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[Continued on next page]

(54) Title: DEVICE FOR MAKING ADDITIVES PACKAGES ("MASTERBATCH") FOR THERMOPLASTIC COMPOSITIONS

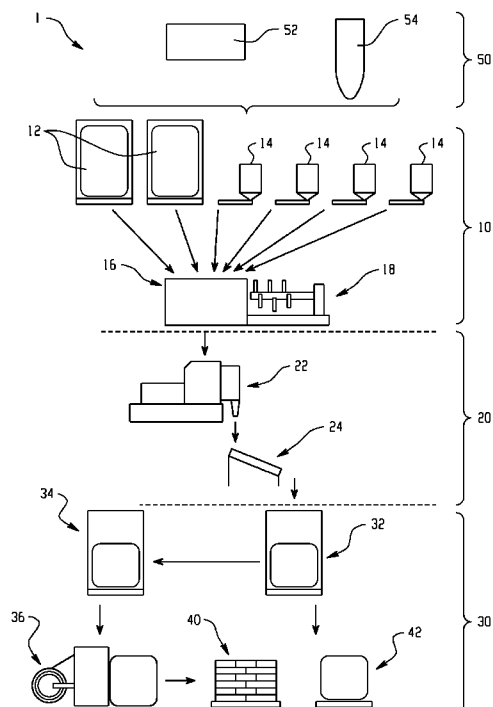


Fig. 1

(57) Abstract: Masterbatch facility comprising: a feed and blend system (10) comprising greater than or equal to one feeder (14), greater than or equal to one discharger (12), a manual feed station (16), or a combination thereof, and further comprising a mixer (18), wherein at least one of the feeders is an assisted component feeder, wherein at least two components are fed via the feeder, discharger, manual feed station, or a combination thereof to the mixer, wherein the mixer is a double shaft mixer rotating in opposite directions, a pellet mill (20) comprising a buffer hopper, a screw feeder, a pellet compactor (22), and a screener (24), wherein the pellet compactor comprises a die plate, a roll, and a cutter hub, a product handling system (30) comprising a product hopper (34) and a filling station (32), and a utilities system (50).

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DEVICE FOR MAKING ADDITIVES PACKAGES ("MASTERBATCH") FOR
THERMOPLASTIC COMPOSITIONS

TECHNICAL FIELD

[0001] The present disclosure describes a process of making a masterbatch and to masterbatches made therefrom.

BACKGROUND

[0002] Additives packages (also referred to as a masterbatch) for thermoplastic compositions are important in industry as they allow for easy application of multiple additives to a thermoplastic composition as a single added component. Current methods of making a masterbatch can be time intensive and improved methods for making a masterbatch and new masterbatch compositions are desired.

BRIEF DESCRIPTION

[0003] Disclosed herein is a facility for making a masterbatch and a process for making the same.

[0004] In an embodiment, a process for making masterbatch pellets comprising: introducing two or more components to a mixer; wherein the components are added via a feeder, a discharger, and/or a manual fill station; mixing the components in the mixer to form a mixed composition; introducing the mixed composition to a buffer hopper; feeding the mixed composition from the buffer hopper to a pellet compactor via a screw feeder; compacting the mixed composition into masterbatch pellets; screening the masterbatch pellets into a desired size range; and feeding the screened masterbatch pellets from the product hopper into a product bag.

[0005] In another embodiment, a masterbatch facility comprising: a feed and blend system comprising a feeder, a discharger, a manual feed station, or a combination thereof, and further comprising a mixer; wherein at least one of the feeders is an assisted component feeder; wherein at least two components are fed via the feeder, discharger, manual feed station, or a combination thereof to the mixer; wherein the mixer is a double shaft mixer rotating in opposite directions; a pellet mill comprising a buffer hopper, a screw feeder, a pellet compactor, and a screener; wherein the pellet compactor comprises a die plate, a roll, and a cutter hub; a product handling system comprising a product hopper and a fill station; and a utilities system.

[0006] The above described and other features are exemplified by the following figures and detailed description.

BRIEF DESCRIPTION OF THE DRAWINGS

[0007] Refer now to the figures, which are exemplary embodiments, and wherein the like elements are numbered alike.

[0008] FIG. 1 is an illustration of the present process of making a masterbatch; and

[0009] FIG. 2 is an illustration of a fill station.

DETAILED DESCRIPTION

The Applicants developed a process for creating a masterbatch comprising and integrating a feed and blend system, a pellet mill, a product handling system, and a utilities system. The present process advantageously results in an improved homogeneity as compared to previous processes. The present process can produce greater than 450 tons of masterbatch per year, specifically, 500 tons of masterbatch per year. The present process can be entirely automated. The present process can reduce the preparation time, for example, by reducing a mixing time from greater than 15 minutes to less than 10 minutes, specifically, 30 seconds to 8 minutes, more specifically, 1 minute to 8 minutes, still more specifically, 3 minutes to 7 minutes. After mixing, the mixed composition processed through to screening, i.e. from the time the mixed composition exits the mixer to screening in less than or equal to 50 minutes, specifically, less than or equal to 40 minutes.

[0010] The feed and blend system comprises various component feeder(s) and/or component discharger(s) for feeding components into a mixer. The feed and blend system comprises at least one component feeder or component discharger, where the component feeder can be used for feeding, for example, less than or equal to 100 kilograms (kg), e.g., less than or equal to 20 kg of a material to the mixer and where the component discharger can be a big bag unloading station, where the big bag can, for example, contain greater than or equal to 300 kg of pellets, for example, 400 kg of pellets. The feed and blend system can comprise 1, specifically, 1 to 10, more specifically 3 to 6 component feeders. The component feeders can be, for example, a feeder as available from K-TRON. The feed and blend system can comprise 1, specifically, 1 to 10, more specifically, 1 to 3 component dischargers. The feed and blend system can also comprise a manual fill location for components that are present in small amounts, such as those that are present in an amount less than or equal to 15 weight percent (wt%), specifically, less than or equal to 11 wt% based on the total weight of the composition, for example 10 wt%.

[0011] At least one of the component feeders can be an assisted component feeder that is designed to handle difficult material, such as one that does not flow without

assistance out of the feeder, where an amount of the component would remain in the feeder and/or along the sides of the feeder. The assisted component feeder can comprise a twin screw, an internal agitator, a vibrator, and a knocker system, or a combination comprising one or more of the foregoing, integrated to avoid material blocks. The vibrator can be a pneumatic vibrator that can impart a frequency a vibration on the feeder to avoid bridge generation of the material and to achieve flow of the material into the mixer. As used herein “bridge generation” refers to the formation of material bridges that span one side of the feeder to another such that the bridge material would otherwise remain in the feeder. The assisted component feeder can be, for example, a vibratory feeder as available from K-TRON.

[0012] The feed and blend system comprises at least 1 mixer. The mixer can be a high speed, double shaft mixer, where the double shaft mixer rotates in opposite directions such as the PEGASUS mixer available from DINNISSEN BV. The use of a double shaft mixer can create a fluidized zone, which lies at the core of the mixing process. Such a mixer can allow for decreased mixing times of less than 5 minutes, specifically, 30 seconds to 4 minutes, more specifically, 30 seconds to 1 minute, while minimizing the amount of energy to be imparted on the composition. A maximum amount of energy that can be imparted on a specific masterbatch can be defined as the energy where at least one of the components, such as an antioxidant, melts. For example, when a component with a melting temperature of 60 degrees Celsius ($^{\circ}\text{C}$), specifically, 50°C melts due to the shear imposed by the mixer.

[0013] The mixer can mix the components at a tip speed of 0.1 to 100 meters per second (m/s), specifically, 1 to 50 m/s, more specifically, 1 to 5 m/s. The mixer mixes the components to form a mixed composition.

[0014] After the mixed composition is prepared, the mixed composition is then fed to the pellet mill. The mixed composition can be fed to the pellet mill via an automated process. For example, the mixer can comprise a discharge gate, where during transfer the discharge gate can be opened to allow for material transfer out of the mixer. The mixer shafts, i.e. the mixer blades, can be rotating during transfer to facilitate transfer and ensure that a maximum amount of material is transferred.

[0015] The pellet mill can comprise a buffer hopper, a mill feeder, a pellet compactor, and a screener. The buffer hopper is responsible for introducing the mixed composition to the mill feeder. The buffer hopper can comprise an internal agitator, a vibrator, and a knocker system, or a combination comprising one or more of the foregoing. For example, the

buffer hopper can comprise a vibrator that can vibrate at a frequency of 2,000 to 100,000 vibrations per minute (vpm), specifically, 10,000 to 40,000 vpm, more specifically, 20,000 to 30,000 vpm, for example, 25,000 vpm in order to facilitate flow of the mixed composition and to avoid bridge generation of the material and to achieve flow of the mixed composition into the mill feeder. The vibrator on the buffer hopper can be a pneumatic vibrator system.

[0016] The mill feeder is responsible for feeding the mixed composition from the buffer hopper to the pellet compactor. The mill feeder can be a screw feeder (such as K2 MV-S60 available from K-TRON). The incorporation of a screw feeder here versus a typical configuration with a butterfly valve has the advantage of better control of the material flow through the feeder. The screw feeder has the advantage of flow control through the feeder as compared to a butterfly valve that has only two positions, open and closed. The mill feeder can operate at a rate of 45 to 4500 decimeters cubed per hour (dm^3/h), specifically, 100 to 2000 dm^3/h .

[0017] The pellet compactor can comprise a die plate, a roll, and a cutter hub, where the roll functions to press the blended composition through die holes in the die plate, after which the cutter hub cuts the material as it is pressed through the holes to form the pellets. It is noted that different die plates can be used to produce pellets of varying size and shape. For example, the die holes can be circular to produce cylinders with a diameter of 0.5 to 5 millimeter (mm), specifically, 2.3 mm to 2.5 mm or can be rectangular with a length:width ratio of 1:10 to 10:1. The die plate can comprise die holes that are all the same size and shape or can comprise die holes with varying size and/or shape. It is further noted that the cutting rate of the cutter hub can be varied to result in pellets of differing height. For example, the resultant pellets can have a height of 1 to 30 mm. The pellet compactor can be one such those available from CPM EUROPE BV.

[0018] The pellets can then be fed to a screener. The screener can be used to separate the pellets into varying size grades and/or to remove one or both of fines (pellets smaller than a minimum desired pellet size, for example, pellets with a length of less than 3 mm) and oversize pellets (pellets larger than a maximum desired pellet size, for example, pellets with a length of greater than 15 mm).

[0019] The product handling system is responsible for packaging the produced pellets. The product handling system can comprise a product hopper, a fill station, a conveyer, a pallet loading station, a stretch wrapper, a labeler, or a combination thereof. The product hopper can comprise an internal agitator, a vibrator, and a knocker system, or a

combination comprising one or more of the foregoing. For example, the product hopper can comprise a product hopper vibrator system that can be used to avoid caverns and bridging generations and ultimately results in an increase in processing rates through the present process. The product hopper vibrator system can be, for example, an external pneumatic vibrator.

[0020] The pellets can be fed to the product handling system via a pellet feeder or can be fed via gravity. The pellets can be fed to a fill station that fills the pellets into product bags. The fill station can be one such as that provided by PAYPER BAGGING TECHNOLOGIES. The fill station can comprise a scale such that when a specified weight of pellets have been introduced to a product bag, then the filling can be paused and a new product bag can be introduced. Likewise, the filling can be monitored by using a specified fill rate and time. The fill station can comprise a vibrating table located under the product bag that is being filled. The vibrating table facilitates the complete filling of the product bags and can be especially useful in promoting settling of the pellets and can be especially useful in filling bags with angles.

[0021] The filled bags can then be moved, for example, via a conveyer such as a conveyer belt or a roller conveyer, to a pallet loader that functions to move the filled bags onto a pallet. Once a full pallet is achieved, the full pallet can be moved to a stretch wrapper to wrap the pallet and to a labeler to label the wrapped pallet. The pallet can then be moved to a storage area.

[0022] The utilities system comprises a ventilation system for removing particles from the air and/or that accumulate on surfaces. The ventilation system can be running throughout the operation, during product change over, and/or as needed. For example, the room housing the present process can comprise an air ventilation system comprising a rotary enthalpy recovery system and blowers (such as a fresh air inlet blower and an exhaust air inlet blower). Likewise, vacuum hoods can be located throughout the room housing the present process and/or in areas of high particle generation (such as near one or more of a component feeder, a component discharger, a mixer, a pellet compactor, a screener, and a fill station) to pull air that comprises airborne particles into the ventilation system to, for example, an air filter. The rated ventilation for the room housing the present process can be 5 to 20, specifically, 8 to 12 air changes per hour. Furthermore, vacuum stations (such as a central vacuum station that can feed the vacuumed particles to a filter) can be provided for

users to vacuum particles that have accumulated on surfaces. There can be at least 1, specifically, 1 to 10 vacuum stations.

[0023] The utilities system can regulate the temperature and/or the humidity. The temperature can be controlled such that temperature is 17 to 26°C. The temperature can be controlled such that the temperature is +/- 1°C of a set temperature, for example, 25°C +/- 1°C or 18°C +/- 1°C (in other words, 24°-26°C or 17°C-19°C). The humidity can be controlled such that the humidity is 40 to 64%.

[0024] The room that houses the present process can comprise an electrical room that houses the electrical and control equipment that monitors the present process. The electrical room can be maintained such that the temperature is less than or equal to 28°C. The humidity of the electrical room can be controlled such that the humidity is 40 to 64%.

[0025] FIG. 1 illustrates a process of making a masterbatch 1. The process comprises a feed and blend system 10, a pellet mill 20, a product handling system 30, and a utilities system 50. FIG. 1 illustrates that components can enter the feed and blend system 10 through one or more of component discharger 12, component feeder 14, or can be manually added through manual feeder 16. The components can be fed from the feeder(s) and/or discharger(s) to mixer 18 that mixes the components to form a mixed composition. The mixed composition then enters the pellet mill 20, where FIG. 1 illustrates the mixed composition entering pellet compactor 22 that forms the mixed composition into pellets. The pellets then enter the screener 24 to screen the pellets based on a specified size range to form a screened composition.

[0026] The screened composition then enters the product handling system 30, where FIG. 1 illustrates the screened composition entering filling station 32. Filling station 32 can directly fill bags produce big bag product bag 42. Likewise, filling station 32 can be a mobile filling station that can be moved to hopper bagger station 34. Hopper bagger station 34 can fill bags at bagger station 36 that can fill bags, place them onto a pallet, wrap, and label said pallet to form small bag product pallet 40.

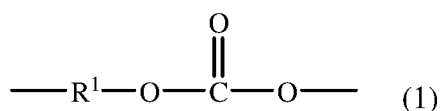
[0027] FIG. 2 illustrates a bagging station 70. Specifically, the pellets are filled into product bag 74 that can be a big bag, such as on that can hold 400 kg of pellets, via pellet filling pipe 72. Product bag 74 can be located on a pallet 76 that can be a pallet. The filling platform can be located on support(s) 78 that can be steel supports. The filling of the product bag 74 can be controlled via limit switch 84 or weighing steel structure 80. When the filling is controlled by a limit switch 84, then the support(s) 78 is supported by floating support 88.

Floating support 88 floats via lifting air pad(s) 82. Limit switch 84 is located near pin 90 that is located on floating support 88. As the weight of the bag increases the floating support 88 lowers and the pin 90 lowers. When the pin 90 reached a minimum point 92, filling of the product bag 74 is ceased and the product bag is replaced. When the filling is controlled via weighing steel structure 80, then support(s) 78 are located on weighing steel structure 80 that may or may not be located on floating support 88. When a predetermined weight is obtained then filling is stopped and the bag is replaced. FIG. 2 further illustrates that vibrator 86 can be located on floating support 88 to improve the product filling.

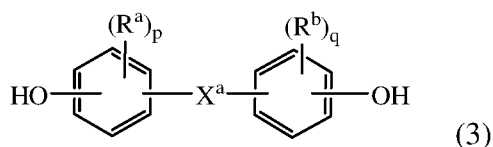
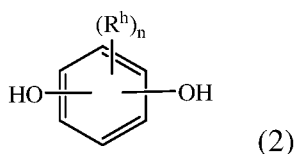
[0028] Referring back to FIG. 1, the process 2 can further comprise utilities system 50, including HVAC unit 52 and central vacuum 54.

[0029] The masterbatch can be prepared by feeding various components to the mixer. The components can include a thermoplastic polymer, a masterbatch quencher, a release agent, an antioxidant, an ultraviolet light (UV) stabilizing agent, a flame retardant, an anti drip agent, an antistatic agent, a colorant, or a combination comprising two or more of the foregoing. The thermoplastic polymer can comprise a polycarbonate, such as a melt or an interfacial polycarbonate.

[0030] "Polycarbonate" as used herein means a polymer or copolymer having repeating structural carbonate units of formula (1)



wherein at least 60 percent of the total number of R^1 groups are aromatic, or each R^1 contains at least one C_{6-30} aromatic group. Specifically, each R^1 can be derived from a dihydroxy compound such as an aromatic dihydroxy compound of formula (2) or a bisphenol of formula (3).



In formula (2), each R^h is independently a halogen atom, for example bromine, a C_{1-10} hydrocarbyl group such as a C_{1-10} alkyl, a halogen-substituted C_{1-10} alkyl, a C_{6-10} aryl, or a halogen-substituted C_{6-10} aryl, and n is 0 to 4.

[0031] In formula (3), R^a and R^b are each independently a halogen, C_{1-12} alkoxy, or C_{1-12} alkyl; and p and q are each independently integers of 0 to 4, such that when p or q is less than 4, the valence of each carbon of the ring is filled by hydrogen. Accordingly, p and q can

each be 0, or p and q can each be 1, and R^a and R^b can each be a C₁₋₃ alkyl group, specifically methyl, disposed meta to the hydroxy group on each arylene group. X^a is a bridging group connecting the two hydroxy-substituted aromatic groups, where the bridging group and the hydroxy substituent of each C₆ arylene group are disposed ortho, meta, or para (specifically para) to each other on the C₆ arylene group, for example, a single bond, -O-, -S-, -S(O)-, -S(O)₂-, -C(O)-, or a C₁₋₁₈ organic group, which can be cyclic or acyclic, aromatic or non-aromatic, and can further comprise heteroatoms such as halogens, oxygen, nitrogen, sulfur, silicon, or phosphorous. For example, X^a can be a substituted or unsubstituted C₃₋₁₈ cycloalkylidene; a C₁₋₂₅ alkylidene of the formula -C(R^c)(R^d) - wherein R^c and R^d are each independently hydrogen, C₁₋₁₂ alkyl, C₁₋₁₂ cycloalkyl, C₇₋₁₂ arylalkyl, C₁₋₁₂ heteroalkyl, or cyclic C₇₋₁₂ heteroarylalkyl; or a group of the formula -C(=R^e)- wherein R^e is a divalent C₁₋₁₂ hydrocarbon group.

[0032] Some illustrative examples of specific dihydroxy compounds include the following: bisphenol compounds such as 4,4'-dihydroxybiphenyl, 1,6-dihydroxynaphthalene, 2,6-dihydroxynaphthalene, bis(4-hydroxyphenyl)methane, bis(4-hydroxyphenyl)diphenylmethane, bis(4-hydroxyphenyl)-1-naphthylmethane, 1,2-bis(4-hydroxyphenyl)ethane, 1,1-bis(4-hydroxyphenyl)-1-phenylethane, 2-(4-hydroxyphenyl)-2-(3-hydroxyphenyl)propane, bis(4-hydroxyphenyl)phenylmethane, 2,2-bis(4-hydroxy-3-bromophenyl)propane, 1,1-bis (hydroxyphenyl)cyclopentane, 1,1-bis(4-hydroxyphenyl)cyclohexane, 1,1-bis(4-hydroxyphenyl)isobutene, 1,1-bis(4-hydroxyphenyl)cyclododecane, trans-2,3-bis(4-hydroxyphenyl)-2-butene, 2,2-bis(4-hydroxyphenyl)adamantane, alpha,alpha'-bis(4-hydroxyphenyl)toluene, bis(4-hydroxyphenyl)acetonitrile, 2,2-bis(3-methyl-4-hydroxyphenyl)propane, 2,2-bis(3-ethyl-4-hydroxyphenyl)propane, 2,2-bis(3-n-propyl-4-hydroxyphenyl)propane, 2,2-bis(3-isopropyl-4-hydroxyphenyl)propane, 2,2-bis(3-sec-butyl-4-hydroxyphenyl)propane, 2,2-bis(3-t-butyl-4-hydroxyphenyl)propane, 2,2-bis(3-cyclohexyl-4-hydroxyphenyl)propane, 2,2-bis(3-allyl-4-hydroxyphenyl)propane, 2,2-bis(3-methoxy-4-hydroxyphenyl)propane, 2,2-bis(4-hydroxyphenyl)hexafluoropropane, 1,1-dichloro-2,2-bis(4-hydroxyphenyl)ethylene, 1,1-dibromo-2,2-bis(4-hydroxyphenyl)ethylene, 1,1-dichloro-2,2-bis(5-phenoxy-4-hydroxyphenyl)ethylene, 4,4'-dihydroxybenzophenone, 3,3-bis(4-hydroxyphenyl)-2-butanone, 1,6-bis(4-hydroxyphenyl)-1,6-hexanedione, ethylene glycol bis(4-hydroxyphenyl)ether, bis(4-hydroxyphenyl)ether, bis(4-hydroxyphenyl)sulfide, bis(4-hydroxyphenyl)sulfoxide, bis(4-hydroxyphenyl)sulfone, 9,9-bis(4-hydroxyphenyl)fluorine,

2,7-dihydroxypyrene, 6,6'-dihydroxy-3,3',3'- tetramethylspiro(bis)indane ("spirobiindane bisphenol"), 3,3-bis(4-hydroxyphenyl)phthalimide, 2,6-dihydroxydibenzo-p-dioxin, 2,6-dihydroxythianthrene, 2,7-dihydroxyphenoxathin, 2,7-dihydroxy-9,10-dimethylphenazine, 3,6-dihydroxydibenzofuran, 3,6-dihydroxydibenzothiophene, and 2,7-dihydroxycarbazole; resorcinol, substituted resorcinol compounds such as 5-methyl resorcinol, 5-ethyl resorcinol, 5-propyl resorcinol, 5-butyl resorcinol, 5-t-butyl resorcinol, 5-phenyl resorcinol, 5-cumyl resorcinol, 2,4,5,6-tetrafluoro resorcinol, 2,4,5,6-tetrabromo resorcinol, or the like; catechol; hydroquinone; substituted hydroquinones such as 2-methyl hydroquinone, 2-ethyl hydroquinone, 2-propyl hydroquinone, 2-butyl hydroquinone, 2-t-butyl hydroquinone, 2-phenyl hydroquinone, 2-cumyl hydroquinone, 2,3,5,6-tetramethyl hydroquinone, 2,3,5,6-tetra-t-butyl hydroquinone, 2,3,5,6-tetrafluoro hydroquinone, 2,3,5,6-tetrabromo hydroquinone, or the like.

[0033] Specific dihydroxy compounds include resorcinol, 2,2-bis(4-hydroxyphenyl) propane ("bisphenol A" or "BPA", in which in which each of A¹ and A² is p-phenylene and Y¹ is isopropylidene in formula (3)), 3,3-bis(4-hydroxyphenyl) phthalimidine, 2-phenyl-3,3'-bis(4-hydroxyphenyl) phthalimidine (also known as N-phenyl phenolphthalein bisphenol, "PPPBP", or 3,3-bis(4-hydroxyphenyl)-2-phenylisoindolin-1-one), 1,1-bis(4-hydroxy-3-methylphenyl)cyclohexane (DMBPC), and from bisphenol A and 1,1-bis(4-hydroxy-3-methylphenyl)-3,3,5-trimethylcyclohexane (isophorone bisphenol).

[0034] The polycarbonate can be a linear homopolymer containing bisphenol A carbonate units (BPA-PC); or a branched, cyanophenyl end-capped BPA-PC

[0035] The polycarbonate can be a copolycarbonate. Specific copolycarbonates include those derived from bisphenol A and bulky bisphenol carbonate units, i.e., derived from bisphenols containing at least 12 carbon atoms, for example 12 to 60 carbon atoms, specifically, 20 to 40 carbon atoms. Examples of such copolycarbonates include copolycarbonates comprising bisphenol A carbonate units and 2-phenyl-3,3'-bis(4-hydroxyphenyl) phthalimidine carbonate units (a BPA-PPPBP copolymer), a copolymer comprising bisphenol A carbonate units and 1,1-bis(4-hydroxy-3-methylphenyl)cyclohexane carbonate units (a BPA-DMBPC copolymer), and a copolymer comprising bisphenol A carbonate units and isophorone bisphenol carbonate units (available, for example, under the trade name APEC from Bayer).

[0036] Polycarbonates manufactured and purified as described herein are suitable for use in a wide variety of compositions and applications as is known in the art. Thus, an

additive composition can be added, for example, in an extruder, to the purified polycarbonate form a polycarbonate composition. The additive composition can be one or more additives selected to achieve a desired property, with the proviso that the additive(s) are also selected so as to not significantly adversely affect a desired property of the thermoplastic composition. The additive composition or individual additives can be mixed at a suitable time during the mixing of the components for forming the composition. The additive can be soluble and/or non-soluble in polycarbonate.

[0037] The additive composition can include an impact modifier, flow modifier, filler (e.g., a particulate polytetrafluoroethylene (PTFE), glass, carbon, mineral, or metal), reinforcing agent (e.g., glass fibers), antioxidant, heat stabilizer, light stabilizer, ultraviolet (UV) light stabilizer, UV absorbing additive, plasticizer, lubricant, release agent (such as a mold release agent), antistatic agent, anti-fog agent, antimicrobial agent, colorant (e.g., a dye or pigment), surface effect additive, radiation stabilizer, flame retardant, anti-drip agent (e.g., a PTFE-encapsulated styrene-acrylonitrile copolymer (TSAN)), or a combination comprising one or more of the foregoing. For example, a combination of a heat stabilizer, mold release agent, and ultraviolet light stabilizer can be used. In general, the additives are used in the amounts generally known to be effective. For example, the total amount of the additive composition (other than any impact modifier, filler, or reinforcing agent) can be 0.001 to 10.0 wt%, or 0.01 to 5 wt%, each based on the total weight of the polymer in the composition.

[0030] The polycarbonate can be prepared via an interfacial polymerization. Although the reaction conditions for interfacial polymerization can vary, an exemplary process generally involves dissolving or dispersing a dihydroxy compound in aqueous caustic NaOH or KOH, adding the resulting mixture to a water-immiscible solvent, and contacting the reactants with a carbonate precursor in the presence of a catalyst such as, for example, a tertiary amine or a phase transfer catalyst, under controlled pH conditions, e.g., 8 to 10. The water-immiscible solvent can be, for example, methylene chloride, 1,2-dichloroethane, chlorobenzene, toluene, and the like. Among tertiary amines that can be used as catalysts in interfacial polymerization are aliphatic tertiary amines such as triethylamine and tributylamine, cycloaliphatic tertiary amines such as N,N-diethyl-cyclohexylamine, and aromatic tertiary amines such as N,N-dimethylaniline. Among the phase transfer catalysts that can be used are catalysts of the formula $(R^3)_4Q^+X$, wherein each R^3 is the same or different, and is a C_{1-10} alkyl; Q is a nitrogen or phosphorus atom; and X is a halogen atom or a C_{1-8} alkoxy or C_{6-18} aryloxy. Exemplary phase transfer catalysts include $(CH_3(CH_2)_3)_4NX$,

$(\text{CH}_3(\text{CH}_2)_3)_4\text{PX}$, $(\text{CH}_3(\text{CH}_2)_5)_4\text{NX}$, $(\text{CH}_3(\text{CH}_2)_6)_4\text{NX}$, $(\text{CH}_3(\text{CH}_2)_4)_4\text{NX}$, $\text{CH}_3(\text{CH}_3(\text{CH}_2)_3)_3\text{NX}$, and $\text{CH}_3(\text{CH}_3(\text{CH}_2)_2)_3\text{NX}$, wherein X is Cl^- , Br^- , a C_{1-8} alkoxy or a C_{6-18} aryloxy. An effective amount of a phase transfer catalyst can be 0.1 to 10 wt%, or 0.5 to 2 wt%, each based on the weight of dihydroxy compound in the phosgenation mixture.

[0038] The polycarbonate can be made by a melt polymerization process, by co-reacting, in a molten state, monomers such as a dihydroxy reactant and a carbonate compound, such as phosgene or diphenyl carbonate. The melt polymerization process can be a batch or a continuous melt process. In either case, the melt polymerization conditions used can comprise two or more distinct reaction stages, for example, a first reaction stage in which the starting aromatic dihydroxy compound and diaryl carbonate are converted into an oligomeric polycarbonate and a second reaction stage wherein the oligomeric polycarbonate formed in the first reaction stage is converted to high molecular weight polycarbonate. Such "staged" polymerization reaction conditions are especially suitable for use in continuous polymerization systems wherein the starting monomers are oligomerized in a first reaction vessel and the oligomeric polycarbonate formed therein is continuously transferred to one or more downstream reactors in which the oligomeric polycarbonate is converted to high molecular weight polycarbonate. Typically, in the oligomerization stage the oligomeric polycarbonate produced has a number average molecular weight (M_n) of 1,000 to 7,500 Daltons. In one or more subsequent polymerization stages, the number average molecular weight of the polycarbonate can be increased to, for example, 8,000 to 25,000 Daltons (using polycarbonate standard).

[0039] The term "melt polymerization conditions" is understood to mean those conditions necessary to affect reaction between a dihydroxy compound and a carbonate compound in the presence of a transesterification catalyst. Although, solvents are generally not used in the process, and the reactants aromatic dihydroxy compound and the carbonate compound are in a molten state, the dihydroxy compound and/or the carbonate compound can be added to the polymerization unit as a solvent mixture, such as a mixture with acetone. The reaction temperature can be 100 to 350°C, specifically, 180 to 310°C. The pressure can be at atmospheric pressure, supra-atmospheric pressure, or a range of pressures from atmospheric pressure to 15 torr in the initial stages of the reaction, and at a reduced pressure at later stages, for example, 0.2 to 15 torr. The reaction time is generally 0.1 hours to 10 hours.

[0040] A transesterification catalyst(s) can be employed in the polymerization. Such catalysts include phase transfer catalysts of formula $(\text{R}^3)_4\text{Q}^+\text{X}$, wherein each R^3 is the same or

different, and is a C₁₋₁₀ alkyl group; Q is a nitrogen or phosphorus atom; and X is a halogen atom or a C₁₋₈ alkoxy group or C₆₋₁₈ aryloxy group. Transesterification catalysts include tetrabutylammonium hydroxide, methyltributylammonium hydroxide, tetrabutylammonium acetate, tetrabutylphosphonium hydroxide, tetrabutylphosphonium acetate, tetrabutylphosphonium phenolate, or a combination comprising at least one of the foregoing. The catalyst can comprise a potassium sodium phosphate of the formula NaKHPO₄.

[0041] Catalysts used in the melt transesterification polymerization production of polycarbonates can include alpha and/or beta catalysts. Beta catalysts are typically volatile and degrade at elevated temperatures and can therefore be used at early low-temperature polymerization stages.

[0042] Possible beta catalyst(s) can comprise a quaternary ammonium compound, a quaternary phosphonium compound, or a combination comprising at least one of the foregoing. The quaternary ammonium compound can be a compound of the structure (R⁴)₄N⁺X⁻, wherein each R⁴ is the same or different, and is a C₁₋₂₀ alkyl, a C₄₋₂₀ cycloalkyl, or a C₄₋₂₀ aryl; and X⁻ is an organic or inorganic anion, for example a hydroxide, halide, acetate, phenoxide, carboxylate, sulfonate, sulfate, formate, carbonate, or bicarbonate. Examples of organic quaternary ammonium compounds include tetramethyl ammonium hydroxide, tetrabutyl ammonium hydroxide, tetramethyl ammonium acetate, tetramethyl ammonium formate, tetrabutyl ammonium acetate, and combinations comprising at least one of the foregoing. Tetramethyl ammonium hydroxide is often used.

[0043] The quaternary phosphonium compound can be a compound of the structure (R⁵)₄P⁺X⁻, wherein each R⁵ is the same or different, and is a C₁₋₂₀ alkyl, a C₄₋₂₀ cycloalkyl, or a C₄₋₂₀ aryl; and X⁻ is an organic or inorganic anion, for example a hydroxide, halide, carboxylate, sulfonate, sulfate, formate, carbonate, or bicarbonate. Where X⁻ is a polyvalent anion such as carbonate or sulfate it is understood that the positive and negative charges in the quaternary ammonium and phosphonium structures are properly balanced. For example, where R²⁰ to R²³ are each methyl and X⁻ is carbonate, it is understood that X⁻ represents 2 (CO₃⁻²). Examples of organic quaternary phosphonium compounds include tetramethyl phosphonium hydroxide, tetramethyl phosphonium acetate, tetramethyl phosphonium formate, tetrabutyl phosphonium hydroxide, tetrabutyl phosphonium acetate (TBPA), tetraphenyl phosphonium acetate, tetraphenyl phosphonium phenoxide, and combinations comprising at least one of the foregoing. TBPA is often used.

[0044] The amount of beta catalyst employed is typically based upon the total number of moles of dihydroxy compound employed in the polymerization reaction. When referring to the ratio of beta catalyst, for example, phosphonium salt, to all dihydroxy compounds employed in the polymerization reaction, it is convenient to refer to moles of phosphonium salt per mole of the dihydroxy compound(s), meaning the number of moles of phosphonium salt divided by the sum of the moles of each individual dihydroxy compound present in the reaction mixture. The amount of beta catalyst (e.g., organic ammonium or phosphonium salts) employed typically will be 1×10^{-2} to 1×10^{-5} , specifically, 1×10^{-3} to 1×10^{-4} moles per total mole of the dihydroxy compounds in the reaction mixture.

[0045] Alpha catalysts are typically more thermally stable and less volatile than beta catalysts. Nearly all of the alpha catalyst (e.g., greater than 80 wt%, specifically greater than 90%) survives the polymerization process. As such, this catalyst is available to catalyze additional (and generally unwanted) reactions downstream of the polymerization process, such as in the extruder.

[0046] The alpha catalyst can comprise a source of alkali or alkaline earth ions. The sources of these ions include alkaline earth hydroxides such as magnesium hydroxide and calcium hydroxide. Sources of alkali metal ions can include the alkali metal hydroxides such as illustrated by lithium hydroxide, sodium hydroxide, potassium hydroxide, and combinations comprising at least one of the foregoing. Examples of alkaline earth metal hydroxides are calcium hydroxide, magnesium hydroxide, and combinations comprising at least one of the foregoing. Of these, sodium hydroxide is particularly desirable. The alpha catalyst typically will be used in an amount sufficient to provide 1×10^{-2} to 1×10^{-8} moles, specifically, 1×10^{-4} to 1×10^{-7} moles of metal hydroxide per mole of the dihydroxy compounds employed. Other possible sources of alkaline earth and alkali metal ions include salts of carboxylic acids (such as sodium acetate) and derivatives of ethylene diamine tetraacetic acid (EDTA) (such as EDTA tetrasodium salt, and EDTA magnesium disodium salt), as well as combinations comprising at least one of the foregoing. For example, the alpha catalyst can comprise alkali metal salt(s) of a carboxylic acid, alkaline earth metal salt(s) of a carboxylic acid, or a combination comprising at least one of the foregoing. In another example, the alpha catalyst comprises Na_2Mg EDTA or a salt thereof.

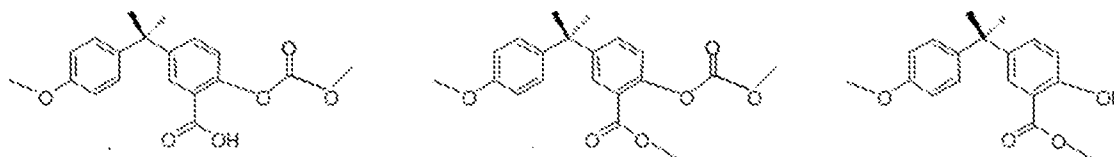
[0047] The alpha transesterification catalyst can also, or alternatively, comprise salt(s) of a non-volatile inorganic acid. For example, the alpha catalyst can comprise salt(s) of a non-volatile inorganic acid such as NaH_2PO_3 , NaH_2PO_4 , Na_2HPO_3 , NaHCO_3 , Na_2CO_3 ,

KH_2PO_4 , CsH_2PO_4 , Cs_2HPO_4 , Cs_2CO_3 , and combinations comprising at least one of the foregoing. Alternatively, or in addition, the alpha transesterification catalyst can comprise mixed alkali metal salt(s) of phosphoric acid, such as NaKHPO_4 , CsNaHPO_4 , CsKHPO_4 , and combinations comprising at least one of the foregoing.

[0048] A quencher can be added, for example to a finishing extruder to reduce the activity of the catalyst. Quenching agents include boric acid esters (e.g., $\text{B}(\text{OCH}_3)_3$, $\text{B}(\text{OCH}_2\text{CH}_3)_3$, and $\text{B}(\text{OC}_6\text{H}_5)_3$, zinc borate, boron phosphate, aluminum stearate, aluminum silicate, zirconium carbonate, zirconium $\text{C}_1\text{-C}_{12}$ alkoxides, zirconium hydroxycarboxylates, gallium phosphide, gallium antimonide, germanium oxide, $\text{C}_1\text{-C}_{32}$ organogermanium compounds, $\text{C}_4\text{-C}_{32}$ tetraorganotin tin compound, $\text{C}_6\text{-C}_{32}$ hexaorganotin compound (e.g., $[(\text{C}_6\text{H}_5\text{O})\text{Sn}(\text{CH}_2\text{CH}_2\text{CH}_2\text{CH}_3)_2]_2\text{O}$), Sb_2O_3 , antimony oxide, $\text{C}_1\text{-C}_{32}$ alkylantimony, bismuth oxide, $\text{C}_1\text{-C}_{12}$ alkylbismuth, zinc acetate, zinc stearate, $\text{C}_1\text{-C}_{32}$ alkoxytitanium, and titanium oxide, phosphoric acid, phosphorous acid, hypophosphorous acid, pyrophosphoric acid, polyphosphoric acid, boric acid, hydrochloric acid, hydrobromic acid, sulfuric acid, sulfurous acid, adipic acid, azelaic acid, dodecanoic acid, L-ascorbic acid, aspartic acid, benzoic acid, formic acid, acetic acid, citric acid, glutamic acid, salicylic acid, nicotinic acid, fumaric acid, maleic acid, oxalic acid, benzenesulfinic acid, $\text{C}_1\text{-C}_{12}$ dialkyl sulfates (e.g., dimethyl sulfate and dibutyl sulfate), alkyl sulfonic esters of the formula $\text{R}_1\text{SO}_3\text{R}_2$ wherein R_1 is hydrogen, $\text{C}_1\text{-C}_{12}$ alkyl, $\text{C}_6\text{-C}_{18}$ aryl, or $\text{C}_7\text{-C}_{19}$ alkylaryl, and R_2 is $\text{C}_1\text{-C}_{12}$ alkyl, $\text{C}_6\text{-C}_{18}$ aryl, or $\text{C}_7\text{-C}_{19}$ alkylaryl (e.g., benzenesulfonate, p-toluenesulfonate, methylbenzene sulfonate, ethylbenzene sulfonate, n-butyl benzenesulfonate, octyl benzenesulfonate and phenyl benzenesulfonate, methyl p-toluenesulfonate, ethyl p-toluenesulfonate, n-butyl p-toluene sulfonate, octyl p-toluenesulfonate and phenyl p-toluenesulfonate, in particular alkyl tosylates such as n-butyl tosylate), sulfonic acid phosphonium salts of the formula $(\text{R}^a\text{SO}_3^-)(\text{PR}^b_4)^+$ wherein R^a is hydrogen, $\text{C}_1\text{-C}_{12}$ alkyl, $\text{C}_6\text{-C}_{18}$ aryl, or $\text{C}_7\text{-C}_{19}$ alkylaryl, and each R^b is independently hydrogen, $\text{C}_1\text{-C}_{12}$ alkyl or $\text{C}_6\text{-C}_{18}$ aryl, sulfonic acid derivatives of the formula $\text{A}^1\text{-(Y}^1\text{-SO}_3\text{X}^1)_m$ wherein A^1 is a $\text{C}_1\text{-C}_{40}$ hydrocarbon group having a valence of m, Y^1 is a single bond or an oxygen atom, X^1 is a secondary or tertiary alkyl group of the formula $-\text{CR}^{15}\text{R}^{16}\text{R}^{17}$, a metal cation of one equivalent, an ammonium cation (e.g., $\text{NR}^b_3^+$ wherein each R^b is independently hydrogen, $\text{C}_1\text{-C}_{12}$ alkyl or $\text{C}_6\text{-C}_{18}$ aryl), or a phosphonium (e.g., $\text{PR}^b_4^+$ wherein each R^b is independently hydrogen, $\text{C}_1\text{-C}_{12}$ alkyl or $\text{C}_6\text{-C}_{18}$ aryl) wherein R^{15} is a hydrogen atom or an alkyl group having 1 to 5 carbon atoms, R^{16} is a hydrogen atom, a phenyl group or an alkyl group having 1 to 5 carbon atoms, and R^{17} is the same as or different

from R^{15} and has the same definition as R^{15} , provided that two of R^{15} , R^{16} , and R^{17} cannot be hydrogen atoms, and m is an integer of 1 to 4, provided that when Y^1 is a single bond, all of X^1 in an amount of m cannot be metal cations of one equivalent, a compound of the formula ${}^+X^2-A^2-Y^1-SO_3^-$ wherein A^2 is a divalent hydrocarbon group, ${}^+X^2$ is a secondary, tertiary or quaternary ammonium cation or a secondary (e.g., , tertiary or quaternary phosphonium cation, and Y^1 is a single bond or an oxygen atom, a compound of the formula $A^3-({}^+X^3)_n\cdot(R-Y^1-SO_3^-)_n$ wherein A^3 is a C_1 - C_{40} hydrocarbon group having a valence of n , ${}^+X^3$ is a secondary, tertiary or quaternary ammonium cation (e.g., $NR^b_3^+$ wherein each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl), or a secondary, tertiary or quaternary phosphonium cation (e.g., $PR^b_4^+$ wherein each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl), R is a monovalent C_1 - C_{40} hydrocarbon group, n is an integer of 2 to 4, and Y^1 is a single bond or an oxygen atom, a compound of the formula $A^5-Ad^1-A^4-(Ad^2-A^5)_\ell$ wherein A^5 is a monovalent or divalent C_1 - C_{40} hydrocarbon group, A^4 is a divalent C_1 - C_{40} hydrocarbon group, each of Ad^1 and Ad^2 is independently an acid anhydride group selected from $-SO_2-O-SO_2-$, $-SO_2-O-CO-$ and $-CO-O-SO_2-$, and ℓ is 0 or 1, provided that when ℓ is 0, $-(Ad^2-A^5)_\ell$ is a hydrogen atom or a bond between A^4 and A^5 , in which A^5 is a divalent hydrocarbon group or a single bond, aminosulfonic esters having the formula $R_aR_bN-A-SO_3R_c$, wherein R_a and R_b are each independently hydrogen, C_1 - C_{12} alkyl, C_6 - C_{22} aryl, C_7 - C_{19} alkylaryl or R_a and R_b , either singly or in combination, form an aromatic or non-aromatic heterocyclic compound with N (e.g., pyrrolyl, pyridinyl, pyrimidyl, pyrazinyl, carbazolyl, quinolinyl, imidazolyl, piperazinyl, oxazolyl, thiazolyl, pyrazolyl, pyrrolinyl, indolyl, purinyl, pyrrolydinyl, or the like), R_c is hydrogen, and A is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl (e.g., compounds such as N-(2-hydroxyethyl) piperazine-N'-3-propanesulfonic acid, 1,4-piperazinebis (ethanesulfonic acid), and 5-dimethylamino-1-naphthalenesulfonic acid), ammonium sulfonic esters of the formula $R_aR_bR_cN^+-A-SO_3^-$, wherein R_a , R_b , are each independently hydrogen, C_1 - C_{12} alkyl, C_1 - C_{12} aryl, C_7 - C_{19} alkylaryl, or R_a and R_b , either singly or in combination, form an aromatic or non-aromatic heterocyclic compound with N (e.g., pyrrolyl, pyridinyl, pyrimidyl, pyrazinyl, carbazolyl, quinolinyl, imidazolyl, piperazinyl, oxazolyl, thiazolyl, pyrazolyl, pyrrolinyl, indolyl, purinyl, pyrrolydinyl, or the like), R_c is a hydrogen, and A is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl, sulfonated polystyrene, methyl acrylate-sulfonated styrene copolymer, and combinations comprising at least one of the foregoing. Quenching agents can include a combination of compounds, for example an alkyl tosylate such as n-butyl tosylate and phosphorus acid.

[0049] Branched polycarbonate can be prepared by adding a branching agent during polymerization. These branching agents include polyfunctional organic compounds containing at least three functional groups selected from hydroxyl, carboxyl, carboxylic anhydride, haloformyl, and mixtures of the foregoing functional groups. Specific examples include trimellitic acid, trimellitic anhydride, trimellitic trichloride, tris-p-hydroxy phenyl ethane, isatin-bis-phenol, tris-phenol TC (1,3,5-tris((p-hydroxyphenyl)isopropyl)benzene), tris-phenol PA (4(4(1,1-bis(p-hydroxyphenyl)-ethyl) alpha, alpha-dimethyl benzyl)phenol), 4-chloroformyl phthalic anhydride, trimesic acid, and benzophenone tetracarboxylic acid. The branching agents can be added at a level of 0.05 to 2.0 wt%. Mixtures comprising linear polycarbonates and branched polycarbonates can be used. The content of the following branching structures can be less than or equal to 2,000 ppm.



[0050] A branching agent can be employed in the polymerization and can result in an increase in polymer melt strength. The branching agent (1,1,1-tris-(hydroxyphenyl) ethane (THPE)) can be introduced to the polymerization unit, specifically, to a polymerization and/or an oligomerization vessel, as a solution of the branching agent dissolved in a branching solvent. The branching solvent selected for dissolving the branching agent can be any solvent capable of dissolving the branching agent at a level sufficient to deliver or introduce the desired amount of branching agent into the polymerization unit. The branching solvent can comprise lower alkanols, such as C₁₋₄ alkanols, including methanol, ethanol, propanol (such as n-propanol and isopropanol), n-butanol, or a combination comprising one or more of the foregoing.

[0051] The branching agent can be introduced in an amount such that it will result in a polycarbonate comprising up to 1.5 mole percent (mol%), specifically, up to 1.0 mol%, more specifically, up to 0.5 mol% branching agent in the final branched polycarbonate. The amount of dissolved branching agent present in the solution can be an amount of 0.5 to 50 weight percent (wt%), specifically, 5 to 40 wt%, more specifically, 15 to 35 wt% relative to the total weight of the branching agent and solvent solution. The polymerized polycarbonate can comprise a branching agent in the amount of 100 to 5,000 parts per million (ppm), specifically, 500 to 4,000 ppm, more specifically, 1,000 to 3,500 ppm based on the total amount of polycarbonate repeat units.

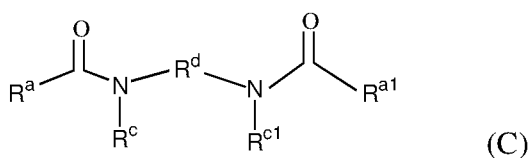
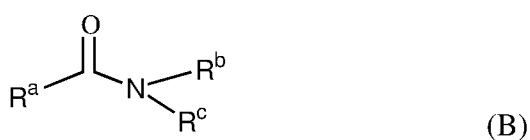
[0052] A chainstopper can be introduced to the polymerization unit. The chainstopper can be, for example, a monofunctional phenol.

[0053] The masterbatch quencher can be the same or different from a quencher used in the polymerization process of a melt polycarbonate that is present in the masterbatch. The masterbatch quencher can comprise boric acid esters (e.g., $B(OCH_3)_3$, $B(OCH_2CH_3)_3$, and $B(OC_6H_5)_3$, zinc borate, boron phosphate, aluminum stearate, aluminum silicate, zirconium carbonate, zirconium C_1 - C_{12} alkoxides, zirconium hydroxycarboxylates, gallium phosphide, gallium antimonide, germanium oxide, C_1 - C_{32} organogermanium compounds, C_4 - C_{32} tetraorganotin tin compound, C_6 - C_{32} hexaorganotin compound (e.g., $[(C_6H_5O)Sn(CH_2CH_2CH_2CH_3)_2]_2O$), Sb_2O_3 , antimony oxide, C_1 - C_{32} alkylantimony, bismuth oxide, C_1 - C_{12} alkylbismuth, zinc acetate, zinc stearate, C_1 - C_{32} alkoxytitanium, and titanium oxide, phosphoric acid, phosphorous acid, hypophosphorous acid, pyrophosphoric acid, polyphosphoric acid, boric acid, hydrochloric acid, hydrobromic acid, sulfuric acid, sulfurous acid, adipic acid, azelaic acid, dodecanoic acid, L-ascorbic acid, aspartic acid, benzoic acid, formic acid, acetic acid, citric acid, glutamic acid, salicylic acid, nicotinic acid, fumaric acid, maleic acid, oxalic acid, benzenesulfinic acid, C_1 - C_{12} dialkyl sulfates (e.g., dimethyl sulfate and dibutyl sulfate), alkyl sulfonic esters of the formula $R_1SO_3R_2$ wherein R_1 is hydrogen, C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl, and R_2 is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl (e.g., benzenesulfonate, p-toluenesulfonate, methylbenzene sulfonate, ethylbenzene sulfonate, n-butyl benzenesulfonate, octyl benzenesulfonate and phenyl benzenesulfonate, methyl p-toluenesulfonate, ethyl p-toluenesulfonate, n-butyl p-toluene sulfonate, octyl p-toluenesulfonate and phenyl p-toluenesulfonate, in particular alkyl tosylates such as n-butyl tosylate), sulfonic acid phosphonium salts of the formula $(R^aSO_3^-)(PR^b_4)^+$ wherein R^a is hydrogen, C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl, and each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl, sulfonic acid derivatives of the formula $A^1-(Y^1-SO_3X^1)_m$ wherein A^1 is a C_1 - C_{40} hydrocarbon group having a valence of m, Y^1 is a single bond or an oxygen atom, X^1 is a secondary or tertiary alkyl group of the formula $-CR^{15}R^{16}R^{17}$, a metal cation of one equivalent, an ammonium cation (e.g., $NR^b_3^+$ wherein each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl), or a phosphonium (e.g., $PR^b_4^+$ wherein each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl) wherein R^{15} is a hydrogen atom or an alkyl group having 1 to 5 carbon atoms, R^{16} is a hydrogen atom, a phenyl group or an alkyl group having 1 to 5 carbon atoms, and R^{17} is the same as or different from R^{15} and has the same definition as R^{15} , provided that two of R^{15} , R^{16} and R^{17} cannot be

hydrogen atoms, and m is an integer of 1 to 4, provided that when Y^1 is a single bond, all of X^1 in an amount of m cannot be metal cations of one equivalent, a compound of the formula $+X^2-A^2-Y^1-SO_3^-$ wherein A^2 is a divalent hydrocarbon group, $+X^2$ is a secondary, tertiary or quaternary ammonium cation or a secondary (e.g., tertiary or quaternary phosphonium cation, and Y^1 is a single bond or an oxygen atom, a compound of the formula $A^3-(+X^3)_n \cdot (R-Y^1-SO_3^-)_n$ wherein A^3 is a C_1 - C_{40} hydrocarbon group having a valence of n, $+X^3$ is a secondary, tertiary or quaternary ammonium cation (e.g., $NR^{b_3}+$ wherein each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl), or a secondary, tertiary or quaternary phosphonium cation (e.g., $PR^{b_4}+$ wherein each R^b is independently hydrogen, C_1 - C_{12} alkyl or C_6 - C_{18} aryl), R is a monovalent C_1 - C_{40} hydrocarbon group, n is an integer of 2 to 4, and Y^1 is a single bond or an oxygen atom, a compound of the formula $A^5-Ad^1-A^4-(Ad^2-A^5)_\ell$ wherein A^5 is a monovalent or divalent C_1 - C_{40} hydrocarbon group, A^4 is a divalent C_1 - C_{40} hydrocarbon group, each of Ad^1 and Ad^2 is independently an acid anhydride group selected from $-SO_2-O-SO_2-$, $-SO_2-O-CO-$ and $-CO-O-SO_2-$, and ℓ is 0 or 1, provided that when ℓ is 0, $-(Ad^2-A^5)_\ell$ is a hydrogen atom or a bond between A^4 and A^5 , in which A^5 is a divalent hydrocarbon group or a single bond, aminosulfonic esters having the formula $R_aR_bN-A-SO_3R_c$, wherein R_a and R_b are each independently hydrogen, C_1 - C_{12} alkyl, C_6 - C_{22} aryl, C_7 - C_{19} alkylaryl or R_a and R_b , either singly or in combination, form an aromatic or non-aromatic heterocyclic compound with N (e.g., pyrrolyl, pyridinyl, pyrimidyl, pyrazinyl, carbazolyl, quinolinyl, imidazolyl, piperazinyl, oxazolyl, thiazolyl, pyrazolyl, pyrrolinyl, indolyl, purinyl, pyrrolydinyl, or the like), R_c is hydrogen, and A is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_{17} - C_{19} alkylaryl (e.g., compounds such as N-(2-hydroxyethyl) piperazine-N'-3-propanesulfonic acid, 1,4-piperazinebis (ethanesulfonic acid), and 5-dimethylamino-1-naphthalenesulfonic acid), ammonium sulfonic esters of the formula $R_aR_bR_cN^+-A-SO_3^-$, wherein R_a , R_b , are each independently hydrogen, C_1 - C_{12} alkyl, C_1 - C_{12} aryl, C_7 - C_{19} alkylaryl, or R_a and R_b , either singly or in combination, form an aromatic or non-aromatic heterocyclic compound with N (e.g., pyrrolyl, pyridinyl, pyrimidyl, pyrazinyl, carbazolyl, quinolinyl, imidazolyl, piperazinyl, oxazolyl, thiazolyl, pyrazolyl, pyrrolinyl, indolyl, purinyl, pyrrolydinyl, or the like), R_c is a hydrogen, and A is C_1 - C_{12} alkyl, C_6 - C_{18} aryl, or C_7 - C_{19} alkylaryl, sulfonated polystyrene, methyl acrylate-sulfonated styrene copolymer, and combinations comprising at least one of the foregoing. Quenching agents can include a combination of compounds, for example an alkyl tosylate such as n-butyl tosylate and phosphorus acid. Specifically, the quencher can comprise butyl tosylate, p-toluenesulphonic acid, phosphoric acid,

phosphorous acid, or sulfuric acid, or a combination comprising one or more of the foregoing.

[0054] The release agent can comprise a polyethylene terephthalate (such as PET 3343 and PET 333), FC1 tryacylglycerides such as glycerol tristearate, monoacylglycerides such as glycerol monostearate; a poly-alpha olefin such as saturated poly(alpha) oligomer and saturated poly(1-decene) oligomer; linear low density polyethylene (LLDPE); acid esters such as dioctyl-4,5-epoxy-hexahydrophthalate; tris-(octoxycarbonyl)ethylisocyanurate; epoxidized soybean oil; silicones, including silicone oils; esters, for example, fatty acid esters such as alkyl stearyl esters, e.g., methyl stearate, stearyl stearate, pentaerythritol tetrastearate, and the like; combinations of methyl stearate and hydrophilic and hydrophobic nonionic surfactants comprising polyethylene glycol polymers, polypropylene glycol polymers, poly(ethylene glycol-co-propylene glycol) copolymers, or a combination comprising at least one of the foregoing glycol polymers, e.g., methyl stearate and polyethylene-polypropylene glycol copolymer in a solvent; waxes such as beeswax, montan wax, and paraffin wax; triglycerides of the formula (A) shown below, and alkyl amides of the structures (B) and (C) shown below, alkyl amides comprising primary amides, the C1 to C6 N-alkyl amides and the, C1 to C6 secondary amides of; linear or branched C12-36 alkyl carboxylic acids, erucic acid, stearic acid, oleic acid, linoleic acid, linolenic acid, myristic acid, palmitic acid, arachidonic acid, behenic acid, lignoceric acid and C6-20 bis amides of C2-6 alkylene diamines or a combination of at least one of the foregoing alkyl amides; and compositions of formulas (B) and (C)



wherein R^a or R^{a1} are a C₁ to C₃₀ alkyl group and R^b , R^c and R^{c1} are independently H or a C₁ to C₃₀ alkyl group and R^d is a C₂ to C₆ alkyl group.

[0055] The antioxidant can comprise organophosphites such as tris(nonyl phenyl)phosphite, tris(2,4-di-*t*-butylphenyl)phosphite, bis(2,4-di-*t*-butylphenyl)pentaerythritol diphosphite, distearyl pentaerythritol diphosphite or the like;

alkylated monophenols or polyphenols; alkylated reaction products of polyphenols with dienes, such as tetrakis[methylene(3,5-di-tert-butyl-4-hydroxyhydrocinnamate)] methane, or the like; butylated reaction products of para-cresol or dicyclopentadiene; alkylated hydroquinones; hydroxylated thiodiphenyl ethers; alkylidene-bisphenols; benzyl compounds; esters of beta-(3,5-di-tert-butyl-4-hydroxyphenyl)-propionic acid with monohydric or polyhydric alcohols; esters of beta-(5-tert-butyl-4-hydroxy-3-methylphenyl)-propionic acid with monohydric or polyhydric alcohols; esters of thioalkyl or thioaryl compounds such as distearylthiopropionate, dilaurylthiopropionate, ditridecylthiodipropionate, octadecyl-3-(3,5-di-tert-butyl-4-hydroxyphenyl)propionate, pentaerythrityl-tetrakis[3-(3,5-di-tert-butyl-4-hydroxyphenyl)propionate or the like; amides of beta-(3,5-di-tert-butyl-4-hydroxyphenyl)-propionic acid or the like, or combinations including at least one of the foregoing antioxidants. Specifically, the antioxidant can comprise antioxidant 168, antioxidant 1076, or a combination comprising one or more of the foregoing.

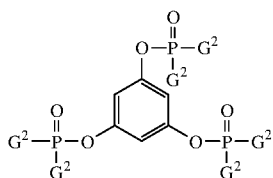
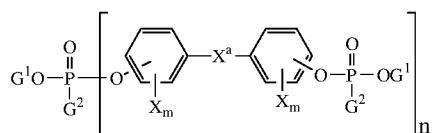
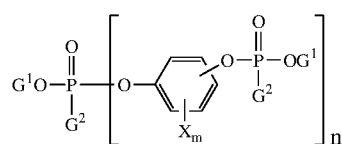
[0056] The UV stabilizer can comprise 2-[2-hydroxy-3,5-di(1,1-dimethylbenzylphenyl)]-2H-benzotriazole; 2,2'-methylenebis(6-(2H-benzotriazol-2-yl)-4-(1,1,3,3-tetramethylbutyl)phenol); or pentaerythritol tetrakis(2-cyano-3,3-diphenylacrylate), 2-benzotriazolyl-4-tert-octylphenol, hydroxybenzophenones; hydroxybenzotriazoles; hydroxybenzotriazines; cyanoacrylates; oxanilides; benzoxazinones; 2-(2H-benzotriazol-2-yl)-4-(1,1,3,3-tetramethylbutyl)-phenol (CYASORB™ 5411); 2-hydroxy-4-n-octyloxybenzophenone (CYASORB™ 531); 2-[4,6-bis(2,4-dimethylphenyl)-1,3,5-triazin-2-yl]-5-(octyloxy)-phenol (CYASORB™ 1164); 2,2'-(1,4-phenylene)bis(4H-3,1-benzoxazin-4-one) (CYASORB™ UV- 3638); 1,3-bis[(2-cyano-3,3-diphenylacryloyl)oxy]-2,2-bis[(2-cyano-3,3-diphenylacryloyl)oxy]methyl]propane (UVINUL™ 3030); 2,2'-(1,4-phenylene)bis(4H-3,1-benzoxazin-4-one); 1,3-bis[(2-cyano-3,3-diphenylacryloyl)oxy]-2,2-bis[(2-cyano-3,3-diphenylacryloyl)oxy]methyl]propane; 2-(2'-hydroxy-5'-tert-octylphenyl)benzotriazole; nano-size inorganic materials such as titanium oxide, cerium oxide, and zinc oxide, all with particle size less than 100 nanometers; or the like, or combinations including at least one of the foregoing UV stabilizers. Specifically, the UV stabilizer can comprise ultraviolet 5411, ultraviolet 3638, ultraviolet360, ultraviolet234, or a combination comprising one or more of the foregoing.

[0057] The flame retardant can comprise a siloxane or a siloxane copolymer, a perfluoroalkyl sulfonate salt (such as salts of C₂₋₁₆ alkyl sulfonate salts such as potassium perfluorobutane sulfonate (Rimar salt), potassium perfluorooctane sulfonate, and

tetraethylammonium perfluorohexane sulfonate), an aromatic phosphate ester, or a combination comprising one or more of the foregoing.

[0058] The aromatic esters of the formula $(GO)_3P=O$, wherein each G is independently an alkyl, cycloalkyl, aryl, alkaryl, or aralkyl group, provided that at least one G is an aromatic group. Two of the G groups can be joined together to provide a cyclic group, for example, diphenyl pentaerythritol diphosphate, which is described by Axelrod in U.S. Pat. No. 4,154,775. Other suitable aromatic phosphates can be, for example, phenyl bis(dodecyl) phosphate, phenyl bis(neopentyl) phosphate, phenyl bis(3,5,5'-trimethylhexyl) phosphate, ethyl diphenyl phosphate, 2-ethylhexyl di(p-tolyl) phosphate, bis(2-ethylhexyl) p-tolyl phosphate, tritolyl phosphate, bis(2-ethylhexyl) phenyl phosphate, tri(nonylphenyl) phosphate, bis(dodecyl) p-tolyl phosphate, dibutyl phenyl phosphate, p-tolyl bis(2,5,5'-trimethylhexyl) phosphate, 2-ethylhexyl diphenyl phosphate, or the like. A specific aromatic phosphate is one in which each G is aromatic, for example, triphenyl phosphate, tricresyl phosphate, isopropylated triphenyl phosphate, and the like.

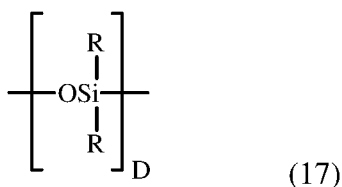
[0059] Di- or polyfunctional aromatic phosphorus-containing compounds are also useful, for example, compounds of the formulas below:



wherein each G^1 is independently a hydrocarbon having 1 to 30 carbon atoms; each G^2 is independently a hydrocarbon or hydrocarbonoxy having 1 to 30 carbon atoms; each X^a is as defined above; each X is independently a hydrogen; m is 0 to 4, and n is 1 to 30. Examples of suitable di- or polyfunctional aromatic phosphorus-containing compounds include resorcinol tetraphenyl diphosphate (RDP), the bis(diphenyl) phosphate of hydroquinone and the bis(diphenyl) phosphate of bisphenol-A, respectively, their oligomeric and polymeric counterparts, and the like.

[0060] The siloxane copolymer can comprise a polycarbonate-polysiloxane copolymer comprises polycarbonate blocks and polydiorganosiloxane blocks. The polycarbonate blocks in the copolymer comprise repeating structural units of formula (1) as described above, for example wherein R^1 is of formula (2) as described above. These units can be derived from reaction of dihydroxy compounds of formula (3) as described above. The dihydroxy compound can be bisphenol A, in which each of A^1 and A^2 is p-phenylene and Y^1 is isopropylidene.

[0061] The polydiorganosiloxane blocks comprise repeating structural units of formula (17) (sometimes referred to herein as 'siloxane'):

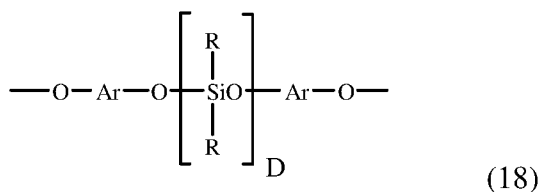


wherein each occurrence of R is same or different, and is a C_{1-13} monovalent organic radical. For example, R can be a C_1 - C_{13} alkyl group, C_1 - C_{13} alkoxy group, C_2 - C_{13} alkenyl group, C_2 - C_{13} alkenyloxy group, C_3 - C_6 cycloalkyl group, C_3 - C_6 cycloalkoxy group, C_6 - C_{10} aryl group, C_6 - C_{10} aryloxy group, C_7 - C_{13} aralkyl group, C_7 - C_{13} aralkoxy group, C_7 - C_{13} alkaryl group, or C_7 - C_{13} alkaryloxy group. Combinations of the foregoing R groups can be used in the same copolymer.

[0062] The value of D in formula (17) can vary widely depending on the type and relative amount of each component in the thermoplastic composition, the desired properties of the composition, and like considerations. Generally, D can have an average value of 2 to 1000, specifically, 2 to 500, more specifically, 5 to 100. D can have an average value of 10 to 75, specifically, 40 to 60. Where D is of a lower value, e.g., less than 40, a relatively larger amount of the polycarbonate-polysiloxane copolymer can be used. Conversely, where D is of a higher value, e.g., greater than 40, a relatively lower amount of the polycarbonate-polysiloxane copolymer can be used.

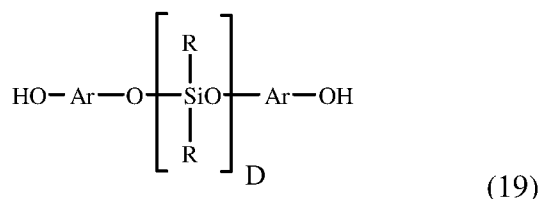
[0063] A combination of a first and a second (or more) polycarbonate-polysiloxane copolymers can be used, wherein the average value of D of the first copolymer is less than the average value of D of the second copolymer.

[0064] The polydiorganosiloxane blocks can be provided by repeating structural units of formula (18):



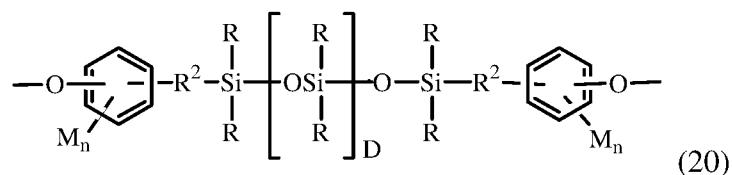
wherein D is as defined above; each R can be the same or different, and is as defined above; and Ar can be the same or different, and is a substituted or unsubstituted C₆-C₃₀ arylene radical, wherein the bonds are directly connected to an aromatic moiety. Suitable Ar groups in formula (9) can be derived from a C₆-C₃₀ dihydroxyarylene compound, for example a dihydroxyarylene compound of formula (3), (4), or (7) above. Combinations comprising at least one of the foregoing dihydroxyarylene compounds can also be used. Specific examples of suitable dihydroxyarylene compounds are 1,1-bis(4-hydroxyphenyl) methane, 1,1-bis(4-hydroxyphenyl) ethane, 2,2-bis(4-hydroxyphenyl) propane, 2,2-bis(4-hydroxyphenyl) butane, 2,2-bis(4-hydroxyphenyl) octane, 1,1-bis(4-hydroxyphenyl) propane, 1,1-bis(4-hydroxyphenyl) n-butane, 2,2-bis(4-hydroxy-1-methylphenyl) propane, 1,1-bis(4-hydroxyphenyl) cyclohexane, bis(4-hydroxyphenyl sulphide), and 1,1-bis(4-hydroxy-*t*-butylphenyl) propane. Combinations comprising at least one of the foregoing dihydroxy compounds can also be used.

[0065] Such units can be derived from the corresponding dihydroxy compound of the following formula (19):



wherein Ar and D are as described above. Such compounds are further described in U.S. Patent No. 4,746,701 to Kress et al. Compounds of this formula can be obtained by the reaction of a dihydroxyarylene compound with, for example, an alpha, omega-bisacetoxypolydiorangonosiloxane under phase transfer conditions.

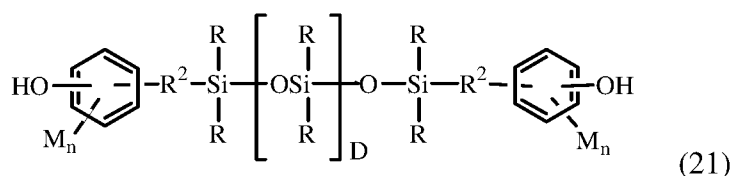
[0066] The polydiorganosiloxane blocks can comprise repeating structural units of formula (20):



wherein R and D are as defined above. R^2 in formula (20) is a divalent C_2 - C_8 aliphatic group. Each M in formula (20) can be the same or different, and can be a halogen, cyano, nitro, C_1 - C_8 alkylthio, C_1 - C_8 alkyl, C_1 - C_8 alkoxy, C_2 - C_8 alkenyl, C_2 - C_8 alkenyloxy group, C_3 - C_8 cycloalkyl, C_3 - C_8 cycloalkoxy, C_6 - C_{10} aryl, C_6 - C_{10} aryloxy, C_7 - C_{12} aralkyl, C_7 - C_{12} aralkoxy, C_7 - C_{12} alkaryl, or C_7 - C_{12} alkaryloxy, wherein each n is independently 0, 1, 2, 3, or 4.

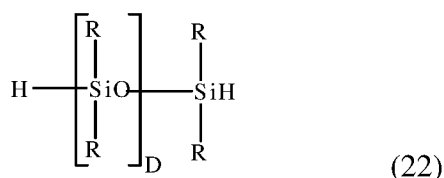
[0067] M can be hydrogen, an alkyl group such as methyl, ethyl, or propyl, an alkoxy group such as methoxy, ethoxy, or propoxy, or an aryl group such as phenyl or tolyl; R^2 can be a dimethylene, trimethylene or tetramethylene group; and R can be a C_{1-8} alkyl, cyanoalkyl, or aryl such as phenyl. R can be methyl, or a mixture of methyl and or a mixture of methyl and phenyl. M can be methoxy, n can be one, R^2 can be a divalent C_1 - C_3 aliphatic group, and R can be methyl.

[0068] These units can be derived from the corresponding dihydroxy polydiorganosiloxane (21):



wherein R, D, M, R^2 , and n are as described above.

[0069] Such dihydroxy polysiloxanes can be made by effecting a platinum catalyzed addition between a siloxane hydride of the formula (22),



wherein R and D are as previously defined, and an aliphatically unsaturated monohydric phenol. Suitable aliphatically unsaturated monohydric phenols included, for example, eugenol, 2-alkylphenol, 4-allyl-2-methylphenol, 4-allyl-2-phenylphenol, 4-allyl-2-*t*-butoxyphenol, 4-phenyl-2-phenylphenol, 2-methyl-4-propylphenol, 2-allyl-4,6-dimethylphenol, 2-allyl-6-methoxy-4-methylphenol and 2-allyl-4,6-dimethylphenol. Mixtures comprising at least one of the foregoing can also be used.

[0070] The polycarbonate-polysiloxane copolymer can be manufactured by reaction of diphenolic polysiloxane (21) with a carbonate source and a dihydroxy aromatic compound of formula (3), optionally in the presence of a phase transfer catalyst as described above. Suitable conditions are similar to those useful in forming polycarbonates. For example, the

copolymers are prepared by phosgenation, at temperatures from below 0°C to 100°C, for example, 25°C to 50°C. Since the reaction is exothermic, the rate of phosgene addition can be used to control the reaction temperature. The amount of phosgene required will generally depend upon the amount of the dihydric reactants. Alternatively, the polycarbonate-polysiloxane copolymers can be prepared by co-reacting in a molten state, the dihydroxy monomers and a diaryl carbonate ester, such as diphenyl carbonate, in the presence of a transesterification catalyst as described above.

[0071] In the production of the polycarbonate-polysiloxane copolymer, the amount of dihydroxy polydiorganosiloxane is selected so as to provide the desired amount of polydiorganosiloxane units in the copolymer. The amount of polydiorganosiloxane units can vary widely, i.e., can be 1 to 99 wt% of polydimethylsiloxane, or an equivalent molar amount of another polydiorganosiloxane, with the balance being carbonate units. The particular amounts used will therefore be determined depending on desired physical properties of the thermoplastic composition, the value of D (of 2 to 1000), and the type and relative amount of each component in the thermoplastic composition, including the type and amount of polycarbonate, type and amount of impact modifier, type and amount of polycarbonate-polysiloxane copolymer, and type and amount of any other additives. Suitable amounts of dihydroxy polydiorganosiloxane can be determined by one of ordinary skill in the art without undue experimentation using the guidelines taught herein. For example, the amount of dihydroxy polydiorganosiloxane can be selected so as to produce a copolymer comprising 1 to 75 wt%, or 1 to 50 wt% polydimethylsiloxane, or an equivalent molar amount of another polydiorganosiloxane. The copolymer can comprise 5 to 40 wt%, optionally 5 to 25 wt% polydimethylsiloxane, or an equivalent molar amount of another polydiorganosiloxane, with the balance being polycarbonate. The copolymer can comprise about 20 wt% siloxane.

[0072] The following examples are provided to illustrate the present process and masterbatches made therefrom. The examples are merely illustrative and are not intended to limit devices made in accordance with the disclosure to the materials, conditions, or process parameters set forth therein.

Examples

[0073] The following components were used in the examples.

Table 1		
Component	Description	Source
PC	PC175; BPA polycarbonate having a Mw of 21800 Daltons with a melt flow of 24 to 32 g/10min (ASTM D1238, 300°C, 2.16 kg)	SABIC's Innovative Plastics™ business
PETS	Release agent; Pentaerythritol tetrastearate	UNDESA
Antioxidant	IRGAFOS™ 168; Tris(2,4-di-tert-butylphenyl) phosphite	Ciba Specialty Chemicals
UV	CYASORB™ UV-5411; 2-(2-hidroxi-5-t-octilfenil) benzotriazole	CYTEC

Examples 1-3: Preparation of masterbatch compositions

[0074] Three different masterbatch compositions were prepared according to the present process.

Table 2			
Example	1	2	3
PC (wt%)	13.2	46.0	68.4
PETS (wt%)	85.1	7.0	20.0
AO (wt%)	1.7	2.0	11.6
UV (wt%)	-	45.0	-
Maximum force (N)	7.38	27.17	6.57

[0075] Specifically, the masterbatch compositions were prepared by adding each of the components listed to a batch mixer (DINNISEN PG-250MG double shaft paddle mixer). The components were fed into the mixer via 1 of 4 feeders, 1 of 2 dischargers, or via a manual feed location. One of the feeders was a feeder model K-TRON K2-ML-T60 twin screw feeder. The mixer mixed the components for 5 minutes (min) at a speed of 25 hertz (Hz). After mixing, the mixed compositions were sent to the pellet mill via a buffer hopper where they were fed via a screw feeder (K-TRON K2-MV-S60 single screw feeder) operating at 60 to 70% of its maximum at a rate of 300 to 400 kilograms per hour (kg/h). The die head in the pellet mill had opening of 20 mm by 3.2 mm or 16 mm by 3.5 mm and the pellets were cut to a length of 7 to 7.5 mm.

Example 4: Pellet strength

[0076] The impact properties of Examples 1-3 were determined by averaging the maximum force at break of 10 pellets per each sample. The experiments were performed on an INSTRON operating at a rate of 4.00 millimeter per minute (mm/min). The impact properties are shown in Table 2. Table 2 shows that the average impact at break ranges from about 6 to about 28 Newtons (N) depending on the composition of the masterbatch.

[0077] Set forth below are embodiments for a masterbatch facility and methods of making a masterbatch.

[0078] Embodiment 1: a masterbatch facility comprising: a feed and blend system comprising greater than or equal to one feeder, greater than or equal to one discharger, a manual feed station, or a combination thereof, and further comprising a mixer; wherein at least one of the feeders is an assisted component feeder; wherein at least two components are fed via the feeder, discharger, manual feed station, or a combination thereof to the mixer; wherein the mixer is a double shaft mixer rotating in opposite directions; a pellet mill comprising a buffer hopper, a screw feeder, a pellet compactor, and a screener; wherein the pellet compactor comprises a die plate, a roll, and a cutter hub; a product handling system comprising a product hopper and a fill station; and a utilities system.

[0079] Embodiment 2: the facility of Embodiment 1, wherein the feed and blend system comprises 4 feeders and/or wherein the feed and blend system comprises 2 dischargers.

[0080] Embodiment 3: The facility of any of Embodiments 1-2, wherein one or more of the assisted component feeder, the product hopper, and the buffer hopper comprises an internal agitator, a vibrator, and a knocker or a combination comprising one or more of the foregoing.

[0081] Embodiment 4: The facility of any of Embodiments 1-3, wherein the buffer hopper is a vibratory buffer hopper, and wherein the product hopper is a vibratory product hopper.

[0082] Embodiment 5: the facility of any of Embodiments 1-4, wherein the mixer is a PEGASUS mixer available from DINNISSEN BV.

[0083] Embodiment 6: the facility of any of Embodiments 1-5, wherein the buffer hopper comprises a twin screw, an internal agitator, a vibrator, a knocker system, or a combination comprising one or more of the foregoing.

[0084] Embodiment 7: the facility of any of Embodiment 6, wherein the vibrator can operate at a frequency of 2,000 to 100,000 vibrations per minute.

[0085] Embodiment 8: the facility of any of Embodiments 1-7, wherein the screw feeder is a K-TRON screw feeder.

[0086] Embodiment 9: the facility of any of Embodiments 1-8, wherein the screw feeder can operate at a rate of 45 to 4500 dm³/h.

[0087] Embodiment 10: the facility of any of Embodiments 1-9, wherein the die plate comprises either or both of circles with a diameter of 0.5 to 5 mm and rectangles with a length to width ratio of 1:10 to 10:1.

[0088] Embodiment 11: the facility of any of Embodiments 1-10, wherein the cutter hub comprises a blade that is located 1 to 30 mm from the die plate.

[0089] Embodiment 12: the facility of any of Embodiments 1-11, wherein the product hopper comprises a twin screw, an internal agitator, a vibrator, a knocker system, or a combination comprising one or more of the foregoing.

[0090] Embodiment 13: the facility of any of Embodiments 1-12, wherein the fills station is monitored by a product weight and/or a filling time.

[0091] Embodiment 14: the facility of any of Embodiments 1-13, wherein the product handling station further comprises a pallet wrapper.

[0092] Embodiment 15: the facility of any of Embodiments 1-14, wherein the product handling station further comprises a product labeler.

[0093] Embodiment 16: the facility of any of Embodiments 1-15, wherein the utilities system comprises a ventilation system, a central vacuum station, a vacuum hood, or a combination comprising one or more of the foregoing.

[0094] Embodiment 17: the facility of any of Embodiment 16, wherein the ventilation system has a rating of 5 to 20 air changes per hour.

[0095] Embodiment 18: the facility of any of Embodiments 16-17, wherein the utilities system comprises 1 to 10 vacuum stations.

[0096] Embodiment 19: the facility of any of Embodiments 1-17, wherein the utilities system can control a temperature and/or a humidity in the facility.

[0097] Embodiment 20: the facility of Embodiment 19, wherein the temperature is 17 to 26°C.

[0098] Embodiment 21: the facility of Embodiment 19 or 20, wherein the humidity is 40 to 64%.

[0099] Embodiment 22: a process for making masterbatch pellets comprising: introducing two or more components to a mixer; wherein the components are added via a feeder, a discharger, or a manual fill station and wherein the mixer is a double shaft mixer rotating in opposite directions; mixing the components in the mixer to form a mixed composition; introducing the mixed composition to a buffer hopper; feeding the mixed composition from the buffer hopper to a pellet compactor via a screw feeder; compacting the

mixed composition into masterbatch pellets; screening the masterbatch pellets into a desired size range; introducing the screened masterbatch pellets to a product hopper; and feeding the screened masterbatch pellets from the product hopper into a product bag.

[0100] Embodiment 23: the process of Embodiment 22, wherein at least one component is added via an assisted component feeder.

[0101] Embodiment 24: the process of Embodiment 22, wherein the assisted component feeder comprises a twin screw, an internal agitator, a vibrator, a knocker system, or a combination comprising one or more of the foregoing.

[0102] Embodiment 25: the process of any of Embodiments 22-24, wherein the mixing occurs for less than or equal to 5 minutes.

[0103] Embodiment 26: the process of any of Embodiments 22-25, wherein the mixing does not melt components with a melting temperature of 60°C.

[0104] Embodiment 27: the process of any of Embodiments 22-26, wherein the mixing does not melt components with a melting temperature of 50°C.

[0105] Embodiment 28: the process of any of Embodiments 22-27, wherein the mixing occurs at a tip-speed of 0.1 to 100 m/s

[0106] Embodiment 29: the process of any of Embodiments 22-28, wherein the mixing occurs at a tip-speed of 1 to 5 m/s.

[0107] Embodiment 30: the process of any of Embodiments 22-29, wherein the introducing is an automated process.

[0108] Embodiment 31: the process of Embodiment 30, wherein the introducing occurs by opening a discharge gate while the double shaft mixer is rotating.

[0109] Embodiment 32: the process of any of Embodiments 22-31, wherein the buffer hopper comprises a twin screw, an internal agitator, a buffer vibrator, a knocker system, or a combination comprising one or more of the foregoing.

[0110] Embodiment 33: the process of Embodiment 32, wherein the buffer hopper comprises the vibrator and wherein the process further comprises operating the buffer vibrator at a frequency of 2,000 to 100,000 vibrations per minute.

[0111] Embodiment 34: the process of any of Embodiments 22-33, wherein the feeding occurs at a rate of 45 to 4500 dm³/h.

[0112] Embodiment 35: the process of any of Embodiments 22-34, wherein the compacting comprises introducing the mixed composition to a die plate comprises either or

both of circles with a diameter of 0.5 to 5 mm and rectangles with a length to width ratio of 1:10 to 10:1.

[0113] Embodiment 36: the process of Embodiment 35, wherein the compacting comprises cutting the mixed composition as it pushes through the die plate.

[0114] Embodiment 37: the process of Embodiment 36, wherein the cutting occurs via a blade located 1 to 30 mm from the die plate.

[0115] Embodiment 38: the process of any of Embodiments 22-37, wherein the compacting does not produce one or both of fines and oversize pellets.

[0116] Embodiment 39: the process of any of Embodiments 22-38, wherein the product hopper a twin screw, an internal agitator, a product vibrator, a knocker system, or a combination comprising one or more of the foregoing.

[0117] Embodiment 40: the process of any of Embodiments 22-39, wherein the feeding is monitored by one or both of a product bag weight and a filling time.

[0118] Embodiment 41: the process of any of Embodiments 22-40, further comprising placing the product bag on a pallet.

[0119] Embodiment 42: the process of Embodiment 22-41, further comprising filling the pallet with product bags and wrapping the pallet.

[0120] Embodiment 43: the process of Embodiment 42, further comprising labeling the pallet.

[0121] Embodiment 44: the process of any of Embodiments 22-43, wherein the entire process is automated.

[0122] Embodiment 45 : the process of any of Embodiments 22-44, wherein the introducing to the screening takes less than or equal to 50 minutes

[0123] Embodiment 46: the process of any of Embodiments 22-45, wherein the component comprises a thermoplastic polymer, a masterbatch quencher, a release agent, an antioxidant, an ultraviolet light (UV) stabilizing agent, a flame retardant, an anti drip agent, an antistatic agent, a colorant, or a combination comprising two or more of the foregoing.

[0124] Embodiment 47: the process of Embodiment 46, wherein the thermoplastic polymer comprises a polycarbonate.

[0125] Embodiment 48: the process of Embodiment 47, wherein the component comprises the polycarbonate, the quencher, or a combination comprising both of the aforementioned components.

[0126] In general, the invention can alternately comprise, consist of, or consist essentially of, any appropriate components herein disclosed. The invention can additionally, or alternatively, be formulated so as to be devoid, or substantially free, of any components, materials, ingredients, adjuvants or species used in the prior art compositions or that are otherwise not necessary to the achievement of the function and/or objectives of the present invention.

[0127] All ranges disclosed herein are inclusive of the endpoints, and the endpoints are independently combinable with each other (e.g., ranges of “up to 25 wt%, or, more specifically, 5 to 20 wt%”, is inclusive of the endpoints and all intermediate values of the ranges of “5 to 25 wt%,” etc.). “Combination” is inclusive of blends, mixtures, alloys, reaction products, and the like. Furthermore, the terms “first,” “second,” and the like, herein do not denote any order, quantity, or importance, but rather are used to denote one element from another. The terms “a” and “an” and “the” herein do not denote a limitation of quantity, and are to be construed to cover both the singular and the plural, unless otherwise indicated herein or clearly contradicted by context. The suffix “(s)” as used herein is intended to include both the singular and the plural of the term that it modifies, thereby including one or more of that term (e.g., the film(s) includes one or more films). Reference throughout the specification to “one embodiment,” “another embodiment,” “an embodiment,” and so forth, means that a particular element (e.g., feature, structure, and/or characteristic) described in connection with the embodiment is included in at least one embodiment described herein, and may or may not be present in other embodiments. In addition, it is to be understood that the described elements can be combined in any suitable manner in the various embodiments.

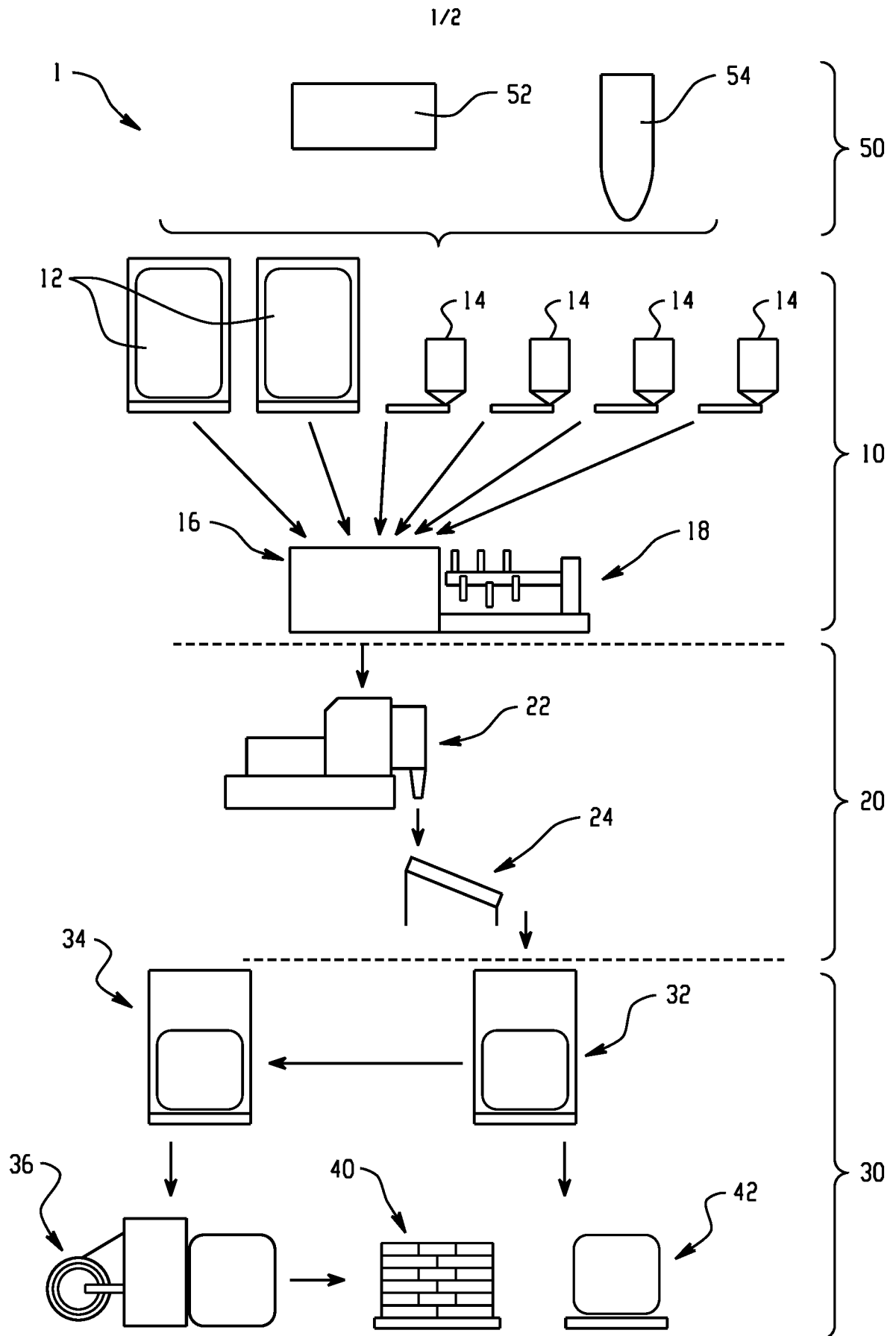
[0128] While particular embodiments have been described, alternatives, modifications, variations, improvements, and substantial equivalents that are or can be presently unforeseen can arise to applicants or others skilled in the art. Accordingly, the appended claims as filed and as they can be amended are intended to embrace all such alternatives, modifications variations, improvements, and substantial equivalents.

[0129] I/we claim:

CLAIMS

1. A masterbatch facility comprising:
a feed and blend system comprising greater than or equal to one feeder, greater than or equal to one discharger, a manual feed station, or a combination thereof, and further comprising a mixer; wherein at least one of the feeders is an assisted component feeder; wherein at least two components are fed via the feeder, discharger, manual feed station, or a combination thereof to the mixer; wherein the mixer is a double shaft mixer rotating in opposite directions;
a pellet mill comprising a buffer hopper, a screw feeder, a pellet compactor, and a screener; wherein the pellet compactor comprises a die plate, a roll, and a cutter hub;
a product handling system comprising a product hopper and a fill station; and
a utilities system.
2. The facility of Claim 1, wherein the feed and blend system comprises 4 feeders, and 2 dischargers.
3. The facility of any of the preceding claims, wherein one or more of the assisted component feeder, the product hopper, and the buffer hopper comprises an internal agitator, a vibrator, and a knocker or a combination comprising one or more of the foregoing.
4. The facility of any of the preceding claims, wherein the buffer hopper is a vibratory buffer hopper, and wherein the product hopper is a vibratory product hopper.
5. The facility of any of the preceding claims, wherein the utilities system comprises a ventilation system, a central vacuum station, a vacuum hood, or a combination comprising one or more of the foregoing.

6. A process for making masterbatch pellets comprising:
 - introducing two or more components to a mixer; wherein the components are added via a feeder, a discharger, or a manual fill station and wherein the mixer is a double shaft mixer rotating in opposite directions;
 - mixing the components in the mixer to form a mixed composition;
 - introducing the mixed composition to a buffer hopper;
 - feeding the mixed composition from the buffer hopper to a pellet compactor via a screw feeder;
 - compacting the mixed composition into masterbatch pellets;
 - screening the masterbatch pellets into a desired size range;
 - introducing the screened masterbatch pellets to a product hopper; and
 - feeding the screened masterbatch pellets from the product hopper into a product bag.
7. The process of Claim 6, wherein at least one component is added via an assisted component feeder.
8. The process of Claim 7, wherein the assisted component feeder comprises a twin screw, an internal agitator, a vibrator, a knocker system, or a combination comprising one or more of the foregoing.
9. The process of any of Claims 6-8, wherein the mixing occurs for less than or equal to 5 minutes.
10. The process of any of Claims 6-9, wherein the mixing does not melt components with a melting temperature of 60°C.
11. The process of any of Claims 6-10, wherein the mixing occurs at a tip-speed of 1 to 5 m/s.
12. The process of any of Claims 6-11, wherein the introducing is an automated process.
13. The process of any of Claims 6-12, wherein the buffer hopper is a vibratory buffer hopper operating at a frequency of 2,000 to 100,000 vibrations per minute.
14. The process of any of Claims 6-13, wherein the feeding occurs at a rate of 45 to 4500 dm³/h.
15. The process of any of Claims 6-14, wherein the entire process is automated.

*Fig. 1*

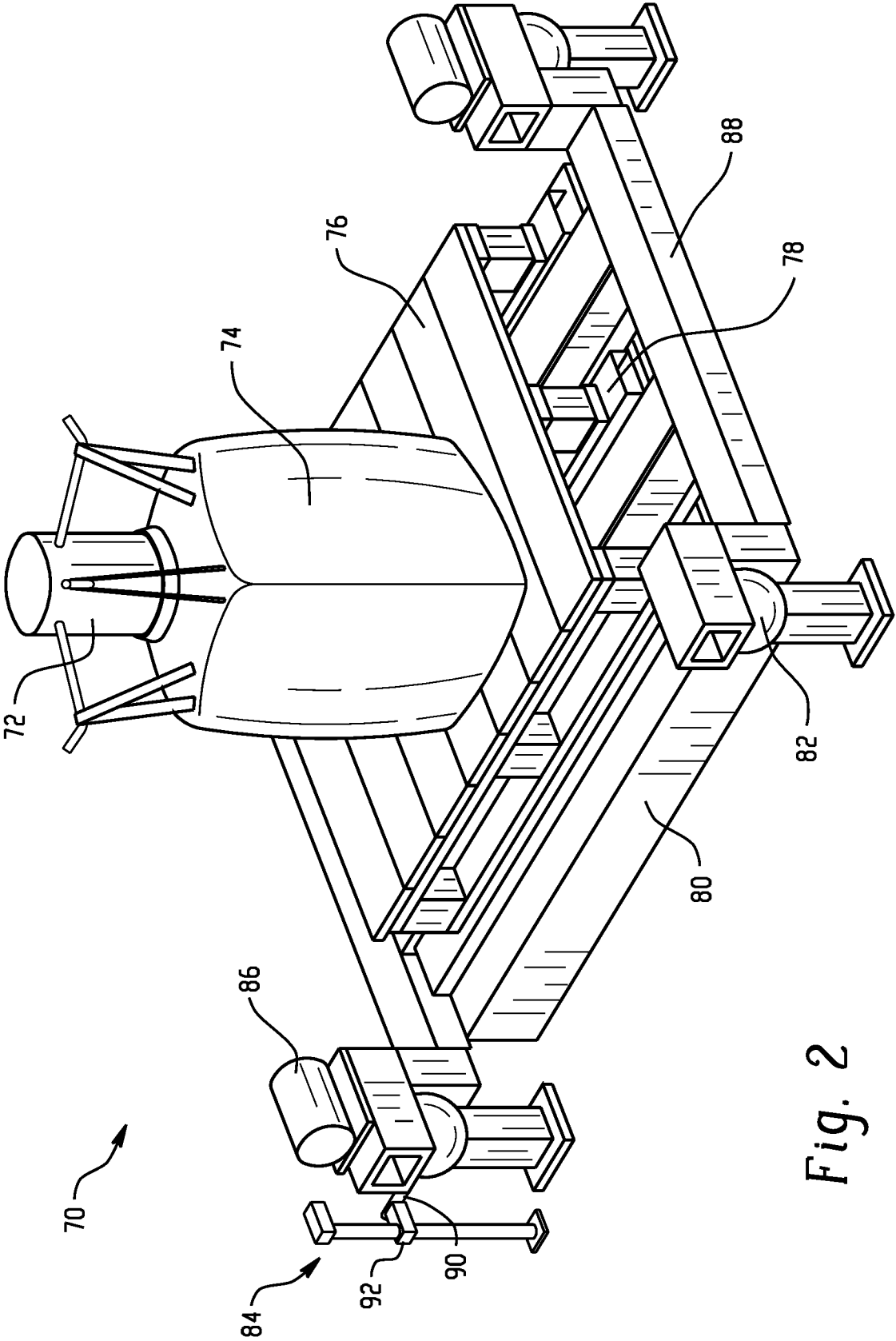


Fig. 2

INTERNATIONAL SEARCH REPORT

International application No
PCT/IB2014/065002

A. CLASSIFICATION OF SUBJECT MATTER INV. B29B9/06 B29B9/12 B29B9/16 ADD.		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) B29B		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) EPO-Internal, WPI Data		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X A	WO 2005/054344 A1 (SCHEIRS J [AU] ET AL) 16 June 2005 (2005-06-16) page 1, lines 13-27 page 4, line 15 - page 5, line 21 page 6, lines 1-6 page 7, line 27 - page 8, line 21 page 14, lines 11-18 page 16, lines 4-6 abstract	1-3,5 4,6-15
X A	----- GB 2 280 187 A (IDYLLIC LTD [IE]) 25 January 1995 (1995-01-25) abstract; figure 1	1-5 6-15
A	----- US 2009/130443 A1 (LUSTIGER A [US]) 21 May 2009 (2009-05-21) paragraphs [0002], [0052] - [0059] abstract; figure 2 -----	1-15
-/-		
☒ Further documents are listed in the continuation of Box C. ☒ See patent family annex.		
* Special categories of cited documents : "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published 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 "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search 17 November 2014		Date of mailing of the international search report 27/11/2014
Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016		Authorized officer Brunold, Axel

INTERNATIONAL SEARCH REPORT

International application No

PCT/IB2014/065002

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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