefore.

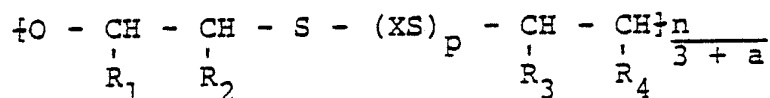
Preferably, the branched chain, non-crystallizing liquid polythioether will have the formula

15



20

where B and Z have the meaning indicated hereinbefore, a is 0 or 1, b is 0 or 1, A is a polymeric backbone or chain consisting of repeating units or groups of the formula

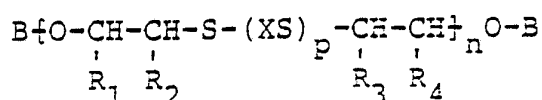


25

wherein R_1 , R_2 , R_3 , R_4 , X, p, n and a have the same meaning as indicated hereinbefore.

The preferred linear polythioether of the present invention having two terminating radicals has the formula

30



35

where R_1 , R_2 , R_3 , R_4 , X, n, p and B have the same meaning as indicated before.

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The type of terminating radical on the liquid polythioethers is not important providing they do not substantially reduce the very desirable properties of the unique backbone of this invention, said properties including water, solvent, fuel and temperature resistance. Thus, the non-crystallizing liquid polythioethers may be used wherever a polymer having such properties are useful. If, for example, a water, solvent, fuel and temperature resistant solid elastomer is desired, the terminal radicals will be terminating vulcanizable radicals and if room or low temperature vulcanizable elastomers are desired such vulcanizable radicals will be low temperature vulcanizable radicals. Such vulcanizable radicals, including low temperature ones, are known in the art and therefore "B" in the previous formulas may include epoxide, reactive silyls, isocyanate, reactive olefinic double bond, mercaptan or is hydrogen of a hydroxyl.

As has already been noted, the polythioethers of the present invention terminated with 2 to 4 hydroxyl groups are made by condensing the beta-thioether diol per se or with the organic triol or tetrol. Polythioethers having other vulcanizable radicals are also easily made. For example, such liquid polythioethers which have reactive olefinic double bonds may be made by adding to the condensation reaction a compound having the formula:
 $\text{HO}-\text{CH}_2-\text{CH}_2-\text{S}-\text{R}'-\text{CH}=\text{CH}_2$ wherein R' is alkylene of 4 to 6 carbon atoms.

Liquid polythioethers having terminating mercaptan radicals may be produced by reacting the polythioethers terminated with olefinic double bonds with an organic compound having two terminal mercaptan groups in the presence of an appropriate catalyst, e.g. a free radical initiating catalyst such as a peroxide and an amine having a pK_a of 6 or less as disclosed in U.S. Patent 3,923,748 issued December 2, 1975.



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As indicated in the 3,923,748 patent, the dimercaptan compounds may have the formula $R''(SH)_2$ wherein R'' is a divalent organic radical such as alkyl, aryl ether, alkyl ether, and the thioether thereof. Exemplary of such dimercaptan compounds, though
5 not limited thereto are beta, beta'-dimercapto diethyl ether, beta, beta'-dimercapto diethyl sulfide, 1,6-dimercapto hexane and p,p'-dimercapto methyl, diphenyl oxide.

The liquid polythioethers having terminating epoxide radicals may be made by reacting the hydroxyl terminated polythioethers
10 with a diepoxide compound such as bisphenol A diglycidyl ether in the presence of an appropriate catalyst.

Similarly, liquid polythioethers having terminating isocyanate radicals may easily be produced by reacting the hydroxyl terminated polythioethers with an organic diisocyanate such as
15 toluene diisocyanate.

The terminating reactive silyl radicals include hydrolyzable silyls such as lower alkoxy silane (e.g. tri (lower)alkoxy silane), acyloxy silane, silane oximes and silane hydrides. For
20 example, a reactive silyl termination may be made by reacting a mercapto silane with the olefin terminated liquid polythioether.

The foregoing liquid polythioethers having terminating olefin radicals can be vulcanized by mixing therewith a stoichiometric amount of di- or trimercaptan and an appropriate catalyst or by free radical mechanism.

25 The liquid polythioethers of the present invention having terminating mercaptan vulcanizable radicals may be vulcanized by using an oxidizing agent such as a dichromate, an organic peroxide, an inorganic peroxide, a diepoxide, etc.

30 The liquid polythioethers having terminating epoxide vulcanizable radicals may be vulcanized by using a di- or triamine or a di- or trimercaptan.

The vulcanized products made from such liquid polythioethers will be solid polythioether elastomers, the vulcanization, in general taking place after application of the
35 liquid polythioether to the desired place, such application being by pouring, brushing, spraying, etc.

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The liquid polythioether may also be mixed with, prior to vulcanization, various additives such as plasticizers, fillers, colorants, and other monomeric or polymeric compounds in order to give the vulcanized polythioether certain desired properties known in the art.

Additionally, cure times and rates may be altered by adding other catalysts, reactants, etc. during vulcanization. For example, the addition of redox catalysts, such as an iron salt has been found to be of value in vulcanizing the mercaptan terminated polythioethers.

In addition to the terminating vulcanizable radicals, the non-crystallizing liquid polythioethers may also contain other terminating radicals such as terminating chemically non-reactive radicals.

It should be noted that by "chemically non-reactive" we mean a radical which is chemically inert or inactive with water and other substances, such as oxygen, generally found in the ambient. We have found, for example, that chemically non-reactive radicals which have a reactivity the same as, or less than the hydrogens on a benzene ring are quite satisfactory. Those chemically non-reactive radicals which are suitable for use in the present invention include aromatic, alkyl, heteroalkyl containing one or more heteroatoms (e.g. thioalkyl, oxyalkyl, etc.), alicyclic and heteroalicyclic, the hetero atom being sulfur and/or oxygen. In general, the number of carbon atoms in the chemically non-reactive radical will not exceed about twenty.

As has already been noted, the liquid polythioethers of our invention which have terminating chemically non-reactive radicals are useful for many purposes including plasticizers, dielectric fluids, high temperature lubricants and non-curing sealants, e.g. mastics.

When the non-crystallizing liquid polythioethers of the present invention are used as plasticizers they may be compounded with a number of liquid polymers with which they are compatible or miscible and may be added in the same amounts and for the same

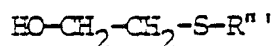


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purpose as any of the common plasticizers. In this regard, the liquid polythioethers having terminating chemically non-reactive radicals of the present invention have all the necessary properties e.g. compatibility, low volatility and non-reactivity, of any good plasticizer but, in addition, also are fuel, solvent, temperature and water resistant as well as being non-crystallizing. The liquid polythioether plasticizers are therefore ideally suited for use with liquid elastomers and, particularly, with fuel, temperature and water resistant elastomers which are non-crystallizing, such as the liquid polythioether elastomers of the present invention.

The liquid polythioethers having terminating chemically non-reactive radicals, when used as plasticizers, may be incorporated with thermoplastic or thermosetting polymers. The amount of plasticizer used with any given polymer is the same as any other known plasticizer and depends upon the properties desired of the final composition. In general, it may be said that the amount of plasticizer will be between 1 and 50 parts by weight per hundred parts by weight of resin (phr). As noted before, such plasticizers are particularly useful when used in conjunction with liquid elastomers such as nitrile rubbers, polysulfides (e.g. Thiokol), etc. Particularly preferred non-crystallizing, water, solvent, fuel and temperature resistant elastomers with which the instant plasticizers are used are the liquid polythioethers of the present invention having terminating vulcanizable radicals.

As has been demonstrated hereinbefore, the liquid polythioethers having terminating chemically non-reactive radicals may be easily made following the teachings herein. For example, liquid non-crystallizing polythioethers having 2 to 4 terminating thioalkyl radicals may be produced by including in the condensation reaction, a beta thioether alcohol having the formula:



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wherein R'' is alkyl of, e.g. from six to eight carbon atoms. Such beta thioether alcohols may be made by reacting mercaptoethanol with an alpha-olefin such as alpha-hexene, alpha-heptene or alpha-octene in the presence of a free radical catalyst.

The aromatic terminated polythioethers may be produced by reacting the hydroxyl terminated polythioethers with para-toluene sulfonyl isocyanate or phenyl isocyanate. Alternatively such aromatic terminated polythioethers may be formed by reacting the hydroxyl terminated polythioethers with an aromatic diisocyanate such as toluene-2, 4-diisocyanate and then reacting the resulting isocyanate terminated polythioether with a lower alkyl alcohol.

Another alternative route to forming liquid polythioethers having terminating chemically non-reactive radicals is to first form polythioethers having terminating reactive radicals other than hydroxyl groups. For example, polythioethers having terminating reactive olefinic double bonds may be produced as exemplified hereinbefore. Such reactive olefinic double bonds may be converted to chemically non-reactive terminals by reacting the olefin terminated polythioethers with a lower alkyl or aryl mercaptan in the presence of an appropriate catalyst, e.g. a free radical initiating catalyst such as a peroxide and an amine having a pK_b of 6 or less as disclosed in U.S. Patent 3,923,748.

In order to fully illustrate the present invention the following examples are given, wherein all parts and percentages are by weight unless otherwise stated.

Example 1

Synthesis of HTN (1-hydroxy, 3-thia, 8-nonene)

To 2105 grams (25.67 moles) of 1,5-hexadiene was added 5.0 grams of t-butyl perbenzoate. This mixture was heated to about 50°C. at which time a solution of 1950 grams (25.0 moles) of 2-mercaptoethanol and 2.5 grams of tetramethyl guanidine was added dropwise with vigorous



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stirring. The addition took 3 hours. After the addition the mixture was allowed to reflux for 2 hours and then allowed to stand overnight. Unreacted 1,5-hexadiene was recovered by distillation. The resulting product contained approximately 85-90% of 1-hydroxy, 3-thia, 8-nonene, a low melting white solid.

Example 2

10 Synthesis of HDT(1,5,13 trihydroxy, 7-oxa, 3,11 dithia tridecane)

A 5 liter glass reactor with stirrer, thermometer and reflux condenser was used. 2496 grams (32.0 moles) of 2-mercaptoethanol were taken in this reactor. To this was added dropwise, 1824 grams (16.0 moles) of allyl glycidyl ether with vigorous stirring. The exotherm was controlled by water bath. After addition of allyl glycidyl ether, 3 grams of t-butyl perbenzoate and 0.3 grams of tetramethyl guanidine were added and the solution stirred. The completion of the reaction was determined by IR spectrum. The resulting material, 3,11-dithia, 7-oxa, 1,5,13 trihydroxy tridecane, was obtained in the form of a viscous liquid.

Example 3

25 Synthesis of branched double bond terminated polythioether

	Thiodiglycol	2500	grams
	Hydroxyethyl, 2-hydroxy-propyl sulfide	1071.5	grams
	HTN (Example 1)	357.2	grams
30	HDT (Example 2)	44.6	grams
	Triphenyl phosphite (catalyst)	35.7	grams
	Thiodiphenol (anti-oxidant)	8.9	grams

Procedure: The above ingredients were stirred together under nitrogen in a 4 liter glass reactor having a thermometer and a condenser for distillation. The temperature of the stirred mixture was kept at 150°C. for 5 hours after which it was raised to 180°C. This process

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was carried out under a stream of nitrogen. The distillate (mainly water) was collected until the vapor temperature of distillate dropped below 70°C. At this point the process of further condensation was carried out under full vacuum at 180-185°C. until the material showed a hydroxyl number of less than 10 in an IR analysis. The resulting olefin terminated polymer had a viscosity of 840 poise and had a golden yellow color. This polymer when kept at 0°F. for 24 hours solidified to a soft gel which readily liquified when allowed to return to room temperature.

Example 4

Synthesis of 2,9-dihydroxy, 4,7-dithiadecane (ethylene bis hydroxy propyl sulfide-glycol from ethane dithiol)

940 grams (10 moles) of ethane dithiol were taken in a flask fitted with a stirrer, a thermometer, a dropping funnel and a condenser. To this 1160 grams (20 moles) of propylene oxide were added dropwise with vigorous stirring. A slow exotherm developed which was controlled by using a water bath. After the exotherm subsided the liquid was examined in an IR analysis. The reaction was found to have completed.

Example 5

Synthesis of 2,12 dihydroxy, 7-oxa, 4,10 dithia tridecane (glycol from dimercaptodiethyl ether)

700 grams (5.07 moles) of dimercaptodiethyl ether were taken in a three necked glass reactor fitted with a stirrer, a thermometer, a dropping funnel and a condenser. To this 588 grams (10.14 moles) of propylene oxide were added dropwise with vigorous stirring. A mild exotherm slowly developed which was controlled by using a water bath. The reaction was found to be complete as evidenced by the absence of mercaptan or epoxy bands in the IR spectrum.



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Example 6

Synthesis of 2,12-dihydroxy, 4,7,10 trithia
tridecane (glycol from dimercapto diethyl sulfide)

To 781 grams (5.07 moles) of dimercapto diethyl
5 sulfide in a 3 necked flask fitted with a stirrer, a
dropping funnel, a thermometer and a condenser, 588 grams
(10.14 moles) of propylene oxide were added dropwise with
vigorous stirring. No immediate reaction was observed
(no exotherm). 5 drops of triethylamine and tetramethyl
10 guanadine catalyst were then added and the mixture warmed
slowly to 50°C. A slow exotherm was observed. The
reaction was continued at 50 to 60°C. with refluxing until
all propylene oxide had been reacted, the composition was
allowed to stand overnight when it solidified to a low
15 melting solid. IR examination indicated the completion of
reaction.

Example 7

Synthesis of TDDO(1,5,14,18-tetrahydroxy, 7,12-
20 dioxo, 3,16-dithia octadecane)

To a 5 liter glass reactor fitted with stirrer,
thermometer, and reflux condenser was added 2,424 grams
(12 moles) of butyldiglycidyl ether. To this was added
1872 grams (24 moles) of 2-mercaptoethanol in the form of a
25 slow stream with constant stirring. The temperature was
raised to 50°C. whereupon an exotherm occurred and the
temperature increased rapidly to 140°C. The temperature
was controlled by water bath. After complete addition of
the mercaptoethanol, which took 4 hours, the mixture was
30 stirred for another 3 hours and then allowed to react over-
night undisturbed. At the end of this period a thick
liquid was obtained. IR spectrum indicated that the reaction
was complete.

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Example 8

Synthesis of branched double bond terminated polythioether

5 In a 4 liter glass reactor fitted with a stirrer, a thermometer and a distillation condenser the following materials were added:

	Thiodiglycol	1645.0	grams
	Hydroxyethyl, 2-hydroxy propyl sulfide	705.4	grams
10	HDT (Example 2)	29.4	grams
	Triphenyl phosphite	26.1	grams
	Thiodiphenol	6.5	grams

The mixture was heated under a stream of nitrogen with stirring at 180°C. for six hours. Water of condensation was collected. At this time 235.2 grams of olefin terminated alcohol (HTN, Example 1) was added. Heating was continued at 180°C. for six more hours after which nitrogen was stopped and vacuum applied and the remaining condensation reaction carried out under these conditions until the IR analysis of polymer showed a hydroxyl number of less than 10. This IR spectrum was identical to that of the material in Example 3 and the two polymer samples showed similar physical properties.

25 Example 9

Synthesis of linear hydroxyl terminated polythioether

	Thiodiglycol	1400	grams
	Hydroxyethyl, 2-hydroxy propyl sulfide	600	grams
30	Triphenyl phosphite	20	grams
	Thiodiphenol	2.5	grams

The above ingredients were mixed in a 4 liter glass reactor fitted with a stirrer, a thermometer and a distillation condenser and heated under a stream of nitrogen at 180°C. until the vapor temperature of condensate



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dropped from initial 120°C. to less than 70°C. At this time vacuum was applied and the reaction of condensation continued at 180°C. until the rate of condensation was negligible as evidenced by collected distillate. The polymer obtained was a thick clear brownish liquid with a viscosity of 475 poise and hydroxyl number of 32.

Example 10

10 Synthesis of linear hydroxyl terminated poly-
thioether (higher viscosity than Example 9)

Thiodiglycol	2420	grams
Hydroxyethyl, 2-hydroxypropyl sulfide	1037	grams
Triphenyl phosphite (catalyst)	34.6	grams
15 Thiodiphenol (anti-oxidant)	8.6	grams

Procedure: The above materials were stirred together under nitrogen in a 4 liter glass reactor equipped with a thermometer and condenser for distillation. The temperature of the mixture was kept at 150°C. for 5 hours after which it was raised to 180°C. This process was carried out under a stream of nitrogen, and 180°C. was maintained until the vapor temperature of the distillate dropped below 90°C. At this point further reaction was carried out under full vacuum at 180-185°C. until the material showed a hydroxyl number of about 22. The resulting polymer was a brown, clear liquid with a viscosity of 1743 poise.

Example 11

30 Synthesis of linear hydroxyl terminated poly-
thioether

Thiodiglycol	1540	grams
Ethylene bis hydroxypropyl sulfide (Example 4)	460	grams
Triphenyl phosphite	20	grams
35 Thiodiphenol	2.5	grams



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In a 4 liter glass reactor fitted with stirrer, thermometer and distillation condenser the above ingredients were heated at 180°C. under a stream of nitrogen until the vapor temperature of condensate dropped below 70°C.

5 At this time nitrogen was stopped and full vacuum applied and the remaining reaction carried out until the rate of condensation became negligible. A thick liquid polymer with a viscosity of 530 poise and hydroxyl number 35 was thus obtained.

10

Example 12

Synthesis of linear hydroxyl terminated
polythioether

15	Thiodiglycol	1467.5	grams
	Bis-hydroxy propyl thioethylene		
	oxide (Example 5)	555.0	grams
	Triphenyl phosphite	20.0	grams
	Thiodiphenol	2.5	grams

20 In a 4 liter glass reactor fitted with distillation condenser, stirrer and thermometer, the above ingredients were allowed to react under a stream of nitrogen at 180°C. Water, the product of condensation reaction, was collected until the rate of condensation dropped and temperature of vapor at condenser head dropped to less than 70°C. At 25 this point nitrogen was stopped, full vacuum applied and the condensation reaction continued under these conditions at 180°C. until the rate of condensation dropped to negligible. The polymer obtained thus was a thick brownish liquid with viscosity 500 poise and hydroxyl number 36.



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Example 13

Synthesis of branched double bond terminated polythioether

	Thiodiglycol	2178	grams
5	Hydroxyethyl, 2-hydroxypropyl sulfide	933	grams
	HTN (Example 1)	311	grams
	HDT (Example 2)	39	grams
	Triphenyl phosphite	31	grams
10	Thiodiphenol	7.8	grams

Procedure: The above ingredients were stirred together under nitrogen in a 4-liter glass reactor equipped with a thermometer and a condenser for distillation. The temperature of the mixture was kept at 150°C. for 5 hours, after which it was raised to 180°C. This process was carried out under nitrogen and the reaction temperature was maintained at 180°C. until the vapor temperature of the distillate dropped below 90°C. At this point further reaction was carried out under full vacuum at 180-185°C. until analysis showed a hydroxyl number of approximately 10 or less. The resulting polymer was a clear, light brown liquid with a viscosity of 406 poise.

Example 14

Synthesis of branched thioalkyl terminated polythioether

	Thiodiglycol	1182.2	grams
	Hydroxyethyl 2-hydroxypropyl sulfide	506.7	grams
30	HDT (Example 2)	21.1	grams
	Hydroxyethyl hexyl sulfide (HEHS)	171.0	grams
	Triphenyl phosphite	16.9	grams
	Thiodiphenol	4.2	grams

Procedure: The above ingredients were stirred together under nitrogen in a 2 liter glass reactor having a thermometer and a condenser for distillation. The temperature of the stirred mixture was kept at 150°C. for 5 hours after which it was raised to 180°C. This process

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was carried out under a stream of nitrogen and this temperature was maintained for 8 hours. At this point, further reaction was carried out under full vacuum at 180-185°C. until analysis showed a hydroxyl number of approximately 10 or less. The resulting polythioether had a viscosity of 110 poise and a clear brown color.

Example 15

Synthesis of branched thioalkyl terminated polythioether of higher viscosity than Example 14

10	Thiodiglycol	1291.0	grams
	Hydroxyethyl, 2-hydroxypropyl sulfide	612.0	grams
	HDT (Example 2)	37.5	grams
15	HEHS	111.4	grams
	Triphenyl phosphite	17.4	grams
	Thiodiphenol	4.3	grams

Procedure: The above ingredients were stirred together under nitrogen in a 2 liter glass reactor having a thermometer and condenser for distillation. The temperature of the stirred mixture was kept at 150°C. for 5 hours after which it was raised to 180°C. This process was carried out under nitrogen, and the temperature was maintained at 180°C. for 8 hours. At this point further reaction was carried out under full vacuum at 180-185°C. Final analysis showed a hydroxyl number of approximately 10 or less. The polythioether thus formed was a clear brown liquid with a viscosity of 630 poise.

Example 16

Synthesis of branched mercaptan terminated polythioether

30	Double bond terminated polymer of Example 3	100	grams
35	Dimercaptodiethyl sulfide	8.2	grams
	T-butyl perbenzoate	0.6	grams
	Tetramethyl guanidine	0.1	grams



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Procedure: The materials were slowly stirred together (no vortex formed) initially in a lined can or a polyethylene container. The batch was covered and placed in a 158°F. oven for 16 hours without stirring. Analysis of infra red spectrum of the resulting product showed conversion of all olefinic groups. The final product had a viscosity of 470 poise at 79°F. and cured to a tack-free rubber of 42 Rex hardness in 24 hours at room temperature when cured with a lead peroxide paste and to a tack-free rubber of 27 Rex hardness when cured with a MnO_2 accelerator.

The compositions of the MnO_2 accelerator and lead peroxide paste are as follows:

A. Composition of manganese dioxide accelerator

Santicizer 278 (phthalate ester			
15	plasticizer)	52.0	grams
	Philblack N-550 Carbon black	5.0	grams
	Diphenyl Guanidine	8.0	grams
	Manganese Dioxide	100.0	grams
	Stearic Acid	0.67	grams
20	Sodium stearate	1.33	grams

B. Composition of lead peroxide paste

Lead peroxide	100.0	grams
Liquid chlorinated paraffin	100.0	grams

25 Example 17

Synthesis of branched siloxane terminated polythioether

Example:

Olefin terminated polymer of

30	Example 3	100.0	grams
	Mercaptopropyl triethoxy silane	10.87	grams
	Triethylamine	0.40	grams
	T-butyl perbenzoate	0.60	grams
	Tetramethyl guanidine	0.10	grams



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Procedure: All ingredients were gently mixed in a polyethylene cup or a phenolic lined can. The batch was nitrogen blanketed, covered and heated without further stirring at 158°F. for 16 hours. Analysis of infrared spectrum of resulting material showed conversion of all olefinic groups. The product cured to a soft tack-free rubber when mixed with dibutyl-tin dilaurate and kept overnight at ambient.

Example 18

Compounding of Polythioether of Example 16

The polythioether of Example 16 was compounded as follows:

		<u>Part by wt.</u>
15	Mercaptan terminated polymer (Example 16)	100
	Calcium carbonate	54
	Hydrated aluminum oxide	15.6
	Zinc oxide	2.0
20	Silane adhesion promoter	1.25
	Ferric acetylacetonate (Redox catalyst)	0.25

The compounded polymer was mixed intimately with Manganese dioxide accelerator of Example 16 in the weight ratio of 10:1 and cured at ambient in the form of a sheet of approximately 1/8" thickness. The following physical properties were obtained:

Tack-free time: 24 hours

Cure Hardness at room temperature: 48 hours 45 Rex
72 hours 48 Rex
96 hours 50 Rex

Tensile strength 260 PSI

Elongation 300%

Thermal (pressure) rupture test as specified in MIL-S-8802 was conducted on a specimen cured according to the schedule of the aforesaid military specification (7 days



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at room temperature followed by 1 day at 140°F.). The specimen performed as follows:

	<u>Test Temp.</u>	<u>Time</u>	<u>Pressure</u>	<u>Extrusion</u>
5	1. 150°F.	30 min.	10 PSI	nil
	2. 375°F.	30 min.	10 PSI	nil
	3. 400°F.	30 min.	10 PSI	1/16
	4. 425°F.	15 min.	10 PSI	Blow out

10 Another thermal rupture specimen was immersed in Jet Reference Fuel (JRF) for 7 days at 140°F. and then tested at 400°F. under 10 PSI pressure. After 30 minutes the extrusion was zero. Fuel resistance of above cured specimens was tested in JRF according to MIL-S-83430. Weight
15 loss was 3.53% (allowed 8%).

The same compounded polymer when cured with dichromate accelerator gave the following hardness rubbers:

	24 hours at room temperature	45 Rex
20	48 hours at room temperature	50 Rex
	96 hours at room temperature	55 Rex

The composition of the Dichromate Accelerator is:

25	Calcium dichromate	80.00 grams
	Water	70.38 grams
	Dimethyl acetamide	98.30 grams
	Raven 1040 Carbon black	2.60 grams
	Burgess clay	54.00 grams

30

Example 19

Synthesis of branched polythioether using 100% hydroxyethyl, 2-hydroxypropyl sulfide (double bond terminated)



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	Hydroxyethyl, 2-hydroxy		
	propyl sulfide	2000	grams
	HTN (Example 1)	182.5	grams
	HDT (Example 2)	23.1	grams
5	Triphenyl phosphite	18.5	grams
	Thiodiphenol	4.6	grams

Procedure: The above ingredients were mixed together under nitrogen in a 4 liter glass reactor fitted with thermometer, a stirrer and a condenser for distillation. The temperature of stirred mixture was maintained at 150°C. under nitrogen for 5 hours after which it was slowly brought to 180°C. The distillate (mainly water) was collected until the vapor temperature of distillate dropped below 80°C. Thereafter the process of condensation was carried out under full vacuum at 180°C. until the material showed a hydroxyl number of less than 10 in an IR analysis. The resulting olefin terminated amber colored polymer had a viscosity of 165 poise. This polymer when kept at 0°F. for 24 hours stayed a thick liquid.

Example 20

Synthesis of branched thioalkyl terminated polythioether using tetrafunctional TDDO as the beta-thioether tetrol

25	Thiodiglycol	1182.2	grams
	Hydroxyethyl, 2-hydroxy-		
	propyl sulfide	506.7	grams
	TDDO (Example 7)	28.0	grams
30	HEHS	171.0	grams
	Triphenyl phosphite	16.9	grams
	Thiodiphenol	4.2	grams

Procedure: The above ingredients were stirred together under nitrogen in a 2 liter glass reactor equipped with a thermometer and condenser for distillation. The temperature of the stirred mixture was maintained at 150°C. for



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5 hours after which it was raised to 180°C. This process was carried out under nitrogen and the 180°C. temperature was maintained for 8 hours. Further condensation was then carried out under full vacuum at 180-185°C. until analysis showed a hydroxyl number of approximately 10 or less. The resulting polythioether was a clear brown liquid with a viscosity of 80 poise.

Example 21

10 Synthesis of linear aromatic terminated polythioether

Hydroxyl terminated polymer of

Example 10	200.0	grams
Tosyl isocyanate	15.2	grams
15 Triethylamine	0.1	grams

Procedure: The above materials were stirred together in a lined can under a stream of nitrogen. The can was covered and placed in a 140°F. oven for 16 hours without stirring. IR analysis of the resultant product showed the absence of hydroxyl and isocyanate bands thus indicating that the reaction was complete. The resulting polythioether had a clear amber color with a viscosity of 3000 poise.

Example 22

25 Synthesis of linear aromatic terminated polythioether

Hydroxyl terminated polymer of

Example 3	200.0	grams
Phenyl isocyanate	9.2	grams
30 Triethylamine	0.1	grams

Procedure: The above materials were stirred together in a lined can under a stream of nitrogen. The can was covered and placed in a 140°F. oven for 16 hours without stirring. IR analysis showed the reaction was complete through the disappearance of the hydroxyl and isocyanate bands. The resulting polythioether was a clear amber liquid with a viscosity of 1725 poise.

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Example 23

Synthesis of linear aromatic terminated polythioether

Hydroxyl terminated polymer

5	of Example 3	200.0	grams
	Toluene-2, 4-diisocyanate	13.4	grams
	Triethylamine	0.1	grams

Procedure: The above materials were stirred together in a lined can under a stream of nitrogen. The can was covered and placed in a 140°F. oven for 16 hours, without stirring. Isocyanate analysis showed the reaction to be complete. At this point 7.6 grams n-butanol were added along with an additional 0.1 gram triethylamine catalyst. The materials were again stirred, covered, and placed in a 158°F. oven for 16 hours. At the end of this period an IR spectrum of the material showed no hydroxyl or isocyanate band. This indicated the completion of reaction. The resulting polythioether was a clear amber liquid with a viscosity of 4800 poise.

Example 24

Synthesis of branched aromatic terminated polythioether

Double bond terminated

25	polymer of Example 13	200.0	grams
	Thiophenol	15.3	grams
	Free radical catalyst	1.2	grams
	Xylene	8.8	grams

Procedure: After mixing the catalyst in Xylene, the above materials were mixed together in a lined can, covered, and placed in a 140°F. oven for 16 hours without stirring. IR analysis showed the reaction to be complete through the disappearance of the double bond as well as mercaptan bands. The resultant polythioether was a clear, light amber liquid having a viscosity of 380 poise.

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Example 25

Synthesis of linear thioalkyl terminated poly-thioether

Hydroxyl terminated polymer

5	of Example 10	1000	grams
	HEHS	64.8	grams
	Triphenyl phosphite	5.0	grams

Procedure: The above materials were stirred together under nitrogen in a 2 liter glass reactor equipped with a thermometer and a condenser for distillation. The mixture temperature was maintained at 150°C. for 5 hours after which it was raised to 180°C. and full vacuum was applied. The reaction was carried out under these conditions until analysis showed a hydroxyl number lower than 10. The resulting polythioether was a clear light amber liquid with a viscosity of 170 poise.

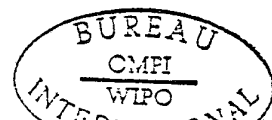
Example 26

Synthesis of branched vulcanizable mercaptan terminated polythioether

Double bond terminated polymer

20	of Example 13	100	grams
	Dimercaptodiethyl sulfide	8.2	grams
	T-butyl perbenzoate	0.6	grams
25	Tetramethyl guanidine	0.1	grams

Procedure: The materials were slowly stirred together (no vortex formed) in a lined can. The batch was covered and placed in a 158°F. oven for 16 hours without stirring. Analysis of infrared spectrum of the resulting product showed conversion of all olefinic groups. The final product had a viscosity of 470 poise at 79°F.



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Example 27

Preparation of elastomeric composition

The polymer of Example 26 was compounded as follows:

		<u>Parts by Wt.</u>
5	Mercaptan terminated polymer	
	of Example 26	100
	Calcium carbonate	55
	Hydrated aluminum oxide	7.5
10	Zinc oxide	3.0
	Silane adhesion promoter	1.5
	Ferric acetyl acetate	
	(Redox catalyst)	0.25
	Polythioether (plasticizer)	
15	of Example 25	5.0

Example 28

Preparation of manganese dioxide accelerator
for curing of composition of Example 27

		<u>Parts by Wt.</u>
20	Plasticizer of Example 25	52.0
	Philblack N-550 carbon black	44.3
	Diphenyl guanidine	8.0
	Manganese dioxide	100.0
25	Stearic acid	0.67
	Sodium stearate	1.33

The compounded polymer of Example 27 was intimately mixed with the manganese dioxide accelerator in the weight ratio of 10:1 and cured at ambient in the form of a sheet of approximately 1/8" thickness. The following physical properties were obtained:

	Tack free time:	24 hours	
	Cure Hardness at room temperature:	48 hours	40 Rex
		72 hours	45 Rex
35		96 hours	50 Rex



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Tensile strength: 495 PSI

Elongation: 250%

Thermal (pressure) rupture test as specified in MIL-S-8802 was conducted on a specimen cured according to schedule of the aforesaid military specification (7 days at room temperature followed by 1 day at 140°F.). The specimen performed as follows:

	<u>Test Temp.</u>	<u>Time</u>	<u>Pressure</u>	<u>Extrusion</u>
	1. 350°F.	30 min.	10 PSI	nil
10	2. 400°F.	30 min.	10 PSI	1/32"

Another similar specimen was immersed in jet reference fuel (JRF) for 7 days at 140°F. and then tested at 400°F. under 10 PSI pressure. After 30 minutes the extrusion was zero.

15 Example 29

Synthesis of branched hydroxyl terminated polythioether

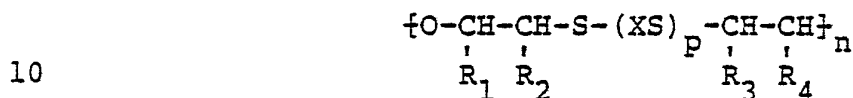
	Thiodiglycol	1400.5	grams
	Thiodipropylene glycol	274.5	grams
20	HDT (Example 2)	21.1	grams
	Triphenyl phosphite	16.7	grams
	Thiodiphenol	4.2	grams

Procedure: The mixture of the above ingredients was stirred under nitrogen in a 4 liter glass reactor fitted with a thermometer and a condenser for distillation. The temperature was maintained at 150°C. for 5 hours after which it was raised to 180°C. This process was carried out under a stream of nitrogen and the temperature of 180°C. was maintained until the vapor temperature dropped below 90°C. At this point further reaction was carried out under full vacuum at 180°C. to 185°C. until the material showed a hydroxyl number of about 25. The resulting polymer was a light yellow clear liquid with a viscosity of 195 poise. The polymer when kept at 0°F. for 18 hours solidified but returned to its original liquid state on thawing.

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We claim:

1. A non-crystallizing, water, solvent, fuel and temperature resistant liquid polythioether having two to four terminating radicals which do not substantially reduce the water, solvent, fuel and temperature resistance and a water, solvent, fuel and temperature resistant polymeric backbone having repeating units of the formula:



wherein each of R_1 , R_2 , R_3 and R_4 is hydrogen or lower alkyl providing that a sufficient number of R_1 , R_2 , R_3 and/or R_4 are lower alkyl in said polymeric backbone to render said backbone non-crystallizing; X is a divalent organic radical selected from $-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{S}-\text{CH}_2-\text{CH}_2-$ or $\text{CH}_2-\text{CH}_2-\text{O}-\text{CH}_2-\text{CH}_2-$; n is 8 to 200; and p is 0 or 1.

2. A liquid polythioether according to claim 1 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/5$.

3. A liquid polythioether according to claim 1 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/4$.

4. A liquid polythioether according to claim 2 or 3 wherein lower alkyl is methyl.

5. A liquid polythioether according to claim 1 wherein p is 0.

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6. A liquid polythioether according to claim 1 wherein at least one of R_1 or R_4 is lower alkyl and each of R_2 and R_3 is hydrogen.

5 7. A liquid polythioether according to claim 1 wherein said terminating radicals do not exceed twenty carbon atoms.

8. A liquid polythioether according to claim 7
10 wherein said terminating radicals are chemically non-reactive.

9. A liquid polythioether according to claim 8 wherein said polythioether is linear and has two chemically
15 non-reactive radicals.

10. A liquid polythioether according to claim 8 wherein said polythioether is branched and has 3 or 4 chemically non-reactive radicals.

20 11. A liquid polythioether according to claims 9 or 10 wherein said terminating chemically non-reactive radical is selected from the group consisting of aromatic, alkyl, heteroalkyl, alicyclic and heteroalicyclic.

25 12. A liquid polythioether according to claim 11 wherein the number of carbon atoms in said chemically non-reactive radical does not exceed ten.

30 13. A liquid polythioether according to claim 8 wherein said terminating chemically non-reactive radical is thioalicyclic or oxyalicyclic.

14. A liquid polythioether according to claim 8
35 wherein said terminating chemically non-reactive radical is aromatic.



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15. A liquid polythioether according to claim 8 wherein said terminating chemically non-reactive radical is heteroalkyl.

5 16. A liquid polythioether according to claim 8 wherein said terminating chemically non-reactive radical is alkyl.

10 17. A liquid polythioether according to claim 15 wherein said heteroalkyl is selected from the group consisting of thioalkyl and oxyalkyl.

15 18. A liquid polythioether according to claim 1 wherein said terminating radicals are vulcanizable.

19. A liquid polythioether according to claim 18 wherein said polythioether is linear and has two vulcanizable radicals.

20 20. A liquid polythioether according to claim 18 wherein said polythioether is branched and has 3 or 4 vulcanizable radicals.

25 21. A liquid polythioether according to claim 19 wherein said vulcanizable radical is hydroxyl.

22. A liquid polythioether according to claim 19 wherein said vulcanizable radical is reactive silyl.

30 23. A liquid polythioether according to claim 20 wherein said low temperature vulcanizable radical is selected from the group consisting of hydroxyl, epoxide, reactive silyl, isocyanate, reactive olefinic double bond and mercaptan.

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24. A liquid polythioether according to claim 23 wherein said vulcanizable radical is hydroxyl.

25. A liquid polythioether according to claim 23 wherein said vulcanizable radical is reactive olefinic double bond.

26. A liquid polythioether according to claim 23 wherein the vulcanizable radical is epoxide.

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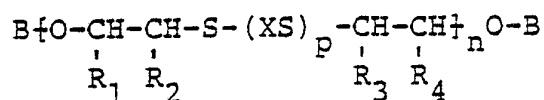
27. A liquid polythioether according to claim 23 wherein the vulcanizable radical is isocyanate.

28. A liquid polythioether according to claim 23 wherein the vulcanizable radical is mercaptan.

15

29. A non-crystallizing, linear, water, solvent fuel and temperature resistant liquid polythioether having the formula

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wherein each of R_1 , R_2 , R_3 and R_4 is hydrogen or lower alkyl with the provision that a sufficient number of R_1 , R_2 , R_3 and/or R_4 are lower alkyl in said polymeric backbone to render said backbone non-crystallizing; X is a divalent organic radical selected from $-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{S}-\text{CH}_2-\text{CH}_2-$, or $-\text{CH}_2-\text{CH}_2-\text{O}-\text{CH}_2-\text{CH}_2-$; n is 8 to 200, p is 0 or 1 and B is a terminating radical which does not substantially reduce the water, solvent and fuel resistance.

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30. A liquid polythioether according to claim 29 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/5$.

5

31. A liquid polythioether according to claim 29 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/4$.

10

32. A liquid polythioether according to claim 29 wherein at least one of R_1 or R_4 is lower alkyl and each of R_2 and R_3 is hydrogen.

15

33. A liquid polythioether according to claims 30, 31 or 32 wherein lower alkyl is methyl.

34. A liquid polythioether according to claim 29 wherein p is 0.

20

35. A liquid polythioether according to claim 29 wherein said terminating radical does not exceed twenty carbon atoms.

25

36. A liquid polythioether according to claim 29 wherein said terminating radical is chemically non-reactive.

37. A liquid polythioether according to claim 36 wherein said chemically non-reactive radical selected from the group consisting of aromatic, alkyl, heteroalkyl, alicyclic and heteroalicyclic.

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38. A liquid polythioether according to claim 37 wherein the number of carbon atoms in said chemically non-reactive radical does not exceed ten.

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39. A liquid polythioether according to claim 37 wherein said chemically non-reactive radical is thioalicyclic or oxyalicyclic.

5 40. A liquid polythioether according to claim 37 wherein said chemically non-reactive radical is aromatic.

10 41. A liquid polythioether according to claim 37 wherein said chemically non-reactive radical is heteroalkyl.

 42. A liquid polythioether according to claim 37 wherein said chemically non-reactive radical is alkyl.

15 43. A liquid polythioether according to claim 41 wherein said heteroalkyl is selected from the group consisting of thioalkyl and oxyalkyl.

20 44. A liquid polythioether according to claims 29 or 35 wherein said terminating radical is a vulcanizable radical.

25 45. A liquid polythioether according to claim 44 wherein said vulcanizable radical is selected from the group consisting of epoxide, reactive silyl, isocyanate, reactive olefinic double bond, mercaptan and hydrogen.

30 46. A liquid polythioether according to claim 44 wherein the vulcanizable radical is epoxy.

 47. A liquid polythioether according to claim 44 wherein the vulcanizable radical is reactive silyl.

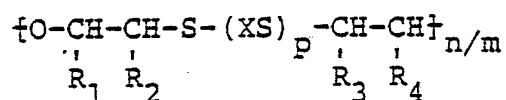


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48. A liquid polythioether according to claim 44 wherein the vulcanizable radical is isocyanate.

49. A liquid polythioether according to claim 5 44 wherein the vulcanizable radical is mercaptan.

50. A non-crystallizing, branched, water, solvent, fuel and temperature resistant liquid polythioether, said liquid polythioether having the formula $R-(A-O-B)_m$ 10 wherein R is the fragment of the organic triol or tetrol $R-(OH)_m$ having a molecular weight of less than 400; m is 3 or 4; B is a terminating radical which does not substantially reduce the water, solvent, fuel and temperature resistance; and A is a polymeric backbone of repeating 15 units of the formula



20 wherein each of R_1 , R_2 , R_3 and R_4 is hydrogen or lower alkyl providing that a sufficient number of R_1 , R_2 , R_3 and/or R_4 are lower alkyl in said polymeric backbone to render said backbone non-crystallizing; X is a divalent organic radical selected from $-\text{CH}_2-\text{CH}_2-$, $-\text{CH}_2-\text{CH}_2-\text{CH}_2-\text{CH}_2-$, 25 $-\text{CH}_2-\text{CH}_2-\text{S}-\text{CH}_2-\text{CH}_2-$ or $-\text{CH}_2-\text{CH}_2-\text{O}-\text{CH}_2-\text{CH}_2-$; n is 8 to 200; m is 3 or 4; and p is 0 or 1.

51. A liquid polythioether according to claim 50 30 wherein $R-(OH)_m$ has a molecular weight of less than 360.

52. A liquid polythioether according to claim 51 wherein each hydroxyl in $R-(OH)_m$ is located beta to a sulfur atom.

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53. A liquid polythioether according to claim 52 wherein R is aliphatic sulfide or heteroaliphatic sulfide.

54. A liquid polythioether according to claim 50
5 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/5$.

55. A liquid polythioether according to claim 50
10 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/4$.

56. A liquid polythioether according to claim 50
15 wherein at least one of R_1 or R_4 is lower alkyl and each of R_2 and R_3 is hydrogen.

57. A liquid polythioether according to claim 56
20 wherein lower alkyl is methyl.

58. A liquid polythioether according to claim 50 wherein p is 0.

59. A liquid polythioether according to claim 50
25 wherein said terminating radical does not exceed twenty carbon atoms.

60. A liquid polythioether according to claim 59
30 wherein said terminating radical is chemically non-reactive.

61. A liquid polythioether according to claim 60
wherein said terminal chemically non-reactive radical is selected from the group consisting of aromatic, heteroalkyl, alicyclic and heteroalicyclic.

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62. A liquid polythioether according to claim 61 wherein the number of carbon atoms in said terminal chemically non-reactive radical does not exceed ten.

5 63. A liquid polythioether according to claim 60 wherein said terminal chemically non-reactive radical is thioalicyclic or oxyalicyclic.

10 64. A liquid polythioether according to claim 60 wherein said terminal chemically non-reactive radical is aromatic.

15 65. A liquid polythioether according to claim 60 wherein said terminal chemically non-reactive radical is heteroalkyl.

20 66. A liquid polythioether according to claim 60 wherein said terminal chemically non-reactive radical is alkyl.

67. A liquid polythioether according to claims 50 or 59 wherein said terminating radical is vulcanizable.

25 68. A liquid polythioether according to claim 67 wherein said vulcanizable radical is selected from the group consisting of epoxide, reactive silyl, isocyanate, reactive olefinic double bond, mercaptan and hydrogen.

30 69. A liquid polythioether according to claim 67 wherein the vulcanizable radical is epoxide.

35 70. A liquid polythioether according to claim 67 wherein the vulcanizable radical is reactive silyl.



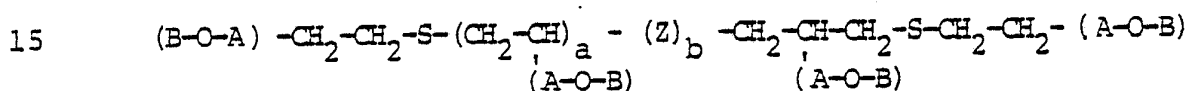
- 45 -

71. A liquid polythioether according to claim 67 wherein the vulcanizable radical is isocyanate.

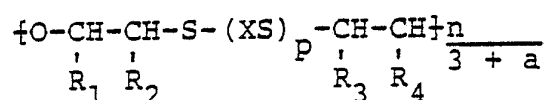
72. A liquid polythioether according to claim 67 wherein the vulcanizable radical is mercaptan.

73. A liquid polythioether according to claim 67 wherein the vulcanizable radical is hydrogen of a hydroxyl.

74. A non-crystallizing, water, solvent, fuel and temperature resistant liquid polythioether having the formula



wherein Z is hetero(lower) aliphatic; B is a terminating radical which does not substantially reduce the water, solvent, fuel and temperature resistance; A is a polymeric backbone consisting of repeating units of the formula



each of a, b, and p is 0 or 1; each of R_1 , R_2 , R_3 and R_4 is hydrogen or lower alkyl providing that a sufficient number of R_1 , R_2 , R_3 and/or R_4 are lower alkyl in said polymeric backbone to render said backbone non-crystallizing; X is a divalent organic radical selected from $-CH_2-CH_2-$, $-CH_2-CH_2-CH_2-CH_2-$, $-CH_2-CH_2-S-CH_2-CH_2-$ or $-CH_2-CH_2-O-CH_2-CH_2-$; and n is 8 to 200.

75. A liquid polythioether according to claim 74 wherein a and b are 0.

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76. A liquid polythioether according to claim 74 wherein b is 0 and a is 1.

5 77. A liquid polythioether according to claim 74 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymer backbone is at least the nearest whole number to the quotient of $n/5$.

10 78. A liquid polythioether according to claim 74 wherein the total number of R_1 , R_2 , R_3 and/or R_4 which are lower alkyl in said polymeric backbone is at least the nearest whole number to the quotient of $n/4$.

15 79. A liquid polythioether according to claim 74 wherein at least one of R_1 or R_4 is lower alkyl and each of R_2 and R_3 is hydrogen.

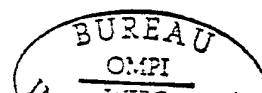
20 80. A liquid polythioether according to claims 77, 78 or 79 wherein lower alkyl is methyl.

81. A liquid polythioether according to claim 74 wherein p is 0.

25 82. A liquid polythioether according to claim 74 wherein said terminating radical is chemically non-reactive.

30 83. A liquid polythioether according to claim 74 wherein said chemically non-reactive radical is selected from the group consisting of aromatic, alkyl, heteroalkyl, alicyclic and heteroalicyclic.

35 84. A liquid polythioether according to claim 82 wherein the number of carbon atoms in said terminal chemically non-reactive radical does not exceed ten.



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85. A liquid polythioether according to claim 82 wherein said terminating chemically non-reactive radical is thioalicyclic or oxyalicyclic.

5 86. A liquid polythioether according to claim 82 wherein said terminating chemically non-reactive radical is aromatic.

10 87. A liquid polythioether according to claim 82 wherein said terminating chemically non-reactive radical is heteroalkyl.

15 88. A liquid polythioether according to claim 82 wherein said terminating chemically non-reactive radical is alkyl.

20 89. A liquid polythioether according to claim 87 wherein said heteroalkyl is selected from the group consisting of thioalkyl and oxyalkyl.

90. A liquid polythioether according to claim 74 wherein said terminating radical is vulcanizable.

25 91. A liquid polythioether according to claim 90 wherein said vulcanizable radical is selected from the group consisting of epoxide, reactive silyl, isocyanate, reactive olefinic double bond, mercaptan and hydrogen.

30 92. A liquid polythioether according to claim 90 wherein the vulcanizable radical is epoxide.

35 93. A liquid polythioether according to claim 90 wherein the vulcanizable radical is reactive silyl.

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94. A liquid polythioether according to claim 90 wherein the vulcanizable radical is isocyanate.

5 95. A liquid polythioether according to claim 90 wherein the vulcanizable radical is mercaptan.

96. A liquid polythioether according to claim 90 wherein the vulcanizable radical is hydrogen.

10

97. A liquid polythioether according to claim 74 wherein Z is oxy(lower) aliphatic.

15 98. The solid vulcanized elastomeric polythioether of the liquid polythioether of claim 18.

99. The solid vulcanized elastomeric polythioether of the liquid polythioether of claim 44.

20 100. The solid vulcanized elastomeric polythioether of the liquid polythioether of claim 67.

101. The solid vulcanized elastomeric polythioether of the liquid polythioether of claim 90.

INTERNATIONAL SEARCH REPORT

International Application No PCT/US81/01573

I. CLASSIFICATION OF SUBJECT MATTER (If several classification symbols apply, indicate all) ³		
According to International Patent Classification (IPC) or to both National Classification and IPC		
INT. CL ³ C08G 75/00		
US CL 528/373		
II. FIELDS SEARCHED		
Minimum Documentation Searched ⁴		
Classification System	Classification Symbols	
US	528/373 568/45, 46	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁵		
III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴		
Category *	Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸
X	US, A, 2,518,245, PUBLISHED 8 AUGUST 1950 MORRIS ET. AL.	1-101
X	US, A, 3,005,803, PUBLISHED 24 OCTOBER 1961 HOLTSCHMIDT ET. AL.	1-101
X	US, A, 3,312,743, PUBLISHED 4 APRIL 1967 SCHMELZER ET. AL.	1-101
X	US, A, 3,985,708, PUBLISHED 12 OCTOBER 1976 CHANG ET. AL.	1-101
X	US, A, 3,335,189, PUBLISHED 8 AUGUST 1967 DEGENER ET. AL.	1-101
X	US, A, 4,089,905, PUBLISHED 16 MAY 1978 SINGH	1-101
X	US, A, 3,951,927, PUBLISHED 20 APRIL 1976 ALOIA	1-101
X	US, A, 4,093,599, PUBLISHED 6 JUNE 1978 ALOIA	1-101
<p>* Special categories of cited documents: ¹⁵</p> <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>"A" document defining the general state of the art</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document cited for special reason other than those referred to in the other categories</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> </div> <div style="width: 45%;"> <p>"P" document published prior to the international filing date but on or after the priority date claimed</p> <p>"T" later document published on or after the international filing date or priority date and not in conflict with the application, but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance</p> </div> </div>		
IV. CERTIFICATION		
Date of the Actual Completion of the International Search ²	Date of Mailing of this International Search Report ²	
11 JANUARY 1982	26 JAN 1982	
International Searching Authority ¹	Signature of Authorized Officer ¹⁹	
ISA/US	MELVYN I. MARQUIS	

FURTHER INFORMATION CONTINUED FROM THE SECOND SHEET

X

US, A, 4,000,213, PUBLISHED 28 DECEMBER 1976
CHANG

1-101

V. ☐ OBSERVATIONS WHERE CERTAIN CLAIMS WERE FOUND UNSEARCHABLE ¹⁰

This international search report has not been established in respect of certain claims under Article 17(2) (a) for the following reasons:

1. ☐ Claim numbers _____, because they relate to subject matter ¹² not required to be searched by this Authority, namely:2. ☐ Claim numbers _____, because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out ¹³, specifically:VI. ☐ OBSERVATIONS WHERE UNITY OF INVENTION IS LACKING ¹¹

This International Searching Authority found multiple inventions in this international application as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims of the international application.2. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims of the international application for which fees were paid, specifically claims:3. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claim numbers:

Remark on Protest

☐ The additional search fees were accompanied by applicant's protest.☐ No protest accompanied the payment of additional search fees.