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(54) Title: GLASS FIBER-REINFORCED POLYCARBONATE MOLDING MATERIALS

**(57) Abrégé/Abstract:**

The invention relates to glass fiber-reinforced polycarbonate compositions and molding materials comprising A) from 10 to 85 parts by weight, preferably from 30 to 80 parts by weight, especially from 40 to 70 parts by weight, of polycarbonate, polyestercarbonate or a mixture thereof, B) from 10 to 50 parts by weight, preferably from 15 to 40 parts by weight, especially from 20 to 35 parts by weight, of rubber-free vinyl copolymer, C) from 5 to 50 parts by weight, preferably 7 to 35 parts by weight, especially from 8 to 25 parts by weight, of a sized glass fiber, the size comprising an epoxy polymer, D) from 0 to 2 parts by weight, preferably from 0 to 1 part by weight, of rubber-modified graft polymers, the composition more preferably being free of rubber-modified graft polymers, and E) from 0 to 10 parts by weight, preferably from 0.01 to 5 parts by weight, especially from 0.1 to 3 parts by weight, of conventional polymer additives, the composition being free of rubber-modified polymers other than component D, and the sum of components A+ B + C + D + E being normalized to 100 parts by weight, which are notable compared to the prior art for high stiffness, high flowability, high processing stability, good chemical resistance and good ageing stability with respect to influences of light and heat, and to the use of the compositions for producing shaped bodies, and to shaped bodies comprising the inventive compositions.

### Abstract

The invention relates to glass fiber-reinforced polycarbonate compositions and molding materials comprising A) from 10 to 85 parts by weight, preferably from 30 to 80 parts by weight, especially from 40 to 70 parts by weight, 5 of polycarbonate, polyestercarbonate or a mixture thereof, B) from 10 to 50 parts by weight, preferably from 15 to 40 parts by weight, especially from 20 to 35 parts by weight, of rubber-free vinyl copolymer, C) from 5 to 50 parts by weight, preferably 7 to 35 parts by weight, especially from 8 to 25 parts by weight, of a sized glass fiber, the size comprising an epoxy polymer, D) from 0 to 2 parts by 10 weight, preferably from 0 to 1 part by weight, of rubber-modified graft polymers, the composition more preferably being free of rubber-modified graft polymers, and E) from 0 to 10 parts by weight, preferably from 0.01 to 5 parts by weight, especially from 0.1 to 3 parts by weight, of conventional polymer additives, the composition being free of rubber-modified polymers other than component D, and 15 the sum of components A + B + C + D + E being normalized to 100 parts by weight, which are notable compared to the prior art for high stiffness, high flowability, high processing stability, good chemical resistance and good ageing stability with respect to influences of light and heat, and to the use of the compositions for producing shaped bodies, and to shaped bodies comprising the 20 inventive compositions.

## GLASS FIBER-REINFORCED POLYCARBONATE MOLDING MATERIALS

The invention relates to glass fibre reinforced polycarbonate compositions and moulding compositions, which are distinguished by high rigidity, high flowability, 5 high processing stability, good chemical resistance and good ageing resistance vis-à-vis the effects of light and heat compared with the prior art.

Compositions containing polycarbonate and rubber-modified styrene polymers, such as e.g. ABS (acrylonitrile-butadiene-styrene polymers), are known for their balance 10 of excellent mechanical properties and good melt flowability. They are used in many different areas of application, for example in car construction, in the building sector and in housings for office equipment and domestic appliances.

A low coefficient of thermal expansion and good dimensional stability, as well as 15 shape stability and high rigidity, are generally needed to produce moulded parts with a large surface area. These properties can be achieved by the addition of fillers or reinforcing materials. High moduli of elasticity can be obtained particularly by adding fibrous reinforcing materials. However, the addition of the fillers or reinforcing materials generally has a disadvantageous effect on the toughness and 20 particularly on the flow properties of the polymer melts, i.e. the processing characteristics. As a result, increased processing temperatures are usually required, which entails a further reduction in material toughness. The practicable degrees of filling with reinforcing material, and thus the material rigidities that can be achieved are, in effect, limited by these parameters, and moulded parts with large surface 25 areas and very thin walls are often impossible to produce with those polycarbonate compositions that correspond to the prior art described below. For these areas of application there is a demand for such polycarbonate compositions to be produced with improved flowability and a higher modulus of elasticity, and with a toughness which is good over a broad processing window and stable vis-à-vis heat ageing. 30 Since moulded parts produced from compositions of this type are often painted and, in the context of the post-treatment needed in connection with this, generally come into contact with chemicals, such as e.g. paint solvents, there is a further demand for

adequate chemical resistance. For this reason, the use of low molecular weight polycarbonates to improve the polymer melt flowability is out of the question, since these usually lead to a negative effect on stress cracking resistance.

5 Rubber-modified vinyl copolymers containing glass fibre reinforced polycarbonate compositions are known from the prior art.

WO-A 00/39210 discloses polycarbonate compositions containing polycarbonate, styrene resin, phosphoric ester and reinforcing agents (e.g. glass fibres), as well as 10 optionally a graft polymer based on a silicone-acrylate composite rubber with a vinyl monomer-based graft shell, which are distinguished by improved hydrolysis resistance, good flame resistance and by improved mechanical properties. The styrene resins employed contain a rubber-based graft polymer. No glass fibre sizes are disclosed.

15

EP-A 1 240 250 discloses polycarbonate compositions containing 10 – 93 wt.% polycarbonate, 3 – 50 wt.% rubber elastic-based graft polymer, 3 – 50 wt.% thermoplastic copolymer and 1 – 20 wt.% of a mixture of particulate mineral and fibrous fillers, which are distinguished by reduced thermal expansion, good toughness, 20 good dimensional stability and high flowability together with improved surface quality in the region of the gate.

EP-A 0 624 621 discloses polycarbonate compositions containing 10 – 80 wt.% polycarbonate, 10 – 80 wt.% rubber-modified graft polymer and 5 – 50 wt.% glass 25 fibres with a coating containing polyolefin wax, which are distinguished by improved toughness and ductility.

EP-A 0 345 652 discloses polycarbonate compositions containing 10 – 75 wt.% polycarbonate, 10 – 50 wt.% rubber-based graft copolymer, up to 50 wt.% styrene 30 copolymer, 0.5 – 50 wt.% terpolymer containing *tert*-butyl (meth)acrylate and 5 to 50 wt.% reinforcing agents (e.g. glass fibres), which are distinguished by high strength, good toughness and by low yellowing. The glass fibres used in this cited application

are generally provided with a size and an adhesion promoter, but the composition of the size is not disclosed here.

The prior art documents cited above do not, however, disclose any compositions that 5 contain polycarbonate, rubber-free vinyl copolymers (e.g. styrene-acrylonitrile copolymers) and no rubber-containing graft polymer or only very small quantities thereof (i.e. up to 2 wt.%).

Disadvantages of the compositions described in the prior art, which contain rubber-10 modified graft polymers in quantities of more than 2 wt.%, are too low a melt flowability and inadequate ageing resistance.

Compositions containing polycarbonate, glass fibres and rubber-free vinyl copolymer, which contain no rubber-modified vinyl copolymers or only very small quantities 15 thereof, are also known from the prior art.

WO-A 84/04317 discloses polycarbonate compositions containing polycarbonate, styrene resin, unsized glass fibres and a hydrogen polysiloxane, which are distinguished by high impact resistance and a high modulus.

20

EP-A 0 647 679 discloses polycarbonate compositions containing special copolycarbonates with bisphenol and resorcinol monomer units, rubber-containing copolymer and/or copolymer of vinyl aromatic and cyanated vinyl monomer components as well as inorganic filler (e.g. glass fibres), which are distinguished by 25 good flowability, high impact resistance and good surface quality. No glass fibre sizes are disclosed.

EP-A 1 038 920 discloses polycarbonate compositions substantially consisting of a special aromatic polycarbonate produced by melt polymerisation, a styrene-based resin 30 (e.g. a styrene-acrylonitrile copolymer with a styrene content of at least 20%, preferably at least 30%), a reinforcing fibrous filler and optionally an elastomeric polymer, which are distinguished by improved moist heat resistance and improved toughness. It is disclosed that the glass fibres used may be coated with a size made of

polymers (such as e.g. epoxy resin, urethane resin, acrylic resin, nylon resin etc.). In the examples, only compositions containing polyurethane-sized glass fibres are disclosed.

WO-A 2006/040087 discloses polycarbonate compositions containing polycarbonate, a 5 terpolymer of styrene, acrylonitrile and maleic anhydride, and long glass fibres, which are distinguished by a combination of improved tensile strength, modulus of elasticity and impact resistance. In addition, these compositions preferably contain at least one polymer selected from the group of the rubber-containing graft polymers and rubber-free copolymers. It is disclosed that the long glass fibres may be surface-modified with 10 a size, without any information on the chemistry of the size being disclosed.

Although the glass fibre reinforced polycarbonate compositions based on rubber-free styrene resins disclosed in the prior art do generally exhibit good melt flowability and ageing resistance, they are, however, distinguished by inadequate toughness for certain 15 areas of application, particularly at higher processing temperatures, and by unsatisfactory chemical resistance and rigidity.

This invention was therefore based on the object of providing free-flowing polycarbonate compositions which are resistant to ageing vis-à-vis the effects of heat 20 and light, with improved processing stability (i.e. stable toughness even at higher processing temperatures), improved rigidity and improved chemical resistance.

Surprisingly, it has been found that this object is achieved by compositions containing

- 25 A) 10 to 85 parts by weight, preferably 30 to 80 parts by weight, especially 40 to 70 parts by weight polycarbonate, polyester carbonate or a mixture thereof,
- B) 10 to 50 parts by weight, preferably 15 to 40 parts by weight, especially 20 to 35 parts by weight rubber-free vinyl copolymer,
- 30 C) 5 to 50 parts by weight, preferably 7 to 35 parts by weight, especially 8 to 25 parts by weight of a sized glass fibre, the size containing an epoxy polymer,

- 5 -

- D) 0 to 2 parts by weight, preferably 0 to 1 parts by weight, particularly preferably the composition is free from rubber-modified graft polymers, and
- E) 0 to 10 parts by weight, preferably 0.01 to 5 parts by weight, especially 0.1 to 3 parts by weight of commercial polymer additives,
  - 5 the composition being free from rubber-modified polymers which differ from component D), and

10 the sum of the components A + B + C + D + E being standardised to 100 parts by weight.

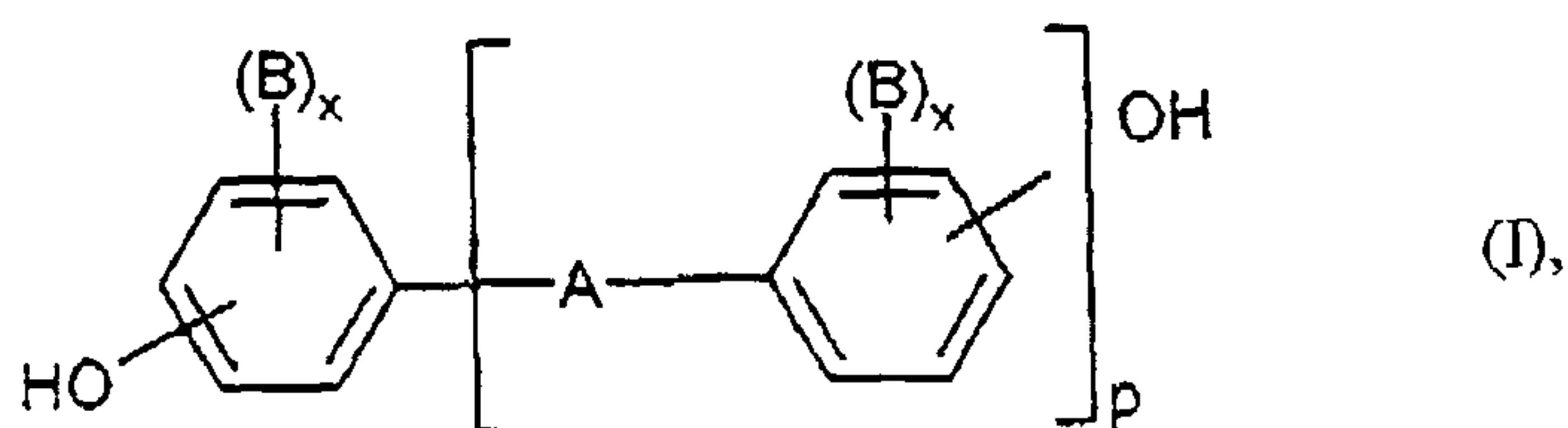
### Component A

15 Aromatic polycarbonates and/or aromatic polyester carbonates according to component A which are suitable according to the invention are known from the literature or can be produced by processes known from the literature (for the production of aromatic polycarbonates, cf. for example Schnell, "Chemistry and Physics of Polycarbonates",  
20 Interscience Publishers, 1964, and DE-AS 1 495 626, DE-A 2 232 877, DE-A 2 703 376, DE-A 2 714 544, DE-A 3 000 610, DE-A 3 832 396; for the production of aromatic polyester carbonates, e.g. DE-A 3 077 934).

25 The production of aromatic polycarbonates takes place e.g. by transesterification of diphenols with carbonic acid halides, preferably phosgene, and/or with aromatic dicarboxylic acid dihalides, preferably benzenedicarboxylic acid dihalides, by the interfacial polycondensation process, optionally using chain terminators, for example monophenols, and optionally using branching agents which are trifunctional or more than trifunctional, for example triphenols or tetraphenols. Production via a melt  
30 polymerisation process by reaction of diphenols with, for example, diphenyl carbonate is also possible.

- 6 -

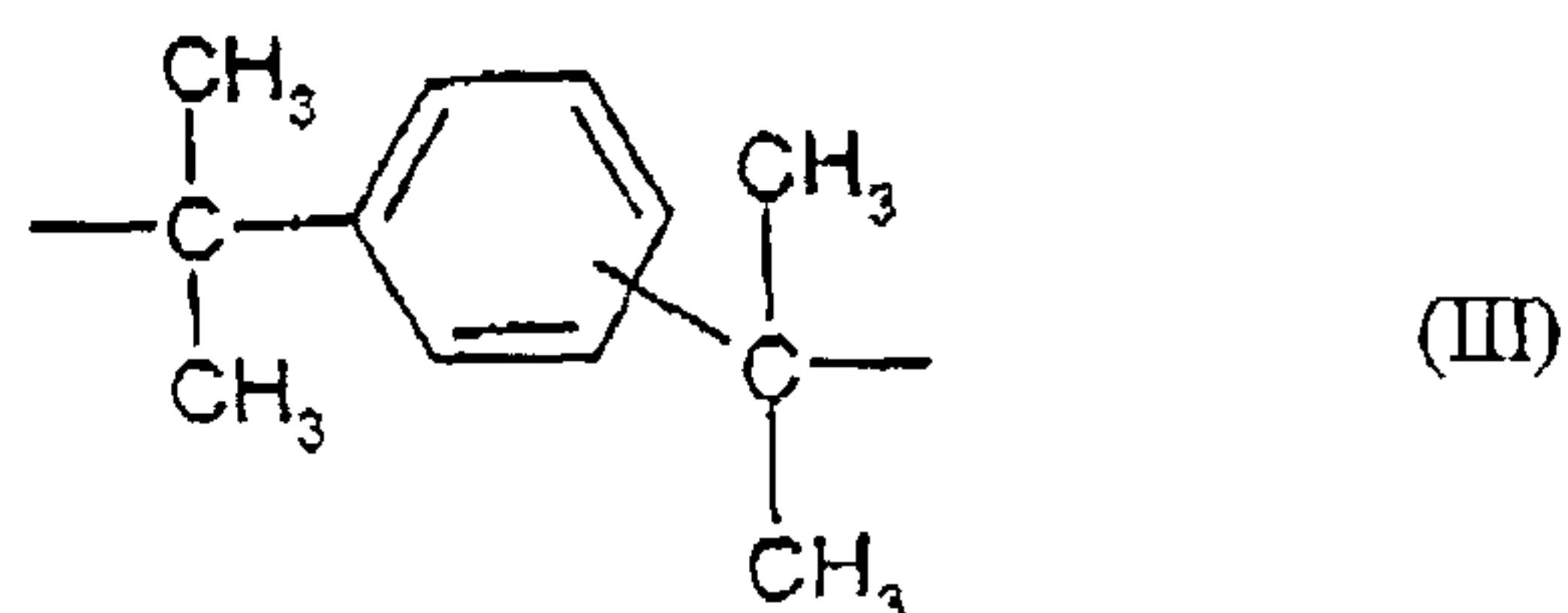
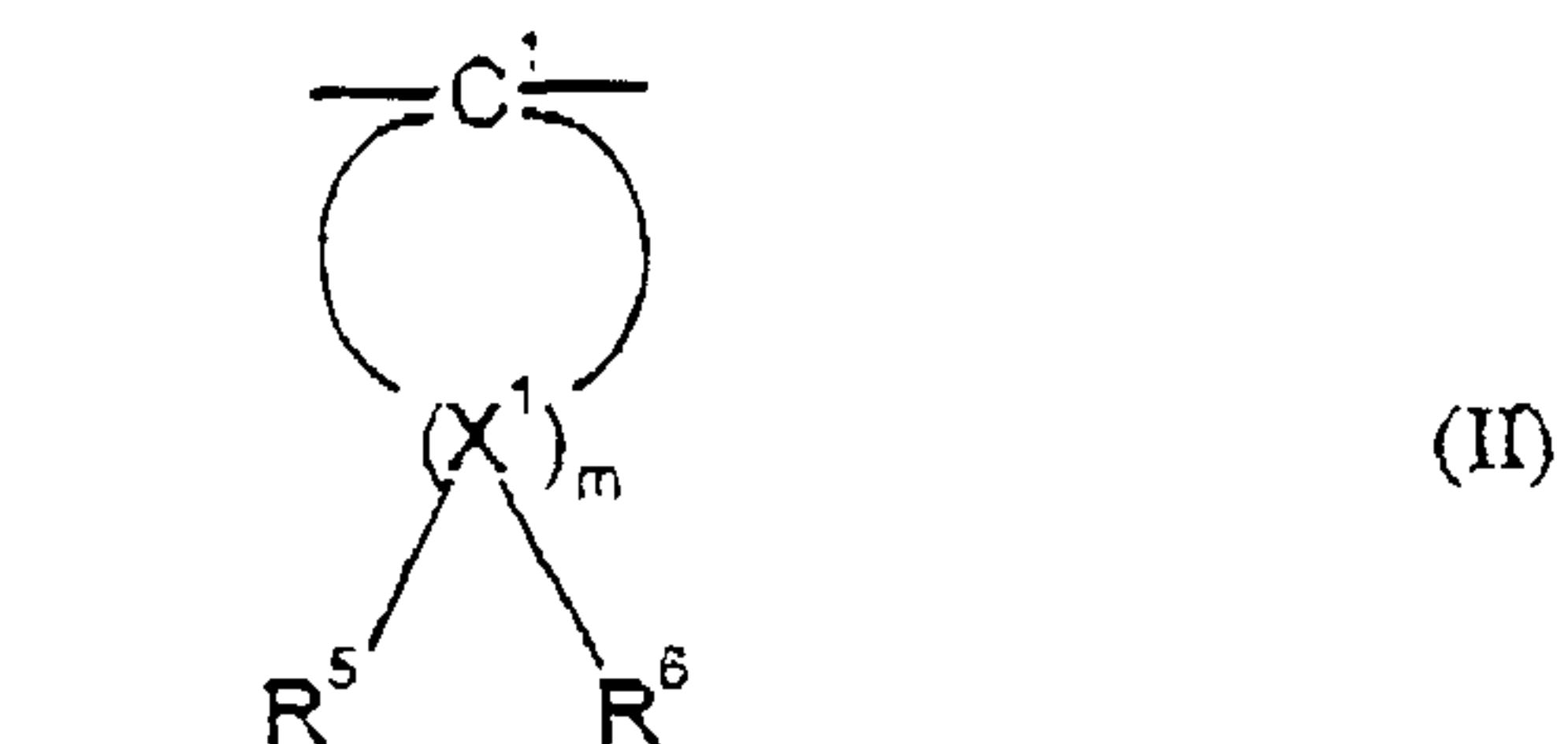
Diphenols for the production of the aromatic polycarbonates and/or aromatic polyester carbonates are preferably those of the formula (I)



5

wherein

A is a single bond, C<sub>1</sub> to C<sub>5</sub> alkylene, C<sub>2</sub> to C<sub>5</sub> alkylidene, C<sub>5</sub> to C<sub>6</sub> cycloalkylidene, -O-, -SO-, -CO-, -S-, -SO<sub>2</sub>-, C<sub>6</sub> to C<sub>12</sub> arylene, on to which further aromatic rings optionally containing heteroatoms may be condensed, or a radical of the formula (II) or (III)



B in each case is C<sub>1</sub> to C<sub>12</sub> alkyl, preferably methyl, or halogen, preferably chlorine and/or bromine,

15 x in each case independently of one another, is 0, 1 or 2,

p is 1 or 0 and

R<sup>5</sup> and R<sup>6</sup> are selected individually for each X<sup>1</sup> and independently of one another denote hydrogen or C<sub>1</sub> to C<sub>6</sub> alkyl, preferably hydrogen, methyl or ethyl,

X<sup>1</sup> denotes carbon and

20 m denotes an integer from 4 to 7, preferably 4 or 5, with the proviso that on at least one atom X<sup>1</sup>, R<sup>5</sup> and R<sup>6</sup> are simultaneously alkyl.

Preferred diphenols are hydroquinone, resorcinol, dihydroxydiphenols, bis(hydroxyphenyl)-C<sub>1</sub>-C<sub>5</sub>-alkanes, bis(hydroxyphenyl)-C<sub>5</sub>-C<sub>6</sub>-cycloalkanes, bis(hydroxyphenyl) ethers, bis(hydroxyphenyl) sulfoxides, bis(hydroxyphenyl) 5 ketones, bis(hydroxyphenyl) sulfones and  $\alpha,\alpha$ -bis(hydroxyphenyl) diisopropylbenzenes and ring-brominated and/or ring-chlorinated derivatives thereof.

Particularly preferred diphenols are 4,4'-dihydroxydiphenyl, bisphenol A, 2,4-bis(4-hydroxyphenyl)-2-methylbutane, 1,1-bis(4-hydroxyphenyl)-cyclohexane, 1,1-bis(4-hydroxyphenyl)-3,3,5-trimethylcyclohexane, 4,4'-dihydroxydiphenyl sulfide, 4,4'-dihydroxydiphenyl sulfone and di- and tetrabrominated or chlorinated derivatives thereof, such as, for example, 2,2-bis(3-chloro-4-hydroxyphenyl)propane, 2,2-bis(3,5-dichloro-4-hydroxyphenyl)propane or 2,2-bis(3,5-dibromo-4-hydroxyphenyl)-15 propane. 2,2-Bis(4-hydroxyphenyl)propane (bisphenol A) is especially preferred.

15

The diphenols may be employed individually or as any desired mixtures. The diphenols are known from the literature or obtainable by processes known from the literature.

20 Chain terminators which are suitable for the production of the thermoplastic, aromatic polycarbonates are, for example, phenol, p-chlorophenol, p-tert-butylphenol or 2,4,6-tribromophenol, and also long-chain alkylphenols, such as 4-[2-(2,4,4-trimethylpentyl)]phenol, 4-(1,3-tetramethylbutyl)phenol according to DE-A 2 842 005 or monoalkylphenol or dialkylphenols having a total of 8 to 20 carbon atoms in the alkyl substituents, such as 3,5-di-tert.-butylphenol, p-iso-octylphenol, p-tert.-octylphenol, p-dodecylphenol and 2-(3,5-dimethylheptyl)phenol and 4-(3,5-dimethylheptyl)phenol. The amount of chain terminators to be employed is generally between 0.5 mole % and 10 mole %, based on the sum of the moles of the particular diphenols employed.

25

30 The thermoplastic, aromatic polycarbonates may be branched in a known manner, and preferably by incorporation of 0.05 to 2.0 mole %, based on the sum of the

diphenols employed, of compounds which are trifunctional or more than trifunctional, for example those having three and more phenolic groups.

Both homopolycarbonates and copolycarbonates are suitable. It is also possible for 1  
5 to 25 wt. %, preferably 2.5 to 25 wt. %, based on the total amount of diphenols to be  
employed, of polydiorganosiloxanes having hydroxyaryloxy end groups to be  
employed for the production of copolycarbonates according to the invention  
according to component A. These are known (US 3 419 634) and can be produced  
by processes known from the literature. The preparation of copolycarbonates  
10 containing polydiorganosiloxanes is described in DE-A 3 334 782.

Preferred polycarbonates are, in addition to the bisphenol A homopolycarbonates,  
the copolycarbonates of bisphenol A with up to 15 mole %, based on the sum of the  
moles of diphenols, of other diphenols mentioned as preferred or particularly  
15 preferred, in particular 2,2-bis(3,5-dibromo-4-hydroxyphenyl)propane.

Aromatic dicarboxylic acid dihalides for the production of aromatic polyester  
carbonates are preferably the diacid dichlorides of isophthalic acid, terephthalic acid,  
diphenyl ether-4,4'-dicarboxylic acid and of naphthalene-2,6-dicarboxylic acid.  
20 Mixtures of the diacid dichlorides of isophthalic acid and of terephthalic acid in a  
ratio of between 1:20 and 20:1 are particularly preferred.

A carbonic acid halide, preferably phosgene, is additionally used as a bifunctional  
acid derivative in the production of polyester carbonates.

25

Possible chain terminators for the preparation of the aromatic polyester carbonates  
are, in addition to the monophenols already mentioned, also chlorocarbonates  
thereof as well as the acid chlorides of aromatic monocarboxylic acids, which may  
optionally be substituted by C<sub>1</sub> to C<sub>22</sub> alkyl groups or by halogen atoms, as well as  
30 aliphatic C<sub>2</sub> to C<sub>22</sub> monocarboxylic acid chlorides.

The quantity of chain terminators is in each case 0.1 to 10 mole %, based on the  
moles of diphenol in the case of the phenolic chain terminators and on the moles of

dicarboxylic acid dichloride in the case of monocarboxylic acid chloride chain terminators.

The aromatic polyester carbonates may also contain incorporated aromatic 5 hydroxycarboxylic acids.

The aromatic polyester carbonates may be either linear or branched in a known manner (in this context see DE-A 2 940 024 and DE-A 3 007 934).

10 Branching agents which may be used are, for example, acyl chlorides which are trifunctional or more than trifunctional, such as trimesic acid trichloride, cyanuric acid trichloride, 3,3',4,4'-benzophenonetetracarboxylic acid tetrachloride, 1,4,5,8-naphthalenetetracarboxylic acid tetrachloride or pyromellitic acid tetrachloride, in quantities of from 0.01 to 1.0 mole % (based on the dicarboxylic acid dichlorides 15 employed), or phenols which are trifunctional or more than trifunctional, such as phloroglucinol, 4,6-dimethyl-2,4,6-tri-(4-hydroxyphenyl)hept-2-ene, 4,6-dimethyl-2,4,6-tri-(4-hydroxyphenyl)heptane, 1,3,5-tri-(4-hydroxyphenyl)benzene, 1,1,1-tri-(4-hydroxyphenyl)ethane, tri-(4-hydroxyphenyl)phenylmethane, 2,2-bis[4,4-bis(4-hydroxyphenyl)cyclohexyl]propane, 2,4-bis(4-hydroxyphenylisopropyl)phenol, 20 tetra-(4-hydroxyphenyl)methane, 2,6-bis(2-hydroxy-5-methylbenzyl)-4-methyl-phenol, 2-(4-hydroxyphenyl)-2-(2,4-dihydroxyphenyl)propane, tetra-(4-[4-hydroxy-phenylisopropyl]phenoxy)methane and 1,4-bis[4,4'-dihydroxytriphenyl)methyl]-benzene, in amounts of from 0.01 to 1.0 mole %, based on the diphenols employed. Phenolic branching agents may be initially introduced into the reaction vessel with 25 the diphenols, and acid chloride branching agents may be introduced together with the acid dichlorides.

The proportion of carbonate structural units in the thermoplastic, aromatic polyester carbonates may be varied as desired. Preferably, the content of carbonate groups is 30 up to 100 mole %, especially up to 80 mole %, particularly preferably up to 50 mole %, based on the sum of ester groups and carbonate groups. Both the ester and the carbonate content of the aromatic polyester carbonates may be present in the polycondensate in the form of blocks or in random distribution.

In a preferred embodiment, the component A has a weight-average molecular weight M<sub>w</sub> (determined by GPC, light scattering or sedimentation) of 23 000 g/mole to 40 000 g/mole, preferably of 24 000 g/mole to 35 000 g/mole, especially of 25 000 5 to 32 000 g/mole.

### Component B

10 In a preferred embodiment, component B is a rubber-free vinyl copolymer of

B.1 70 to 80 wt. %, preferably 72 to 78 wt.%, especially 75 to 78 wt.% (based in each case on component B), of at least one monomer selected from the group of the vinyl aromatics (such as, for example, styrene and  $\alpha$ -methylstyrene) or 15 ring-substituted vinyl aromatics (such as, for example, p-methylstyrene and p-chlorostyrene) and

B.2 20 to 30 wt. %, preferably 22 to 28 wt.%, especially 22 to 25 wt.% (based in each case on component B), of at least one monomer selected from the group 20 of the vinyl cyanides (such as, for example, unsaturated nitriles, such as acrylonitrile and methacrylonitrile), (meth)acrylic acid (C<sub>1</sub>-C<sub>8</sub>) alkyl esters (such as, for example, methyl methacrylate, n-butyl acrylate and tert.-butyl acrylate), unsaturated carboxylic acids and derivatives of unsaturated carboxylic acids (for example maleic anhydride and N-phenylmaleimide).

25

The copolymers B are resinous, thermoplastic and rubber-free. Particularly preferably, component B is a rubber-free copolymer of styrene (B.1) and acrylonitrile (B.2).

30 Copolymers of this type are known and can be produced by free-radical polymerisation, especially by emulsion, suspension, solution or bulk polymerisation.

The (co)polymers preferably possess average molecular weights (M<sub>w</sub>) (weight average, determined by GPC, light scattering or sedimentation) between 15 000 and

- 11 -

250 000 g/mole, particularly between 50 000 and 200 000 g/mole, especially between 80 000 and 160 000 g/mole.

## 5 Component C

In a preferred embodiment, component C is a sized glass fibre with

10 C.1 a glass fibre selected from at least one component from the group consisting of continuous strands (rovings), long glass fibres and chopped glass strands,

C.2 a size containing an epoxy polymer, and

C.3 optionally an adhesion promoter.

15

Size C.2 and adhesion promoter C.3 are preferably employed in component C in an amount such that the carbon content measured in component C is 0.1 to 1 wt.%, preferably 0.2 to 0.8 wt.%, particularly preferably 0.3 to 0.7 wt.%.

20 The glass fibres according to component C.1 are preferably made from E-, A- or C-glass. The diameter of the glass fibres is preferably 5 to 25 µm, particularly preferably 6 to 20 µm, most preferably 7 to 15 µm. The long glass fibres preferably have a length of 5 to 50 mm, particularly preferably 5 to 30 mm, most preferably 7 to 25 mm. Long glass fibres are described e.g. in WO-A 2006/040087. At least 70 wt.% of the glass

25 fibres in the chopped glass strands preferably have a length of more than 60 µm.

The size C.2 preferably consists of

30 C.2.1 50 to 100 wt.%, preferably 70 to 100 wt.%, particularly preferably 80 to 100 wt.% (based on C.2 in each case) epoxy polymer and

C.2.2 0 to 50 wt.%, preferably 0 to 30 wt.%, particularly preferably 0 to 20 wt.% (based on C.2 in each case) of one or more other polymers.

Most preferably, the size C.2 consists exclusively of epoxy polymer C.2.1 (i.e. the size C.2 is free from other polymers according to component C.2.2).

5 The epoxy polymer according to C.2.1 can be an epoxy resin, an epoxy resin ester or an epoxy resin polyurethane, for example.

In a preferred embodiment, the epoxy polymer according to component C.2.1 is an epoxy resin made from

10

C.2.1.1 epichlorohydrin and

C.2.1.2 a preferably aromatic alcohol, which has at least two hydroxyl groups.

15 Component C.2.1.2 is preferably a phenolic resin, for example a novolak, or a compound of formula (I). Component C.2.1.2 is particularly preferably bisphenol A.

Component C.2.2 is preferably at least one polymer selected from the group consisting of polyurethanes, polyolefins, acrylate-containing polymers, styrene-containing  
20 polymers and polyamides.

Component C.3 is preferably a silane. In a preferred embodiment, the silane possesses a functional group selected from the group of the amino group, epoxy group, carboxylic acid group, vinyl group and mercapto group for binding to the polymer of  
25 the size, as well as one to three, preferably three alkoxy groups for binding to the glass fibre. For example and preferably, at least one silane selected from the group consisting of vinyltrichlorosilane, vinyltriethoxysilane, vinyltrimethoxysilane,  $\gamma$ -methacryloxy-propyltrimethoxysilane,  $\beta$ -(3,4-epoxycyclohexyl)ethyltrimethoxysilane,  $\gamma$ -glycidoxypropyltrimethoxysilane, N- $\beta$ -(aminoethyl)- $\gamma$ -aminopropyltrimethoxysilane,  $\gamma$ -amino-  
30 propyltriethoxysilane, N-phenyl- $\gamma$ -aminopropyltrimethoxysilane,  $\gamma$ -mercaptopropyltrimethoxysilane and  $\gamma$ -chloropropyltrimethoxysilane is used as component C.3. Sized glass fibres which contain the component C.3 exhibit better adhesion of the size to the glass fibre.

**Component D**

5 Component D comprises one or more graft polymers of

D.1 5 to 70 wt.%, preferably 10 to 60 wt.%, especially 20 to 50 wt.% of at least one vinyl monomer on

10 D.2 30 to 95 wt.%, preferably 40 to 90 wt.%, especially 50 to 80 wt.% of one or more backbones with glass transition temperatures of < 10°C, preferably < 0°C, particularly preferably < -20°C.

Monomers D.1 are preferably mixtures of

15

D.1.1 50 to 99 parts by weight vinyl aromatics and/or ring-substituted vinyl aromatics (such as styrene,  $\alpha$ -methylstyrene, p-methylstyrene, p-chlorostyrene) and/or ( $C_1$ - $C_8$ ) alkyl methacrylates, such as methyl methacrylate, ethyl methacrylate, and

20

D.1.2 1 to 50 parts by weight of vinyl cyanides (unsaturated nitriles such as acrylonitrile and methacrylonitrile) and/or ( $C_1$ - $C_8$ ) alkyl (meth)acrylates, such as methyl methacrylate, n-butyl acrylate, t-butyl acrylate, and/or derivatives (such as anhydrides and imides) of unsaturated carboxylic acids, 25 for example maleic anhydride and N-phenylmaleimide.

Preferred monomers D.1.1 are selected from at least one of the monomers styrene,  $\alpha$ -methylstyrene and methyl methacrylate; preferred monomers D.1.2 are selected from at least one of the monomers acrylonitrile, maleic anhydride and methyl 30 methacrylate. Particularly preferred monomer combinations are D.1.1 styrene and D.1.2 acrylonitrile or D.1.1 and D.1.2 methyl methacrylate.

The backbones D.2 suitable for the graft polymers D are, in a preferred embodiment, saturated, i.e. substantially free from double bonds. D.2 is particularly preferably at least one rubber selected from the group consisting of acrylate rubbers, silicone rubbers and silicone-acrylate composite rubbers. Most preferably, D.2 is at least one 5 rubber selected from the group consisting of silicone rubbers and silicone-acrylate composite rubbers.

Suitable acrylate rubbers according to D.2 are preferably polymers of alkyl acrylates, optionally with up to 40 wt.%, based on D.2, of other polymerisable, 10 ethylenically unsaturated monomers. The preferred polymerisable acrylates include C<sub>1</sub> to C<sub>8</sub> alkyl esters, for example methyl, ethyl, butyl, n-octyl and 2-ethylhexyl esters; haloalkyl esters, preferably halo-C<sub>1</sub>-C<sub>8</sub>-alkyl esters, such as chloroethyl acrylate, as well as mixtures of these monomers.

15 For crosslinking purposes, monomers with more than one polymerisable double bond can be copolymerised. Preferred examples of crosslinking monomers are esters of unsaturated monocarboxylic acids with 3 to 8 C atoms and unsaturated monohydric alcohols with 3 to 12 C atoms, or saturated polyols with 2 to 4 OH groups and 2 to 20 C atoms, such as ethylene glycol dimethacrylate, allyl 20 methacrylate; polyunsaturated heterocyclic compounds, such as trivinyl and triallyl cyanurate; polyfunctional vinyl compounds, such as di- and trivinyl benzenes; but also triallyl phosphate and diallyl phthalate. Preferred crosslinking monomers are allyl methacrylate, ethylene glycol dimethacrylate, diallyl phthalate and heterocyclic compounds having at least three ethylenically unsaturated groups. Particularly 25 preferred crosslinking monomers are the cyclic monomers triallyl cyanurate, triallyl isocyanurate, triacryloylhexahydro-s-triazine, triallyl benzenes. The quantity of the crosslinked monomers is preferably 0.02 to 5, especially 0.05 to 2 wt.%, based on the backbone D.2. In the case of cyclic crosslinking monomers with at least three ethylenically unsaturated groups, it is advantageous to limit the quantity to less than 30 1 wt.% of the backbone D.2.

Preferred "other" polymerisable, ethylenically unsaturated monomers which may optionally be used in addition to the acrylates for the production of the backbone D.2

- 15 -

are e.g. acrylonitrile, styrene,  $\alpha$ -methylstyrene, acrylamides, vinyl-C<sub>1</sub>-C<sub>6</sub>-alkyl ethers and methyl methacrylate.

Other suitable backbones according to D.2 are silicone rubbers with graft-active 5 points, as described in DE-OS 3 704 657, DE-OS 3 704 655, DE-OS 3 631 540 and DE-OS 3 631 539.

The graft copolymers D are produced by free-radical polymerisation, preferably by emulsion polymerisation.

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The backbone D.2 generally has an average particle size (d<sub>50</sub> value) of 0.05 to 1  $\mu$ m, preferably 0.07 to 0.5  $\mu$ m, particularly preferably 0.1 to 0.4  $\mu$ m. The average particle size d<sub>50</sub> is the diameter having 50 wt.% of the particles lying above it and 50 wt.% below it. It can be determined by means of ultracentrifuge measurement (W. 15 Scholtan, H. Lange, Kolloid, Z. und Z. Polymere 250 (1972), 782-1796).

The gel content of the backbone D.2 in graft polymers produced by emulsion polymerisation is preferably at least 30 wt.%, particularly preferably at least 40 wt.%, especially at least 50 wt.% (measured in toluene). The gel content is 20 determined at 25°C in a suitable solvent as the portion that is insoluble in these solvents (M. Hoffmann, H. Krömer, R. Kuhn, Polymeranalytik I and II, Georg Thieme-Verlag, Stuttgart 1977).

Since it is known that, during the graft reaction, the graft monomers are not 25 necessarily grafted on to the backbone completely, graft polymers D according to the invention are also understood to mean those products obtained by (co)polymerisation of the graft monomers in the presence of the backbone and jointly forming during the work-up. These products can therefore also contain free (co)polymer of the graft monomers, i.e. not chemically bonded to the rubber.

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**E) Other components**

The composition may contain other additives as component E, with polymer additives such as flame retardants (e.g. organic phosphorus or halogen compounds, 5 especially bisphenol A-based oligophosphate), anti-drip agents (e.g. compounds of the classes of substances of the fluorinated polyolefins, the silicones and aramid fibres), lubricants and mould release agents, e.g. pentaerythritol tetrastearate, nucleating agents, antistatic agents, stabilisers, fillers and reinforcing materials other than component C (e.g. carbon fibres, talc, mica, kaolin,  $\text{CaCO}_3$ ), as well as dyes 10 and pigments (e.g. titanium dioxide or iron oxide), being particularly suitable.

**Production of the moulding compositions and shaped articles**

15 The thermoplastic moulding compositions according to the invention can be produced, for example, by mixing the respective components in a known manner and melt-compounding and melt-extruding them at temperatures of 200°C to 320°C, preferably at 240 to 300°C, in conventional equipment such as internal mixers, extruders and twin screw extruders.

20 The mixing of the individual components can take place in a known manner, either successively or simultaneously, and either at about 20°C (room temperature) or at a higher temperature.

25 In a preferred embodiment, the production of the compositions according to the invention takes place in a twin screw extruder, the components A, B, D and E first being melted and mixed and the glass fibres C then being introduced into the melt mixture via a subsidiary extruder and dispersed therein.

30 The invention thus also provides a process for the production of the compositions according to the invention.

The moulding compositions according to the invention can be used for the production of shaped articles of all kinds. These can be produced, for example, by injection moulding, extrusion and blow moulding processes. Another form of processing is the production of shaped articles by thermoforming from previously 5 produced sheets or films.

Examples of these shaped articles are films, profiles, all kinds of housing parts, e.g. for domestic appliances such as juice presses, coffee machines, mixers; for office equipment such as monitors, flat screens, notebooks, printers, copiers; sheets, pipes, 10 electrical installation ducts, windows, doors and other profiles for the construction sector (interior finishing and exterior applications) as well as electrical and electronic parts such as switches, plugs and sockets and components for utility vehicles, particularly for the car sector. The compositions according to the invention are also suitable for the production of the following shaped articles or moulded 15 parts: interior fittings for rail vehicles, ships, aircraft, buses and other motor vehicles, body parts for motor vehicles, housings for electrical appliances containing small transformers, housings for equipment for data processing and transfer, housings and claddings for medical equipment, massage equipment and housings therefor, toy vehicles for children, flat wall elements, housings for safety devices, 20 thermally insulated transport containers, mouldings for sanitary and bath equipment, covering grid plates for ventilation openings and housings for garden equipment.

- 18 -

**Examples**

**Component A:**

Linear polycarbonate based on bisphenol A with a weight-average molecular weight 5  $M_w$  of 28 000 g/mole (determined by GPC).

**Component B-1:**

SAN copolymer with an acrylonitrile content of 23 wt.% and a weight-average molecular weight of about 130 000 g/mole.

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**Component B-2:**

ABS polymer with an acrylonitrile content : butadiene : styrene ratio of 20 : 28 : 52 wt.%, produced by emulsion polymerisation.

15 **Component C-1:**

Chopped glass strands with an average diameter of 13  $\mu\text{m}$  and a size made of epoxy resin produced from epichlorohydrin and bisphenol A. The carbon content of component C-1 is 0.6 wt.%.

20 **Component C-2:**

Chopped glass strands with an average diameter of 13  $\mu\text{m}$  and a polyurethane size. The carbon content of component C-1 is 0.4 wt.%.

**Component D:**

25 Metablen<sup>®</sup> SRK200 (Mitsubishi Rayon, Japan): styrene-acrylonitrile grafted acrylate-silicone composite rubber, produced by emulsion polymerisation.

**Component E-1:** Pentaerythritol tetrastearate

**Component E-2:** Phosphite stabiliser

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**Production and testing of the moulding compositions according to the invention**

The components are mixed in a ZSK-25 twin screw extruder from Werner & Pfleiderer at a melt temperature of 260°C. The mouldings are produced at melt temperatures of 5 260°C and 300°C and a mould temperature of 80°C using an injection moulding machine of the Arburg 270 E type.

The melt viscosity measured at 260°C and a shear rate of 1000 s<sup>-1</sup> in accordance with ISO 11443 serves as a measure of the melt flowability.

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The impact resistance is determined at 23°C in accordance with ISO 180-1U on specimens measuring 80 mm x 10 mm x 4 mm. The specimens were injection moulded at melt temperatures of 260°C and 300°C. The change in impact resistance  $a_K$  on increasing the processing temperature serves as a measure of the processing stability of 15 the composition and is calculated as follows:

$$\text{Processing stability} = \frac{a_K^{260^\circ\text{C}} - a_K^{300^\circ\text{C}}}{a_K^{260^\circ\text{C}}} * 100\%$$

The modulus of elasticity is determined on test bars injection moulded at 260°C, in accordance with ISO 527.

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The stress cracking (ESC) resistance in rapeseed oil at room temperature serves as a measure of the chemical resistance. The time taken to fracture failure induced by stress cracking is determined on a specimen measuring 80 mm x 10 mm x 4 mm, injection moulded at a melt temperature of 260°C, which is subjected to an outer fibre strain of 25 2.4% using a strain jig and completely immersed in the medium. The measurement is performed on the basis of ISO 4599.

The reduction in impact resistance determined at 23°C in accordance with ISO 180-1U on specimens measuring 80 mm x 10 mm x 4 mm, injection moulded at 260°C, when 30 stored in hot air at 120°C for 1500 h serves as a measure of heat ageing resistance.

- 20 -

The change in colour (change in grey scale) of specimens measuring 60 mm x 40 mm x 2 mm, injection moulded at 260°C, subjected to hot light ageing in accordance with VW standard PV 1303 over 6 illumination cycles, serves as a measure of UV light resistance.

**Table 1: Moulding compositions and their properties**

<u>Components [parts by wt.]</u>	1 (cp.)	2 (cp.)	3 (cp.)	4 (cp.)	5 (cp.)	6 (cp.)	7 (cp.)	8 (cp.)	9 (cp.)	10 (cp.)	11 (cp.)	12 (cp.)
A PC	60.64	60.64	60.64	60.64	49.75	49.75	49.75	49.75	61.81	61.94	49.46	43.52
B-1 SAN	-	28.83	-	28.83	-	29.85	-	29.85	21.93	26.97	29.67	25.72
B-2 ABS	28.83	-	28.83	-	29.85	-	29.85	-	-	-	-	-
C-1 GF (epoxy-sized)	-	-	9.94	9.94	-	-	19.90	19.90	9.97	9.99	19.78	29.67
C-2 GF (PU-sized)	9.94	9.94	-	-	19.90	19.90	-	-	-	-	-	-
D Metablen SRK200	-	-	-	-	-	-	-	-	5.98	0.50	0.49	0.49
E-1 PETS	0.50	0.50	0.50	0.50	0.40	0.40	0.40	0.40	0.20	0.50	0.49	0.49
E-2 Irganox B900	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10	0.10
<b>Properties</b>												
Impact resistance $\Delta K^{260^\circ\text{C}}$ [kJ/m <sup>2</sup> ]	30	25	43	39	23	27	n.m.	40	39	37	40	38
Impact resistance $\Delta K^{300^\circ\text{C}}$ [kJ/m <sup>2</sup> ]	33	17	n.m.	35	n.m.	n.m.	n.m.	n.m.	39	37	37	38
Processing stability [%]	-10.0	32.0	n.m.	10.3	n.m.	n.m.	n.m.	n.m.	0.0	0.0	7.5	0.0
Melt viscosity [Pas]	315	193	329	229	333	187	356	202	247	212	198	233
Modulus of elasticity [MPa]	3736	5147	3961	5070	5729	7000	5994	7488	4623	5189	7604	10178
ESC - time to fracture [h]	1.5	0.1	n.m.	21	0.5	0.02	n.m.	19	2.5	11	8	0.07
Change in toughness with heat ageing (1500h at 120°C) [%]	n.m.	n.m.	n.m.	-41	n.m.	n.m.	+4	n.m.	n.m.	n.m.	n.m.	n.m.
Colour change with hot light ageing (change in grey scale in 6 cycles)	n.m.	n.m.	n.m.	-1.5	n.m.	n.m.	+/- 0	n.m.	n.m.	n.m.	n.m.	n.m.

n.m. = not measured

It can be seen from Table 1 that those compositions containing butadiene rubber-modified styrene resin (comparative examples 1, 3, 5, 7 and 9) or SAN in combination with a relatively large amount of a rubber-modified graft polymer (comparative example 9) exhibit inadequate flowability and an inadequate modulus of elasticity 5 compared with examples according to the invention having the same glass fibre content (examples 4, 8, 10-12). Moreover, when butadiene rubber-modified styrene resins are used (comparative examples 5), the heat ageing and light resistance are also unsatisfactory. The compositions that do not contain glass fibres having an epoxy 10 polymer-based size (comparative examples 1, 2, 5 and 6) are distinguished by poorer toughness compared with those comparable compositions with glass fibres having an epoxy polymer-based size. Although the rubber-free compositions containing glass fibres without an epoxy polymer-based size (comparative examples 2 and 6) do exhibit 15 good flowability, however, they have very poor chemical resistance and processing stability. A good combination of flowability, rigidity, chemical resistance, toughness, processing stability and ageing resistance under the effects of light and heat is only achieved in the compositions according to the invention (examples 4, 8, 10-12).

- 23 -

**Claims**

1. A composition containing
  - 5 A) 10 to 85 parts by weight polycarbonate, polyester carbonate or a mixture thereof,
  - B) 10 to 50 parts by weight rubber-free vinyl copolymer,
  - 10 C) 5 to 50 parts by weight of sized glass fibre, the size containing an epoxy polymer,
  - D) 0 to 2 parts by weight rubber-modified graft polymers, and
  - 15 E) 0 to 10 parts by weight commercial polymer additives,

the composition being free from rubber-modified polymers which differ from component D).
- 20 2. The composition according to claim 1, containing 15 to 40 parts by weight of rubber-free vinyl copolymer (component B).
3. The composition according to claim 1, containing 20 to 35 parts by weight of rubber-free vinyl copolymer (component B).
- 25 4. The composition according to one of claims 1 to 3, containing 0 to 1 parts by weight of rubber-modified graft polymers (component D).
5. The composition according to one of claims 1 to 3, which is free from rubber-modified graft polymers (component D).

- 24 -

6. The composition according to one of claims 1 to 5, wherein component C is a sized glass fibre with

5 C.1 a glass fibre selected from at least one component from the group consisting of continuous strands, long glass fibres and chopped glass strands,

10 C.2 a size containing an epoxy polymer, and

10 C.3 optionally an adhesion promoter.

7. The composition according to claim 6 containing as component C a glass fibre with a size C.2 consisting substantially of

15 C.2.1 50 to 100 wt.%, based on C.2, epoxy polymer and

C.2.2 0 to 50 wt.%, based on C.2, of one or more other polymers selected from the group of the polyurethanes, polyolefins, acrylate-containing polymers, styrene-containing polymers and polyamides.

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8. The composition according to claim 7, in which, as the epoxy polymer C.2.1, an epoxy resin is used made from

25 C.2.1.1 epichlorohydrin and

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C.2.1.2 an alcohol, which has at least two hydroxyl groups.

9. The composition according to claim 8, in which bisphenol A is used as the bifunctional alcoholic component C.2.1.2.

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10. The composition according to one of claims 1 to 9, in which the sized glass fibre according to component C has a carbon content of 0.1 to 1 wt.%.

- 25 -

11. The composition according to one of claims 1 to 10, in which the glass fibre according to component C has an average diameter of 5 to 25  $\mu\text{m}$ .
12. The composition according to one of claims 1 to 11, wherein as component E, 5 at least one additive is contained, selected from the group consisting of flame retardants, anti-drip agents, lubricants and mould release agents, nucleating agents, antistatic agents, stabilisers, fillers and reinforcing materials other than component C, as well as dyes and pigments.
- 10 13. The composition according to one of claims 1 to 12, in which component B is a rubber-free vinyl copolymer of 15
  - B.1 70 to 80 wt. %, based on component B, of at least one monomer selected from the group of the vinyl aromatics or ring-substituted vinyl aromatics and
  - B.2 20 to 30 wt. %, based on component B, of at least one monomer selected from the group of the vinyl cyanides, (meth)acrylic acid ( $\text{C}_1$ - $\text{C}_8$ ) alkyl esters, unsaturated carboxylic acids and derivatives of 20 unsaturated carboxylic acids.
14. The composition according to claim 13, in which component B.1 is styrene and component B.2 is acrylonitrile.
- 25 15. The composition according to one of claims 1 to 14, containing as component D a rubber-based graft polymer which is substantially free from double bonds.
16. The composition according to claim 15, containing as component D a rubber-based graft polymer selected from the group consisting of acrylate rubber, 30 silicone rubber and silicone-acrylate composite rubber.
17. The use of the composition according to one of claims 1 to 16 for the production of shaped articles.

18. Shaped articles containing a composition according to one of claims 1 to 16.