

DESCRIPTION

METHOD OF PRODUCING A MOLDED ARTICLE

5 Technical Field

The present invention relates to a method of producing a molded article which has high heat resistance at the time of molding, a good color and excellent transparency.

10 Background of the Art

Polycarbonate resin is a material which has relatively high heat resistance among polymer materials. However, many types of additives have been used in the polycarbonate resin to meet growing demand for high-function and

15 high-performance materials, thereby reducing the heat resistance of the resin containing such additives.

For example, an internal mold release agent is often added to polycarbonate resin in order to improve the releasability of a resin molded article from a metal mold
20 at the time of melt molding. However, when an effective amount of this internal mold release agent is added, the polycarbonate resin may be colored due to the decomposition of the release agent itself at the time of thermoforming or the induction of the deterioration of the polycarbonate resin
25 by the decomposed product of the release agent.

Patent Document 1 and Patent Document 2 teach that the heat resistance of polycarbonate resin is improved by adding a specific phosphorus-based heat stabilizer to the polycarbonate resin. Although the addition of these heat
30 stabilizers is effective in the improvement of the heat resistance of the polycarbonate, there is a case in which fully satisfactory heat resistance cannot be obtained even by adding a heat stabilizer. When a large amount of the heat stabilizer is used, the mechanical properties and hydrolytic

decomposition resistance of the polycarbonate resin may be deteriorated.

(Patent Document 1) JP-A 2001-081302

(Patent Document 2) JP-A 2001-192544

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Disclosure of the Invention

It is an object of the present invention to provide a method of producing a molded article having a good color and excellent transparency by improving the heat resistance of polycarbonate resin at the time of molding.

There have been proposed polycarbonate resin compositions comprising a heat stabilizer as disclosed by Patent Document 1 and Patent Document 2. The development of a new heat stabilizer is desired under the present situation where products are becoming diverse and at the same time, it is now important that the stabilization effect and other properties of existing stabilizers for use in resin compositions comprising a heat stabilizer should be improved as much as possible.

The inventors of the present invention have conducted intensive studies to attain the above object and have found that the heat resistance of polycarbonate resin at the time of molding is significantly improved by adding a small amount of a specific phosphonite-based compound as a heat stabilizer to the polycarbonate resin. They have also found that a melt molded article is colored and the color and transparency of the obtained molded article are greatly deteriorated when a specific amount or more of rust within a tank for blending and storing a polycarbonate resin granule is adhered to the granule. The present invention has been accomplished based on these findings.

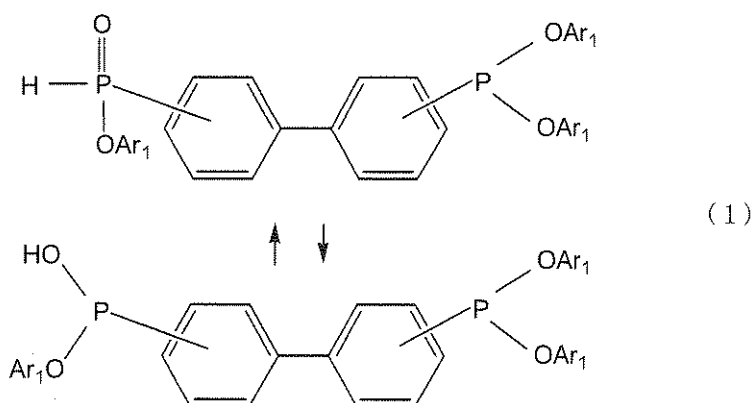
That is, according to the present invention, there are provided the following inventions.

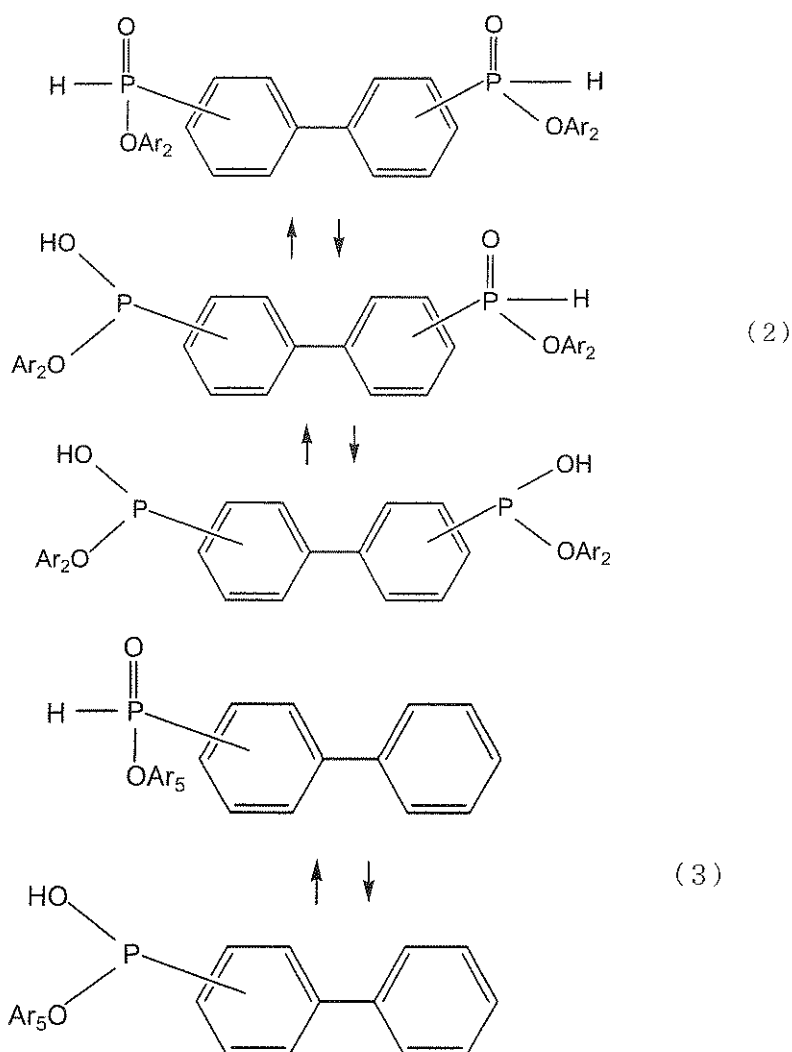
1. A method of producing a molded article by melting a

granule at a temperature of 280 to 380°C and molding it, wherein

the granule satisfies the following conditions (I) and (II):

- 5 (I) when 100 parts by weight of the granule is cleaned with 100 parts by weight of a 1N nitric acid aqueous solution, the amount of an Fe compound eluted into the 1N nitric acid aqueous solution cleaning fluid is 1 to 100 ppb in terms of the Fe atom based on
- 10 the granule; and
- (II) the granule comprises (A) 100 parts by weight of a polycarbonate resin (component a) and (B) 0.00010 to 0.5 part by weight of at least one phosphorus-based compound (component b) selected
- 15 from the group consisting of a phosphorus-based compound represented by the following formula (1) (component b-1), a phosphorus-based compound represented by the following formula (2) (component b-2) and a phosphorus-based compound represented by the following formula (3) (component b-3).
- 20



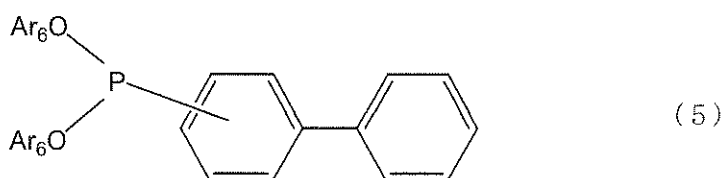
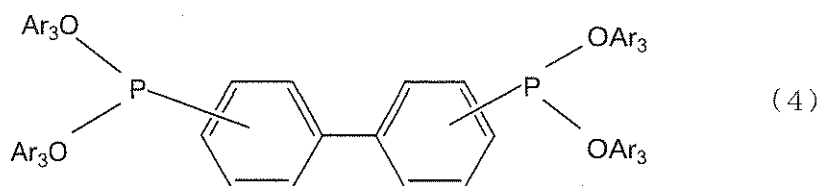


[wherein Ar_1 , Ar_2 and Ar_5 may be the same or different and are each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent.]

2. The production method according to the above paragraph 1, wherein the granule satisfies the following condition (III) in addition to the conditions (I) and (II):

(III) the granule comprises (A) the polycarbonate resin (component a), (B) the phosphorus-based compound represented by the formula (1) (component b-1), the phosphorus-based compound represented by the formula (2) (component b-2) and the phosphorus-based compound represented by the formula (3) (component b-3), and (C) a phosphorus-based compound represented by the following

formula (4) (component c-1) and a phosphorus-based compound represented by the following formula (5) (component c-2); and the total amount of the components b-1 to b-3 and the components c-1 and c-2 is 0.0005 to 0.5 part by weight based on 100 parts by weight of the component a, and the weight ratio (x/y) of the total amount (x parts by weight) of the components b-1 to b-3 to the total amount (y parts by weight) of the components c-1 and c-2 is 0.01 to 2.0.



[wherein Ar₃ and Ar₆ may be the same or different and are each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent.]

3. The production method according to the above paragraph 1 or 2, wherein the above component b-1 is
 4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
 4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
 3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite or
 3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite.

4. The production method according to any one of the above paragraphs 1 to 3, wherein the above component b-2 is
 4,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
 3,4'-bis(2,4-di-tert-butylphenyl)-biphenylene

diphosphonite or

3,3'-bis(2,4-di-tert-butylphenyl)-biphenylene
diphosphonite.

5. The production method according to any one of the above
5 paragraphs 1 to 4, wherein the above component b-3 is
2,4-di-tert-butylphenyl-4-phenyl-phenyl phosphonite or
2,4-di-tert-butylphenyl-3-phenyl-phenyl phosphonite.

6. The production method according to the above paragraph
2, wherein the above component c-1 is
10 tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene
diphosphonite,
tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene
diphosphonite or
tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene
15 diphosphonite.

7. The production method according to the above paragraph
2, wherein the above component c-2 is
bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl phosphonite
or bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl
20 phosphonite.

8. The method according to any one of the above paragraphs
1 to 7, wherein the molded article is an optical lens.

9. The method according to any one of the above paragraphs
1 to 8, wherein the molded article is a spectacle lens.

25 10. A method of preventing the coloring of a molded article
when a granule is molded, wherein

the granule satisfies the following conditions (I) and
(II):

(I) when 100 parts by weight of the granule is cleaned
30 with 100 parts by weight of a 1N nitric acid aqueous
solution, the amount of an Fe compound eluted into
the 1N nitric acid aqueous solution cleaning fluid
is 1 to 100 ppb in terms of the Fe atom based on
the granule; and

(II) the granule comprises (A) 100 parts by weight of a polycarbonate resin (component a) and (B) 0.00010 to 0.5 part by weight of at least one phosphorus-based compound (component b) selected from the group consisting of a phosphorus-based compound represented by the above formula (1) (component b-1), a phosphorus-based compound represented by the above formula (2) (component b-2) and a phosphorus-based compound represented by the above formula (3) (component b-3).

11. The production method according to the above paragraph 10, wherein the granule satisfies the following condition (III) in addition to the conditions (I) and (II):

(III) the granule comprises (A) the polycarbonate resin (component a), (B) the phosphorus-based compound represented by the above formula (1) (component b-1), the phosphorus-based compound represented by the above formula (2) (component b-2) and the phosphorus-based compound represented by the above formula (3) (component b-3), and (C) a phosphorus-based compound represented by the above formula (4) (component c-1) and a phosphorus-based compound represented by the above formula (5) (component c-2); and the total amount of the components b-1 to b-3 and the components c-1 and c-2 is 0.0005 to 0.5 part by weight based on 100 parts by weight of the component a, and the weight ratio (x/y) of the total amount (x parts by weight) of the components b-1 to b-3 to the total amount (y parts by weight) of the components c-1 and c-2 is 0.01 to 2.0.

12. The production method according to the above paragraph 10 or 11, wherein the above component b-1 is 4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite, 4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,

3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite or

3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite.

5 13. The production method according to any one of the above paragraphs 10 to 12, wherein the above component b-2 is 4,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,

3,4'-bis(2,4-di-tert-butylphenyl)-biphenylene

10 diphosphonite or

3,3'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite.

14. The production method according to any one of the above paragraphs 10 to 13, wherein the above component b-3 is

15 2,4-di-tert-butylphenyl-4-phenyl-phenyl phosphonite or 2,4-di-tert-butylphenyl-3-phenyl-phenyl phosphonite.

15. The production method according to any one of the above paragraphs 10 to 14, wherein the above component c-1 is tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene

20 diphosphonite,

tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene diphosphonite or

tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene diphosphonite.

25 16. The production method according to any one of the above paragraphs 10 to 15, wherein the above component c-2 is bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl phosphonite or bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl phosphonite.

30 17. The method according to any one of the above paragraphs 10 to 16, wherein the molded article is an optical lens.

18. The method according to any one of the above paragraphs 10 to 17, wherein the molded article is a spectacle lens.

Brief Description of the Drawings

Fig. 1 is a chart showing the HPLC measurement results of a phosphorus-based stabilizer A used in Comparative Examples of the present invention; and

5 Fig. 2 is a chart showing the HPLC measurement results of a phosphorus-based stabilizer B used in Examples of the present invention.

Explanation of letters or notations

- | | | |
|----|---|--|
| 10 | 1 | peak of component b-3 |
| | 2 | peak of component b-2 |
| | 3 | peak of component c-2 |
| | 4 | peak of component b-1 |
| | 5 | peak of tris(2,4-di-tert-butylphenyl)phosphite |
| 15 | | component |
| | 6 | peak of component c-1 |

Best Mode for Carrying out the Invention

The present invention will be described in detail
20 hereinunder.

(method of producing a molded article)

(polycarbonate resin (component a))

The granule used in the present invention comprises a polycarbonate resin (component a) as the main component.
25 The polycarbonate resin (may be simply referred to as "polycarbonate" hereinafter) is obtained by reacting a diphenol with a carbonate precursor. Examples of the reaction include interfacial polycondensation, melt ester interchange, the solid-phase ester interchange of a
30 carbonate prepolymer and the ring-opening polymerization of a cyclic carbonate compound.

Typical examples of the diphenol include dihydroxy compounds such as hydroquinone, resorcinol, 4,4'-dihydroxydiphenyl, 1,4-dihydroxynaphthalene,

bis(4-hydroxyphenyl)methane,
 bis{(4-hydroxy-3,5-dimethyl)phenyl}methane,
 1,1-bis(4-hydroxyphenyl)ethane,
 1,1-bis(4-hydroxyphenyl)-1-phenylethane,
 5 2,2-bis(4-hydroxyphenyl)propane (commonly known as
 "bisphenol A"),
 2,2-bis{(4-hydroxy-3-methyl)phenyl}propane,
 2,2-bis{(4-hydroxy-3,5-dimethyl)phenyl}propane,
 2,2-bis{(3,5-dibromo-4-hydroxy)phenyl}propane,
 10 2,2-bis{(3-isopropyl-4-hydroxy)phenyl}propane,
 2,2-bis{(4-hydroxy-3-phenyl)phenyl}propane,
 2,2-bis(4-hydroxyphenyl)butane,
 2,2-bis(4-hydroxyphenyl)-3-methylbutane,
 2,2-bis(4-hydroxyphenyl)-3,3-dimethylbutane,
 15 2,4-bis(4-hydroxyphenyl)-2-methylbutane,
 2,2-bis(4-hydroxyphenyl)pentane,
 2,2-bis(4-hydroxyphenyl)-4-methylpentane,
 1,1-bis(4-hydroxyphenyl)cyclohexane,
 1,1-bis(4-hydroxyphenyl)-4-isopropylcyclohexane,
 20 1,1-bis(4-hydroxyphenyl)-3,3,5-trimethylcyclohexane,
 9,9-bis(4-hydroxyphenyl)fluorene,
 9,9-bis{(4-hydroxy-3-methyl)phenyl}fluorene,
 α,α' -bis(4-hydroxyphenyl)-o-diisopropylbenzene,
 α,α' -bis(4-hydroxyphenyl)-m-diisopropylbenzene,
 25 α,α' -bis(4-hydroxyphenyl)-p-diisopropylbenzene,
 1,3-bis(4-hydroxyphenyl)-5,7-dimethyladamantane,
 4,4'-dihydroxydiphenyl sulfone, 4,4'-dihydroxydiphenyl
 sulfoxide, 4,4'-dihydroxydiphenyl sulfide,
 4,4'-dihydroxydiphenyl ketone, 4,4'-dihydroxydiphenyl
 30 ether and 4,4'-dihydroxydiphenyl ester. These diphenols
 may be used alone or in combination of two or more.

Out of the above diphenols,
 2,2-bis(4-hydroxyphenyl)propane (bisphenol A) is preferred
 as the main diphenol component. More specifically, the

content of bisphenol A is not less than 50 mol%, preferably not less than 70 mol%, more preferably not less than 80 mol% based on the total of all the diphenol components. An aromatic polycarbonate resin comprising a diphenol component
5 substantially composed of bisphenol A is particularly preferred.

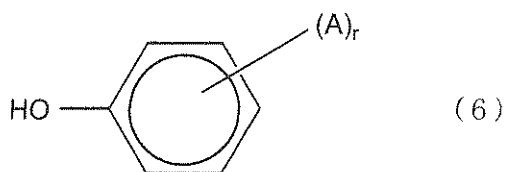
The carbonate precursor is a carbonyl halide, carbonate ester or haloformate, as exemplified by phosgene, diphenyl carbonate and dihaloformates of a diphenol.

10 For the manufacture of the polycarbonate resin from a diphenol and a carbonate precursor by an interfacial polymerization or melt process, one or more diphenols may be used, and a catalyst, a terminal capping agent and an antioxidant for diphenols may be optionally used. The
15 polycarbonate resin may be a branched polycarbonate resin obtained by copolymerizing a polyfunctional aromatic compound having 3 or more aromatic groups. It may be a mixture of two or more polycarbonate resins.

The reaction by the interfacial polymerization process
20 is generally a reaction between a diphenol and phosgene in the presence of an acid binder and an organic solvent. Examples of the acid binder include alkali metal hydroxides such as sodium hydroxide and potassium hydroxide, and amine compounds such as pyridine. Examples of the organic solvent
25 include halogenated hydrocarbons such as methylene chloride and chlorobenzene. A catalyst such as a tertiary amine or quaternary ammonium salt may be used to promote the reaction. The reaction temperature is generally 0 to 40°C, and the reaction time is several minutes to 5 hours.

30 In the polymerization reaction, a monofunctional phenol may be used as a terminal capping agent. When phosgene is used as the carbonate precursor in the reaction, a monofunctional phenol is generally used as a terminal capping agent to control the molecular weight. The obtained

polycarbonate resin is superior in heat stability to a polycarbonate resin whose terminals are not capped by a group derived from a monofunctional phenol. The monofunctional phenol is generally phenol or a lower alkyl-substituted phenol which is a monofunctional phenol represented by the following formula (6) as long as it is used as a terminal capping agent for polycarbonates.



[wherein A is a hydrogen atom, alkyl group having 1 to 9 carbon atoms or phenylalkyl group having 6 to 15 carbon atoms, and r is an integer of 1 to 5, preferably 1 to 3.]

Examples of the monofunctional phenol include phenol, p-tert-butylphenol, p-cumylphenol and isooctylphenol.

An organic solvent solution of the polycarbonate resin obtained by the above interfacial polycondensation process is generally washed in water. This washing step is carried out by using water having an electric conductivity of 10 $\mu\text{S}/\text{cm}$ or less, more preferably 1 $\mu\text{S}/\text{cm}$ or less, such as ion exchange water. The above organic solvent solution and water are mixed together, stirred and divided into an organic solvent solution phase and a water phase by standing or using a centrifugal separator to extract the organic solvent solution phase repeatedly so as to remove water-soluble impurities. The water-soluble impurities are removed efficiently by washing in high-purity water, whereby the color of the obtained polycarbonate resin becomes good.

It is also preferred that the organic solvent solution of the polycarbonate resin should be washed with an acid or alkali to remove impurities such as the catalyst.

It is further preferred that foreign matter which is an insoluble impurity should be removed from the organic

solvent solution. To remove this foreign matter, the organic solvent solution is preferably filtered or processed by a centrifugal separator.

5 The solvent is then removed from the organic solvent solution which has been washed in water to obtain a granule of the polycarbonate resin.

To obtain the granule (granulation step), a method of producing slurry by continuously supplying the organic solvent solution of the polycarbonate into a granulator in
10 which a granule and hot water (about 65 to 90°C) are existent under agitation to evaporate the solvent is preferably employed as it is simple in operation and post-treatment. A mixer such as an agitation tank or kneader is used as the granulator. The produced slurry is continuously discharged
15 from the upper or lower part of the granulator.

The discharged slurry may be then subjected to a hydrothermal treatment. In the hydrothermal treatment step, the organic solvent contained in the slurry is removed by supplying the slurry into a hydrothermal treatment container
20 filled with 90 to 100°C hot water or setting the temperature of water to 90 to 100°C by blowing steam after the slurry is supplied.

Water and the organic solvent are preferably removed from the slurry discharged from the granulating step or the
25 slurry after the hydrothermal treatment by filtration or centrifugation, and then the slurry is dried to obtain a granule (powder or flake).

The drier may be of conduction heating system or hot air heating system, and the granule may be left to stand,
30 transferred or stirred. A groove type or cylindrical drier which employs conduction heating system to stir the granule is preferred, and a groove type drier is particularly preferred. The drying temperature is preferably in the range of 130 to 150°C. The granule obtained after drying can be

pelletized by a melt extruder. This pellet is to be molded.

The reaction by the melt process is generally an ester interchange reaction between a diphenol and a diphenyl carbonate. The diphenol and the diphenyl carbonate are mixed
 5 together in the presence of an inert gas to be reacted with each other under reduced pressure at 120 to 350°C in most cases. The degree of pressure is changed stepwise and reduced to 1.3×10^2 Pa or less in the end to remove the formed phenol to the outside of the system. The reaction time is
 10 generally about 1 to 4 hours.

The molten polycarbonate resin obtained by the melt ester interchange process can be pelletized by a melt extruder. This pellet is to be molded.

The molecular weight of the polycarbonate resin
 15 (component a) in the present invention is preferably 1.0×10^4 to 5.0×10^4 , more preferably 1.4×10^4 to 3.5×10^4 in terms of viscosity average molecular weight (M). The polycarbonate resin having the above viscosity average molecular weight is preferred because a molded article
 20 obtained from the polycarbonate resin has certain mechanical strength while maintaining relatively high fluidity at the time of extrusion and molding.

The viscosity average molecular weight in the present invention is M obtained by inserting the specific viscosity
 25 (η_{sp}) of a solution prepared by dissolving 0.7 g of the polycarbonate in 100 ml of methylene chloride at 20°C into the following equation.

$$\eta_{sp}/c = [\eta] + 0.45 \times [\eta]^2 c \quad ([\eta] \text{ represents an intrinsic viscosity})$$

$$30 \quad [\eta] = 1.23 \times 10^{-4} M^{0.83}$$

$$c = 0.7$$

The viscosity average molecular weight of the granule can be measured by the following procedure. That is, the granule is dissolved in methylene chloride in a weight ratio

of 1:20 to 1:30, soluble matter is collected by cerite filtration, the solvent is removed, and the soluble matter is fully dried so as to obtain a methylene chloride-soluble solid. 0.7 g of the solid is dissolved in 100 ml of methylene chloride to measure the specific viscosity (η_{sp}) of the obtained solution at 20°C with an Ostwald viscometer so as to calculate its viscosity average molecular weight (M) from the above equation.

The granule may be in the form of a powder, pellet or flake. The pellet may have an ordinary shape such as columnar, prismatic or spherical shape but preferably a columnar shape. The diameter of the column is preferably 1 to 5 mm, more preferably 1.5 to 4 mm, much more preferably 2 to 3.3 mm. The length of the column is preferably 1 to 30 mm, more preferably 2 to 5 mm, much more preferably 2.5 to 3.5 mm.

The OH terminal amount of the polycarbonate resin preferably used in the present invention is preferably 1 to 5,000 ppm, more preferably 5 to 2,000 ppm, much more preferably 10 to 1,000 ppm in terms of the weight of the OH group.

(Fe compound)

In the present invention, the granule satisfies the following condition (I). That is, (I) when 100 parts by weight of the granule is cleaned with 100 parts by weight of a 1N nitric acid aqueous solution, the amount of an Fe compound eluted into the 1N nitric acid aqueous solution cleaning fluid is 1 to 100 ppb in terms of the Fe atom based on the granule.

The amount of the Fe compound is 1 to 100 ppb, preferably 1 to 50 ppb, more preferably 1 to 40 ppb, much more preferably 1 to 25 ppb, particularly preferably 1 to 10 ppb in terms of the Fe atom based on the granule. When the amount of the Fe compound in terms of the Fe atom is larger than 100 ppb,

the heat resistance degrades and the color of a molded article obtained by melt molding the granule tends to become worse disadvantageously.

The amount of the Fe compound can be measured by the following method. That is, a quartz glass conical flask and a quartz glass bar are cleaned with a 1N nitric acid aqueous solution in advance, and it is confirmed that the amount of an Fe component in the 1N nitric acid aqueous solution cleaning fluid is not more than 0.1 ppb. 100 parts by weight of the granule is then put into the inspected conical flask, and 100 parts by weight of a 1N nitric acid aqueous solution is added to the flask, stirred with the inspected glass bar for 1 minute, left to stand for 2 hours, stirred again for 1 minute and then left to stand to determine the amount of Fe by the ICP emission spectrometry of a liquid phase.

The amount of the Fe compound on the surface of the granule is increased by contact between the granule and a tank, container or pipe having a material such as stainless steel (SUS) containing Fe on the inner wall. An increase in the amount of the Fe compound adhered to the surface of the granule becomes significant when part of the inside of the tank, container or pipe rusts or when a welded part on the inner wall cracks.

The amount of the Fe compound adhered to the surface of the granule can be reduced by cleaning the granule with a nitric acid aqueous solution.

It is preferred that the granule should be stored or blended by using a storage tank or blend tank whose inner wall has been passivated. In this case, the amount of the Fe compound on the surface of the granule stored in the tank is measured on a regular basis so that a granule having the Fe compound adhered thereto in an amount larger than the reference value is not used in the manufacture of a molded article which requires a good color and transparency. A

granule having the Fe compound adhered thereto in an amount larger than the reference value may be mixed with a granule having a small amount of the Fe compound adhered thereto before molding. The granule to be molded in the present invention is characterized in that the amount of the Fe compound adhered to the surface of the granule falls within a specific range.

The present invention is a method of producing a molded article by melting a granule of a polycarbonate resin stored in a tank at a temperature of 280 to 380°C and molding it, wherein the granule is molded after it is confirmed that the granule satisfies the above condition (I).

(phosphorus-based compound (component b))

In the present invention, the granule satisfies the following condition (II). That is, (II) the granule contains (A) 100 parts by weight of the polycarbonate resin (component a) and (B) 0.00010 to 0.5 part by weight of at least one phosphorus-based compound (component b) selected from the group consisting of a phosphorus-based compound represented by the above formula (1) (component b-1), a phosphorus-based compound represented by the above formula (2) (component b-2) and a phosphorus-based compound represented by the above formula (3) (component b-3).

The above phosphorus-based compound (component b) is effective in improving molding heat resistance as a stabilizer for resins. The content of the component b is 0.00010 to 0.5 part by weight, preferably 0.001 to 0.3 part by weight, most preferably 0.003 to 0.1 part by weight based on 100 parts by weight of the polycarbonate resin (component a). When the content of the phosphorus-based compound is lower than 0.00010 part by weight, the molding heat resistance of the polycarbonate resin becomes unsatisfactory disadvantageously.

As for the phosphorus-based compound (component b), the phosphorus-based compounds of the above formulas (1), (2) and (3) are tautomers. The content of each of the tautomers may be arbitrary.

5 In the formulas (1), (2) and (3), Ar₁, Ar₂ and Ar₅ may be the same or different and are each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent. Examples of the aromatic ring in the aromatic hydrocarbon group include phenyl and naphthyl, out of which
10 phenyl is preferred. The alkyl substituent which may substitute the above aromatic ring is preferably an alkyl group having 1 to 10 carbon atoms such as methyl group, ethyl group, propyl group, isopropyl group, butyl group or tert-butyl group. Out of these, methyl group and tert-butyl
15 group are preferred, and tert-butyl group is particularly preferred.

Examples of the compound (component b-1) of the formula (1) include
4-bis(2,4-di-iso-propylphenyl)-4'-mono(2,4-di-iso-propyl
20 phenyl)-biphenylene diphosphonite,
4-bis(2,4-di-n-butylphenyl)-4'-mono(2,4-di-n-butylphenyl)-biphenylene diphosphonite,
4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
25 4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butyl
30 phenyl)-biphenylene diphosphonite,
4-bis(2,6-di-iso-propylphenyl)-4'-mono(2,6-di-iso-propylphenyl)-biphenylene diphosphonite,
4-bis(2,6-di-n-butylphenyl)-4'-mono(2,6-di-n-butylphenyl)-biphenylene diphosphonite,

- 4-bis(2,6-di-tert-butylphenyl)-4'-mono(2,6-di-tert-butylphenyl)-biphenylene diphosphonite,
 4-bis(2,6-di-tert-butylphenyl)-3'-mono(2,6-di-tert-butylphenyl)-biphenylene diphosphonite,
 5 3-bis(2,6-di-tert-butylphenyl)-4'-mono(2,6-di-tert-butylphenyl)-biphenylene diphosphonite,
 3-bis(2,6-di-tert-butylphenyl)-3'-mono(2,6-di-tert-butylphenyl)-biphenylene diphosphonite,
 4-bis(2,4-di-tert-butyl-5-methylphenyl)-4'-mono(2,4-di-
 10 tert-butyl-5-methylphenyl)-biphenylene diphosphonite,
 4-bis(2,4-di-tert-butyl-5-methylphenyl)-3'-mono(2,4-di-tert-butyl-5-methylphenyl)-biphenylene diphosphonite,
 3-bis(2,4-di-tert-butyl-5-methylphenyl)-4'-mono(2,4-di-tert-butyl-5-methylphenyl)-biphenylene diphosphonite and
 15 3-bis(2,4-di-tert-butyl-5-methylphenyl)-3'-mono(2,4-di-tert-butyl-5-methylphenyl)-biphenylene diphosphonite.

Out of these, tris(di-tert-butylphenyl)-biphenylene diphosphonites are preferred, and
 tris(2,4-di-tert-butylphenyl)-biphenylene diphosphonites
 20 are more preferred. More specifically, the
 tris(2,4-di-tert-butylphenyl)-biphenylene diphosphonites are preferably
 4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
 25 4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
 3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite and
 3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butyl
 30 phenyl)-biphenylene diphosphonite.

Examples of the compound (component b-2) of the formula (2) include 4,4'-bis(2,4-di-iso-propylphenyl)-biphenylene diphosphonite, 4,4'-bis(2,4-di-n-butylphenyl)-biphenylene diphosphonite,

- 4,4'-bis(2,4-di-tert-butylphenyl)-biphenylene
diphosphonite,
3,4'-bis(2,4-di-tert-butylphenyl)-biphenylene
diphosphonite,
5 3,3'-bis(2,4-di-tert-butylphenyl)-biphenylene
diphosphonite,
4,4'-bis(2,6-di-iso-propylphenyl)-biphenylene
diphosphonite, 4,4'-bis(2,6-di-n-butylphenyl)-biphenylene
diphosphonite,
10 4,4'-bis(2,6-di-tert-butylphenyl)-biphenylene
diphosphonite,
3,4'-bis(2,6-di-tert-butylphenyl)-biphenylene
diphosphonite,
3,3'-bis(2,6-di-tert-butylphenyl)-biphenylene
15 diphosphonite,
4,4'-bis(2,4-di-tert-butyl-5-methylphenyl)-biphenylene
diphosphonite,
3,4'-bis(2,4-di-tert-butyl-5-methylphenyl)-biphenylene
diphosphonite and
20 3,3'-bis(2,4-di-tert-butyl-5-methylphenyl)-biphenylene
diphosphonite.

Examples of the compound (component b-3) of the formula
(3) include 2,4-di-iso-propylphenyl-4-phenyl-phenyl
phosphonite, 2,4-di-n-butylphenyl-3-phenyl-phenyl
25 phosphonite, 2,4-di-tert-butylphenyl-4-phenyl-phenyl
phosphonite, 2,4-di-tert-butylphenyl-3-phenyl-phenyl
phosphonite, 2,6-di-iso-propylphenyl-4-phenyl-phenyl
phosphonite, 2,6-di-n-butylphenyl-3-phenyl-phenyl
phosphonite, 2,6-di-tert-butylphenyl-4-phenyl-phenyl
30 phosphonite, 2,6-di-tert-butylphenyl-3-phenyl-phenyl
phosphonite and
2,4-di-tert-butyl-5-methylphenyl-3-phenyl-phenyl
phosphonite.

Out of these, (di-tert-butylphenyl)-phenyl-phenyl

phosphonites are preferred, and
(2,4-di-tert-butylphenyl)-phenyl-phenyl phosphonites are particularly preferred. More specifically,
2,4-di-tert-butylphenyl-4-phenyl-phenyl phosphonite and
5 2,4-di-tert-butylphenyl-3-phenyl-phenyl phosphonite are preferred.

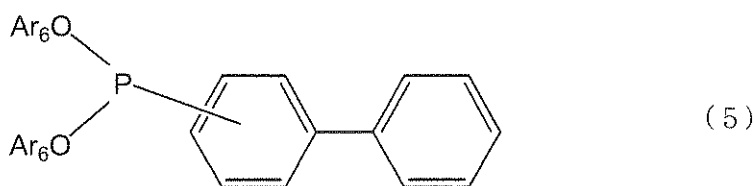
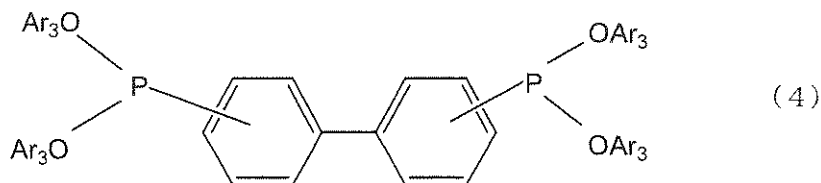
(phosphorus-based compound (component c))

In the present invention, the phosphorus-based
10 compound used as the above component b can be obtained by hydrolyzing the phosphorus-based compound (component c) of the formula (4) or (5). That is, the phosphorus-based compound (component b-1) of the formula (1) and the phosphorus-based compound (component b-2) of the formula (2)
15 can be obtained by hydrolyzing the phosphorus-based compound (component c-1) of the formula (4). The phosphorus-based compound (component b-3) of the formula (3) can be obtained by hydrolyzing the phosphorus-based compound (component c-1) of the formula (5).

20 Therefore, the granule preferably satisfies the following condition (III) in addition to the conditions (I) and (II).

That is, (III) the granule contains (A) the polycarbonate resin (component a), (B) the phosphorus-based
25 compound represented by the formula (1) (component b-1), the phosphorus-based compound represented by the formula (2) (component b-2) and the phosphorus-based compound represented by the formula (3) (component b-3) and (C) a phosphorus-based compound represented by the following
30 formula (4) (component c-1) and a phosphorus-based compound represented by the following formula (5) (component c-2), the total amount of the components b-1 to b-3 and c-1 and c-2 being preferably 0.0005 to 0.5 part by weight based on 100 parts by weight of the component a, and the weight ratio

(x/y) of the total amount (x parts by weight) of the components b-1 to b-3 to the total amount (y parts by weight) of the components c-1 and c-2 being preferably 0.01 to 2.0.



5

In the formulas (4) and (5), Ar_3 and Ar_6 may be the same or different and are each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent. Examples of the aromatic ring in the aromatic hydrocarbon group include phenyl and naphthyl, out of which phenyl is preferred. The alkyl substituent which may substitute the aromatic ring is preferably an alkyl group having 1 to 10 carbon atoms such as methyl group, ethyl group, propyl group, isopropyl group, butyl group and tert-butyl group. Out of these, methyl group and tert-butyl group are preferred, and tert-butyl group is particularly preferred.

Examples of the compound (component c-1) of the formula (4) include

tetrakis(2,4-di-iso-propylphenyl)-4,4'-biphenylene diphosphonite,

tetrakis(2,4-di-n-butylphenyl)-4,4'-biphenylene diphosphonite,

tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene diphosphonite,

tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene diphosphonite,

tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene diphosphonite,

- tetrakis(2,6-di-iso-propylphenyl)-4,4'-biphenylene
diphosphonite,
tetrakis(2,6-di-n-butylphenyl)-4,4'-biphenylene
diphosphonite,
5 tetrakis(2,6-di-tert-butylphenyl)-4,4'-biphenylene
diphosphonite,
tetrakis(2,6-di-tert-butylphenyl)-4,3'-biphenylene
diphosphonite,
tetrakis(2,6-di-tert-butylphenyl)-3,3'-biphenylene
10 diphosphonite,
tetrakis(2,4-di-tert-butyl-5-methylphenyl)-4,4'-
biphenylene diphosphonite,
tetrakis(2,4-di-tert-butyl-5-methylphenyl)-4,3'-
biphenylene diphosphonite and
15 tetrakis(2,4-di-tert-butyl-5-methylphenyl)-3,3'-
biphenylene diphosphonite.

- Out of these,
tetrakis(di-tert-butylphenyl)-biphenylene diphosphonites
are preferred, and
20 tetrakis(2,4-di-tert-butylphenyl)-biphenylene
diphosphonites are more preferred. More specifically, the
tetrakis(2,4-di-tert-butylphenyl)-biphenylene
diphosphonites are preferably
tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene
25 diphosphonite,
tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene
diphosphonite and
tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene
diphosphonite. These compounds may be used in combination
30 of two or more.

Examples of the compound (component c-2) of the formula
(5) include bis(2,4-di-iso-propylphenyl)-4-phenyl-phenyl
phosphonite, bis(2,4-di-n-butylphenyl)-3-phenyl-phenyl
phosphonite, bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl

phosphonite, bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl
 phosphonite, bis(2,6-di-iso-propylphenyl)-4-phenyl-phenyl
 phosphonite, bis(2,6-di-n-butylphenyl)-3-phenyl-phenyl
 phosphonite, bis(2,6-di-tert-butylphenyl)-4-phenyl-phenyl
 5 phosphonite, bis(2,6-di-tert-butylphenyl)-3-phenyl-phenyl
 phosphonite and
 bis(2,4-di-tert-butyl-5-methylphenyl)-3-phenyl-phenyl
 phosphonite.

Out of these, bis(di-tert-butylphenyl)-phenyl-phenyl
 10 phosphonites are preferred, and
 bis(2,4-di-tert-butylphenyl)-phenyl-phenyl phosphonites
 are more preferred. More specifically, the
 bis(2,4-di-tert-butylphenyl)-phenyl-phenyl phosphonites
 are preferably
 15 bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl phosphonite
 and bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl
 phosphonite. These compounds may be used in combination of
 two or more.

When the above phosphorus-based compound (component
 20 b) is to be mixed with the polycarbonate resin (component
 a), a phosphorus-based compound obtained by hydrolyzing a
 phosphorus-based compound containing a mixture of the
 components c-1 and c-2 can be preferably used.

In this case, the phosphorus-based compound to be mixed
 25 with the polycarbonate resin (component a) is a
 phosphorus-based compound which contains components b and
 c. In this phosphorus-based compound, the weight ratio (x/y)
 of the total amount (x parts by weight) of the components
 b-1 to b-3 to the total amount (y parts by weight) of the
 30 components c-1 and c-2 is preferably 0.01 to 2.0, more
 preferably 0.03 to 1.8. This phosphorus-based compound is
 mixed to ensure that the total amount of the components b-1
 to b-3 and the components c-1 and c-2 becomes 0.0005 to 0.5
 part by weight, preferably 0.001 to 0.3 part by weight, more

preferably 0.003 to 0.2 part by weight based on 100 parts by weight of the polycarbonate resin (component a). When the content of the phosphorus-based compound is lower than 0.0005 part by weight, the molding heat resistance of the polycarbonate resin becomes unsatisfactory disadvantageously. Even when the content of the phosphorus-based compound is higher than 0.5 part by weight, it does not have a bad effect on the characteristic properties of the polycarbonate resin but the phosphorus-based compound is fused and solidified by the absorption of moisture with the result of reduced handling ease.

(another phosphorus-based compound)

In the present invention, a phosphorus-based compound except for the above components b and the above components c may be mixed with the polycarbonate resin (component a) as a heat stabilizer. Examples of the phosphorus-based compound include tris(dialkyl-substituted phenyl)phosphites such as tris(dimethylphenyl)phosphite, tris(diethylphenyl)phosphite, tris(di-iso-propylphenyl)phosphite, tris(di-n-butylphenyl)phosphite, tris(2,4-di-tert-butylphenyl)phosphite, tris(2,6-di-tert-butylphenyl)phosphite and tris(2,4-di-tert-butyl-5-methylphenyl)phosphite. Bis(2,6-di-tert-butyl-4-methylphenyl)pentaerythritol diphosphite, 2,2-methylenebis(4,6-di-tert-butylphenyl)octyl phosphite, bis(nonylphenyl)pentaerythritol diphosphite, bis(2,4-di-tert-butylphenyl)pentaerythritol diphosphite, distearyl pentaerythritol diphosphite, tributyl phosphate, triethyl phosphate, trimethyl phosphate, triphenyl phosphate, diphenyl monoorthoxenyl phosphate, dibutyl phosphate, dioctyl phosphate, diisopropyl phosphate,

dimethyl benzenephosphonate, diethyl benzenephosphonate and dipropyl benzenephosphonate are also included in the above examples.

Out of these, tris(di-tert-butylphenyl)phosphites are preferred, and tris(2,4-di-tert-butylphenyl)phosphite is particularly preferred. These phosphorus-based compounds may be used alone or in combination of two or more. The phosphorus-based compound is used in an amount of preferably 0.0005 to 0.2 part by weight, more preferably 0.005 to 0.1 part by weight based on 100 parts by weight of the polycarbonate resin (component a).

(release agent)

In the present invention, an internal mold release agent may be mixed with the polycarbonate resin to improve the releasability from a metal mold of a resin molded article at the time of melt molding. Preferably, the internal mold release agent comprises not less than 90 wt% of an ester of an alcohol and a fatty acid. The ester of an alcohol and a fatty acid is, for example, an ester of a monohydric alcohol and a fatty acid and/or a partial or whole ester of a polyhydric alcohol and a fatty acid. The ester of a monohydric alcohol and a fatty acid is preferably an ester of a monohydric alcohol having 1 to 20 carbon atoms and a saturated fatty acid having 10 to 30 carbon atoms. The partial or whole ester of a polyhydric alcohol and a fatty acid is preferably a partial or whole ester of a polyhydric alcohol having 1 to 25 carbon atoms and a saturated fatty acid having 10 to 30 carbon atoms.

Examples of the ester of a monohydric alcohol and a saturated fatty acid include stearyl stearate, palmityl palmitate, butyl stearate, methyl laurate and isopropyl palmitate, out of which stearyl stearate is preferred.

Examples of the partial or whole ester of a polyhydric

alcohol and a saturated fatty acid include monoglyceride stearate, diglyceride stearate, triglyceride stearate, monosorbitate stearate, monoglyceride behenate, pentaerythritol monostearate, pentaerythritol

5 tetrastearate, pentaerythritol tetrapelargonate, propylene glycol monostearate, biphenyl biphenate, sorbitan monostearate, 2-ethylhexyl stearate and a partial or whole ester of a dipentaerythritol such as dipentaerythritol hexastearate.

10 Out of these esters, monoglyceride stearate, triglyceride stearate, pentaerythritol tetrastearate and a mixture of triglyceride stearate and stearyl stearate are preferred. Monoglyceride stearate is particularly preferred.

15 The content of the above ester in the internal mold release agent is not less than 90 wt%, more preferably not less than 95 wt% based on 100 wt% of the internal mold release agent.

The acid value of the above fatty acid ester is
20 preferably not more than 3, more preferably not more than 2. Monoglyceride stearate preferably has an acid value of not more than 1.5 and a purity of not less than 95 wt%, particularly preferably an acid value of not more than 1.2 and a purity of not less than 98 wt%. The acid value of the
25 fatty acid ester can be measured by a known method.

Examples of the internal mold release agent except for the above esters include olefin-based wax, olefin-based waxes containing a carboxyl group and/or a carboxylic anhydride group, silicone oil, organopolysiloxane, paraffin
30 wax and bees wax.

The content of the internal mold release agent in the polycarbonate resin is preferably 0.001 to 1.0 part by weight, more preferably 0.01 to 0.6 part by weight, most preferably 0.1 to 0.5 part by weight based on 100 parts by weight of

the polycarbonate resin.

(ultraviolet absorbent)

The granule may contain an ultraviolet absorbent. At
 5 least one any known ultraviolet absorbent may be selected.
 The ultraviolet absorbent is selected from a
 benzotriazole-based ultraviolet absorbent,
 benzophenone-based ultraviolet absorbent and
 triazine-based ultraviolet absorbent. Out of these, a
 10 benzotriazole-based ultraviolet absorbent is particularly
 preferred because it produces an effect such as the molding
 heat resistance of the polycarbonate resin more effectively.

The amount of the ultraviolet absorbent is preferably
 0.01 to 1.5 parts by weight, more preferably 0.05 to 0.7 part
 15 by weight, much more preferably 0.1 to 0.5 part by weight
 based on 100 parts by weight of the polycarbonate resin.
 Within the above range, the effects of the phosphorus-based
 compounds in the present invention are fully obtained, the
 object of the present invention can be attained, and
 20 satisfactory weatherability is provided to the polycarbonate
 resin advantageously.

Examples of the benzotriazole-based ultraviolet
 absorbent include

2-(2-hydroxy-5-methylphenyl)benzotriazole,
 25 2-(2-hydroxy-5-tert-octylphenyl)benzotriazole,
 2-(2-hydroxy-3,5-dicumylphenyl)phenylbenzotriazole,
 2-(2-hydroxy-3-tert-butyl-5-methylphenyl)-5-
 chlorobenzotriazole,
 2,2'-methylenebis[4-(1,1,3,3-tetramethylbutyl)-6-(2N-
 30 benzotriazol-2-yl)phenol],
 2-(2-hydroxy-3,5-di-tert-butylphenyl)benzotriazole,
 2-(2-hydroxy-3,5-di-tert-butylphenyl)-5-chlorobenzo
 triazole,
 2-(2-hydroxy-3,5-di-tert-amylphenyl)benzotriazole,

2-(2-hydroxy-5-tert-octylphenyl)benzotriazole,
 2-(2-hydroxy-5-tert-butylphenyl)benzotriazole,
 2-(2-hydroxy-4-octoxyphenyl)benzotriazole,
 2,2'-methylenebis(4-cumyl-6-benzotriazolephenyl),
 5 2,2'-p-phenylenebis(1,3-benzoxazin-4-one) and
 2-[2-hydroxy-3-(3,4,5,6-tetrahydrophthalimidomethyl)-5-methylphenyl]benzotriazole. They may be used alone or in combination of two or more.

2-(2-hydroxy-5-methylphenyl)benzotriazole,
 10 2-(2-hydroxy-5-tert-octylphenyl)benzotriazole,
 2-(2-hydroxy-3,5-dicumylphenyl)phenylbenzotriazole,
 2-(2-hydroxy-3-tert-butyl-5-methylphenyl)-5-chlorobenzotriazole,
 2,2'-methylenebis[4-(1,1,3,3-tetramethylbutyl)-6-(2H-
 15 benzotriazol-2-yl)phenol] and
 2-[2-hydroxy-3-(3,4,5,6-tetrahydrophthalimidomethyl)-5-methylphenyl]benzotriazole are preferred, and
 2-(2-hydroxy-5-tert-octylphenyl)benzotriazole and
 2,2'-methylenebis[4-(1,1,3,3-tetramethylbutyl)-6-(2H-
 20 benzotriazol-2-yl)phenol] are more preferred.
 2-(2-hydroxy-5-tert-octylphenyl)benzotriazole is particularly preferred.

The benzotriazole-based ultraviolet absorbent has a drying loss of preferably not more than 0.5 wt%, more
 25 preferably not more than 0.1 wt%, particularly preferably not more than 0.03 wt% when it is dried at 105°C for 2 hours. The benzotriazole-based ultraviolet absorbent has a 500 nm dissolution color (light transmittance of a 1 cm cell obtained by dissolving 5 g of the ultraviolet absorbent in
 30 100 ml of toluene) of preferably not less than 95 %, more preferably not less than 98 %, particularly preferably not less than 99 %.

Examples of the benzophenone-based ultraviolet absorbent include 2,4-dihydroxybenzophenone,

2-hydroxy-4-methoxybenzophenone,
 2-hydroxy-4-octoxybenzophenone,
 2-hydroxy-4-benzyloxybenzophenone,
 2-hydroxy-4-methoxy-5-sulfoxybenzophenone,
 5 2-hydroxy-4-methoxy-5-sulfoxytrihydride benzophenone,
 2,2'-dihydroxy-4-methoxybenzophenone,
 2,2',4,4'-tetrahydroxybenzophenone,
 2,2'-dihydroxy-4,4'-dimethoxybenzophenone,
 2,2'-dihydroxy-4,4'-dimethoxy-5-sodium
 10 sulfoxybenzophenone,
 bis(5-benzoyl-4-hydroxy-2-methoxyphenyl)methane,
 2-hydroxy-4-n-dodecyloxybenzophenone and
 2-hydroxy-4-methoxy-2'-carboxybenzophenone.

Examples of the triazine-based ultraviolet absorbent
 15 include
 2-(4,6-diphenyl-1,3,5-triazin-2-yl)-5-[(hexyl)oxy]-
 phenol, and
 2-(4,6-bis(2,4-dimethylphenyl)-1,3,5-triazin-2-yl)-5-
 [(octyl)oxy]-phenol.

20 (hindered phenol-based stabilizer)

The granule may contain a hindered phenol-based
 stabilizer as long as the object of the present invention
 is not impaired.

25 Examples of the hindered phenol-based stabilizer
 include pentaerythritol
 tetrakis[3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate],
 thiodiethylenebis[3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 30 propionate],
 octadecyl-3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate, 3,5-bis(1,1-dimethylethyl)-4-hydroxyalkyl
 ester benzenepropanoates (the alkyl has a side chain with
 7 to 9 carbon atoms),

2,4-dimethyl-6-(1-methylpentadecyl)phenol,
 3,3',3'',5,5',5''-hexa-tert-butyl-a,a',a''-(mesitylene-2,4,
 6-toluy)tri-p-cresol,
 ethylenebis(oxyethylene)bis[3-(5-tert-butyl-4-hydroxy-m-
 5 tolyl)propionate],
 hexamethylenebis[3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate and
 1,3,5-tris(3,5-di-tert-butyl-4-hydroxybenzyl)-1,3,5-
 triazine-2,4,6(1H,3H,5H)-trione. Out of these,
 10 pentaerythritol
 tetrakis[3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate] and
 octadecyl-3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate are preferred.

15 The amount of the hindered phenol-based stabilizer is
 preferably 0.015 to 0.15 part by weight, more preferably 0.03
 to 0.08 part by weight based on 100 parts by weight of the
 polycarbonate resin.

20 (antioxidant)

 The granule may contain an antioxidant to prevent its
 oxidation. Examples of the antioxidant include
 pentaerythritol tetrakis(3-mercaptopropionate),
 pentaerythritol tetrakis(3-laurylthiopropionate),
 25 glycerol-3-stearyl thiopropionate, triethylene
 glycol-bis[3-(3-tert-butyl-5-methyl-4-hydroxyphenyl)
 propionate],
 1,6-hexanediol-bis[3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate],
 30 pentaerythritol-tetrakis[3-(3,5-di-tert-butyl-4-
 hydroxyphenyl)propionate],
 octadecyl-3-(3,5-di-tert-butyl-4-hydroxyphenyl)
 propionate,
 1,3,5-trimethyl-2,4,6-tris(3,5-di-tert-butyl-4-

hydroxybenzyl)benzene,

N,N-hexamethylenebis(3,5-di-tert-butyl-4-hydroxy-hydrocinnamide),

3,5-di-tert-butyl-4-hydroxy-benzylphosphonate-diethyl
5 ester,

tris(3,5-di-tert-butyl-4-hydroxybenzyl)isocyanurate,

tetrakis(2,4-di-tert-butylphenyl) 4,4'-biphenylene

diphosphinate and 3,9-bis{1,1-dimethyl-2-[β -

(3-tert-butyl-4-hydroxy-5-methylphenyl)propionyloxy]

10 ethyl}-2,4,8,10-tetraoxaspiro(5,5)undecane. The amount of the antioxidant is preferably 0.001 to 0.05 part by weight based on 100 parts by weight of the polycarbonate resin.

(antistatic agent)

15 The granule may contain an antistatic agent. Examples of the antistatic agent include polyether ester amides, ammonium salts of dodecylbenzenesulfonic acid, phosphonium salts of dodecylbenzenesulfonic acid, monoglyceride maleic anhydride, diglyceride maleic anhydride, carbon, graphite
20 and metal powders. Further, "partial esters of a polyhydric alcohol and a saturated fatty acid" such as glycerin monostearate are also included in the above examples. The polyhydric alcohol and the fatty acid may have a low molecular weight or a high molecular weight, and an aromatic ring may
25 be partially introduced into these. Not only an alcohol moiety but also a fatty acid moiety may have a branch structure. The amount of the antistatic agent is preferably 0.1 to 10 parts by weight based on 100 parts by weight of the polycarbonate resin.

30

(bluing agent)

The granule may contain a bluing agent as long as the object of the present invention is not impaired. The bluing agent is effective in erasing the yellow tinge of the resin

composition. Since a composition provided with weatherability contains a predetermined amount of an ultraviolet absorbent, a resin product is apt to be tinged with yellow according to "the function and color of the ultraviolet absorbent". To provide natural transparency to a sheet or lens product in particular, use of the bluing agent is very effective. The amount of the bluing agent is preferably 0.05 to 1.5 ppm, more preferably 0.1 to 1.2 ppm based on the granule. Typical examples of the bluing agent include the Macrolex Violet and Terasol Blue RLS of Bayer Co., Ltd. However, the bluing agent is not particularly limited.

(flame retardant)

The granule may contain a flame retardant in limits that do not impair the object of the present invention. Examples of the flame retardant include polycarbonate-based flame retardants of halogenated bisphenol A, organic salt-based flame retardants, halogenated aromatic phosphate-based flame retardants and aromatic phosphate-based flame retardants. The granule may contain at least one of them.

The polycarbonate-based flame retardants of halogenated bisphenol A include polycarbonate type flame retardants of tetrabromobisphenol A and copolycarbonate type flame retardants of tetrabromobisphenol A and bisphenol A.

The organic salt-based flame retardants include dipotassium diphenylsulfone-3,3'-disulfonate, potassium diphenylsulfone-3-sulfonate, sodium 2,4,5-trichlorobenzenesulfonate, potassium 2,4,5-trichlorobenzenesulfonate, potassium bis(2,6-dibromo-4-cumylphenyl)phosphate, sodium bis(4-cumylphenyl)phosphate, potassium bis(p-toluenesulfone)imide, potassium

bis(diphenylphosphate)imide, potassium
 bis(2,4,6-tribromophenyl)phosphate, potassium
 bis(2,4-dibromophenyl)phosphate, potassium
 bis(4-bromophenyl)phosphate, potassium diphenylphosphate,
 5 sodium diphenylphosphate, potassium
 perfluorobutanesulfonate, sodium or potassium
 laurylsulfate and sodium or potassium hexadecylsulfate.

The halogenated aromatic phosphate-based flame
 retardants include tris(2,4,6-tribromophenyl)phosphate,
 10 tris(2,4-dibromophenyl)phosphate and
 tris(4-bromophenyl)phosphate.

The aromatic phosphate-based flame retardants include
 triphenyl phosphate, tris(2,6-xylyl)phosphate,
 tetrakis(2,6-xylyl)resorcin diphosphate,
 15 tetrakis(2,6-xylyl)hydroquinone diphosphate,
 tetrakis(2,6-xylyl)-4,4'-biphenol diphosphate,
 tetraphenyl resorcin diphosphate, tetraphenyl hydroquinone
 diphosphate, tetraphenyl-4,4'-biphenol diphosphate,
 aromatic polyphosphates containing no phenolic OH group
 20 obtained from resorcin and phenol as aromatic ring sources,
 aromatic polyphosphates containing a phenolic OH group
 obtained from resorcin and phenol as aromatic ring sources,
 aromatic polyphosphates containing no phenolic OH group
 obtained from hydroquinone and phenol as aromatic sources,
 25 aromatic polyphosphates containing a phenolic OH group
 obtained from hydroquinone and phenol as aromatic sources
 (the aromatic polyphosphates shown below mean both aromatic
 polyphosphates containing a phenolic OH group and aromatic
 polyphosphates containing no phenolic OH group), aromatic
 30 polyphosphates obtained from bisphenol A and phenol as
 aromatic ring sources, aromatic polyphosphates obtained from
 tetrabromobisphenol A and phenol as aromatic ring sources,
 aromatic polyphosphates obtained from resorcin and
 2,6-xyleneol as aromatic ring sources, aromatic

polyphosphates obtained from hydroquinone and 2,6-xylenol as aromatic ring sources, aromatic polyphosphates obtained from bisphenol A and 2,6-xylenol as aromatic ring sources and aromatic polyphosphates obtained from
5 tetrabromobisphenol A and 2,6-xylenol as aromatic ring sources.

(another resin, elastomer)

The granule may contain small amount of another resin
10 or elastomer in limits that do not impair the object of the present invention.

Examples of the another resin include polyester resins such as polyethylene terephthalate and polybutylene terephthalate, polyamide resin, polyimide resin, polyether
15 imide resin, polyurethane resin, silicone resin, polyphenylene ether resin, polyphenylene sulfide resin, polysulfone resin, polyolefin resins such as polyethylene and polypropylene, polystyrene resin, acrylonitrile/styrene copolymer (AS resin),
20 acrylonitrile/butadiene/styrene copolymer (ABS resin), polymethacrylate resin, phenol resin and epoxy resin.

Examples of the elastomer include isobutylene/isoprene rubber, styrene/butadiene rubber, ethylene/propylene rubber, acrylic-based elastomer,
25 polyester-based elastomers, polyamide-based elastomers, MBS (methyl methacrylate/styrene/butadiene) rubber which is a core-shell type elastomer, and MAS (methyl methacrylate/acrylonitrile/styrene) rubber.

30 (production of granule)

Any method is employed to blend the polycarbonate resin (component a) with the phosphorus-based compound (component b) and other additives. For example, a method for mixing them together by means of a tumbler, twin-cylinder mixer,

super mixer, Nauter mixer, Banbury mixer, kneading roll or extruder is suitably employed. The powdery and pellet-like granule may be molded into a molded article or sheet by a generally known method such as injection molding, extrusion molding, compression molding or sheet extrusion directly or after it is formed into a pellet by a melt extruder.

The phosphorus-based compound and other additives may be blended with the polycarbonate resin in one stage or two or more stages. To blend them together in two stages, part of the polycarbonate resin powder or pellet is blended with the additives, that is, the additives are diluted with the polycarbonate resin powder to prepare a master batch of the additives which is finally blended.

For example, to blend them together in one stage, a method in which a mixture of predetermined amounts of additives is blended with the polycarbonate resin powder or pellet, or a method in which predetermined amounts of additives are weighed separately, added to the polycarbonate resin powder or pellet one after another and blended with it may be employed.

To blend the phosphorus-based compound and other additives, the additives may be directly added and injected into an extruder. In this case, the additives may be injected after they are molten by heating.

In the solution polymerization (interfacial polymerization) process, a method in which the organic solvent solution of the polycarbonate resin after polymerization is introduced into stirred hot water to produce a polycarbonate granule in a stirred stream is often employed. In this case, the phosphorus-based compound containing the above component c is added to and dissolved in the organic solvent solution of the polycarbonate resin, and the resulting solution is introduced into hot water to hydrolyze part of the phosphorus-based compound as the

component c so as to modify it into the above component b, thereby introducing the above component b into the polycarbonate resin.

5 (molding)

The granule is molten at a temperature of 280 to 380°C to be molded. Molding may be injection molding, compression molding, extrusion compression molding, rotational molding, blow molding or sheet extrusion.

10 Examples of the molded article include optical lenses such as spectacle lenses, camera lenses, binocular lenses, microscope lenses, projector lenses, Fresnel lenses, lenticular lenses, fθ lenses, head lamp lenses and pick-up lenses, car window glasses, roofs, head lamp covers, buttons
15 for mobile phones, phase difference plates, polarizing plates, light diffusion plates, faces plates (protective covers for meters), helmet shields and sheets such as windshield sheets for motorcycles.

Since a molded article having excellent heat
20 resistance, a good color and high total light transmittance (transparency) is obtained by the production method of the present invention, the production method is advantageously used for the molding of optical lenses, particularly spectacle lenses.

25 According to the present invention, a molded article which is a 5 mm-thick flat plate having a color (YI value) of preferably 0.3 to 3.0, more preferably 0.5 to 2.0 when measured by a transmission method in accordance with ASTM D1925 can be obtained. According to the present invention,
30 a molded article which is a 2 mm-thick flat plate having a total light transmittance of not less than 90 % in accordance with ISO 13468 can be obtained.

(coloring prevention method)

The present invention includes a method of preventing the coloring of a molded article when the granule is molded, wherein the granule satisfies the above conditions (I) and (II).

5 The granule preferably satisfies the above condition (III) in addition to the conditions (I) and (II). The components b-1, b-2, b-3, c-1 and c-2 are as described above. In this method, the molded article is preferably an optical lens, particularly preferably a spectacle lens.

10

Examples

The following examples are provided for the purpose of further illustrating the present invention but are in no way to be taken as limiting. "Parts" means parts by weight and evaluations were made by the following methods.

I. evaluation

(1) method of determining the amount of an Fe compound on the surface of a pellet

20 A 300 ml quartz glass conical flask and a quartz glass bar were cleaned with 100 ml of a 1N nitric acid aqueous solution in advance, and it was confirmed that the content of an Fe component in the 1N nitric acid aqueous solution cleaning fluid was not more than 0.1 ppb. The quartz glass
25 conical flask was made empty, 100 g of the pellet was put into the flask, and 100 g of a 1N nitric acid aqueous solution was added to the flask and stirred with the quartz glass bar for 1 minute. The solution was left to stand for 2 hours, stirred again for 1 minute and left to stand to determine
30 the content of the Fe atom in a liquid phase by ICP emission spectrometry and express the weight of the Fe atom in the Fe compound eluted into the 1N nitric acid aqueous solution cleaning fluid as a concentration (ppb) based on the weight of the pellet.

(2) determination of composition of phosphorus-based compound (phosphorus-based stabilizer used in Examples)

10 mg of a phosphorus-based compound was dissolved in
5 25 ml of hexane to carry out high-speed liquid chromatography (HPLC) under conditions shown in Table 1. Peak components were separated for each peak and isolated by using a fraction collector connected to an HPLC apparatus. The solvent was removed from the isolated components, each component was
10 dried up, and a certain weight of each component was measured off and dissolved in hexane to prepare a reference solution so as to draw a calibration curve. Acetonitrile (AN), isopropanol (IPA) and hexane dehydrated by a molecular sieve were used.

15 Used reagents

Hexane; manufactured by Wako Pure Chemical Industries, Ltd., for high-speed liquid chromatography

Acetonitrile; manufactured by Wako Pure Chemical Industries, Ltd., for high-speed liquid chromatography

20 Isopropanol; manufactured by Wako Pure Chemical Industries, Ltd., for high-speed liquid chromatography

Molecular sieve; manufactured by Wako Pure Chemical Industries, Ltd., 4A 1/16

Table 1

HPLC apparatus			
8020 series of Tosoh Corporation			
Degasser	SD-8022		
Pump	CCPS X 2		
Column oven	CO-8020		
Auto sampler	AS-8020		
Ultraviolet-visible detector	UV-8020		
Fraction collector	FC-8020		
Data processing unit	SC-8020		
Column	ODS-120T 4.6 X 250mm Tosoh Corporation		
Operation conditions			
Column temperature	40°C		
Flow rate	1ml/min		
Concentration of sample	15mg/25mL		
Amount of injection	10μL		
Eluant	isopropanol (IPA)		
	acetonitrile (AN)		
Gradient	R.T. (min)	IPA (%)	AN (%)
	0	5	95
	15	5	95
	20	30	70
	30	30	70
	35	40	60
	50	40	60

(3) color (YI value)

After the pellet was dried at 120°C for 5 hours, it was molded into a flat plate having a length of 70 mm, a width of 50 mm and a thickness of 5 mm by the J85-EL2 injection molding machine of JSW Co., Ltd. at a cylinder temperature of 300°C and a mold temperature of 105°C. The color (YI value) of this 5 mm-thick flat plate was measured with a C

light source at a view angle of 2° by using the Color-Eye7000A of Gretag Macbeth Co., Ltd. in accordance with a transmission method specified in ASTM D1925. Although the YI value changes according to the amount of an additive, when the amount of the additive is the same, as the YI value becomes smaller, discoloration at the time of molding becomes less and heat resistance becomes higher.

The existence of the dullness of the flat plate was visually inspected.

10

(4) total light transmittance

After the pellet was dried at 120°C for 5 hours, it was molded into a flat plate having a length of 90 mm, a width of 50 mm and a thickness of 2 mm by the J85-EL2 injection molding machine of JSW Co., Ltd. at a cylinder temperature of 350°C and a mold temperature of 80°C . The total light transmittance of this 2 mm-thick flat plate was measured by using the NDH-2000 of Nippon Denshoku Co., Ltd. in accordance with ISO13468.

20

(5) molding heat resistance (residence heat resistance)

After the pellet was dried at 120°C for 5 hours, it was molded into a "flat plate for measuring color before residence" (length of 70 mm, width of 50 mm and thickness of 2 mm) by the J85-EL2 injection molding machine of JSW Co., Ltd. at 350°C for a cycle time of 1 minute. Further, after the resin was held in the cylinder for 10 minutes, it was molded into a "flat plate for measuring color after residence" (length of 70 mm, width of 50 mm and thickness of 2 mm). The color of the flat plate before and after residence was measured with the C light source by using the SE-2000 of Nippon Denshoku Co., Ltd. to obtain a color difference ΔE from the following equation. As ΔE becomes smaller, molding heat resistance becomes higher.

$$\Delta E = \{(L - L')^2 + (a - a')^2 + (b - b')^2\}^{1/2}$$

color of "flat plate for measuring color before residence":

L, a, b

color of "flat plate for measuring color after residence":

5 L', a', b'

(6) molding heat resistance (difference in residence
molecular weight)

The viscosity average molecular weight (M) of the "flat
10 plate for measuring color before residence" and the viscosity
average molecular weight (M') of the "flat plate for
measuring color after residence" obtained in the above test
(5) were measured to obtain the difference ΔM (M-M'). As
 ΔM becomes smaller, molding heat resistance becomes higher.

15

II. stabilizer and the like

The phosphorus-based stabilizers, release agents,
ultraviolet absorbents and bluing agents used in Examples
and Comparative Examples are given below.

20 1. phosphorus-based stabilizer A (for Comparative Examples)

The HOSTANOX P-EPQ (trade name) phosphonite-based compound
(of Clariant Japan Co., Ltd.) was used. Peaks 1 to 6 under
the above HPLC measurement conditions are the following
25 phosphorus-based compounds (see Fig. 1).

(1) component b

(1-i) component b-1 (peak 4)

a mixture of four components which are

4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butyl
30 phenyl)-biphenylene diphosponite,
4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butyl
phenyl)-biphenylene diphosponite,
3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butyl
phenyl)-biphenylene diphosponite and

3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite

(1-ii) component b-2 (peak 2)

a mixture of three components which are

5 4,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,

3,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite and

10 3,3'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite

(1-iii) component b-3 (peak 1)

a mixture of two components which are

2,4-di-tert-butylphenyl-4-phenyl-phenyl phosphonite and

2,4-di-tert-butylphenyl-3-phenyl-phenyl phosphonite

15 (2) component c

(2-i) component c-1 (peak 6)

a mixture of three components which are

tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene diphosphonite,

20 tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene diphosphonite and

tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene diphosphonite

(2-ii) component c-2 (peak 3)

25 a mixture of two components which are

bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl phosphonite

and bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl phosphonite

(3) other major components (peak 5)

30 (3-i) tris(2,4-di-tert-butylphenyl)phosphite

* weight ratio of (total amount of components b and c) to (weight of phosphorus-based stabilizer A) = 0.91

* weight ratio of (component b) to (component c) = 0.004

2. phosphorus-based stabilizer B (for Examples)

The phosphorus-based stabilizer A which was exposed to a 50°C and 90 %RH atmosphere in a thermo-hygrostat for 24 hours was used. The chart obtained under the above HPLC measurement conditions is shown in Fig. 2.

* weight ratio of (total amount of components b and c)
to (weight of phosphorus-based stabilizer B) = 0.91

* weight ratio of (component b) to (component c) = 0.234

10 3. phosphorus-based stabilizer C (for Examples)

The phosphorus-based stabilizer A which was exposed to a 50°C and 90 %RH atmosphere in a thermo-hygrostat for 36 hours was used.

* weight ratio of (total amount of components b and c)
15 to (weight of phosphorus-based stabilizer C) = 0.89

* weight ratio of (component b) to (component c) = 0.386

4. another phosphorus-based stabilizer D

tris(2,4-di-tert-butylphenyl)phosphite (Irgafos 168 (trade
20 name) of Ciba Specialty Chemicals Co., Ltd.)

5. hindered phenol-based stabilizer E

octadecyl-3-(3,5-di-tert-butyl-4-hydroxyphenyl)
propionate (Irganox 1076 (trade name) of Ciba Specialty
25 Chemicals Co., Ltd.)

6. release agent A (fatty acid ester A)

monoglyceride stearate (acid value of 0.8, purity of 97.0
wt%) (Rikemal S-100A (trade name) of Riken Vitamin Co., Ltd.)

30

7. release agent B (fatty acid ester B)

a mixture of triglyceride stearate and stearyl stearate (acid
value of 2.0) (Rikemal SL-900 (trade name) of Riken Vitamin
Co., Ltd.)

8. release agent C (fatty acid ester C)
pentaerythritol tetrastearate (acid value of 0.6) (Rikestar
EW-400 (trade name) of Riken Vitamin Co., Ltd.)

5

9. ultraviolet absorbent A
2-(2-hydroxy-5-tert-octylphenyl)benzotriazole (Chemisorb
79 (trade name) of Chemipro Kasei Kaisha, Ltd.)

10 10. ultraviolet absorbent B
2-(3-tert-butyl-5-methyl-2-hydroxyphenyl)-5-
chlorobenzotriazole (Tinubin 326 (trade name) of Ciba
Specialty Chemicals Co., Ltd.)

15 11. bluing agent
anthraquinone-based compound (Macrolex Violet B (trade name)
of Bayer Co., Ltd.)

Examples 1, 3, 5, 6 and 7 and Comparative Examples 1, 5, 6
20 and 7

A phosphorus-based stabilizer, a release agent and an
ultraviolet absorbent were added to and mixed with 100 parts
by weight of a polycarbonate resin obtained from bisphenol
A, p-tert-butylphenol (terminal capping agent) and phosgene
25 by the interfacial polymerization process in amounts shown
in Tables 2 and 3, the obtained mixture was melt extruded
by an extruder at 280°C, and the obtained pellet was stored
in a product storage tank, transferred to a blend tank and
blended, and then the above evaluations were made on the
30 obtained blends. The results are shown in Tables 2 and 3.

One month passed after the product storage tank, the
blend tank and accessory equipment used above were cleaned.

Examples 2 and 4 and Comparative Example 2

A phosphorus-based stabilizer, a release agent and an ultraviolet absorbent were added to and mixed with 100 parts by weight of a polycarbonate resin obtained from bisphenol A, p-tert-butylphenol (terminal capping agent) and phosgene by the interfacial polymerization process in amounts shown in Tables 2 and 3, the obtained mixture was melt extruded by an extruder at 280°C, and the obtained pellet was stored in a product storage tank, transferred to a blend tank and blended, and then the above evaluations were made on the obtained blends. The results are shown in Tables 2 and 3.

One year passed after the product storage tank, the blend tank and accessory equipment used above were cleaned.

Comparative Examples 3 and 4

A phosphorus-based stabilizer, release agent and ultraviolet absorbent were added to and mixed with 100 parts by weight of a polycarbonate resin obtained from bisphenol A, p-tert-butylphenol (terminal capping agent) and phosgene by the interfacial polymerization process in amounts shown in Tables 2 and 3, the obtained mixture was melt extruded by an extruder at 280°C, and the obtained pellet was stored in a product storage tank, transferred to a blend tank and blended, and then the above evaluations were made on the obtained blends. The results are shown in Tables 2 and 3.

Three years passed after the product storage tank, the blend tank and accessory equipment used above were cleaned.

Table 2

		Weight ratio of component b to component c	Weight ratio of total of components b and c to stabilizer	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7
Blending ratio (parts by weight)	Polycarbonate resin (viscosity average molecular weight $\times 10^3$)	-	-	100 (22.4)	100 (22.4)	100 (22.4)	100 (22.4)	100 (19.7)	100 (19.7)	100 (24.2)
	Stabilizer A	0.004	0.91							
	Stabilizer B	0.234	0.91	0.020	0.020			0.020	0.020	
	Stabilizer C	0.386	0.89			0.020	0.020			0.020
	Stabilizer D	-	-	0.080	0.080	0.080	0.080		0.030	
	Stabilizer E	-	-	0.050	0.050	0.050	0.050		0.050	
	Release agent A	-	-	0.100	0.100	0.100	0.100	0.100		
	Release agent B	-	-							0.250
	Release agent C	-	-						0.100	
	Ultraviolet absorbent A	-	-	0.300	0.300	0.300	0.300		0.300	0.300
	Ultraviolet absorbent B	-	-							0.050
	Bluing agent	-	-	0.6ppm	0.6ppm	0.6ppm	0.6ppm	0.6ppm	0.6ppm	0.7ppm

Ex.: Example

Table 2 (continued)

		Weight ratio of component b to component c	Weight ratio of total of components b and c to stabilizer	Ex. 1	Ex. 2	Ex. 3	Ex. 4	Ex. 5	Ex. 6	Ex. 7
Fe compounds	Fe compound in terms of Fe atom	-	-	42ppb	94ppb	53ppb	84ppb	48ppb	57ppb	51ppb
color of molded plate (thickness of 5 mm)	YI value	-	-	1.42	1.48	1.45	1.49	1.37	1.41	1.38
	dullness (seen, not seen)	-	-	Not seen	Not seen	Not seen	Not seen	Not seen	Not seen	Not seen
Molded plate (thickness of 2 mm)	Molded plate (thickness of 2 mm) total light transmittance (%)	-	-	90	90	90	90	90	90	90
Molding heat resistance	ΔE	-	-	0.28	0.35	0.33	0.29	0.38	0.24	0.24
	ΔM	-	-	0.4	0.5	0.3	0.2	0.3	0.2	0.3

Ex.: Example

Table 3

		Weight ratio of component b to component c	Weight ratio of total of components b and c to stabilizer	C.Ex. 1	C.Ex. 2	C.Ex. 3	C.Ex. 4	C.Ex. 5	C.Ex. 6	C.Ex. 7
Amount (parts by weight)	Polycarbonate resin (viscosity average molecular weight x 10 ³)	-	-	100 (22.4)	100 (22.4)	100 (22.4)	100 (22.4)	100 (19.7)	100 (19.7)	100 (24.2)
	Stabilizer A	0.004	0.91	0.020	0.020	0.020		0.020	0.020	0.020
	Stabilizer B	0.234	0.91				0.020			
	Stabilizer C	0.386	0.89							
	Stabilizer D	-	-	0.030	0.030	0.030	0.030	0.030		
	Stabilizer E	-	-	0.080	0.080	0.080	0.080	0.050		
	Release agent A	-	-	0.100	0.100	0.100	0.100		0.100	
	Release agent B	-	-							0.250
	Release agent C	-	-					0.100		
	Ultraviolet absorbent A	-	-	0.300	0.300	0.300	0.300	0.300		0.300
	Ultraviolet absorbent B	-	-							0.050
	Bluing agent	-	-	0.6ppm	0.6ppm	0.6ppm	0.6ppm	0.6ppm	0.6ppm	0.7ppm

C.Ex.: Comparative Example

Table 3 (continued)

		Weight ratio of component b to component c	Weight ratio of total of components b and c to stabilizer	C.Ex. 1	C.Ex. 2	C.Ex. 3	C.Ex. 4	C.Ex. 5	C.Ex. 6	C.Ex. 7
Fe compounds	Fe compound in terms of Fe atom	-	-	46 ppb	89 ppb	124 ppb	132 ppb	36 ppb	49 ppb	38 ppb
color of molded plate (thickness of 5 mm)	YI value	-	-	1.51	1.57	1.67	1.71	1.53	1.49	1.51
	dullness (seen, not seen)	-	-	Not seen	Seen	Seen	Seen	Not seen	Not seen	Not seen
Molded plate (thickness of 2 mm)	Total light transmittance rate (%)	-	-	90	90	90	90	90	90	90
Molding heat resistance	ΔE	-	-	0.66	0.78	0.93	0.69	0.81	0.72	0.83
	ΔM	-	-	1.8	1.9	2.3	1.7	1.3	1.6	1.4

C.Ex.: Comparative Example

Effect of the Invention

According to the present invention, by containing a specific phosphorus-based compound (component b) in a polycarbonate resin (component a), molding heat resistance can be improved with a small amount of the phosphorus-based component. According to the present invention, by reducing the content of an Fe compound in a granule of the polycarbonate resin to not more than a specific value, a molded article having a good color and high transparency can be obtained.

10

Industrial Applicability

Since the molded article obtained by the present invention has excellent heat resistance, color and total transmittance (transparency), it is advantageously used as an optical lens, particularly a spectacle lens.

15

Claims

1. A method of producing a molded article by melting a granule at a temperature of 280 to 380°C and molding it, wherein

5 the granule satisfies the following conditions (I) and (II):

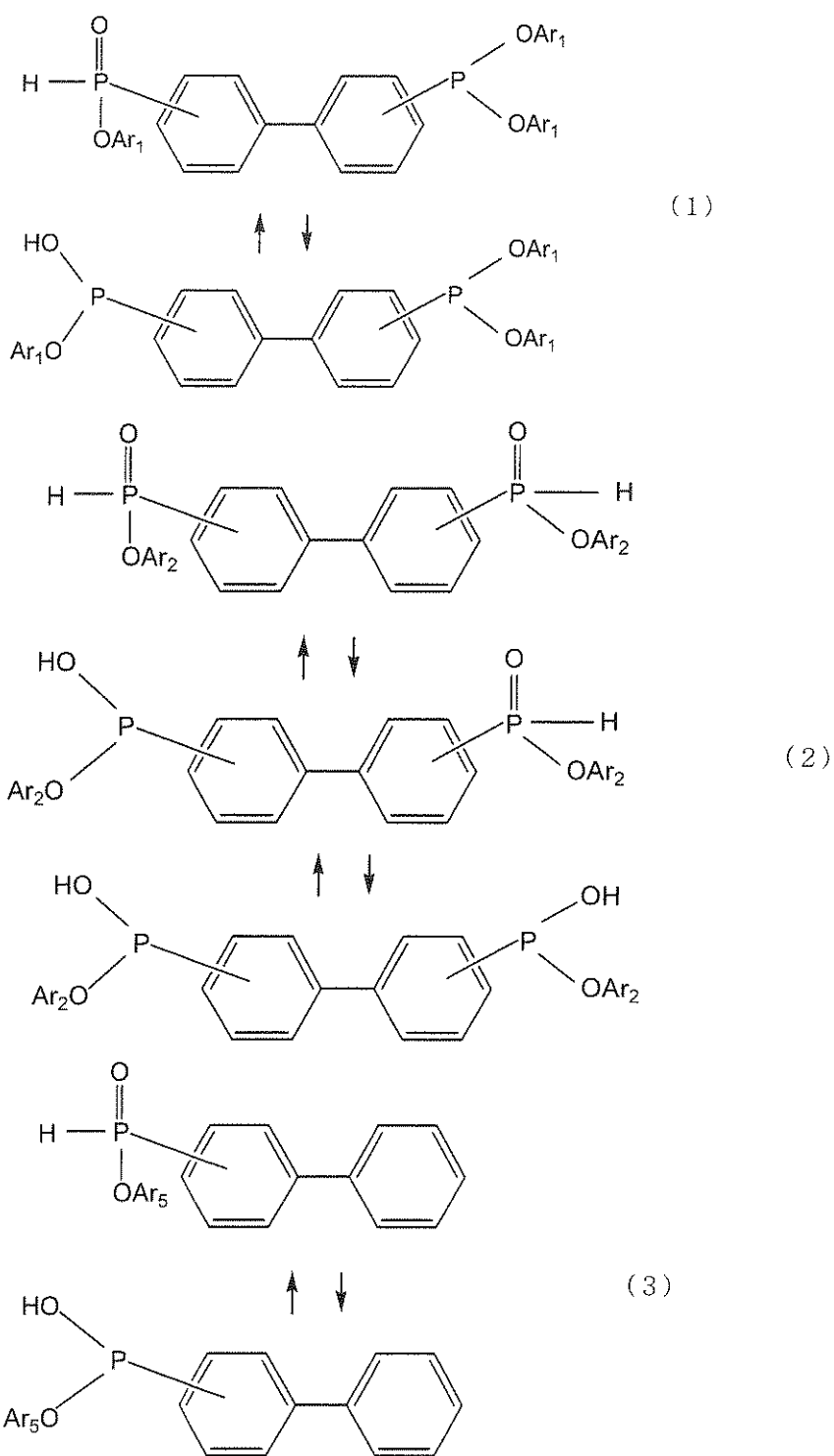
(I) when 100 parts by weight of the granule is cleaned with 100 parts by weight of a 1N nitric acid aqueous solution, the amount of an Fe compound eluted into the 1N nitric acid aqueous solution cleaning fluid is 1 to 100 ppb in terms of the Fe atom based on the granule; and

10

(II) the granule comprises (A) 100 parts by weight of a polycarbonate resin (component a) and (B) 0.00010 to 0.5 part by weight of at least one phosphorus-based compound (component b) selected from the group consisting of a phosphorus-based compound represented by the following formula (1) (component b-1), a phosphorus-based compound represented by the following formula (2) (component b-2) and a phosphorus-based compound represented by the following formula (3) (component b-3).

15

20

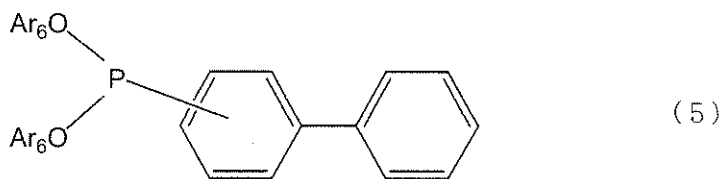
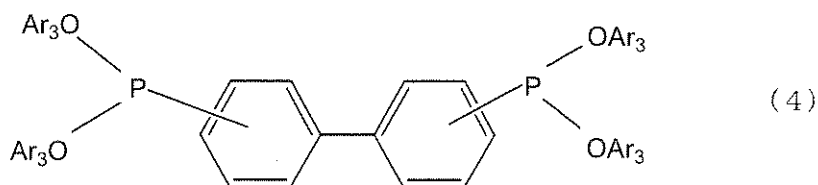


5 [wherein Ar₁, Ar₂ and Ar₅ may be the same or different and are each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent.]

2. The production method according to claim 1, wherein

the granule satisfies the following condition (III) in addition to the conditions (I) and (II):

(III) the granule comprises (A) the polycarbonate resin (component a), (B) the phosphorus-based compound represented by the formula (1) (component b-1), the phosphorus-based compound represented by the formula (2) (component b-2) and the phosphorus-based compound represented by the formula (3) (component b-3), and (C) a phosphorus-based compound represented by the following formula (4) (component c-1) and a phosphorus-based compound represented by the following formula (5) (component c-2); and the total amount of the components b-1 to b-3 and the components c-1 and c-2 is 0.0005 to 0.5 part by weight based on 100 parts by weight of the component a, and the weight ratio (x/y) of the total amount (x parts by weight) of the components b-1 to b-3 to the total amount (y parts by weight) of the components c-1 and c-2 is 0.01 to 2.0.



[wherein Ar₃ and Ar₆ may be the same or different and are each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent.]

3. The production method according to claim 1 or 2, wherein the above component b-1 is 4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,

4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite or
5 3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite.

4. The production method according to any one of claims 1 to 3, wherein the above component b-2 is
10 4,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
3,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite or
3,3'-bis(2,4-di-tert-butylphenyl)-biphenylene
15 diphosphonite.

5. The production method according to any one of claims 1 to 4, wherein the above component b-3 is
2,4-di-tert-butylphenyl-4-phenyl-phenyl phosphonite or
20 2,4-di-tert-butylphenyl-3-phenyl-phenyl phosphonite.

6. The production method according to claim 2, wherein the above component c-1 is
tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene
25 diphosphonite,
tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene diphosphonite or
tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene diphosphonite.

30

7. The production method according to claim 2, wherein the above component c-2 is
bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl phosphonite
or bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl

phosphonite.

8. The method according to any one of claims 1 to 7, wherein the molded article is an optical lens.

5

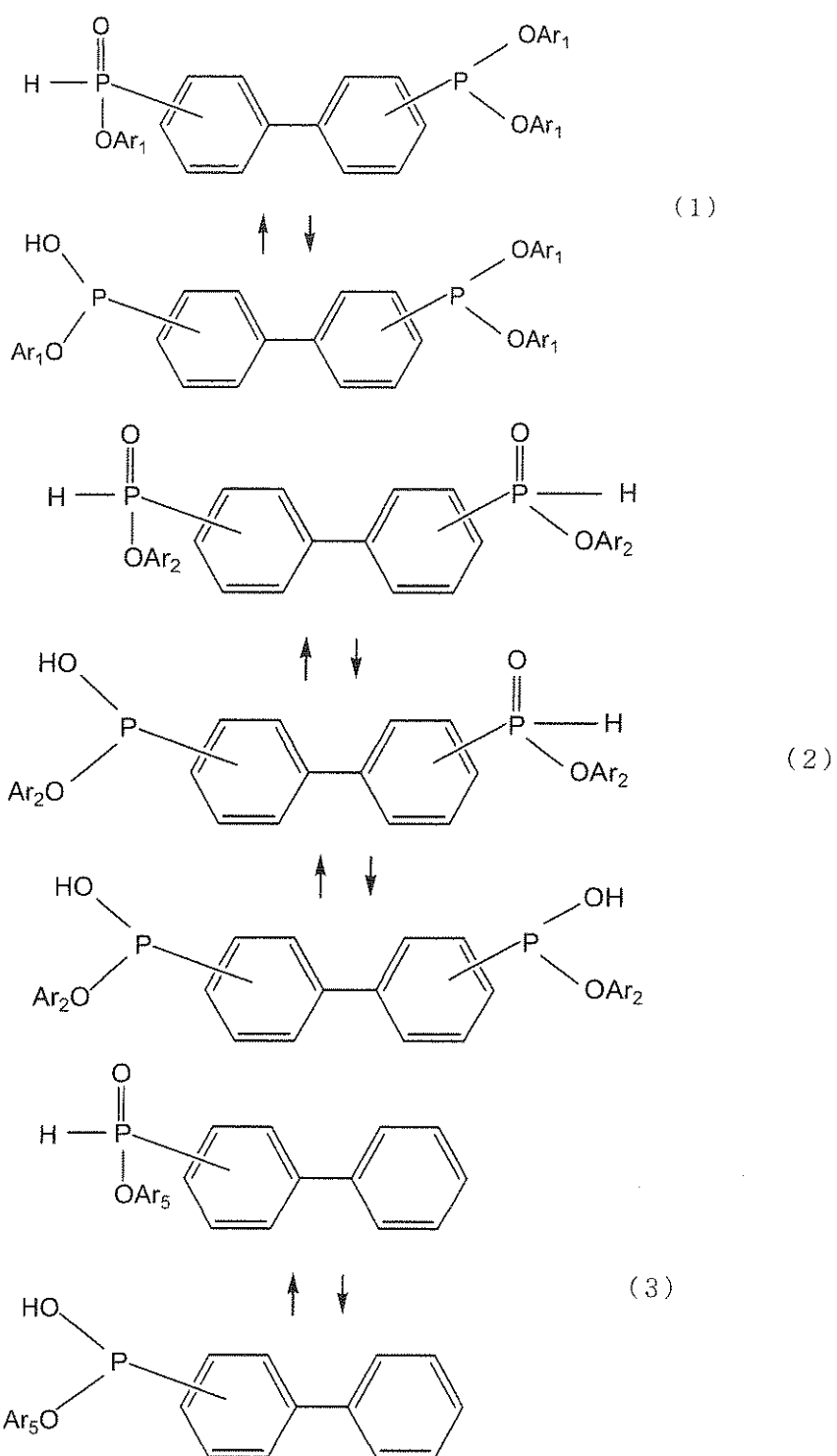
9. The method according to any one of claims 1 to 8, wherein the molded article is a spectacle lens.

10. A method of preventing the coloring of a molded article when a granule is molded, wherein

the granule satisfies the following conditions (I) and (II):

(I) when 100 parts by weight of the granule is cleaned with 100 parts by weight of a 1N nitric acid aqueous solution, the amount of an Fe compound eluted into the 1N nitric acid aqueous solution cleaning fluid is 1 to 100 ppb in terms of the Fe atom based on the granule; and

(II) the granule comprises (A) 100 parts by weight of a polycarbonate resin (component a) and (B) 0.00010 to 0.5 part by weight of at least one phosphorus-based compound (component b) selected from the group consisting of a phosphorus-based compound represented by the following formula (1) (component b-1), a phosphorus-based compound represented by the following formula (2) (component b-2) and a phosphorus-based compound represented by the following formula (3) (component b-3).

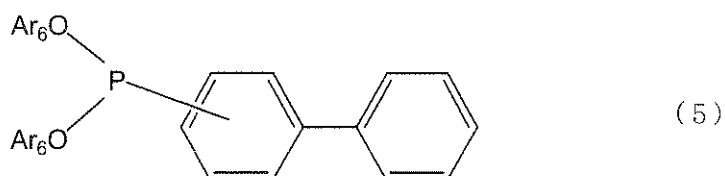
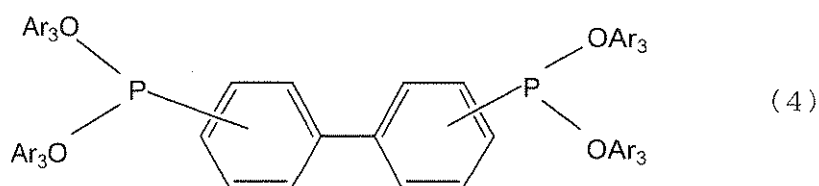


[wherein Ar_1 , Ar_2 and Ar_5 may be the same or different and
 5 are each an aromatic hydrocarbon group having 6 to 20 carbon
 atoms which may have an alkyl substituent.]

11. The production method according to claim 10, wherein
 the granule satisfies the following condition (III) in

addition to the conditions (I) and (II):

(III) the granule comprises (A) the polycarbonate resin (component a), (B) the phosphorus-based compound represented by the formula (1) (component b-1), the
 5 phosphorus-based compound represented by the formula (2) (component b-2) and the phosphorus-based compound represented by the formula (3) (component b-3), and (C) a phosphorus-based compound represented by the following
 10 formula (4) (component c-1) and a phosphorus-based compound represented by the following formula (5) (component c-2);
 and the total amount of the components b-1 to b-3 and the components c-1 and c-2 is 0.0005 to 0.5 part by weight based on 100 parts by weight of the component a, and the weight
 15 ratio (x/y) of the total amount (x parts by weight) of the components b-1 to b-3 to the total amount (y parts by weight) of the components c-1 and c-2 is 0.01 to 2.0.



[wherein Ar₃ and Ar₆ may be the same or different and are
 20 each an aromatic hydrocarbon group having 6 to 20 carbon atoms which may have an alkyl substituent.]

12. The production method according to claim 10 or 11,
 wherein the above component b-1 is
 25 4-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,
 4-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,

3-bis(2,4-di-tert-butylphenyl)-4'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite or

3-bis(2,4-di-tert-butylphenyl)-3'-mono(2,4-di-tert-butylphenyl)-biphenylene diphosphonite.

5

13. The production method according to any one of claims 10 to 12, wherein the above component b-2 is 4,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite,

10 3,4'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite or 3,3'-bis(2,4-di-tert-butylphenyl)-biphenylene diphosphonite.

15 14. The production method according to any one of claims 10 to 13, wherein the above component b-3 is 2,4-di-tert-butylphenyl-4-phenyl-phenyl phosphonite or 2,4-di-tert-butylphenyl-3-phenyl-phenyl phosphonite.

20 15. The production method according to any one of claims 10 to 14, wherein the above component c-1 is tetrakis(2,4-di-tert-butylphenyl)-4,4'-biphenylene diphosphonite, tetrakis(2,4-di-tert-butylphenyl)-4,3'-biphenylene
25 diphosphonite or tetrakis(2,4-di-tert-butylphenyl)-3,3'-biphenylene diphosphonite.

16. The production method according to any one of claims
30 10 to 15, wherein the above component c-2 is bis(2,4-di-tert-butylphenyl)-4-phenyl-phenyl phosphonite or bis(2,4-di-tert-butylphenyl)-3-phenyl-phenyl phosphonite.

17. The method according to any one of claims 10 to 16,
wherein the molded article is an optical lens.

18. The method according to any one of claims 10 to 17,
5 wherein the molded article is a spectacle lens.