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PEROXIDES, THEIR PREPARATION PROCESS AND USE

5 The present invention relates to particular peroxides, their preparation process, and their use. More particularly, the present invention relates to the preparation process of these peroxides, which are obtainable by the reaction of a corresponding ketone peroxide and an alkyl vinyl ether or an acetal. Finally, the present invention relates to the use of these peroxides as polymerization
10 initiators, curing agents for unsaturated polyesters, and modifying agents, and to formulations comprising these peroxides.

US-A-3,576,826 discloses ether peroxy compounds and their preparation from alpha-substituted vinyl ether. In the class of ether peroxides (v) the adjacent
15 peroxide groups may be separated by an unidentified aliphatic or cycloaliphatic group.

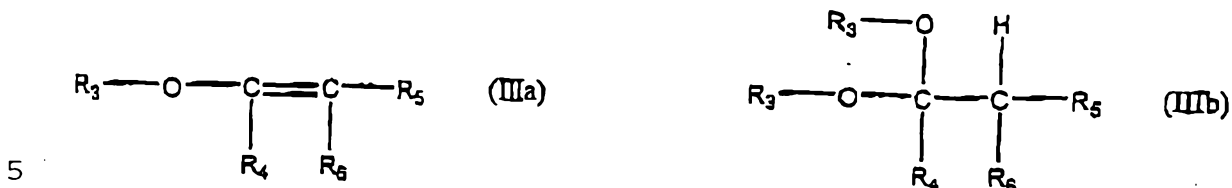
It is an object of the present invention to provide a new class of peroxides which are useful as polymerization initiators, curing agents for unsaturated
20 polyesters, and modifying agents.

It is another object of the invention to provide peroxides with a higher reactivity in view of compounds of US-A-3,576,826.

25 It is a further object of the invention to provide peroxides with a better storage stability at room temperature in view of compounds of US-A-3,576,826.

Accordingly the present invention provides a process for the preparation of a peroxide having the general formula (I),

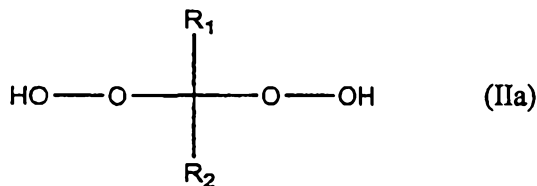
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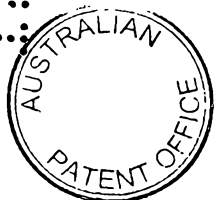
wherein R_3 , R_4 , R_5 and R_6 have the identified meaning, in the presence of an acid catalyst.

The ketone peroxide of formula II may be a so-called T_4 -ketone peroxide ($n=1$) and/or a so-called T_3 -ketone peroxide ($n=2$).

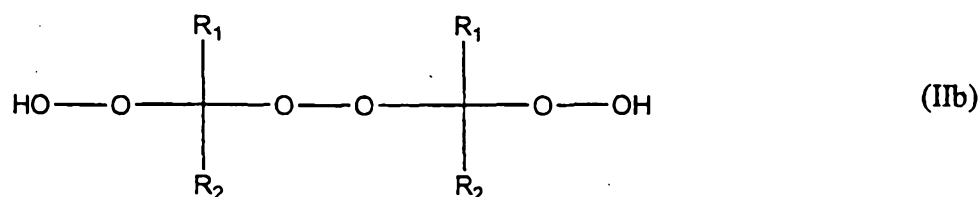
The T_4 -ketone peroxides having general formula IIa



which are suitable for the reaction with said alkyl vinyl ether of formula IIIa or with said acetal of formula IIIb are those formed from the following ketones: acetone, acetophenone, methyl-n-amyl ketone, ethylbutyl ketone, ethylpropyl ketone, methylisoamyl ketone, methylheptyl ketone, methylhexyl ketone, ethylamyl ketone, diethylketone, dipropyl ketone, methylethyl ketone, methylisobutyl ketone, methylisopropyl ketone, methylpropyl ketone, methyl-n-butyl ketone, methyl-t-butyl ketone, methyl cyclohexanone, isobutylheptyl ketone, diisobutyl ketone, methoxy acetone, cyclohexanone, 3,3,5-trimethyl cyclo hexanone, N-butyllevulinate, ethylacetoacetate, methylbenzyl ketone, phenylethyl ketone, methylchloromethyl ketone, methylbromomethyl ketone; also other ketones having the appropriate R_1 and R_2 groups corresponding to the peroxides of the formula II can be employed, as well as mixtures of two or more different ketones.



The T₃-ketone peroxides having the general formula IIb



which are suitable for the reaction with said alkyl vinyl ether of formula IIIa or said acetal IIIb are those that are derived from the same group of ketones as mentioned for the T₄-ketone peroxides.

Preferably, the ketone peroxide is formed or derived from methylethyl ketone, methylisopropyl ketone, methylisobutyl ketone, acetone, cyclohexanone and/or 3,3,5-trimethylcyclohexanone. Methyl isobutyl ketone and methyl ethyl ketone are most preferable.

The alkyl vinyl ethers of formula IIIa (in which R₄ is hydrogen) may be exemplified as follows:

vinyl 2,2-bis(vinyloxymethyl)butyl ether, allyl 2,3-epoxypropyl ether, n-propyl vinyl ether, 1-ethoxy-4-methyl-1-nonene, tert.amyl vinyl ether, 2,2-bis (4-vinyloxyphenyl)propane, hexadecyl vinyl ether, methyl vinyl ether, 4-methylhexyl vinyl ether, 2-(2-ethoxyethoxy)ethyl vinyl ether, 2-methoxyethyl vinyl ether, 2-vinyloxy ethanol, 4-methyl-1-decenyl vinyl ether, benzyl 1-methyl vinyl ether, butanediol divinyl ether, tert.butyl vinyl ether, isobutyl vinyl ether, cyclohexanedimethanol divinyl ether, cyclohexyl vinyl ether, ethyleneglycol divinyl ether, 1-ethoxy-4-(1-ethoxyvinyl)-3,3,5,5-tetramethylcyclohexene, allyl vinyl ether, isopropyl vinyl ether, ethyl vinyl ether, tetraethyleneglycol divinyl ether, 1-methoxy-1-buten-3-yne, heptyl vinyl ether, 4-(1-ethoxyvinyl)-3,3,5,5-tetramethylcyclohexanone, 2-butoxyethyl vinyl ether, allyl ethyl ether, divinyl ether, 1,3-divinyloxy-2,2-dimethylpropane, 4-vinyloxybutanol, diethyleneglycol divinyl ether, 4-(vinyloxymethyl) cyclohexylmethanol, isopentyl vinyl ether, diethyleneglycol monovinyl ether, n-butyl vinyl ether, 1,4-bis(2-vinyloxyethyl)benzene, hexanediol divinyl ether, 1-methoxy-1,3-butadiene, decyl vinyl

ether, 4-(allyloxymethyl)-1,3-dioxolan-2-one, 1,1-diethylpropyl vinyl ether, 2-methoxyvinyl benzene, octyl vinyl ether, bis(vinyloxy)methane, 1,4-dimethoxy-1,3-butadiene, triethyleneglycol divinyl ether, pentyl vinyl ether, octadecyl vinyl ether, triethyleneglycol methyl vinyl ether, 2,3-epoxypropyl vinyl ether, dodecyl
5 vinyl ether, 1,1-bis(vinyloxy) butane, hexyl vinyl ether, 6-vinyloxyhexanol, (z)-1-methoxy-1-buten-3-yne, phenyl vinyl ether, 2-ethylhexyl vinyl ether, poly-THF-divinyl ether, pluriol-E-200-divinyl ether, trimethylolpropane trivinyl ether, aminopropyl vinyl ether, 2-diethylaminoethyl vinyl ether, ethyl propenyl ether.

10 Examples of alkyl vinyl ethers of formula IIIa in which R_4 is alkyl are as follows: 2-methoxy-2-butene, 1,1,3-trimethoxypropene, 2,3-dimethoxy-1,3-butandiene, 2-methoxypropene, 2-ethoxy propene, 2-isobutoxypropene, 2-ethoxy-2-butene, 2-isobutoxy-2-propene.

Examples of tri-substituted and cyclic alkyl vinyl ethers are 1-methoxy-2-methyl
15 cyclohexene and 2-methoxy-2-methyl-2-butene. Examples of the cyclic alkyl vinyl ethers are 2-methyl-2,3-dihydrofuran, 2,3-dihydrofuran, 2-methyl-3,4-dihdropyran, 3,4-dihdropyran, 1-methoxy cyclohexene. Preferred are ethyl vinyl ether, isobutyl vinyl ether, propyl vinyl ether, and butyl vinyl ether. Most preferred is isobutyl vinyl ether.

20 Examples of acetals of formula IIIb are 2,2-dimethoxypropane, 2,2-diethoxypropane (with R_4 is alkyl) or, 1,1-dimethoxybutane, 2-propyl-1,3-dioxolane, 1,1-dimethoxyethane, 1,1-diethoxyethane, 1,1-diethoxypropane, and 1,1-dimethoxycyclohexane (with R_4 is hydrogen). Preferred is 1,1-
25 dimethoxyethane.

The reaction between the ketone peroxide of formula II and the alkyl vinyl ether of fomula IIIa or acetal of formula IIIb is carried out under conditions conventional for this type of addition reaction. The temperature generally is in
30 the range of 0-50°C and preferably is between 10-25°C. The reaction is carried

out in the presence of an acid catalyst. The amount of acid catalyst generally is 0.01-30 g/mole and preferably 0.1-15 g/mole of ketone peroxide.

The acid catalyst for the process is a conventional acidic catalyst such as a C₁-
5 C₁₀ alkane or aryl sulphonic acid, a halogenated C₁-C₁₀ alkane sulphonic acid or a mixture of one or more of these compounds. The preferred catalysts for use are, but are not limited to, p-toluenesulfonic acid and methane sulfonic acid.

Although this reaction may be carried out without a solvent, it is preferred to carry out the reaction in a conventional homogenous solvent system.

10

Suitable solvents generally are hydrocarbon solvents, esters, aromatic hydrocarbon solvents, aralkyl solvents, paraffinic oils, white oils, and silicone oils, as well as their mixtures. Useful solvents include, but are not limited to, benzene, xylene, toluene, mesitylene, hexane, hydrogenated oligomers of
15 alkanes such as Isopar^R products (ex. Exxon), Shellsol^R products (ex Shell), pentane, heptane, decane, isododecane, decalin, dibutyl phthalate, dioctyl adipate, dioctyl terephthalate, 2,2,4-tri methyl-1,3-pentanediol diisobutyrate, butylbenzoate, and the like. Among the paraffinic oils useful as solvents is paraffinic diesel oil. Other oils, including white oils, epoxidized soybean oils,
20 and silicone oils are also useful in the present invention.

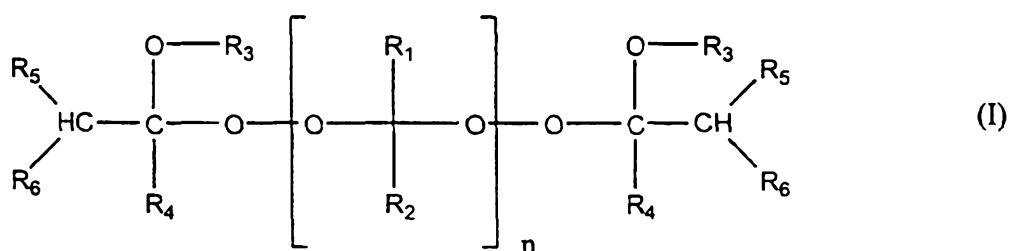
Preferably, R₄ is hydrogen because the peroxides show a better storage stability at ambient temperature and are less sensitive to hydrolysis. More preferably, R₄ and R₅ and/or R₆ are hydrogen.

25

Generally, the preparation process of the peroxide is carried out such that an equivalent amount of the alkyl vinyl ether of formula IIIa or of the acetal of formula IIIb is in the range of 1-5 equivalents. Preferably, the range is from 1.5 to 3.0 equivalents, more preferably from 2.0 to 2.5 equivalents. These numbers
30 of equivalents are selected such that the chemical yield is optimal.

It is noted that in the preparation process the ketone peroxide used may be pure (T_4) ketone peroxide of formula IIa or (T_3) ketone peroxide of formula IIb. For specific properties it may be recommendable to use a mixture of T_4 - and T_3 -ketone peroxides. For instance, the T_3 - or T_4 -ketone peroxide may comprise
 5 5%-30%, e.g., 5%-25% and 10%-15%, of the other ketone peroxide.

Furthermore, the invention relates to the peroxides of formula I



10 wherein R_1 , R_2 , R_3 , R_4 , R_5 , and R_6 have the identified meaning and which are obtainable with the above-described preparation process.

The peroxides according to the present invention produced with the preparation processes according to the present invention may be used as initiators for
 15 polymer production and in particular for the preparation of poly(vinylchloride), acrylic (co)polymers, polystyrene, polyethylene, for curing unsaturated polyester resins, and for polymer modification (such as grafting of monomers).

In the present invention, the polymerization is conducted by any conventional
 20 process, except that a specified radical polymerization initiator (or composition) is used. The polymerization processes may be carried out in the usual manner, for example in bulk, suspension, emulsion or solution. In the case of the production of ethylene (co)polymers, the reaction is usually carried out under high pressure, e.g. about 1000 to about 3500 bar.

The amount of initiator, which varies depending on the polymerization temperature, the capacity for removing the heat of polymerization, and, where applicable, the kind of monomer to be used, and the applied pressure, should be an effective amount for achieving polymerization. Usually, from 0.001-25 wt.% of peroxide, based on the weight of the (co)polymer, is employed. Preferably, from 0.001-20 wt.% of peroxide is employed and most preferably from 0.001-15 wt.%.

For most reactions within the present invention the polymerization temperature usually is 30° to 350°C, preferably 40° to 300°C. In general, if the temperature is below 30°C, the polymerization time becomes too long. However, when it exceeds 350°C, the radical polymerization initiator is spent in the initial stage of the polymerization, making it difficult to attain a high conversion. In order to reduce the amount of unreacted monomer, however, it is also possible to conduct the polymerization using a temperature profile, e.g., to perform the initial polymerization at below 100°C and then elevate the temperature above 100°C to complete the polymerization. These variations are all known to the man skilled in the art, who will have no difficulty selecting the reaction conditions of choice, depending on the particular polymerization process and the specific radical polymerization initiator to be used.

Suitable monomers for polymerization using the peroxides according to the present invention are olefinic or ethylenically unsaturated monomers, for example substituted or unsubstituted vinyl aromatic monomers, including styrene, alpha-methylstyrene, p-methylstyrene, and halogenated styrenes; divinylbenzene; ethylene; ethylenically unsaturated carboxylic acids and derivatives thereof, such as (meth)acrylic acids, (meth)acrylic esters, butyl acrylate, hydroxyethyl (meth)acrylate, methyl(meth)acrylate, 2-ethylhexyl (meth)acrylate, and glycidyl methacrylate; ethylenically unsaturated nitriles and amides, such as acrylonitrile, methacrylonitrile, and acrylamide; substituted or unsubstituted ethylenically unsaturated monomers, such as butadiene,

isoprene, and chloroprene; vinyl esters, such as vinyl acetate and vinyl propionate; ethylenically unsaturated dicarboxylic acids and their derivatives including mono- and diesters, anhydrides, and imides, such as maleic anhydride, citraconic anhydride, citraconic acid, itaconic acid, nadic anhydride, 5 maleic acid, fumaric acid, aryl, alkyl and aralkyl citraconimides and maleimides; vinyl halides, such as vinyl chloride and vinylidene chloride; vinyl ethers, such as methylvinyl ether and n-butyl vinyl ether; olefins, such as isobutene and 4-methylpentene; allyl compounds, such as (di)allyl esters, for example diallyl phthalates, (di)allyl carbonates, and triallyl (iso)cyanurate.

10

During (co)polymerization, the formulations may also contain the usual additives and fillers. As examples of such additives may be mentioned: stabilizers such as inhibitors of oxidative, thermal or ultraviolet degradation, lubricants, extender oils, pH controlling substances, such as calcium carbonate, 15 release agents, colourants, reinforcing or non-reinforcing fillers such as silica, clay, chalk, carbon black, and fibrous materials, such as glass fibres, plasticizers, diluents, chain transfer agents, accelerators, and other types of peroxides. These additives may be employed in the usual amounts.

20 Finally, the polymerization process of the present invention can be employed to introduce functional groups into the (co)polymers. This may be accomplished by employing a peroxide which contains one or more functional groups attached thereto. These functional groups remain intact in the free radicals formed by the peroxides and thus are introduced into the (co)polymer. Conventional 25 polymerization conditions and equipment may be used to achieve this object of the present invention.

The peroxides according to the invention which may be used as a curing agent for the unsaturated polyesters and unsaturated polyester resins according to 30 the present invention usually include an unsaturated polyester and one or more ethylenically unsaturated monomers. Suitable polymerizable monomers include

styrene, alpha-methylstyrene, p-methylstyrene, chlorostyrenes, bromostyrenes, vinylbenzyl chloride, divinylbenzene, diallyl maleate, dibutyl fumarate, triallyl phosphate, triallyl cyanurate, diallyl phthalate, diallyl fumarate, methyl (meth)acrylate, n-butyl (meth)acrylate, ethyl acrylate, and mixtures thereof
5 which are copolymerizable with the unsaturated polyesters. The unsaturated polyesters are, for example, polyesters as they are obtained by esterifying at least one ethylenically unsaturated di- or polycarboxylic acid, anhydride or acid halide, such as maleic acid, fumaric acid, glutaconic acid, itaconic acid, mesaconic acid, citraconic acid, allylmalonic acid, tetrahydrophthalic acid, and
10 others, with saturated and unsaturated di- or polyols, such as ethylene glycol, diethylene glycol, triethylene glycol, 1,2- and 1,3-propane diols, 1,2-, 1,3-, and 1,4-butane diols, 2,2-dimethyl-1,3-propane diols, 2-hydroxymethyl-2-methyl-1,3-propane diol, 2-buten-1,4-diol, 2-butyne-1,4-diol, 2,4,4-trimethyl-1,3-pentane diol, glycerol, pentaerythritol, mannitol, and others. The di- or polycarboxylic acids
15 may be partially replaced by saturated di- or polycarboxylic acids, such as adipic acid, succinic acid, and others, and/or by aromatic di- or polycarboxylic acids, such as phthalic acid, trimellitic acid, pyromellitic acid, isophthalic acid, and terephthalic acid. The acids used may be substituted with groups such as halogen. Suitable halogenated acids include, for example, tetrachlorophthalic
20 acid and tetrabromophthalic acid.

The peroxides of the present invention are suited for use in the modification of polymers such as degradation, cross-linking or grafting. More particularly, these peroxides can be employed in processes for grafting monomers onto polymers
25 such as polyolefins and elastomers, and for the functionalization of polyolefins in the case of functional group-containing peroxides of the present invention.

In general, the peroxide may be brought into contact with the (co)polymer in various ways, depending upon the particular object of the modification process.

The polymer material may be in the solid state, the molten state, in the form of a solution in the case of an elastomer, in a plastic state or in any physical form including finely divided particles (flakes), pellets, film, sheet, in the melt, in solution, and the like. Polymers may also be in the liquid form, e.g. liquid
5 rubbers.

In general, any (co)polymer comprising abstractable hydrogen atoms, in particular polyolefins, can be modified by the present process.

10 The amount of peroxide used in the modification process of the present invention should be an effective amount for achieving significant modification of the (co)polymer when treating a (co)polymer. More particularly, from 0.001-15.0 wt.% of peroxide, based on the weight of the (co)polymer, should be employed. More preferably, from 0.005-10.0 wt.% percent is employed. Most preferably,
15 an amount of 0.01-5.0 wt.% is employed.

The peroxides can be prepared, transported, stored, and applied in the form of powders, granules, pellets, pastilles, flakes, slabs, pastes, solid masterbatches, and liquids. These formulations may have the form of a dispersion, such as a
20 suspension or an emulsion. They can be be phlegmatized if necessary, depending on the particular peroxide and its concentration in the formulation. Which of these forms is to be preferred depends partly on the application for which it will be used and partly on the manner in which it will be mixed. Also, considerations of safety may play a role to the extent that phlegmatizers may
25 have to be incorporated into certain compositions to ensure their safe handling.

The formulations of the present invention are transportable, storage stable, and contain 1.0-90 wt.% of one or more peroxides according to the present invention. Transportable means that the formulations of the present invention
30 have passed the pressure vessel test (PVT). Storage stable means that the

formulations of the present invention are both chemically and physically stable during a reasonable storage period under standard conditions.

Preferred formulations in accordance with the present invention contain 10-90
5 wt.% of one or more of the peroxides, more preferably these formulations contain 30-90 wt.% of the peroxides, most preferably these formulations contain 40-80 wt.% of the peroxides.

The formulations of the present invention can be liquids, solids or pastes,
10 depending on the melting point of the peroxide and the diluent employed. Liquid formulations can be made using liquid phlegmatizers for the ketone peroxide, liquid plasticizers, organic peroxides, and mixtures thereof as the diluent. The liquid component generally is present in an amount of 1-99 wt.% of the composition, preferably 10-90 wt.%, more preferably 30-90 wt.%, and most
15 preferably 40-80 wt.% of the liquid formulation consists of liquid diluents.

It should be noted that certain phlegmatizers may not be suitable for use with all of the peroxides of the present invention. More particularly, in order to obtain a safe composition, the phlegmatizer should have a certain minimum flash point
20 and a boiling point relative to the decomposition temperature of the peroxide such that the phlegmatizer cannot be boiled off leaving a concentrated, unsafe ketone peroxide composition behind. Thus, the lower-boiling phlegmatizers mentioned below may only be useful, for example, with particular substituted peroxides of the present invention which have a low decomposition
25 temperature.

In liquid formulations a liquid carrier or diluent is used. Preferably, this carrier or diluent is a solvent. Examples of the solvents are those given above for the preparation of the various peroxides.

In the solid and/or paste formulations of the present invention solid carrier materials are employed. Examples of such solid carriers are low-melting solids, such as dicyclohexyl phthalate, dimethyl fumarate, dimethyl isophthalate, triphenyl phosphate, glyceryl tribenzoate, trimethyl olethane tribenzoate, 5 dicyclohexyl terephthalate, paraffinic waxes, dicyclohexyl isophthalate, polymers, and inorganic supports. Inorganic supports include materials such as fumed silica, precipitated silica, hydrophobic silica, chalk, whiting, surface-treated clays such as silane-treated clays, calcined clays, and talc.

10 Polymers useful in the formulations of the present invention include polyethylene, polypropylene, ethylene/propylene copolymers, ethylene/propylene/diene monomer terpolymers, chlorosulphonated polyethylene, chlorinated polyethylene, polybutylene, polyisobutylene, ethylene/vinyl acetate copolymers, polyisoprene, polybutadiene, butadiene/styrene copolymers, 15 natural rubber, polyacrylate rubber, butadiene/acrylonitrile copolymers, acrylonitrile/butadiene/styrene terpolymers, silicone rubber, polyurethanes, polysulphides, solid paraffins, and polycaprolactone.

Storage stable formulations must be both physically and chemically stable. By 20 physically stable formulations are meant those formulations which do not suffer from significant phase separation upon storage. The physical stability of the present formulations can, in some instances, be improved by the addition of one or more thixotropic agents selected from cellulose esters, hydrogenated castor oil, and fumed silica. Examples of such cellulose esters are the reaction 25 products of cellulose and acid compounds selected from, for example, acetic acid, propionic acid, butyric acid, phthalic acid, trimellitic acid, and mixtures thereof.

By chemically stable formulations are meant those formulations which do not 30 lose a significant amount of their active oxygen content upon storage. The chemical stability of the present formulations can, in some instances, be

improved by the addition of one or more known additives including sequestering agents such as dipicolinic acid and/or antioxidants such as 2,6-di(t-butyl)-4-methyl phenol and para-nonyl phenol.

- 5 The formulations of the present invention may also contain optional other additives as long as these do not have a significant adverse effect on the transportability and/or storage stability of the formulations. As examples of such additives may be mentioned: anti-caking agents, free-flowing agents, anti-ozonants, anti-oxidants, anti-degradants, U.V. stabilizers, coagents, fungicides,
10 antistats, pigments, dyes, coupling agents, dispersing aids, blowing agents, lubricants, process oils, and mould-release agents. These additives may be employed in their usual amounts.

The peroxides according to the invention may also be used as a dispersion,
15 preferably in a polar medium. The medium in which the initiator according to the invention is dispersed should be inert towards the initiator and so polar that the initiator will hardly dissolve in it. The initiator preferably is dispersed in water or an alcohol. Most preferable is a dispersion in water. The use of such a medium makes for comparatively easy removal of any remnant, for example after the
20 modification of the (co)polymer if so desired. Furthermore, the use of water or alcohols is attended with far fewer organoleptic and other drawbacks than the use of organic diluents, such as toluene and xylene, which has been common up to now.

- 25 As is well-known to the skilled person, the use of other adjuvants in initiator dispersions may be advisable or even essential in order to ensure the dispersion's chemical and/or physical stability for a sufficiently long period of time. For instance, if the storage temperature of the initiator dispersion is lower than the freezing point of the medium in which the initiator is dispersed, an
30 appropriate freezing point depression agent can be added to counteract freezing. Also, a wide range of substances can be used for altering the

rheology of the formulation. To this end generally use is made of one or more surface-active materials and one or more thickeners. If so desired, other additives may be incorporated into the formulation. As examples of such additives may be mentioned pH buffers, biocides, chemical stabilizers which
5 counteract premature decomposition of the initiator, and anti-agers which counteract particle size growth in the dispersion.

The following examples illustrate the preparation processes for the peroxides according to the present invention and their applications.

10

Example 1

Preparation of a mixture of 2,2-bis(1-(1-methylpropoxy)ethylperoxy) butane and bis[1-methyl-1(1-(2-methylpropoxy)ethylperoxy)propyl] peroxide

To a stirred solution of 25 g methylethyl ketone peroxide containing 27.82 wt.%
15 2,2-bis(hydroperoxy)butane T4 ketone peroxide and 14.4 wt.% bis (1-hydroperoxy-1-methylpropyl)peroxide T3 in dimethylphthalate was added 0.86 g p-toluene sulfonic acid monohydrate. Then 18.3 g isobutyl vinyl ether were added in 16 min, the reaction temperature being kept at 20°C by cooling with an ice-water bath. The mixture was stirred for 2 min at 20°C, washed with
20 bicarbonate solution, and dried over magnesium sulphate, yielding 41.6 g of product with an active oxygen content of 6.33% (chemical yield: 90%).

The following Table 1 shows the results of the preparation of other peroxides according to the invention (R_1 = methyl; R_4 , R_5 , and R_6 = H).

Table 1

Example	R3	R2	n=1 ; n=2 Mole/mol	Solvent	Yield (%)	Active Oxygen (%)
1a	Ethyl	Ethyl	56:44	Dimethylphthalate	87	7.04
1b	Ethyl	Ethyl	77:23	Dimethylphthalate	90	7.52
1c	Isobutyl	Ethyl	56:44	Dimethylphthalate	91	6.24
1d	Isobutyl	Ethyl	77:23	Dimethylphthalate	91	6.33
1e	Ethyl	Isobutyl	16:84	Pentadecane	97	5.89
1f	n-propyl	Isobutyl	43:57	Isododecane	93	6.53
1g	n-propyl	Isobutyl	43:57	Isododecane	88	6.20
1h	Isobutyl	Isobutyl	43:57	Isododecane	90	6.41
1i	Isobutyl	Isobutyl	96: 4	Ethylacetate	77	5.46
1j	Isobutyl	Isobutyl	0:100	Isododecane	70	6.26

Example 2

- 5 Preparation of a mixture of 2,2-bis(1-methoxy-1-methylethylperoxy)-4-methyl pentane and bis(1-(1-methoxy-1-methylethylperoxy)-1,3-dimethylbutyl) peroxide
- To a stirred solution of 50 g of methylisobutyl ketone peroxide containing 7.89 wt.% dihydroperoxy-1,3-dimethylbutane and 36.84 wt.% bis(1-hydroperoxy-1,3-dimethylbutyl) peroxide in pentadecane was added 0.60 g acetic acid. Then
- 10 13.73 g 2-methoxypropene were added in 10 min, the reaction temperature being kept at 20°C by cooling with an ice-water bath. The mixture was stirred for 30 min and 1.20 g of acetic acid were added. The mixture was allowed to stand overnight, yielding 65 g of product with an active oxygen content of 6.15%. Chemical yield: 97%.

15

Example 3

Preparation of 1,1-bis(1-isobutoxyethylperoxy) cyclohexane

To a stirred solution of 30 g of 1,1-dihydroperoxycyclohexane in ethylacetate was added 0.4 g p-toluene sulfonic acid. Then 19.6 g isobutyl vinyl ether were

added in 10 min, the reaction temperature being kept at 20°C by cooling with an ice-water bath. The mixture was stirred for 60 min. The mixture was washed with sodium bicarbonate solution and dried on MgSO₄. Yield 35 g of product with an active oxygen content of 6.75% Chemical yield:67%.

5

Example 4

Preparation of 2,2-bis(1-ethoxypropylperoxy)-4-methyl pentane

To a stirred solution of 5 g of methyl isobutyl ketone peroxide containing 35.7 wt.% bis(1-hydroperoxy-1,3-dimethylbutyl) peroxide in isododecane was added 0.05 g p-toluene sulfonic acid. Then 1.8 g ethyl propenyl ether were added in 10 min, the reaction temperature being kept at 20°C by cooling with an ice-water bath. The mixture was stirred for 20 min at 15°C. The mixture was washed with bicarbonate solution and dried over magnesium sulphate, yielding 5.8 g of product with an active oxygen content of 5.12% Chemical yield:91%.

15

Example 5

Preparation of a mixture of 2,2-di(1-methoxybutylperoxy)butane and di(1-(1-methoxybutylperoxy)1-methylpropyl) peroxide.

To a stirred solution of 25 g methylethyl ketone peroxide, containing 27.82 wt.% 2,2-bis(hydroperoxy)butane and 14.4 wt.% bis(1-hydroperoxy-1-methylpropyl)-peroxide in dimethyl phthalate was added 0.86 g p-toluene sulfonic acid monohydrate. Then 21.8 g 1,1-dimethoxybutane were added in 16 min, keeping the reaction temperature at 20°C by cooling with an ice-water bath. The mixture was stirred 20 min more at 20°C, washed with bicarbonate solution, and dried over magnesium sulphate, yielding 35.2 g of product with an active oxygen content of 6.68%. (chemical yield: 90%).

25

Example 6

Curing of unsaturated polyester

The curing performance of peroxides as curing agent for unsaturated polyester was determined and compared with tertiary butyl peroxy-2-ethyl hexanoate.

30

A time-temperature curve was measured at 100°C on compounds containing 100 parts of polyester resin, 150 parts of sand as filler, and 1 part of peroxide. This was carried out according to the method outlined by the Society of Plastic Institute. 25 g of the compounds were poured into a test tube and a thermocouple was placed through the enclosure at the centre of the tube. The glass tube was then placed in the oil bath maintained at a specific test temperature and the time-temperature curve was measured. From the curve the following parameters were calculated.

10 Gel time (GT) = time in minutes elapsed between 16.7°C below and 5.6°C above the bath temperature.

Time to peak exotherm (TTP) = time elapsed between the start of the experiment and the moment that the peak temperature is reached.

15 Peak exotherm (PE) = the maximum temperature which is reached. The results are shown in Table 2

Table 2

<u>Peroxide</u>	<u>Test temp. °C</u>	<u>GT min.</u>	<u>TTP. Min</u>	<u>PE °C</u>
t-butyl peroxy-2-ethyl hexanoate	100	0.87	3.4	197
Example 1c	100	2.17	5.57	184
Example 1g	100	0.78	3.38	197
Example 1h	100	0.67	3.22	195

Example 7

20 High-solids acrylic resin synthesis

The suitability of the peroxides according to the invention for the production of high-solids acrylic resin was determined and compared with tert. butyl peroxy-2-ethyl hexanoate.

25 Polymerizations were conducted under nitrogen in a jacketed glass reactor equipped with a turbine stirrer, a thermocouple, a reflux condenser, and an

injection inlet. The peroxide initiator was added to the monomers. This mixture was dosed to the solvent in a stirred vessel via the laboratory pump at the prescribed temperature in approx. 4 hours. The reaction was continued for an additional hour to reduce residual monomer/initiator. From the resins obtained

5 the molecular weights, colour, and percentage of solids were determined. The temperature was 165°C. The results are shown in Table 3.

Table 3.

<u>Initiator</u>	<u>Initiator</u> <u>meq/100g M</u>	<u>Solids</u> <u>content</u> <u>(%)</u>	<u>Mw</u> <u>(g/mol)</u>	<u>Mn</u> <u>(g/mol)</u>	<u>Disp.</u>
Example 1	30	71.0	5400	2700	2.0
t-butyl peroxy-2-ethyl hexanoate	30	74.3	5400	2900	1.9

10 Recipe:

Monomers (in parts by weight)

n-butylacrylate (BA) : 40
 styrene (STY) : 20
 2-hydroxyethyl methacrylate (HEMA): 28
 15 methyl methacrylate (MMA) : 10
 methacrylic acid (MA) : 2

Solvesso 100 (S-100) : 40 (solvent)

20 Initiator concentration: 30meq/100 g monomers

Temperature: 165°C

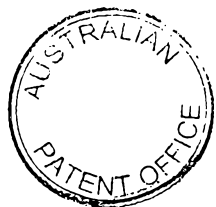
Molecular weights were determined by gel permeation chromatography using polystyrene standards, according to method AR/94.14-1/HPLC obtainable from

25 Akzo Nobel. Solids contents were determined by percentage of non-volatile

matter (0.5 hour at 150°C).

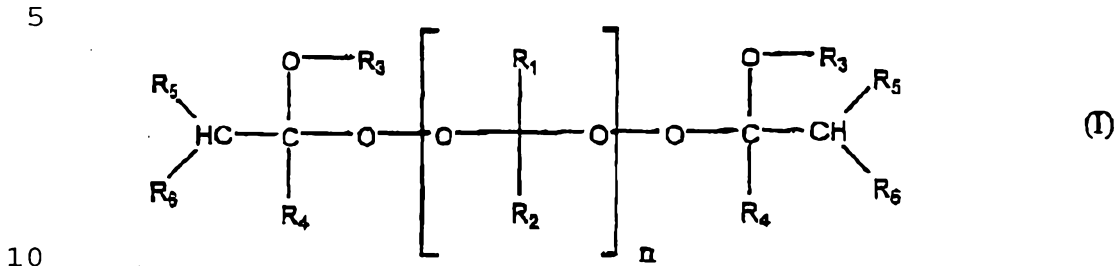
5 It is to be understood that, if any prior art publication is referred to herein, such reference does not constitute an admission that the publication forms a part of the common general knowledge in the art, in Australia or in any other country.

10 For the purposes of this specification it will be clearly understood that the word "comprising" means "including but not limited to", and that the word "comprises" has a corresponding meaning.



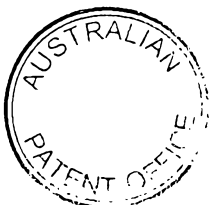
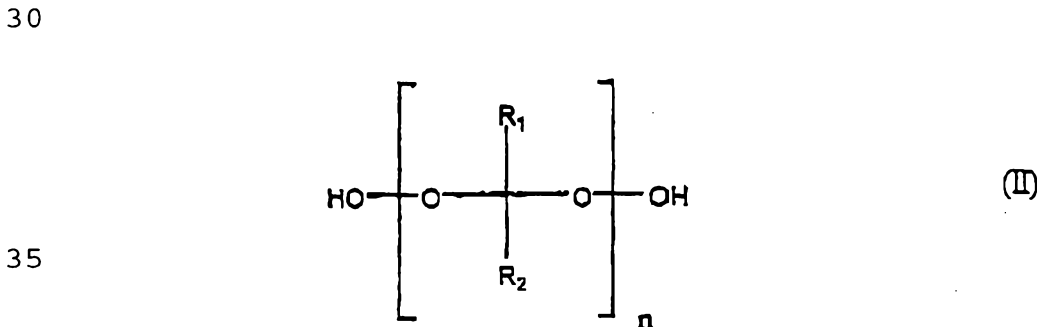
THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A process for the preparation of a peroxide having the general formula (I),



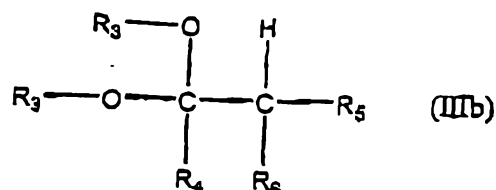
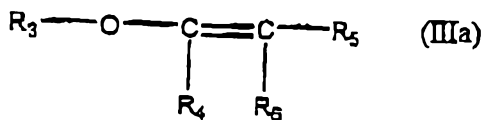
wherein $n = 1$ or 2 , R_1 , R_2 , R_4 , R_5 and R_6 are independently selected from hydrogen, C_1 - C_{20} alkyl, C_3 - C_{20} cycloalkyl, C_6 - C_{20} aryl, C_7 - C_{20} aralkyl, or C_7 - C_{20} alkaryl, or R_1 and R_2 form a C_3 - C_{12} cycloalkyl group, which groups may include linear or branched alkyl moieties; and each R_1 , R_2 , R_4 , R_5 and R_6 may optionally be substituted with one or more of hydroxy, alkoxy, linear or branched alkyl, aryloxy, halogen, ester, carboxy, nitrile, or amido, and

20 R_3 is independently C_1 - C_{20} alkyl, C_3 - C_{20} cycloalkyl, C_6 - C_{20} aryl, C_7 - C_{20} aralkyl, and C_7 - C_{20} alkaryl, which groups may include linear or branched alkyl moieties; and R_3 may optionally be substituted with one or more of hydroxy, alkoxy, linear or branched alkyl, aryloxy, halogen, ester, carboxy, nitrile, or amido, and any pair of the optionally substituted R_3 , R_4 , R_5 , and R_6 may form a ring, including the reaction of the corresponding ketone peroxide with the general formula (II)



wherein n, R₁, and R₂ have the identified meaning, with a
alkyl vinyl ether with the general formula (IIIa) or with
an acetal with the general formula (IIIb)

5



10 wherein R₃, R₄, R₅ and R₆ have the identified meaning, in
the presence of an acid catalyst.

2. A process as claimed in claim 1, wherein R₄ is
hydrogen.

15

3. A process as claimed in claim 1 or 2 wherein R₅
and/or R₆ are hydrogen.

4. A process as claimed in any one of claims 1 to 3
20 wherein the equivalent amount of the alkyl vinyl ether
(IIIa) or acetal (IIIb) is in the range of 1 to 5
equivalents of the ketone peroxide.

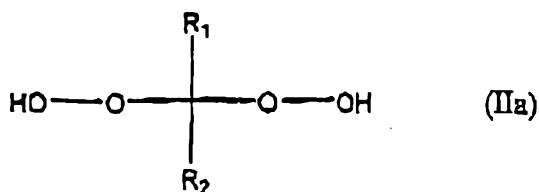
5. A process as claimed in claim 6 wherein the
25 equivalent amount of the alkyl vinyl ether (IIIa) or
acetal (IIIb) is in the range of 1.5 to 3.0 equivalents.

6. A process as claimed in claim 4 or 5 wherein the
equivalent amount of the alkyl vinyl ether (IIIa) or
30 acetal (IIIb) is in the range of 2.0 to 2.5 equivalents.

7. A process as claimed in any one of claims 1 to 6
wherein the ketone peroxide (II) is a mixture of the
ketone peroxide having the general formula IIa,

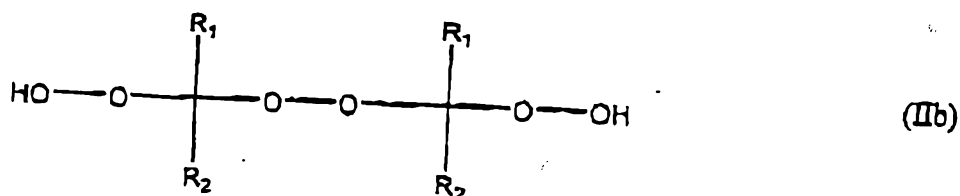
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and of the ketone peroxide with the general formula IIb



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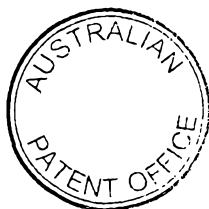
8. A process as claimed in any one of claims 1 to 5
15 wherein the ketone peroxide is derived from methylethyl
ketone, methylisopropyl ketone, methylisobutyl ketone,
acetone, cyclohexanone and/or 3,3,5-
trimethylcyclohexanone.

20 9. A process as claimed in claim 8 wherein the
ketone peroxide is derived from methylisobutyl ketone or
methylethyl ketone.

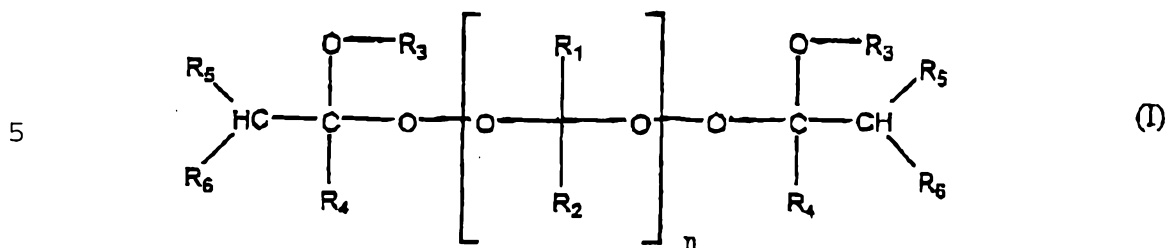
25 10. A process as claimed in any one of claims 1 to 9
wherein the alkyl vinyl ether (IIIa) is ethyl vinyl ether,
isobutyl vinyl ether, propyl vinyl ether or butyl vinyl
ether or the acetal (IIIb) is 2,2-dimethoxypropane, 2,2-
diethoxypropane, 1,1-dimethoxybutane, 2-propyl-1,3-
dioxolane, 1,1-dimethoxyethane, 1,1-diethoxyethane, 1,1-
30 diethoxypropane, or 1,1-dimethoxycyclohexane.

11. A process as claimed in claim 10 wherein the
alkyl vinyl ether (IIIa) is isobutyl vinyl ether.

35 12. A process as claimed in claim 10 wherein the
acetal (IIIb) is 1,1-dimethoxyethane.



13. A peroxide having the general formula (I)



10 wherein n , R_1 , R_2 , R_3 , R_4 , R_5 and R_6 have the identified meaning as given in any one of claims 1 to 12.

14. The use of a peroxide as claimed in claim 13 as a polymerization initiator, a curing agent for unsaturated polyester, and/or a modifying agent.

15

15. A formulation including a peroxide as claimed in claim 14, and a carrier or diluent.

16. A formulation as claimed in claim 15, including the peroxide in an amount of 1.0-99% by wt.

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17. A formulation as claimed in claim 16, including the peroxide in an amount of 10-90% by wt.

18. A formulation as claimed in claim 16, including the peroxide in an amount of 30-90% by wt.

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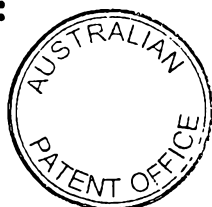
19. A formulation as claimed in claim 16, including the peroxide in an amount of 40-80% by wt

30

20. A formulation as claimed in any one of claims 15 to 19 wherein the carrier or diluent is a solid, liquid or paste.

21. A formulation as claimed in any one of claims 15 to 20 wherein the liquid is a polar solvent.

35



22. A formulation as claimed in any one of claims 15 to 21 having the form of a dispersion.

23. A formulation as claim 22 in which the dispersion
5 is a suspension or emulsion.

24. A process for the preparation of a peroxide,
substantially as herein before described with reference to
any one of the foregoing examples.
10

25. A peroxide, substantially as herein before
described with reference to any one of the foregoing
examples.

15 26. The use of a peroxide, substantially as herein
before described with reference to any one of the
foregoing examples.

20 27. A formulation, substantially as herein before
described with reference to any one of the foregoing
examples.

Dated this 11th day of June 2002

25 AKZO NOBEL N.V.

By their Patent Attorneys

GRIFFITH HACK

Fellows Institute of Patent and
Trade Mark Attorneys of Australia

