

TITLE: Low Phosphorus Low Color Polyamides

BACKGROUND

[0001] Polyamide resins and means for their preparation are well known. When manufactured according to known processes but in the absence of known pigments, these resins tend to exhibit varying degrees of undesired yellowness, with the yellowness increasing over time. Polyamide resins also generally exhibit increased yellowness when exposed to the high temperatures associated with subsequent commonly employed melt processing operations. Since many of these polyamide resins are stored for extended periods of time and in view of the potential for repeated cycles of melting during molding and extrusion, there is an incentive to provide improved polyamide resins which initially show low color and which continue to show low color over time.

[0002] Phosphorus-containing compounds are well known catalysts for polymerization of polyamides. Notably, the use of these compounds results in polyamides having a greater degree of whiteness and color stability, presumably by reducing the degree of oxidative and thermal degradation of the polyamide. See, *e.g.*, U.S. Patent No. 5,929,200. More particularly, hypophosphite compounds have been used as catalysts for polymerization of the polyamides, as described in, for example, U.S. Patent Nos. 3,860,558; 3,173,898; and 3,691,131.

[0003] The addition of phosphorus-containing compounds to polyamides such as nylon 6,6 serve as color stabilizers for the polyamides. However, these compounds also serve as polymerization catalysts and sometimes as nucleating agents. See, *e.g.*, U.S. Patent Nos. 6,197,855; and 4,237,034. Nucleants have often been used to improve the molding cycle time or crystallization rate of polyamides. For example, U.S. Patent No. 3,080,345 discloses using as a nucleating agent sodium phenylphosphinate, sodium isobutylphosphinate, magnesium oxide, mercuric bromide, mercuric chloride, cadmium acetate, lead acetate, or phenolphthalein. U.S. Patent Nos. 3,585,264 and 4,866,115 also disclose using nucleating agents for improving the rate of crystallization of polyamides. U.S. Patent No. 6,197,855 discloses the incorporation of nylon 2,2 and a phosphorous-containing whitening agent into the polyamide before, during or after the polycondensation step. Preferably, the

phosphorous-containing whitening agent is added during the polycondensation step to result in a white polymer.

[0004] Persistent problems, however, attributed to the use of phosphorus-containing compounds include viscosity build during injection molding and deposits formed in process/polymerization equipment during manufacturing.

[0005] The present technique is directed to (i) the use of low phosphorus content for the purpose of improving color, catalytic activity, and low deposit/plate out, (ii) end group configuration designed to maximize injection molding productivity; and (iii) application of a metal-containing compound to the outside of the polyamide (typically in pellet form) after polymerization, but before injection molding to reduce the catalytic activity of the phosphorus-containing compound during injection molding, while preserving the integrity of the catalytic behavior of the phosphorus-containing compound during polymerization.

[0006] The present technique reflects the unexpected discovery that the use of phosphorus-containing compounds in amounts thought to be too low to be effective protection against yellowing are surprisingly effective in preparing low color polyamides, where the low color does not degrade over an extended period of time. These same low levels of phosphorus that provide improvement in color and polymerization rate also mitigate the negative effect of phosphate plate out in the polymerization and processing equipment.

SUMMARY

[0006a] The invention is defined in the independent claim. Further embodiments of the invention are defined in the dependent claims.

[0007] An aspect of the present technique is a low-color polyamide comprising 25 to 50 ppm of phosphorus, wherein the phosphorus is present as a phosphorus-containing compound.

[0008] Another aspect of the technique is a process for preparing a low-color polyamide comprising 25 to 50 ppm of phosphorus.

[0009] Another aspect of the technique is an article comprising a low-color polyamide comprising 25 to 50 ppm of phosphorus.

[00010] In an aspect of the technique, the low-color polyamide comprises 25 to 45 ppm, such as 25 to 40 ppm, such as 25 to 35 ppm, such as 25 to 30 ppm of phosphorus.

[00011] In an aspect of the technique, the phosphorus-containing compound is selected from the group consisting of hypophosphorus acid, phosphorus acid and their respective salts. Hypophosphorus acid and sodium hypophosphite (SHP) are preferred phosphorus-containing compounds.

[00012] In an aspect of the technique, the low-color polyamide further comprises at least one of a metal-containing compound capable of reducing the catalytic effect of the phosphorus-containing compound, especially during injection molding.

[00013] In an aspect of the technique, the low-color polyamide further comprises 1,200 to 1,800 ppm of a carboxylic acid, such as a lower carboxylic acid (*e.g.*, acetic acid or propionic acid), phthalic acid, benzoic acid or other compound capable of rendering various end groups of the polyamide inert (*i.e.*, non-reactive).

[00014] In an aspect of the technique, the polyamide is selected from the group consisting of nylon 6, nylon 4/6, nylon 6/6, nylon 6/10, nylon 6/12, nylon 11 and nylon 12.

[00015] In an aspect of the technique, the polyamide is nylon 6/6 (also referred to herein as nylon 66 or nylon 6,6 or nylon66 or polyamide 66 or PA 66 or PA66).

[00016] In an aspect of the technique the low-color polyamide further comprises one or more additives, fillers, reinforcing agents and modifiers.

[00017] In an aspect of the technique, the low-phosphorus polyamide comprises 250 to 1,500 ppm, such as 250 to 1,000 ppm, such as 250 to 750 ppm, such as 250 to 500 ppm, such as 500 to 1,500 ppm, such as 500 to 1,000 ppm, such as 500 to 750 ppm of a metal-containing compound.

[00018] In an aspect of the technique, the yellow color index ranges from -3 to -9, such as -3 to -8, such as -3 to -7, such as -3 to -6, such as -4 to -9, such as -4 to -8, such as -5 to -9, such as -5 to -8.

[00019] In an aspect of the technique, the metal-containing compound is applied to the external surface of a solid form of the polyamide – *e.g.*, after the polyamide has already been processed, wherein the solid form is, for example, a pellet or a flake. Alternatively, the metal-containing compound may be applied internal to the pellet.

[00020] In an aspect of the technique, the low-phosphorus polyamide (such as nylon 66) has a specific configuration of end groups, such as, for example, amine end groups, carboxylate end groups and so-called inert end groups including mono-carboxylic acids, mono amines, lower dicarboxylic acids capable of forming inert imine end groups, phthalic acids and derivatives thereof). The specific combination of all of these components provides the observed polymerization performance in the form of catalytic activity of the phosphorus-containing compound, the whiteness of the final product, low deposition during polymerization and processing, and improved melt stability during the injection molding process.

BRIEF DESCRIPTION OF THE DRAWINGS

[00021] The figures represent exemplary embodiments and are not intended to limit the scope of the present invention as otherwise described herein.

[00022] **Figure 1** illustrates a scanning electron microscope image of a filter element containing deposits.

[00023] **Figure 2** illustrates the reduced cost of filter changes associated with reduced levels of phosphorus.

[00024] **Figure 3** illustrates a graphical representation of the rise in filter pressure versus increasing phosphorus levels.

[00025] **Figure 4** illustrates the effect of phosphorus (SHP) levels on the color (YI) of PA66.

[00026] **Figure 5** illustrates the effect of phosphorus (SHP) levels on the color (YI) of molded plaques.

[00027] **Figure 6** illustrates the effect of phosphorus content on RV build during SSP.

[00028] **Figure 7** illustrates the relationship between phosphorus levels and transfer line pressure.

[00029] **Figure 8** illustrates the change in RV upon injection molding of PA66 containing a phosphorus-containing compound.

[00030] **Figure 9** illustrates the change in RV upon injection molding of PA66 containing a phosphorus-containing compound and end capped with acetic acid.

[00031] **Figure 10** illustrates the average installation success rate for cable ties comprised of materials containing no phosphorus, materials containing 20 ppm phosphorus and materials containing 45 ppm phosphorus.

DETAILED DESCRIPTION

[00032] Unless defined otherwise, all technical and scientific terms described herein have the same meaning as commonly understood by one of ordinary skill in the art to which this disclosure belongs.

[00033] As described herein, “relative viscosity” or “RV” refers to a comparison of the viscosity of a solution of polymer in formic acid with the viscosity of the formic acid itself and is measured using 90% formic acid and glass capillary Ubbelohde viscometers according to ASTM D789. For samples containing fiberglass or other fillers, the weight of sample to be dissolved is adjusted according to the amount of filler to provide the required 11.0 grams of neat resin per 100 ml formic acid.

[00034] As described herein, “low color” refers to a lowering of the yellowness index by 3 to 5 units lower compared to the absence of a phosphorus-containing compound as measured by ASTM 6290. Suitable color determinations can be used as well, as described by the standard, Yellowness Index (YI), CIE X, Y, Z, and Hunter L, a, b, or CIE L*, a*, b*.

[00035] Phosphorus concentration ranges of 25-45 ppm with allowance for other ranges, as noted. End groups should be noted to be in the ranges using micro-equivalents (moles per million grams polyamide) and should cover the ranges say 5 to 40 moles per million grams, preferably 15 to 25 micromoles, and most preferably 20-33 moles per million grams of polyamide. The metal content should be described as moles metal per mole of phosphorus.

[00036] In an aspect of the technique, the polyamide is selected from the group consisting of nylon 6, nylon 4/6, nylon 6/6, nylon 6/10, nylon 6/12, nylon 11, nylon 12, nylon MXD6, copolymer nylon (a copolymer of caprolactam with hexamethylenediamine adipate), nylon block copolymers, and copolymers comprising these nylons as main components. The

general methods of preparation of polyamides such as nylon 6/6 are well known. The low-phosphorus polyamides described herein are prepared by methods known in the art – such as the polycondensation of amino carboxylic acids or of mixtures of diamines and dicarboxylic acids including interpolyamides obtained by the polycondensation of different polyamide forming components. See, *e.g.*, U.S. Patent Nos. 6,197,855; 4,981,906; 4,320,213; 4,346,200; 4,713,415; 4,031,164; 2,071,250; 2,071,251; 2,130,523; 2,130,948; 2,241,322; 2,312,966; 2,512,606; and 3,393,210.

[00037] Suitable phosphorus-containing compounds include hypophosphorus acids, phosphorus acid, and their corresponding salts. Preferred phosphorus-containing compounds include hypophosphorus acid and hypophosphite salts, such as lithium, sodium, potassium, strontium or zinc hypophosphite.

[00038] Multivalent metal-containing compounds used in the present technique serve as phosphorus catalyst deactivators, with the effect of reducing undesirable increases in the molecular weight of the polyamide during subsequent melt processing operations. The degree of phosphorus catalyst deactivation may be controlled by the amount of the phosphorus-containing compound and the multivalent metal-containing compound added to the polyamide. Suitable multivalent metal-containing compounds are well known to one skilled in the art and include halides, nitrates, and carboxylate salts (*e.g.*, acetates, propionates, benzoates and stearates) of Group IIA metals, zinc and aluminum. A preferred multivalent metal-containing compound is a stearate, such as, for example aluminum distearate or zinc stearate.

[00039] Suitable carboxylic acids include acetic acid, propionic acid, benzoic acid, phthalic acid, or succinic acid.

[00040] The low-phosphorus polyamide has a relative viscosity (RV) range between 35 and 80, such as between 40 and 80, such as between 40 and 65, such as between 40 and 50.

[00041] Known injection molding, extrusion molding, blow molding, press molding, compression molding and gas assist molding techniques are generally suitable for molding of the compounded polyamides. See, *e.g.*, U.S. Patent Nos. 8,658,757; 4,707,513; 7,858,172; and 8,192,664.

[00042] The low-color polyamide may be mixed/blended with materials that include but are not limited to, glass fibers (*e.g.*, fiberglass, such as in chopped or roving form), waxes (including, *e.g.*, ethylene bis-stearamide or stearyl erucamide), minerals, carbon fibers, aramide fibers, fiber reinforcement, chain terminators, viscosity modifiers, plasticizers, heat stabilizers, UV stabilizers, colorants (such as, *e.g.*, nigrosine or carbon black), catalysts, other polymers and impact modifiers, flame retardants, delusterants, fillers, antimicrobial agents, antistatic agents, optical brighteners, extenders, processing aids, talc, mica, gypsum, wollastonite and other commonly used additives known to those of skill in the art. Preferably, additives are hydrolysis resistant chopped glass, heat stabilizers (including, *e.g.*, copper heat stabilizers such as CuI or KI) and nucleating agents. Additional suitable additives may be found in Plastics Additives, An A-Z reference, edited by Geoffrey Pritchard (1998). The optional addition of a stabilizer to the additive dispersion is present in an exemplary embodiment at between about 0.75% and about 7.5% by total dispersion weight. Stabilizers suitable for the additive dispersion include, but are not limited to, polyethoxylates (such as the polyethoxylated alkyl phenol Triton X-100), polypropoxylates, block copolymeric polyethers, long chain alcohols, polyalcohols, alkyl-sulfates, alkyl-sulfonates, alkyl-benzenesulfonates, alkyl-phosphates, alkyl-phosphonates, alkyl-naphthalene sulfonates, carboxylic acids and perfluoronates.

[00043] In exemplary embodiments, the material to be mixed/blended with the polyamide is added to the polyamide as itself (or a salt thereof) or is formed *in situ* using appropriate reactants. The terms "added" or "addition" without further clarification are intended to encompass either the addition of the material itself to the polymer or the *in situ* formation of the material in the polyamide. In another embodiment, the material to be mixed/blended with the polyamide is added via masterbatch. In a particular embodiment, a masterbatch containing a low molecular weight carrier polymer and a high concentration of the additive material can be melt blended with the main polyamide source. In an embodiment, the material(s) to be mixed/blended are added to the interior of the polyamide product (*e.g.*, in pellet or flake form), while in another embodiment, the material(s) to be mixed/blended are added exterior to the polyamide product (*e.g.*, in pellet or flake form).

[00044] Examples of applications which would benefit from the improvements described herein include articles prepared by injection molding processes, profile extrusion processes, sheet extrusion processes, and other forming processes known to those skilled in the art. These articles may be used in electrical and electronic applications (such as, but not limited to, circuit breakers, terminal blocks, connectors and the like), automotive applications (such as, but not limited to, air handling systems, radiator end tanks, fans, shrouds, and the like), furniture and appliance parts, and wire positioning devices such as cable ties.

EXAMPLES/EXPERIMENTAL RESULTS

[00045] There are several aspects relating to the use of phosphorus-containing compounds in the production of polyamides. Phosphorus-containing compounds are used to improve color and to act as catalysts to achieve improved polymerization rates. Negative consequences associated with the use of certain phosphorus-containing compounds include the deposition of condensed polyphosphates in polymerization equipment, the lack of RV control during injection molding, and a reduction in the physical properties of articles molded from materials containing these phosphorus-containing compounds.

[00046] Thus, the use of a phosphorus-containing compound in the manufacture of polyamides such as nylon requires a balancing between the desired improvement in the color of the polyamide and the undesired toll on the polymerization equipment. Assessment of wear on the polymerization equipment was measured by filter life and the degree of die drooling (*i.e.*, deposits forming adjacent to capillary holes present on die surface). The deposits observed to form on the filter elements and the die holes were identified by X-ray diffraction analysis as pentasodium-tripolyphosphate. Figure 1 is a scanning electron microscope image of a filter element coated with these triphosphate deposits.

[00047] It is believed that the presence of this deposit is caused by the condensation of phosphates in the process of preparing the polyamide. A test was conducted where the level of phosphorus was decreased from 60 ppm to 45 ppm and the costs associated with changing the filter element was monitored for 6 months prior to reduction of the phosphorus levels and then monitored for several months subsequent to reduction of the

phosphorus levels. A reduction in filter change expenses of approximately 50% was observed. Figure 2 depicts the monthly average filter change expenses for a polymerization line running polyamides containing phosphorus. Surprisingly, the monthly costs were reduced on average by 50% by reducing the phosphorus levels from an average of about 57 ppm to an average of about 50 ppm from the first half of 2013 to the fourth quarter of 2013 and the first quarter of 2014.

[00048] The effects of the amount of phosphorus on the undesirable deposition of the phosphate deposits was analyzed by extruding nylon 6,6 through a filter pack and monitoring the rise in filter pressure. A variety of phosphorus levels were tested and the rise in pressure was observed to increase significantly with concentration. See Figure 3. Thus, there is an upper level of phosphorus content for practical reasons above which will impart negative effects.

[00049] Having observed a practical upper limit for phosphorus levels, a lower limit for practical usage for color improvement and process rate was investigated. A laboratory autoclave process was used to produce PA66 samples with different phosphorus levels in order to determine the minimum level of effectiveness for color improvement and for process rate improvement. Table 1 outlines the experimental design, which includes the lab autoclave experiment and additive targets.

Table 1.

Polymer Targets			Calculated Beaker Addition Amounts (g)				
[P] (ppm)	[Acetic Acid] (ueq/g polymer)	HMD Spike (ueq/g polymer)	Salt	SHP 5% Solution	Acetic Acid Solution	HMD Solution	Finish Cycle Time (min)
0	20	30	1700	0.000	3.959	5.741	35
22	20	30	1700	1.520	3.959	5.741	35
44	20	30	1700	2.759	3.959	5.741	35
66	20	30	1700	3.998	3.959	5.741	35

[00050] The RV, color (YI), phosphorus level, amine end groups, and acetic acid end groups for the PA66 autoclave batches were measured for each batch and are summarized in Table 2.

Table 2.

	Actual Beaker Addition Amounts (g)			Flake Analytical Results				
Batch Number	Salt	SHP 5% Solution	Acetic Acid Solution	RV	NH ₂ (μeq/g)	Acetic (ppm)	Phosphorus (ppm)	YI
040714C2B 2	1700.2	0	3.97	40.8	47	1152	0	-2.10
040914C2B 1	1700.4	0	3.99	42.3	46	1153	0	-2.09
040714C2B 1	1700.17	1.52	3.96	45.9	40.8	1242	24	-4.04
041114C2B 1	1700.42	1.52	3.97	45.6	41.2	1235	24	-4.76
041014C2B 1	1700.2	2.77	3.97	48.2	42	1435	45	-5.33
041614C2B 1	1700.0	2.76	3.96	46.3	40.8	1242	48	-4.98
040814C2B 2	1700.22	4.02	3.97	46.9 9	40.1	1149	69	-5.13
041414C2B 2	1700.67	3.99	3.96	47.5 7	41.1	1278	68	-6.27

[00051] The yellowness index is higher for the zero or low phosphorus containing batches. Figure 4 illustrates the effect of phosphorus (P) on color of PA66 prepared with varying phosphorus levels. The YI of these materials was unexpectedly observed to change significantly between zero (0) P and about 24 ppm P, and then slightly more at about 45 ppm P and very slightly more at about 69 ppm P. These results clearly and unexpectedly show a diminishing effect of increasing phosphorus content on color at low phosphorus levels.

[00052] PA66 produced in a continuous polymerization unit was prepared with two different phosphorus content levels using SHP as the phosphorus-containing compound. Plaques were molded from materials containing these two different phosphorus levels and the color of the materials was measured. The color of the plaques were determined weekly or so for several months. Figure 5 shows the results of the YI measurement of these molded plaques. The difference in color between plaques prepared with 56 ppm phosphorus and plaques

prepared with 45 ppm phosphorus is minor, and this difference in color does not significantly change over time. This study demonstrates that the color of PA66 is improved with the addition of SHP, but that once an effective level is reached, there is little or no improvement in color or color stability over time.

[00053] An additional benefit of employing a phosphorus-containing compound of the present technique in the manufacture of a polyamide such as PA66 is that the phosphorus-containing compound is a catalyst and higher production rates are achievable with it. To answer the question regarding the practical maximum and minimum concentrations of the phosphorus content, the catalytic effectiveness at different phosphorus levels was determined using the lab autoclave samples described in Tables 1 and 2. Each sample was subjected to solid state polymerization at 175°C. Samples were retrieved at incremental times and the relative viscosity or RV was determined for each time. The results are summarized in Table 3 which shows the effect of phosphorus levels on SSP RV build, and are shown graphically in Figure 6.

Table 3.

Batch Number	Phosphorus	Time @ 175°C (min)	RV
040914C2B1	0 ppm	0	42.26
		70	47.88
		140	50.44
		210	53.43
		285	58.17
		360	61.68
040914C2B2	28 ppm	0	45.75
		70	60.13
		140	70.21
		210	80.52
		285	113
		360	131.76
041414C2B1	46 ppm	0	47.3
		70	70.89
		140	85.81
		210	112.68
		285	144.84
		360	166.43
041014C2B2	68 ppm	0	48.16
		70	69.14
		140	84.5
		210	102.98
		285	140.05
		360	153.28

[00054] The results of the polymerization rate test indicate that there is an increase in RV build rate with the addition of 28 ppm phosphorus and 46 ppm phosphorus, but adding 68 ppm phosphorus does not increase the rate of RV build over that of the sample containing 46 ppm phosphorus. This study shows that there is unexpectedly a practical lower limit of phosphorus content of about 45 ppm phosphorus and a diminished improvement of catalytic activity at about 68 ppm phosphorus.

[00055] The effectiveness of SHP as a polymerization catalyst has been demonstrated in a continuous polymerization process. The level of phosphorus was reduced from

approximately 56 ppm to approximately 40 ppm (*i.e.*, the addition rate was diminished from 1.18 lbs/min to 0.8 lbs/min). The viscosity of the finished polymer can be estimated from the pressure differential in the transfer line directly before the stranding die and pelletization step. In the following test, the amount of phosphorus-containing catalyst was reduced 68% (*i.e.*, from 1.18 lbs/min to 0.8 lbs/min) a change from 56 ppm to approximately 40 ppm phosphorus. The pressure drop in the transfer line did not change over a four hour run period. This run period provides sufficient residence time for the polymer with the reduced level of phosphorus to have made it through the process. No discernible change in transfer line pressure differential was observed during this test. See Figure 7. The conclusion is that the product melt viscosity (and therefore the product molecular weight) had not changed due to the presence of the reduced amount of phosphorus. The catalytic effectiveness of the phosphorus-containing compound was not changed significantly between approximately 40 ppm P and approximately 56 ppm P.

[00056] These examples show that while there is color improvement and catalytic rate improvement with the addition of phosphorus, there is a minimum phosphorus content that is required for effectiveness, and increasing that content above that minimal amount does not significantly improve the effectiveness of the color of the polyamide or the catalytic activity attributed to the phosphorus. There is a clear reduction in the performance of the melt filter screens, and other aspects of nylon polymerization with an increase of phosphorus content. A process improvement has been demonstrated upon changing the target phosphorus content from 56 ppm to 45 ppm.

[00057] In an exemplary embodiment, nylon 6,6 is the preferred polyamide and is used to prepare injection molded articles, such as, for example, cable ties, such as for electrical installation. The cable ties can be tested for performance using various techniques, such as those described by Underwriters Laboratory (UL) Standard No. 62275, which describes, for example, how to install a cable tie.

[00058] In a particular embodiment, the cable ties were injection molded from one or more nylon 6,6-containing materials, and sealed in moisture proof packaging to keep them 'dry as molded' The cable ties were then installed on, for example, a steel mandrel using an installation tool with an adjustable tensioning capability, set to deliver approximately 35 to

37 lbs of tension during installation before cutting the excess “tail” off of the tie. Installation of the ties is considered successful if the assembled cable tie is installed without any breakage, and remains intact after installation. The installation test is therefore a pass-fail type of test, wherein the success rate (*i.e.*, the percentage of ties passing the installation test) is a measure of the toughness of the nylon 6,6-containing materials comprising the ties, as a fraction of the cable ties failed to be installed successfully.

[00059] In an experiment designed to assess the correlation between phosphorus levels in the nylon 6,6-containing materials with the installation success of cable ties comprising such materials, a series of materials with different phosphorus (P) levels were molded into cable ties, the ties collected and maintained in a “dry as molded” state. Several items were molded from each material, consisting of different production lots. A number of cable ties from each item were subjected to an installation test and the fraction of specimens achieving successful installation recorded. The results of three such materials with differing phosphorus levels are summarized in table 4.

Table 4.

Material	average success rate	P level (ppm)	n (items)	n (ties)	95% CI
Vydyne 21SPC	96.00	45	10	11884	0.36
PIQ621	97.78	20	10	7895	0.32
21Z	98.87	0	3	2393	0.42

P level = phosphorus level

n (items) = number of items tested

n (ties) = number of cable ties tested

The results revealed that the average installation success rate is highest for materials containing no phosphorus, intermediate for materials containing 20 ppm phosphorus and lowest for materials containing 45 ppm phosphorus. These results are displayed graphically in Figure 10. Because the test is a pass-fail type of test, the expectation is that the results follow a binomial distribution. The standard deviation (σ) of a binomial distribution is determined from the probability of successful installation (mean fraction passing) and the number of specimens (cable ties) tested. As such, the uncertainty associated with a measurement can be decreased by increasing the number of specimens tested. The 95%

confidence interval (CI) is determined to be +/- 1.96x the standard deviation as indicated below:

$$\mu \text{ (mean)} = \text{mean fraction passing (pbar)}$$

$$\sigma \text{ (std. dev.)} = \sqrt{\{(\text{pbar} * (1 - \text{pbar})) / n\}}$$

$$\text{pbar's 95\% CI} = \text{pbar} \pm 1.96\sigma$$

The high number of specimens tested and the high probability of passing the test allows for a high degree of confidence - approximately 0.4% - which is sufficient to allow a statement that the difference in performance between the three tested materials is significant at the 95% confidence interval.

[00060] The potential of a phosphorus-containing compound for increasing the RV or molecular weight of nylon 6,6 during injection molding is well known. Two known approaches described in the literature for controlling RV build during injection molding are the incorporation into the nylon melt either before or during polymerization of a (divalent) metal that deactivates the catalyst. See, *e.g.*, U.S. Patent Nos. 8,501,900 and 5,929,200. The problem with this approach is that although the incorporation of the metal-containing compound reduces the catalytic effect of the phosphorus-containing compound, it also interferes with the positive aspect of accelerated polymerization which in turn improves productivity. In a second approach, the use of so-called end group cappers such as acetic acid has been described. The problem with the end group cappers approach is that it is not very effective. In the following examples, it is shown that the application of a metal-containing compound external to the molding resin unexpectedly provides superior control of molecular weight or RV build during injection molding. The application of this effective catalytic control is applied post polymerization of the polyamide product so that the full catalytic effect of the phosphorus is enjoyed throughout the polymerization of the product. A study was conducted where a polyamide 6,6 pellet was injection molded at a variety of moisture levels, and the difference in RV or molecular weight build is determined for each moisture condition. Figure 8 shows that at lower moistures, the change in RV is greater than 20 units, whereas with the addition to the external surface of the pellet a metal-

containing compound, in this case 500 ppm zinc stearate, causes the material to be less reactive and exhibit a change in RV under low moisture conditions of less than 11 RV units.

[00061] In another study, the effect of phosphorus levels and acetic acid end capping was demonstrated. As shown in Figure 9, the change in RV upon injection molding was greater than 16 RV units, and approaching 20 RV units for samples containing 1300 to 1500 ppm acetic acid. The use of acetic acid end cappers is therefore not as effective for controlling RV build ion injection molding compared to the addition of a metal-containing compound.

[00062] All published documents (*e.g.*, patents, journal articles, books) cited herein are incorporated by reference in their entireties.

IN THE CLAIMS:

1. A low-color polyamide comprising:
a phosphorus-containing compound, wherein the phosphorus-containing compound contains 25 to 50 ppm of phosphorus; and
a metal-containing compound present on the surface of the polyamide in a concentration of 500 to 1,500 ppm.
2. The polyamide according to claim 1, further comprising a carboxylic acid.
3. The polyamide according to claim 2, wherein the carboxylic acid is selected from the group consisting of acetic acid, propionic acid and benzoic acid.
4. The polyamide according to claim 2, wherein the carboxylic acid is present in a concentration of 1,200 to 1,800 ppm.
5. The polyamide according to claim 1, wherein the metal-containing compound is a stearate.
6. The polyamide according to claim 5, wherein the stearate is selected from the group consisting of aluminum, iron, lead, lithium, magnesium, sodium and potassium stearates.
7. The polyamide according to claim 1, wherein the phosphorus-containing compound is sodium hypophosphite.
8. The polyamide according to claim 5, wherein the stearate is aluminum distearate.

9. The polyamide according to claim 1, wherein the polyamide has a relative viscosity in a range of 40 to 80, when measured using 90% formic acid and glass capillary Ubbelohde viscometers according to standard test method ASTM D789 by comparing viscosity of a solution of polyamide in formic acid with viscosity of the formic acid.
10. An article comprising the low-color polyamide according to claim 1.
11. The polyamide according to claim 1, wherein the polyamide is nylon 6,6.
12. The polyamide according to claim 1 wherein the polyamide exhibits reduced plate-out and deposits during manufacture and processing.
13. The polyamide according to claim 1 wherein the polyamide exhibits increased production rate due to the presence of catalytic amount of the phosphorus-containing compound.
14. The polyamide according to claim 1, further comprising at least one selected from the group consisting of glass fibers, waxes, minerals, carbon fibers, chain terminators, viscosity modifiers, plasticizers, heat stabilizers, UV stabilizers, colorants, impact modifiers, flame retardants, delusterants, fillers, antimicrobial agents, antistatic agents and optical brighteners.