

FLAME RETARDED POLYURETHANE FOAM

TECHNICAL FIELD

[0001] This invention relates to flame retarded rigid polyurethane foams, and to compositions which can be used in forming such foams.

BACKGROUND

[0002] Rigid polyurethane foam is processed using a cast process or spray process. The cast process is generally utilized for block foam production, continuous double band lamination, and discontinuous panel production. Spray polyurethane foam has been used as a roofing insulation and sealing product for many years. Spray polyurethane foam adheres to and also forms to the walls and floors to create a tight seal and insulating barrier that stops air leakage.

[0003] Fire resistance is an important property of these materials. Various compounds or mixtures thereof have been used effectively to meet applicable fire safety standards. However, in addition to effectiveness as flame retardants, it is desired to provide compounds and/or mixtures that are compatible with the foam manufacturing processes, and do not migrate out of the polyurethane foam over time.

SUMMARY OF THE INVENTION

[0004] This invention provides compositions and processes for producing flame retardant polyurethane foams, which are generally closed-celled, rigid polyurethane foams. Also provided are formulations that can be used to make flame retardant rigid polyurethane foams.

[0005] An embodiment of this invention is a flame retardant composition which is comprised of or formed from components comprising at least one isocyanate-reactive sulfur-containing compound and at least one isocyanate-reactive brominated flame retardant.

[0006] Other embodiments of this invention include formulations, processes for forming rigid polyurethane foams, and rigid polyurethane foams.

[0007] These and other embodiments and features of this invention will be still further apparent from the ensuing description and appended claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008] Fig. 1A is a photograph showing the char on the underside of a rigid polyurethane foam square formed from ingredients including E-300 and RB-79.

[0009] Fig. 1B is a photograph showing the char on the underside of a rigid polyurethane foam square formed from ingredients including E-300, RB-79, and a nanoclay.

[0010] Fig. 2 shows cone calorimeter heat release rate curves for Example 3, Run i (solid line), and Example 3, Run ii (dashed line).

FURTHER DETAILED DESCRIPTION OF THE INVENTION

[0011] As used throughout this document, the phrase "reactive brominated flame retardant" has equivalent meaning to "isocyanate-reactive brominated flame retardant." Similarly, the phrase "reactive sulfur-containing compound" has equivalent meaning to "isocyanate-reactive sulfur-containing compound" as used throughout this document.

[0012] The reactive sulfur-containing compounds used pursuant to this invention are isocyanate-reactive sulfur-containing compounds which contain at least one functional group which is available for, and capable of, reacting with another polyurethane-forming component during polyurethane formation so that the resultant polyurethane contains the reactive brominated flame retardant in chemically-bound form. It is believed that the functional groups of the reactive sulfur-containing compound react with isocyanate groups during the preparation of polyurethane foam. The isocyanate-reactive groups are typically amine groups (primary or secondary) and/or hydroxyl groups. In some embodiments, it is preferred that there are two isocyanate-reactive groups.

[0013] One or more sulfur atoms are present in the sulfur-containing compound; often, there are two sulfur atoms in the molecule. When the reactive sulfur-containing compound has two or more sulfur atoms, the sulfur atoms may be adjacent to one another, or may be spaced apart by one or more other atoms in the molecule. The organic portion of the molecule can be aliphatic (straight chain, branched, or cyclic), aromatic, alk-aromatic, or a mixture of these.

[0014] In various embodiments of the invention, the isocyanate-reactive sulfur-containing compounds are disulfides, especially where the organic portion of the disulfide is an aliphatic straight chain, and sulfur-containing aromatic diamines.

[0015] In some embodiments, the reactive sulfur-containing compound is one or more sulfur-containing aromatic diamines. The sulfur-containing aromatic diamines used pursuant to this invention are in the form of a benzene ring having two primary amino

groups, two methylthio groups, and a methyl group on the ring. The amino groups are at the 3 and 5 positions on the ring; the methyl group is in the 1 position; and the methylthio groups are in either the 2 and 4 or the 2 and 6 positions on the ring. Sulfur-containing aromatic diamines are typically sold commercially as chain extenders or curatives for use in polyurethane formation.

[0016] Those of skill in the art will recognize that there are several ways to name sulfur-containing aromatic diamines. For example, 3,5-dimethylthio-toluene-2,4-diamine can be called 2,4-dimethylthio-6-methyl-1,3-benzenediamine, 2,4-dimethylthio-6-methyl-1,3-phenylenediamine, or 3,5-dimethylthio-2,4-diaminotoluene. The sulfur-containing aromatic diamines are 3,5-dimethylthio-toluene-2,4-diamine, 3,5-dimethylthio-toluene-2,6-diamine, and mixtures thereof. When a mixture is used, the two sulfur-containing aromatic diamines can be in any amount relative to each other, often ranging from about 90:10 to 10:90, and preferably about 20:80 to 80:20 by weight of 3,5-dimethylthio-toluene-2,4-diamine to 3,5-dimethylthio-toluene-2,6-diamine.

[0017] Preferred in the practice of this invention is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine, which is commercially available from Albemarle Corporation as Ethacure[®] 300 curative (E-300), typically having about 75 wt% to about 85 wt% 3,5-dimethylthio-toluene-2,4-diamine and about 15 wt% to about 25 wt% of 3,5-dimethylthio-toluene-2,6-diamine.

[0018] In other embodiments, the reactive sulfur-containing compound is a disulfide, preferably in which the organic portion is an aliphatic straight chain, and the reactive groups are hydroxy groups. Preferably, each aliphatic portion has one to about ten carbon atoms, more preferably one to about six carbon atoms. A preferred disulfide is bis(2-hydroxyethyl)disulfide, which is also called 2-hydroxyethyl disulfide or 2,2'-dithiodiethanol, and is sometimes abbreviated herein as BHEDS.

[0019] An isocyanate-reactive brominated flame retardant contains at least one functional group which is available for, and capable of, reacting with another polyurethane-forming component during polyurethane formation so that the resultant polyurethane contains the reactive brominated flame retardant in chemically-bound form. It is believed that the functional groups of the reactive brominated flame retardant react with isocyanate groups during the preparation of polyurethane foam; usually, the functional (reactive) groups in the reactive brominated flame retardants are hydroxyl groups.

[0020] Suitable isocyanate-reactive brominated flame retardants in the practice of this invention include brominated aromatic diester diols, 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, dibromoneopentyl glycol and tetrabromobenzenedimethanol. In some embodiments, 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, and/or a brominated aromatic diester diol are preferred isocyanate-reactive brominated flame retardants.

[0021] Brominated aromatic diester diols in the practice of this invention are liquid diol esters of polybromophthalic acid or anhydride, where the aromatic moiety has 1 to 4, preferably 2 to 4, more preferably 4, bromine atoms. Examples of such compounds are a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol (Saytex[®] RB-79 flame retardant, Albemarle Corporation). Methods for manufacturing such compounds are described for example in U.S. Pat. No. 4,564,697.

[0022] The reactive brominated flame retardant 2,3-dibromo-2-propen-1-ol is often referred to as 2,3-dibromoallyl alcohol or DBAA. DBAA is a known molecule, but is not commercially available. Synthesis of DBAA from propargyl alcohol (2-propyn-1-ol) and elemental bromine (Br₂) at room temperature in a solvent is known.

[0023] Tribromoneopentyl alcohol is commercially available, and is also referred to as pentaerythritol tribromide and as 2,2-bis(bromomethyl)-3-bromo-propan-1-ol.

[0024] Dibromoneopentyl glycol is commercially available, and is also referred to as pentaerythritol dibromide and as 2,2-bis(bromomethyl)-3-bromo-propan-1-ol.

[0025] Tetrabromobenzenedimethanol is also called tetrabromo(hydroxymethyl)phenylmethanol and tetrabromo-xylene-diol. More properly, tetrabromobenzenedimethanol is named 2,3,5,6-tetrabromobenzene-1,3-dimethanol, or {2,3,5,6-tetrabromo-4-(hydroxymethyl)phenyl}methanol, or 2,3,5,6-tetrabromo-*p*-xylene- α,α' -diol. While the *ortho* and *meta* isomers are known and usable, the *para* isomer is typically used, and is commercially available.

[0026] In the flame retardant composition, when the reactive sulfur-containing compound is one or more sulfur-containing aromatic diamines, the relative amount of the isocyanate-reactive brominated flame retardant to the sulfur-containing aromatic diamine is typically in the range of about 0.2:1 to about 6:1 by weight, preferably about 1:1 to about 6:1. In some embodiments, the relative amount of the reactive brominated flame retardant to the sulfur-containing aromatic diamine is typically in the range of about 1.5:1 to about 4:1 by weight; in other embodiments, the relative amount of the brominated

aromatic diester diol to the sulfur-containing aromatic diamine is typically in the range of about 3:1 to about 5:1 by weight.

[0027] When the reactive sulfur-containing compound in the flame retardant composition is one or more disulfides, the relative amount of the isocyanate-reactive brominated flame retardant to the disulfide is typically in the range of about 0.75:1 to about 5:1 by weight, preferably about 1:1 to about 4:1.

[0028] When the reactive sulfur-containing compound is one or more sulfur-containing aromatic diamines, amounts of the sulfur-containing aromatic diamine in the flame retardant composition in some embodiments are in an amount of about 10 wt% to about 45 wt%, preferably about 15 wt% to about 30 wt%, relative to the total weight of the flame retardant composition. In other embodiments, amounts of the sulfur-containing aromatic diamine in the flame retardant composition are about 0.5 wt% to about 10 wt%, preferably about 1 wt% to about 7 wt%, relative to the total weight of the flame retardant composition.

[0029] In some embodiments in which the reactive sulfur-containing compound is one or more sulfur-containing aromatic diamines, amounts of the isocyanate-reactive brominated flame retardant in the flame retardant composition are in an amount of about 45 wt% to about 80 wt%, preferably about 50 wt% to about 75 wt%, relative to the total weight of the flame retardant composition. More preferably, when the reactive brominated flame retardant is DBAA, the amount is about 50 wt% to 65 wt%, relative to the total weight of the flame retardant composition; when the reactive brominated flame retardant is a brominated aromatic diester diol, the amount is about 55 wt% to 75 wt%, relative to the total weight of the flame retardant composition.

[0030] In other embodiments, amounts of the isocyanate-reactive brominated flame retardant, especially brominated aromatic diester diols, in the flame retardant composition are in an amount of about 5 wt% to about 30 wt%, preferably about 10 wt% to about 20 wt%, relative to the total weight of the flame retardant composition.

[0031] When the reactive sulfur-containing compound is a disulfide, amounts of the disulfide in the flame retardant composition in some embodiments are about 10 wt% to about 55 wt%, preferably about 15 wt% to about 25 wt%, relative to the total weight of the flame retardant composition. In other embodiments, the disulfide amount is preferably about 45 wt% to about 85 wt%, relative to the total weight of the flame retardant composition.

[0032] In still other embodiments, amounts of the isocyanate-reactive brominated flame retardant, especially DBAA, in the flame retardant composition are in an amount of about 60 wt% to about 90 wt%, preferably about 75 wt% to about 90 wt%, relative to the total weight of the flame retardant composition, especially when the reactive sulfur-containing compound is a disulfide.

[0033] The flame retardant composition may further comprise tris(1-chloro-2-propyl)phosphate, sometimes referred to as tris(2-chloropropyl)phosphate, especially when the reactive sulfur-containing compound is one or more sulfur-containing aromatic diamines. When present, the tris(1-chloro-2-propyl)phosphate is typically used in an amount of about 50 wt% to about 90 wt%, preferably about 60 wt% to about 85 wt%, more preferably about 70 wt% to about 85 wt%, relative to the total weight of the flame retardant composition. Tris(1-chloro-2-propyl)phosphate is preferably used in combination with a brominated aromatic diester diol.

[0034] Nanoclays in the flame retardant composition are surface-modified hydrophilic clays, preferably surface-modified montmorillonite nanoclays. More particularly, the nanoclays have been modified with an amine compound containing saturated hydrocarbyl groups preferably having about 8 to about 24 carbon atoms, and have an average particle size of about 25 microns or less, preferably about 20 microns or less, more preferably about 15 microns to about 20 microns. A preferred nanoclay is a montmorillonite clay surface modified with 0.5 to 5 wt% aminopropyltriethoxysilane and 15 to 35 wt% octadecylamine (Nanomer[®] I.31PS, Sigma-Aldrich). Nanoclays are generally present in an amount of about 0.5 wt% to about 5 wt%, preferably about 1 wt% to about 4 wt%, more preferably about 1 wt% to about 3 wt%, relative to the total weight of the flame retardant composition.

[0035] In some preferred embodiments, the flame retardant composition comprises a sulfur-containing aromatic diamine, an isocyanate-reactive brominated flame retardant, and either a nanoclay or tris(1-chloro-2-propyl)phosphate, preferably both a nanoclay and tris(1-chloro-2-propyl)phosphate, especially when the reactive brominated flame retardant is a brominated aromatic diester diol.

[0036] In other preferred embodiments, the flame retardant composition comprises a sulfur-containing aromatic diamine as the isocyanate-reactive sulfur-containing compound, and a brominated aromatic diester diol and tribromoneopentyl alcohol as the isocyanate-reactive brominated flame retardant. In still other preferred embodiments, the

isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is tribromoneopentyl alcohol or 2,3-dibromoallyl alcohol. More preferably, the sulfur-containing aromatic diamine in these embodiments is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine.

[0037] In another preferred embodiment, the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and a disulfide, and the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol. More preferably, the sulfur-containing aromatic diamine in this embodiment is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine and the disulfide is bis(hydroxyethyl)disulfide.

[0038] In still another preferred embodiment, the isocyanate-reactive sulfur-containing compound is a disulfide and the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, 2,3-dibromoallyl alcohol, and/or tribromoneopentyl alcohol. Preferred combinations include a disulfide and a brominated aromatic diester diol; a disulfide and 2,3-dibromoallyl alcohol; and a disulfide and tribromoneopentyl alcohol. More preferably, the disulfide in these embodiments is bis(hydroxyethyl)disulfide.

[0039] In an embodiment, in the flame retardant composition, the sulfur-containing aromatic diamine is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine, preferably in an amount of about 10 wt% to about 45 wt%; and the reactive brominated flame retardant is 2,3-dibromoallyl alcohol, preferably in an amount of about 50 wt% to about 75 wt%, more preferably about 50 wt% to about 65 wt%. All of the wt% values in this paragraph are relative to the total weight of the flame retardant composition.

[0040] In another embodiment, in the flame retardant composition, the sulfur-containing aromatic diamine is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine, preferably in an amount of about 0.5 to about 10 wt%; the reactive brominated flame retardant is a brominated aromatic diester diol which is a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol, preferably in an amount of about 5 wt% to about 30 wt%; and either tris(1-chloro-2-propyl)phosphate, preferably in an amount of about 50 wt% to about 90 wt%, or a surface-modified montmorillonite clay, preferably a montmorillonite clay surface modified with 0.5 to 5 wt% aminopropyltriethoxysilane and 15 to 35 wt% octadecylamine, are present,

preferably in an amount of about 0.5 wt% to about 5 wt%. Preferably, both tris(1-chloro-2-propyl)phosphate and a surface-modified montmorillonite clay are present in the flame retardant composition. All of the wt% in this paragraph are relative to the total weight of the flame retardant composition.

[0041] In still another embodiment, in the flame retardant composition, the disulfide is bis(hydroxyethyl)disulfide, preferably in an amount of about 15 wt% to about 25 wt%; and the reactive brominated flame retardant is 2,3-dibromoallyl alcohol, preferably in an amount of about 75 wt% to about 90 wt%.

[0042] In yet another embodiment, in the flame retardant composition, the disulfide is bis(hydroxyethyl)disulfide, preferably in an amount of about 25 wt% to about 75 wt%; and the reactive brominated flame retardant is tribromoneopentyl alcohol, preferably in an amount of about 35 wt% to about 60 wt%.

[0043] In another embodiment, in the flame retardant composition, the disulfide is bis(hydroxyethyl)disulfide, preferably in an amount of about 10 wt% to about 60 wt%, more preferably about 15 to 55 wt%; and the reactive brominated flame retardant is a brominated aromatic diester diol, preferably in an amount of about 35 wt% to about 90 wt%, more preferably about 45 wt% to about 85 wt%.

[0044] Formulations of the invention, which can be used as the B side in processes for forming polyurethane foams, comprise a polyol, a blowing agent, a catalyst, a surfactant, and an isocyanate-reactive brominated flame retardant. When producing a formulation of the invention, the sulfur-containing aromatic diamine and the reactive brominated flame retardant can be introduced separately or in the form of a flame retardant composition of the invention.

[0045] When the reactive sulfur-containing compound is one or more sulfur-containing aromatic diamines, the amount of sulfur-containing aromatic diamine in the formulation is in the range of about 1 wt% to about 20 wt%, preferably in the range of about 2 wt% to about 15 wt%, and more preferably in the range of about 2 wt% to about 12 wt%, based on the total weight of the formulation.

[0046] In the formulation, the amount of isocyanate-reactive brominated flame retardant is in the range of about 1 wt% to about 25 wt%, preferably about 4 wt% to about 20 wt%, more preferably about 4 to about 15 wt%, based on the total weight of the formulation.

[0047] Tris(1-chloro-2-propyl)phosphate, when present in the formulation, is typically in an amount of about 20 wt% to about 60 wt%, preferably about 20 wt% to about 45 wt%,

more preferably about 25 wt% to about 40 wt%, based on the total weight of the formulation.

[0048] Amounts of nanoclay in the formulations of this invention are in an amount of about 0.5 wt% to about 5 wt%, preferably about 1 wt% to about 4 wt%, more preferably about 1 wt% to about 3 wt%, based on the total weight of the formulation.

[0049] When the reactive sulfur-containing compound is a disulfide, the amount of disulfide in the formulation is in the range of about 1 wt% to about 15 wt%, preferably in the range of about 3 wt% to about 12 wt%, based on the total weight of the formulation.

[0050] Polyurethane foams are typically produced by contacting two main liquid components, *viz.*, polyisocyanates (A side) and polyols (B side). It is desirable for the B side (here, the formulation of the invention), which contains all of the components other than the polyisocyanates, to be in the form of a liquid. As used herein, the term "liquid" means that the formulation is in the liquid state of aggregation at 22°C. Nanoclays are not liquids; however, when a nanoclay is included in the B-side formulation, the nanoclay remains suspended in solution for a minimum of several hours, at least on the laboratory scale.

[0051] In an embodiment, in the formulation, the reactive sulfur-containing compound is a sulfur-containing aromatic diamine which is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine, preferably in an amount of about 2 wt% to about 15 wt%; and the reactive brominated flame retardant is preferably in an amount of about 4 wt% to about 20 wt%; preferably, the reactive brominated flame retardant is 2,3-dibromoallyl alcohol or a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol with tris(1-chloro-2-propyl)phosphate, preferably in an amount of about 50 wt% to about 70 wt%, and/or a surface-modified montmorillonite clay, preferably montmorillonite clay surface modified with 0.5 to 5 wt% aminopropyltriethoxysilane and 15 to 35 wt% octadecylamine, preferably in an amount of about 1 wt% to about 4 wt%. Preferably, both tris(1-chloro-2-propyl)phosphate and a surface-modified montmorillonite clay are present in the formulation with the sulfur-containing aromatic diamine. All of the wt% in this paragraph are based on the total weight of the formulation.

[0052] In another embodiment, in the formulation, the reactive sulfur-containing compound is a disulfide which is bis(2-hydroxyethyl)disulfide, preferably in an amount of about 3 wt% to about 12 wt%; and the reactive brominated flame retardant is preferably in an amount of about 5 wt% to about 20 wt%; preferably, the reactive brominated flame

retardant is 2,3-dibromoallyl alcohol or tribromoneopentyl alcohol. All of the wt% values in this paragraph are based on the total weight of the formulation.

[0053] The isocyanate-reactive brominated flame retardants become part of the polyurethane foam, along with the isocyanate-reactive sulfur-containing compounds. This provides the advantage that these components do not migrate out of the foam, in contrast to other compounds often used in polyurethane foams for flame retardant purposes.

[0054] The polyol or polyols used in forming the polyurethane foams in the practice of this invention can be any polyol that is typically used to produce rigid polyurethane foams. Often, mixtures of polyols are used, with the particular polyols selected for their effect on the properties of the polyurethane foam being formed.

[0055] The polyol usually is a polyol or mixture of polyols having hydroxyl numbers in the range of about 100 to about 850 mg KOH/g, preferably in the range of about 110 to about 600 mg KOH/g. When polymeric polyols are used, they typically have molecular weights in the range of about 250 to about 5000, often about 400 to about 3000.

[0056] Suitable polyols for forming polyurethane foams include polyether polyols, polyester polyols, aliphatic polyols, and polyoxyalkylene glycols. Mixtures of two or more polyols can be used. Preferred polyols for forming rigid polyurethane foams include polyester polyols.

[0057] Polyoxyalkylene glycols that can be used include polyoxyethylene glycol, polyoxypropylene glycol, and block and heteric polyoxyethylene-polyoxypropylene glycols.

[0058] The aliphatic polyols typically contain up to about 18 carbon atoms per molecule. Suitable aliphatic polyols include ethylene glycol, propylene glycol, the isomeric butylene glycols, diethylene glycol, 1,5-pentanediol, 1,6-hexanediol, triethylene glycol, glycerol, trimethylolethane, trimethylolpropane, 1,2,6-hexanetriol, pentaerythritol, tetraethylene glycol, dipentaerythritol, sorbitol, sucrose, and alpha-methylglycoside.

[0059] Polyether polyols are produced by reacting one or more alkylene oxides having 2 to about 8 carbons in the alkylene radical with an initiator molecule containing two or more hydroxyl groups. Suitable polyether polyols include sucrose/glycerine polyether polyol; sucrose polyether polyol based on glycerine, propylene oxide and ethylene oxide; glycerin-initiated polyether polyols, *e.g.*, glycerine/propylene oxide polyether polyol; and mannich-based polyether polyols.

[0060] Polyester polyols are produced by polymerizing polycarboxylic acids or their derivatives, for example their acid chlorides or anhydrides, with a polyol. Suitable

polyester polyols include aromatic polyester polyols and diethylene glycol-phthalic anhydride polyester polyol.

[0061] For forming rigid polyurethane foams, the amount of polyol typically ranges from about 40 wt% to about 80 wt%, and often from about 50 wt% to about 70 wt%, based on the total weight of the B side components (formulation). These amounts refer to the total amount of polyol in the formulation, when there is more than one polyol present.

[0062] The blowing agent is preferably present in an amount of about 5 to about 25 wt% of the total weight of the formulation; more preferably, the blowing agent is about 7.5 to about 20 wt% of the formulation. In some embodiments, the blowing agent is about 7.5 to about 15 wt% of the formulation; in other embodiments, the blowing agent is about 10 to about 20 wt% of the formulation.

[0063] Suitable blowing agents include water; halocarbons (fully halogenated chlorofluorocarbons), in particular trichlorofluoromethane (CFC-11); halohydrocarbons (hydrogen-containing chlorofluorocarbons, or HCFC's) such as 1,1-dichloro-1-fluoroethane (HCFC-141b), 1-chloro-1,1-difluoroethane (HCFC-142b), chlorodifluoromethane (HCFC-22), and *trans*-1-chloro-3,3,3-trifluoropropene (HFO-1233zd(E)); partially fluorinated hydrocarbons (HFC's) such as 1,1,1,3,3-pentafluoropropane (HFC-245fa), 1,1,1,2-tetrafluoroethane (HFC-134a), 1,1,1,3,3,3-hexafluoropropane (HFC-236fa), 1,1,2,3,3,3-hexafluoropropane (HFC-236ea), 1,1,1,4,4,4-hexafluorobutane (HFC-356mffm) and 1,2-bis(trifluoromethyl)ethene; and hydrocarbons such as n-pentane, isopentane, and cyclopentane. Mixtures of any two or more blowing agents can be used. Preferred blowing agents when forming rigid foams include water, 1,1,1,3,3-pentafluoropropane, *trans*-1-chloro-3,3,3-trifluoropropene, 1,2-bis(trifluoromethyl)ethene and mixtures of water with 1,1,1,3,3-pentafluoropropane, *trans*-1-chloro-3,3,3-trifluoropropene, or 1,2-bis(trifluoromethyl)ethene. In some instances, 2,3-dibromoallyl alcohol permits formulations in which water is the only blowing agent.

[0064] Types of catalysts that can be used in the practice of this invention include tertiary amines, tin catalysts, typically an organic tin compound, bismuth catalysts, other organometallic catalysts, and potassium salts of organic carboxylic acids. Mixtures of catalysts of the same type and/or different types can be used in the practice of this invention. The catalyst is preferably present in the formulation in an amount in the range of about 1 wt% to about 10 wt%, more preferably about 2.5 wt% to about 7.5 wt%, based on the total weight of the formulation. These amounts refer to the total amount of catalyst in the formulation, when there is more than one catalyst present.

[0065] In the tertiary amine catalysts, the groups on the tertiary amine are preferably alkyl groups; more preferably, the groups are oxygen-containing groups such as etheric or saturated alcoholic groups. Suitable tertiary amines include dimethylethyl amine, triethylenediamine, dimethylethylamine, dimethylcyclohexylamine, dimethylbenzylamine, tetramethyldipropylenetriamine, pentamethyldiethylenetriamine, tris(dimethylaminopropyl)hydrotriazine, 1-methyl-4-(2-dimethylaminoethyl)piperazine, 1,4-diaza(2,2,2)bicyclooctane, 3-methoxy-N,N-dimethylpropylamine, N-methylmorpholine, N-ethylmorpholine, N-cocomorpholine, bis(dimethylaminoethyl) ether, and ethanol amine catalysts, such as dimethylethanolamine, 2-(2-dimethylaminoethoxy)ethanol, and N,N,N'-trimethylaminoethyl-ethanol amine.

[0066] Types of tin compounds that can be used as catalysts include dialkyl(dialkylthio) stannanes, stannous(II) salts of organic carboxylic acids, and dialkyltin(IV) salts of carboxylic acids. Suitable tin catalysts in the practice of this invention include dibutylbis(dodecylthio) stannane, stannous(II) octoate, stannous(II) acetate, dibutyltin dilaurate, and dioctyltin diacetate.

[0067] Still another type of catalyst is one or more potassium salts of organic carboxylic acids. Suitable potassium salts include potassium acetate and potassium octoate.

[0068] A surfactant is often needed for production of polyurethane foam, and surfactants are normally used when forming polyurethane foams. Suitable silicone-based surfactants in the practice of this invention include silicone glycols, silicone glycol copolymers, polyether modified polysiloxanes, polyether modified dimethylpolysiloxanes such as a polyether polydimethylsiloxane copolymer, polysiloxane polyoxoalkylene copolymers, polysiloxane polyoxoalkylene copolymers, polysiloxane copolymers, and the like. Polyether modified dimethylpolysiloxanes are preferred silicone-based surfactants. The silicone-based surfactant is preferably present in the formulation in an amount in the range of about 0.5 wt% to about 5 wt%, more preferably about 0.75 wt% to about 3 wt%, based on the total weight of the formulation.

[0069] Other surfactants that can be used when forming rigid polyurethane foams include emulsifiers such as sodium salts of castor oil sulfates or fatty acids; fatty acid salts with amines, *e.g.*, diethylamine oleate and diethanolamine stearate; salts of sulfonic acids, *e.g.*, alkali metal or ammonium salts of *e.g.*, dodecylbenzenedisulfonic acid and ricinoleic acid; ethoxylated alkylphenols, ethoxylated fatty alcohols; ether amine quaternary ammonia compounds; 2-hydroxypropyltrimethylammonium formate; sodium hydroxy-

nonylphenyl-N-methylglycinate (the sodium salt of N-((2-hydroxy-5-nonylphenyl)methyl)-N-methyl-glycine), and castor oil.

[0070] One or more optional additives which can be included in a formulation of the invention include antioxidants, diluents, chain extenders or cross-linkers, synergists (preferably melamine), stabilizers, fungistats, pigments, dyes, fillers, antistatic agents, and plasticizers.

[0071] The components of the formulation can be combined in any order; preferably, the blowing agent is the last ingredient added. More preferably, the components of the flame retardant composition are combined with the polyol(s), followed by the surfactant, catalyst, and any optional ingredients, followed by the blowing agent.

[0072] The polyisocyanate (A-side component) used in forming the polyurethane foams in the practice of this invention include can be any polyisocyanate that can be used to produce rigid polyurethane foams. When a polymeric polyisocyanate is used, it preferably has an isocyanate (NCO) content of about 25 wt% to about 50 wt%, preferably about 25 wt% to about 40 wt%.

[0073] When forming rigid polyurethane foams, polyisocyanates are used, and the polyisocyanate can be aromatic or aliphatic. Suitable polyisocyanates for rigid polyurethane foams in the practice of this invention include, but are not limited to, 1,4-tetramethylene diisocyanate, 1,5-pentamethylene diisocyanate, 2-methyl-1,5-pentamethylene diisocyanate, 1,6-hexamethylene diisocyanate (HMDI), 1,7-heptamethylene diisocyanate, 1,10-decamethylene diisocyanate, cyclohexylene diisocyanate, isophorone diisocyanate (IPDI), 4,4'-methylenedicyclohexyl diisocyanate (H12MDI), hexahydrotoluene diisocyanate and isomers thereof, 2,2,4-trimethylhexamethylene diisocyanate, 2,4,4-trimethylhexamethylene diisocyanate, 4,4'-methylenebis(cyclohexylisocyanate), phenylene diisocyanate, toluene diisocyanate (TDI), xylene diisocyanate, other alkylated benzene diisocyanates, toluene diisocyanate, 1,5-naphthalene diisocyanate, diphenylmethane diisocyanate (MDI, sometimes called methylene diisocyanate), 1-methoxyphenyl-2,4-diisocyanate, 4,4'-diphenylmethane diisocyanate, 2,4'-diphenylmethane diisocyanate, mixtures of 4,4'- and 2,4'-diphenylmethane diisocyanate, 4,4'-biphenylene diisocyanate, 3,3'-dimethoxy-4,4'-biphenyl diisocyanate, 3,3'-dimethyl-4,4'-biphenyl diisocyanate, 4,4',4''-triphenylmethane triisocyanate, toluene 2,4,6-triisocyanate, 4,4'-dimethyldiphenylmethane-2,2',5,5'-tetraisocyanate, polymeric polyisocyanates such as polymethylene polyphenylene polyisocyanate, and mixture of any two or more of the foregoing.

[0074] Polyisocyanates that can be used in forming rigid polyurethane foams of the present invention include those isocyanates commonly referred to as polymeric methylene diphenyl diisocyanate (MDI), polyisocyanate-based prepolymers, and mixtures thereof. Polymeric MDI contains varying amounts of isomeric diphenylmethane diisocyanates and three-ring, four-ring, and greater than four-ring oligomers. In general, any commercial polymeric MDI having an isocyanate content of about 25 wt% or more may be used. A preferred polymeric MDI has an isocyanate content of about 30 wt% or more. Other isocyanates may be present with the polymeric MDI in minor amounts, as long as the polyisocyanate mixture as whole remains liquid. Preferably, the polyisocyanate is a polymeric MDI.

[0075] Polyurethane foam compositions of this invention are formed from two components, an A side and a B side. The A side is one or more polyisocyanates as described above, and the B side comprises a formulation of this invention. The A side and B side components are typically contacted in a ratio of about 1:1 by volume. The polyurethane formation reaction generally occurs readily at room temperature; normally, the A side and the B side begin to react with each other as soon as they are in contact, and continue to react (cure), forming a polyurethane foam. Often, the mixture of the A side and B side is sprayed or cast to form a polyurethane foam.

[0076] The polyurethane foam compositions of this invention are formed from A side and B side components in which the A side is a polyisocyanate as described above and the B side comprises a formulation of the invention.

[0077] The amount of isocyanates and/or polyisocyanate may be defined in terms of the Isocyanate Index.

$$\text{Isocyanate Index} = \frac{\text{Actual equivalent amount of isocyanate used}}{\text{Theoretical equivalent amount of reactive hydrogens}} \times 100$$

[0078] The theoretical equivalent amount of isocyanate is equal to one equivalent of isocyanate per one equivalent of reactive hydrogens from the B side. Rigid polyurethane foams are usually formed by bringing together polyisocyanates with compounds having isocyanate-reactive hydrogen atoms (*e.g.*, hydroxyl groups) in amounts such that the Isocyanate Index is in the range of about 85 to about 1000, preferably from about 95 to about 400, more preferably about 95 to about 200.

[0079] To form polyurethane foams, the functionality (*i.e.*, average number of hydroxyl groups per molecule), of the formulation (B side) which is typically provided by the polyol

or mixture of polyols, is usually about 2 or more, preferably about 2 to about 8; more preferably about 3 or more, especially about 3 to about 8, more especially about 3 to about 7. Monoalcohol reactive brominated flame retardants such as 2,3-dibromoallyl alcohol and tribromoneopentyl alcohol have a functionality of one (*i.e.*, one hydroxyl group in the molecule), which is chain-terminating, so at least a portion of the polyols in the formulation have three or more hydroxyl groups per molecule to form polyurethane foams. The hydroxyl groups of the isocyanate-reactive brominated flame retardants are included in the calculation of the average functionality of the B side.

[0080] The polyurethane foams formed in this invention have a density range that varies with the end use application. For open-cell insulation foams, the density range is generally about 0.4 lb/ft³ to about 1.2 lb/ft³ (6.3 kg/m³ to 18.9 kg/m³). For closed-cell insulation foams, the density range is typically about 1.6 lb/ft³ to about 3.5 lb/ft³ (25.6 kg/m³ to 56.1 kg/m³). For molded architectural foams, the density range is usually about 4.0 lb/ft³ to about 31 lb/ft³ (64.0 kg/m³ to 497 kg/m³).

[0081] The following examples are presented for purposes of illustration, and are not intended to impose limitations on the scope of this invention.

EXAMPLES - GENERAL

[0082] In the Examples, some of the substances used are referred to by their trade names. More specifically:

E-300: a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine (Ethacure[®] 300 curative, Albemarle Corporation).

Saytex[®] RB-79: a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol (Saytex[®] RB-79 flame retardant, Albemarle Corporation).

DBAA: 2,3-dibromoallyl alcohol.

BHEDS: bis(2-hydroxyethyl)disulfide.

TCPP: tris(1-chloro-2-propyl)phosphate.

EB: 2-butoxyethanol.

Nanoclay: montmorillonite clay, surface modified to contain 0.5 to 5 wt% aminopropyltriethoxysilane (Nanomer[®] I.31PS, Sigma-Aldrich).

Voranol[®] 280: a polyether polyol with a functionality of about 7.0, a hydroxyl number of about 280, and an average molecular weight of about 1400 (Dow Chemical Company).

Terate[®] HT 5349: an aromatic polyester polyol with a functionality of about 2.45, and a hydroxyl number of 295-315 (Invista).

Stepanpol[®] PS-2412: a modified aromatic polyester polyol with a functionality of about 2.0, a hydroxyl number of about 240, and an average molecular weight of about 468 (Stepan Chemical Company).

Carpol[®] GP-1500: glycerin-initiated polyether polyol with a functionality of about 3, a hydroxyl number of 112, and an average molecular weight of about 1500; **Carpol[®] GP-700:** glycerine and propylene oxide polyether polyol with a functionality of 3, a hydroxyl number of 240, and an average molecular weight of about 700 (all Carpol[®] materials are products of Carpenter Company).

Dabco[®] DC193: silicone surfactant; **Dabco[®] T-120:** dibutylbis(dodecylthio) stannane; **Dabco[®] K-15:** potassium octoate; **Dabco[®] TMR-2:** 2-hydroxypropyltrimethylammonium formate; **Dabco[®] T:** amine with hydroxyl groups; **Dabco[®] PM-300:** 2-butoxyethanol (all Dabco[®] materials are products of Air Products and Chemicals, Inc).

Polycat[®] 204: amine catalyst (Air Products and Chemicals, Inc).

Solstice[®] LBA: *trans*-1-chloro-3,3,3-trifluoropropene (Honeywell).

Genetron[®] 245fa: 1,1,1,3,3-pentafluoropropane (Honeywell).

Opteon[™] 1100: 1,2-bis(trifluoromethyl)ethene; also called Formacel[®] 1100 (The Chemours Company).

Papi[®] 27: polymeric MDI (Dow Plastics).

[0083] To prepare each polyurethane foam, blends of the B-side other than the catalyst(s) (polyols, surfactants, reactive brominated flame retardant(s), reactive sulfur-containing compound, and blowing agent) were made. The polyisocyanate and the B-side formulation were weighed into a 16 oz. (473 mL) paper cup and then mixed at 2000 rpm with a bow tie agitator for 15 seconds, at which point the catalyst(s) were injected into the mixture while the agitation continued. At the 20-second mark, the agitation was discontinued. After allowing the foam to sit for at least 24 hours, it was cut to generate the specimens for cone calorimeter testing. The specimen dimension was 4 in. x 4 in. x 1 in. (10.2 cm x 10.2 cm x 2.54 cm). Each specimen was weighed to determine the foam density. The catalyst was added after the A side and B side were brought into contact, which is related to handling and timing on the laboratory scale; at larger scales, the catalyst(s) are included in the B side formulations.

[0084] Cone calorimetry measurements were performed on a Fire Testing Technology Dual Cone Calorimeter according to ASTM E-1354. For Examples 1-2 and 4, an incident heat flux of 40 kW/m² was used in the cone calorimetry tests for the Predicted Smoke Index calculations and an incident heat flux of 100 kW/m² was used in the cone calorimetry tests for the Predicted Flame Spread Index calculations. In Example 3, an incident heat flux of 50 kW/m² was used in the cone calorimetry tests for both the Predicted Smoke Index calculations and the Predicted Flame Spread Index calculations. The Peak Heat Release Rate (PHRR), the maximum value of the heat released during combustion of the sample in the cone calorimeter, was measured. The ASTM E-84 burn profiles for Predicted Smoke Index calculations and for predicted Flame Spread Index calculations were calculated from the cone calorimetry results. Using mathematical equations that were previously derived from a cone calorimeter and ASTM E-84 correlation study, the cone calorimeter results were converted into predicted numbers as in ASTM E-84. The target value for the Flame Spread Index was less than 25, and the target value for the Smoke Index was less than 450. The term "Smoke Index" is short for "smoke density developed", which is also referred to as "Smoke Developed Index" and "Smoke Density Index."

[0085] For some samples, the dimensional stability was determined. Some samples were subjected to a thermal conductivity test, and R values were calculated from the thermal conductivities. The R value (or R-value) is a measure of insulation efficiency or thermal resistance (the ability of a material to slow down heat transfer within itself), and is often used in the building and construction industry. The higher the R-value, the more a material prevents heat transfer.

EXAMPLE 1 - COMPARATIVE

[0086] In the runs of this Example, the reactive sulfur-containing compound, the reactive brominated flame retardant, or both, were omitted from the foam. Amounts of the components are listed in Table 1, in which all amounts are reported as wt%; results are summarized in Table 2.

[0087] In regard to Run e, the RB-79 and TCPP were added as Saytex[®] RB-7001 flame retardant, a preformed mixture. Saytex[®] RB-7001 flame retardant is a blend of a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol and tris(2-chloropropyl)phosphate in a 45:55 ratio (Albemarle Corporation).

TABLE 1

Example 1 - Run	a	b	c	d	e	f	g	h
B side								
Viscosity (cPs; at 25°C)	1520	1455	-	-	1220	1090	890	1270
E-300	-	4.59	11.97	-	-	-	-	-
TCPP	-	-	-	11.97	6.58	-	-	7.96
RB-79	-	-	-	-	5.39	-	-	-
DBAA	-	-	-	-	-	7.38	11.97	4.01
Terate [®] HT 5349	54.85	51.80	46.91	46.91	46.91	49.95	46.91	48.21
Voranol [®] 280	27.85	26.31	23.82	23.82	23.82	25.37	23.82	24.49
Dabco [®] DC193	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00
Dabco [®] T-120	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Dabco [®] K-15	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Polycat 204	4.00	4.00	4.00	4.00	4.00	4.00	4.00	4.00
Water	0.80	0.80	0.80	0.80	0.80	0.80	0.80	0.80
Solstice [®] LBA	10.00	10.00	10.00	10.00	10.00	10.00	10.00	10.00
A side								
Papi [®] 27	100	100	100	100	100	100	100	100

TABLE 2

Example 1 - Foam properties						
Run	a	b	e	f	g	h
E-300	-	2.22 wt%	-	-	-	-
TCPP	-	-	3.29 wt%	-	-	6.65 wt%
RB-79	-	-	2.70 wt%	-	-	-
DBAA	-	-	-	3.64 wt%	5.97 wt%	3.35 wt%
Density	2.11 lb/ft ³ (33.8 kg/m ³)	2.18 lb/ft ³ (34.9 kg/m ³)	2.08 lb/ft ³ (33.3 kg/m ³)	1.87 lb/ft ³ (30.0 kg/m ³)	1.77 lb/ft ³ (28.4 kg/m ³)	1.95 lb/ft ³ (31.2 kg/m ³)
Peak Heat Release Rate	255	264	213	229	205	201
R-value	7.84/inch	7.46/inch	7.29/inch	7.38/inch	7.89/inch	7.61/inch
	1.356 m ² K/W	1.290 m ² K/W	1.261 m ² K/W	1.276 m ² K/W	1.364 m ² K/W	1.316 m ² K/W
Predicted Flame Spread Index	23	20.8	19	21.1	19.5	19.2
Predicted Smoke Index	81	134	23	16	24	25

EXAMPLE 2

[0088] In the runs of this Example, a sulfur-containing aromatic diamine and a reactive brominated flame retardant were included in the foam. The sulfur-containing aromatic diamine and the reactive brominated flame retardant were combined, and the properties of these mixture were tested; results are summarized in Table 3. In the runs of this Example, the foams were made with equivalent (equimolar) bromine content. Amounts of the components used in making the foam are listed in Table 4; results on the foams are summarized in Table 5.

TABLE 3

Example 2 - Run	1	2	3	4
E-300	27.69 wt%	22.15 wt%	38.36 wt%	32.85 wt%
RB-79	72.31 wt%	57.85 wt%	-	-
DBAA	-	-	61.6 wt%	52.76 wt%
EB	-	20.00%	-	14.39 wt%
Viscosity (25 °C)	31,650 cPs	450 cPs	60 cPs	50 cPs
Bromine content	32.9 wt%	26.3 wt%	45.6 wt%	39.0 wt%
Sulfur content	8.3 wt%	6.6 wt%	8.4 wt%	9.8 wt%
Specific Gravity	1.585	1.389	1.696	1.516
OH number, mg KOH/g	302.4	336.9	361.3	377.7

TABLE 4

Example 2 - Run	1	2	3	4
B side				
Viscosity (25 °C)	2106 cPs	1265 cPs	960 cPs	805 cPs
E-300	4.60 wt%	4.60 wt%	4.59 wt%	4.59 wt%
RB-79	12.00 wt%	12.00 wt%	-	-
DBAA	-	-	7.37 wt%	7.37 wt%
EB	-	4.15 wt%	-	2.00 wt%
Terate [®] HT 5349	43.84 wt%	41.09 wt%	46.91 wt%	45.58 wt%
Voranol [®] 280	22.26 wt%	20.87 wt%	23.82 wt%	23.15 wt%
Dabco [®] DC193	2.00 wt%	2.00 wt%	2.00 wt%	2.00 wt%
Dabco [®] T-120	0.25 wt%	0.25 wt%	0.25 wt%	0.25 wt%
Dabco [®] K-15	0.25 wt%	0.25 wt%	0.25 wt%	0.25 wt%
Polycat 204	4.00 wt%	4.00 wt%	4.00 wt%	4.00 wt%
Water	0.80 wt%	0.80 wt%	0.80 wt%	0.80 wt%
Solstice [®] LBA	10.00 wt%	10.00 wt%	10.00 wt%	10.00 wt%
A side				
Papi [®] 27	100 wt%	100 wt%	100 wt%	100 wt%

TABLE 5

Foam properties				
Example 2 - Run	1	2	3	4
E-300	2.3 wt%	2.3 wt%	2.30 wt%	2.30 wt%
RB-79	6.00 wt%	6.00 wt%	-	-
DBAA	-	-	3.68 wt%	3.68 wt%
EB	0 wt%	2.08 wt%	-	1.0 wt%
Density	2.02 lb/ft ³ (32.4 kg/m ³)	2.05 lb/ft ³ (32.8 kg/m ³)	1.92 lb/ft ³ (30.8 kg/m ³)	1.86 lb/ft ³ (29.8 kg/m ³)
Peak Heat Release Rate	233	237	200	214
R-value	7.88/inch	7.56/inch	7.55/inch	7.68/inch
	1.363 m ² K/W	1.307 m ² K/W	1.306 m ² K/W	1.328 m ² K/W
Predicted Flame Spread Index	19.5	19.4	16	20.7
Predicted Smoke Index	14	23	27	13

EXAMPLE 3

[0089] In the runs of this Example, a sulfur-containing aromatic diamine and a reactive brominated flame retardant were included in the foam. One of the runs in this Example employed a nanoclay. RB-79 and TCPP were added as Saytex[®] RB-7001 flame retardant; additional TCPP was added to the B-side mixture.

[0090] In the two runs of this Example, the foams were made with equivalent (equimolar) bromine content. Amounts of the components used in making the foam are listed in Table 6. Some of the curing properties of the foams were measured; results are summarized in Table 7; results on the foams are also summarized in Table 7.

[0091] **Fig. 1A** is a photograph showing the char on the underside of rigid polyurethane foam square formed as in Run i, in which the ingredients included E-300 and RB-79. **Fig. 1B** is a photograph showing the char on the underside of rigid polyurethane foam square formed as in Run ii, in which the ingredients included E-300, RB-79, and a nanoclay. Fig. 2 shows cone calorimeter heat release rate curves for Example 3, Run i (solid line), and Example 3, Run ii (dashed line). With the addition of 0.7 wt% nanoclay to the formulation, the flame retardant performance of the foam was improved.

TABLE 6

Example 4 - Run	i	ii
B side		
E-300	1.54 wt%	1.54 wt%
RB-79	6.46 wt%	6.46 wt%
TCPP	30.18 wt%	29.52 wt%
Nanoclay	0 wt%	0.66 wt%
Stepanpol [®] PS-2412	2.07 wt%	2.07 wt%
Dabco [®] DC193	0.88 wt%	0.88 wt%
Dabco [®] TMR-2	0.86 wt%	0.86 wt%
Dabco [®] K-15	1.29 wt%	1.29 wt%
Dabco [®] T	0.44 wt%	0.44 wt%
Dabco [®] PM-300	0.44 wt%	0.44 wt%
Water	0.44 wt%	0.44 wt%
Genetron [®] 245fa	7.84 wt%	7.84 wt%
A side		
Papi [®] 27	47.55 wt%	47.55 wt%

TABLE 7

Example 4 - Formulation	Run i	Run ii (+ clay)
Cream time	9 sec	8.72 sec
Gel time	43 sec	45 sec
Rise time	1 min. 5 s	1 min. 20 s
Tack free time	2 min. 17 s	3 min. 16 s
Density	1.89 lb/ft ³ (30.3 kg/m ³)	2.01 lb/ft ³ (32.2 kg/m ³)
LOI ¹	31.7	31.9
R value	5.5/inch	5.4/inch
	0.951 m ² K/W	0.934 m ² K/W
Dimensional stability ² (vol. change)	-6.62%	-4.42%
Compressive Strength	11.2 psi (7.72x10 ⁴ Pa)	9.8 psi (6.76x10 ⁴ Pa)

¹ Limiting Oxygen Index.

² Dimensional stability was measured at 70°C for 14 days at 95% RH.

EXAMPLE 4

[0092] In the runs of this Example, a disulfide and a reactive brominated flame retardant were included in the foam. In the runs of this Example, the foams were made with equivalent (equimolar) bromine content. Amounts of the components used in making the foam are listed in Table 8, in which all amounts are reported as wt%; results on the foams are summarized in Table A below.

[0093] Some of the runs employing BHEDS as the sulfur-containing compound have not been optimized with regard to the balance of polyol and/or polyether present in the formulation. Table C shows that most of the B-side formulations containing BHEDS had relatively low viscosities (under 1000 cPs).

TABLE 8

Example 4 - Run	A	B	C	D	E	F
B side						
Viscosity (25 °C)	930 cPs	1275 cPs	325 cPs	640 cPs	625 cPs	570 cPs
BHEDS	2.01	2.00	2.00	2.00	2.00	2.00
DBAA	8.02	8.00	8.00	8.00	8.00	8.00
Terate [®] HT 5349	46.34	53.34	--	33.34	46.2	47.72
Voranol [®] 280	24.47	--	--	--	--	--
Carpol [®] GP-700	--	28.16	81.35	--	24.4	25.20
Carpol [®] GP-1500	--	--	--	48.01	--	--
Dabco [®] DC193	2.01	2.00	2.00	2.00	2.00	2.00
Dabco [®] T-120	0.25	0.25	0.25	0.25	0.25	0.25
Dabco [®] K-15	0.25	0.25	0.25	0.25	0.25	0.25
Polycat 204	4.01	4.00	4.00	4.00	4.00	4.00
Water	0.60	2.00	2.15	2.15	0.65	0.58
Opteon [™] 1100	10.00	--	--	12.00	--	--
A side						
Papi [®] 27	100	100	100	100	100	100
Isocyanate Index	1.107	0.899	1.051	1.087	1.153	1.157

EXAMPLE 5

[0094] In the runs of this Example, various combinations of disulfide, a sulfur-containing aromatic diamine, and reactive brominated flame retardant(s) were included in the inventive foams. Runs 1-10 are comparative. In the runs of this Example, the foams were made with equivalent (equimolar) bromine content. Amounts of the components used in making the foam are listed below in Tables B-1 to B-4; results on the foams are summarized in Tables C-1 to C-5 below.

TABLE A

Example 4 - Foam properties						
Run	A	B	C	D	E	F
BHEDS	1.00 wt%	1.00 wt%	1.00 wt%	1.00 wt%	1.00 wt%	1.00 wt%
DBAA	4.01 wt%	4.00 wt%	4.00 wt%	4.00 wt%	4.00 wt%	4.00 wt%
Density	1.99 lb/ft ³ (31.9 kg/m ³)	2.12 lb/ft ³ (34.0 kg/m ³)	2.08 lb/ft ³ (33.3 kg/m ³)	2.48 lb/ft ³ (39.7 kg/m ³)	2.03 lb/ft ³ (32.5 kg/m ³)	2.01 lb/ft ³ (32.2 kg/m ³)
Dimensional Stability (vol. change)	3.99%	-72.6%	-48.85%	1.31%	14.64%	1.49%
Peak Heat Release Rate	229	251	292	696	246	224
R-value	7.67/inch	6.55/inch	4.92/inch	4.24/inch	7.57/inch	6.69/inch
	1.326 m ² K/W	1.133 m ² K/W	0.851 m ² K/W	0.733 m ² K/W	1.309 m ² K/W	1.157 m ² K/W
Predicted Flame Spread Index	19.8	22.4	23.3	23.3	21.5	20.3
Predicted Smoke Index	20	13	326	1509	19	34

*Dimensional stability was measured at 70°C for 14 days at 95% RH.

TABLE B-1

Example 5 - Run	1	2	3	4	5	6	7	8	9	10
B side										
Viscosity (25°C)	1180 cPs	1405 cPs	1810 cPs	580 cPs	700 cPs	1880 cPs	1910 cPs	1150 cPs	1170 cPs	1560 cPs
E-300	19.03	--	--	--	--	--	--	--	--	11.69
BHEDS	--	19.56	19.29	--	--	--	--	--	--	--
RB-79	--	--	--	--	--	17.72	16.83	--	--	11.18
DBAA	--	--	--	19.63	18.20	--	--	--	--	--
Br ₃ neopentylOH	--	--	--	--	--	--	--	19.11	17.55	--
Terate [®] HT 5349	40.22	44.57	49.39	38.69	44.27	40.58	44.91	39.22	44.91	39.28
Voranol [®] 280	21.80	25.08	20.53	22.82	18.67	22.81	19.37	22.82	18.68	18.92
Dabco [®] DC193	1.96	2.16	2.16	1.96	1.96	1.96	1.96	1.96	1.96	1.96
Dabco [®] T-120	0.24	0.27	0.27	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Dabco [®] K-15	0.24	0.27	0.27	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Polycat 204	3.92	4.31	4.31	3.93	3.93	3.92	3.92	3.93	3.93	3.92
Water	0.83	--	--	0.69	0.69	0.74	0.74	0.68	0.69	0.78
Opteon [™] 1100	11.76	3.78	3.78	11.78	11.78	11.77	11.77	11.78	11.78	11.77
A side										
Papi [®] 27	100	100	100	100	100	100	100	100	100	100

TABLE B-2

Example 5 - Run	11	12	13	14	15	16	17	18	19	20	21	22
B side												
Viscosity (25°C)	710 cPs	1155 cPs	1100 cPs	1170 cPs	1185 cPs	1150 cPs	2010 cPs	1500 cPs	1175 cPs	1200 cPs	800 cPs	880 cPs
E-300	11.73	14.52	4.15	9.01	19.61	9.01	--	--	--	--	--	--
BHEDS	--	--	--	--	--	--	4.17	11.61	11.82	11.82	8.37	8.37
RB-79	--	--	--	--	--	--	19.69	10.23	--	--	--	--
DBAA	11.32	3.01	--	--	--	--	--	--	--	--	9.59	9.59
Br ₃ neopentyIOH	--	--	19.63	9.26	4.15	9.26	--	--	11.68	11.68	--	--
Terate [®] HT 5349	38.69	44.89	38.73	42.04	38.66	42.04	38.83	39.98	40.30	40.30	42.53	42.51
Voranol [®] 280	19.37	18.66	18.68	20.80	18.66	20.80	18.74	21.98	20.68	20.68	21.22	21.20
Dabco [®] DC193	1.96	1.96	1.96	1.96	1.96	1.96	1.97	2.03	2.04	2.04	1.98	1.98
Dabco [®] T-120	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Dabco [®] K-15	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Polycat 204	3.92	3.92	3.93	3.92	3.92	3.92	3.94	4.05	4.09	4.09	3.95	3.95
Water	0.74	0.78	0.64	0.74	0.78	0.74	0.34	--	--	--	--	0.05
Opteon [™] 1100	11.77	11.76	11.78	11.77	11.76	11.77	11.82	9.62	8.89	8.89	11.86	11.85
A side												
Papi [®] 27	100	100	100	100	100	100	100	100	100	100	100	100

TABLE B-3

Example 5 - Run	23	24	25	26	27	28	29	30
B side								
Viscosity (25°C)	1270 cPs	1330 cPs	1250 cPs	1380 cPs	685 cPs	1535 cPs	715 cPs	1285 cPs
E-300	--	--	--	--	--	1.94	0.47	--
BHEDS	6.87	6.90	4.17	22.17	5.34	--	--	4.15
RB-79	8.52	8.55	5.61	1.08	--	11.40	--	11.67
DBAA	--	--	--	3.61	17.42	--	9.50	3.31
Br ₃ neopentylOH	5.72	5.75	14.10	--	1.12	8.22	10.13	0.54
Terate [®] HT 5349	41.73	41.88	38.84	43.72	38.87	38.71	41.20	38.83
Voranol [®] 280	18.78	18.86	18.75	21.10	18.76	20.87	19.84	22.89
Dabco [®] DC193	1.97	2.00	1.97	2.22	1.97	1.96	1.96	1.97
Dabco [®] T-120	0.25	0.25	0.25	0.28	0.25	0.25	0.25	0.25
Dabco [®] K-15	0.25	0.25	0.25	0.28	0.25	0.25	0.25	0.25
Polycat 204	3.95	3.96	3.94	4.43	3.94	3.93	3.93	3.94
Water	0.12	0.20	0.30	--	0.25	0.69	0.69	0.39
Opteon [™] 1100	11.84	11.40	11.82	1.11	11.83	11.78	11.78	11.81
A side								
Papi [®] 27	100	100	100	100	100	100	100	100

TABLE B-4

Example 5 - Run	31	32	33	34	35	36	37	38
B side								
Viscosity (25°C)	1120 cPs	1055 cPs	1430 cPs	1025 cPs	940 cPs	1105 cPs	990 cPs	1250 cPs
E-300	9.88	9.79	6.48	7.97	8.89	0.19	4.20	2.97
BHEDS	10.20	10.11	5.42	0.03	3.35	0.84	2.28	1.67
RB-79	0.94	0.94	7.57	6.71	--	10.17	5.09	3.32
DBAA	--	--	--	6.80	3.95	9.46	4.83	3.30
Br ₃ neopentylOH	--	--	--	--	3.47	--	7.31	2.15
Terate® HT 5349	41.92	41.54	43.03	39.86	38.82	40.93	38.78	44.95
Voranol® 280	20.09	19.91	18.97	19.74	22.87	19.60	18.82	22.83
Dabco® DC193	2.01	1.99	1.97	1.96	1.97	1.96	1.97	1.96
Dabco® T-120	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Dabco® K-15	0.25	0.25	0.25	0.25	0.25	0.25	0.25	0.25
Polycat 204	4.02	3.98	3.94	3.92	3.93	3.93	3.93	3.93
Water	0.10	--	0.30	0.74	0.45	0.64	0.49	0.64
Opteon™ 1100	10.34	11.24	11.82	11.77	11.80	11.78	11.80	11.78
A side								
Papi® 27	100	100	100	100	100	100	100	100

TABLE C-1

Ex. 5 - Run	1	2	3	4	5	6	7
E-300	19.03 wt%	--	--	--	--	--	--
BHEDS	--	19.56 wt%	19.29 wt%	--	--	--	--
RB-79	--	--	--	--	--	17.72 wt%	16.83 wt%
DBAA	--	--	--	19.63 wt%	18.20 wt%	--	--
Br ₃ neopentylOH	--	--	--	--	--	--	--
Density	2.15 lb/ft ³ (34.4 kg/m ³)	2.08 lb/ft ³ (33.3 kg/m ³)	3.66 lb/ft ³ (58.6 kg/m ³)	2.06 lb/ft ³ (33.0 kg/m ³)	1.93 lb/ft ³ (30.9 kg/m ³)	2.23 lb/ft ³ (35.7 kg/m ³)	2.27 lb/ft ³ (36.4 kg/m ³)
Compressive Strength	30.6 psi (2.11x10 ⁵ Pa)	15.1 psi (1.04x10 ⁵ Pa)	55.1 psi (3.80x10 ⁵ Pa)	15.9 psi (1.10x10 ⁵ Pa)	15.0 psi (1.03x10 ⁵ Pa)	25.4 psi (1.75x10 ⁵ Pa)	22.3 psi (1.54x10 ⁵ Pa)
Dimensional Stability* (vol. change)	0.00	-52.58	-8.20	-9.88	-11.44	0.73	2.78
Peak Heat Release Rate	257	290	283	196	181	231	201
R-value	7.34/inch	7.12/inch	7.07/inch	7.99/inch	7.65/inch	8.10/inch	8.13/inch
	1.269 m ² K/W	1.231 m ² K/W	1.223 m ² K/W	1.382 m ² K/W	1.323 m ² K/W	1.401 m ² K/W	1.406 m ² K/W
Predicted Flame Spread Index	21.7	22.1	17.3	16.2	16.7	19.8	18.6
Predicted Smoke Index	32	318	275	39	48	38	28

*Dimensional stability was measured at 70°C for 14 days at 95% RH.

TABLE C-2

Ex. 5 - Run	8	9	10	13	14	15	16
E-300	--	--	11.69 wt%	4.15 wt%	9.01 wt%	19.61 wt%	9.01 wt%
BHEDS	--	--	--	--	--	--	--
RB-79	--	--	11.18 wt%	--	--	--	--
DBAA	--	--	--	--	--	--	--
Br ₃ neopentylOH	19.11 wt%	17.55 wt%	--	19.63 wt%	9.26 wt%	4.15 wt%	9.26 wt%
Density	2.14 lb/ft ³ (34.3 kg/m ³)	2.17 lb/ft ³ (34.8 kg/m ³)	2.11 lb/ft ³ (33.8 kg/m ³)	2.05 lb/ft ³ (32.8 kg/m ³)	2.17 lb/ft ³ (33.8 kg/m ³)	2.16 lb/ft ³ (34.6 kg/m ³)	2.20 lb/ft ³ (35.2 kg/m ³)
Compressive Strength	18.7 psi (1.29x10 ⁵ Pa)	21.0 psi (1.45x10 ⁵ Pa)	29.2 psi (2.01x10 ⁵ Pa)	22.7 psi (1.57x10 ⁵ Pa)	26.5 psi (1.83x10 ⁵ Pa)	27.8 psi (1.57x10 ⁵ Pa)	28.2 psi (1.92x10 ⁵ Pa)
Dimensional Stability* (vol. change)	-0.35	0.56	0.56	-1.93	-3.16	3.36	0.93
Peak Heat Release Rate	180	189	204	187	213	225	205
R-value	7.74/inch	8.05/inch	7.62/inch	8.22/inch	7.89/inch	7.72/inch	7.56/inch
	1.338 m ² K/W	1.392 m ² K/W	1.318 m ² K/W	1.421 m ² K/W	1.364 m ² K/W	1.335 m ² K/W	1.307 m ² K/W
Predicted Flame Spread Index	19.6	15.9	18.7	15.1	19.1	20.2	19.7
Predicted Smoke Index	67	50	19	37	25	23	26

*Dimensional stability was measured at 70°C for 14 days at 95% RH.

TABLE C-3

Example 5 - Run	11	12	17	18	19	20	21	22
E-300	11.73 wt%	14.52 wt%	--	--	--	--	--	--
BHEDS	--	--	4.17 wt%	11.61 wt%	11.82 wt%	11.82 wt%	8.37 wt%	8.37 wt%
RB-79	--	--	19.69 wt%	10.23 wt%	--	--	--	--
DBAA	11.32 wt%	3.01 wt%	--	--	--	--	9.59 wt%	9.59 wt%
Br ₃ neopentylOH	--	--	--	--	11.68 wt%	11.68 wt%	--	--
Density	2.07 lb/ft ³ (33.1 kg/m ³)	2.15 lb/ft ³ (34.4 kg/m ³)	2.63 lb/ft ³ (42.1 kg/m ³)	2.9163 lb/ft ³ (46.6 kg/m ³)	3.0863 lb/ft ³ (49.3 kg/m ³)	3.2663 lb/ft ³ (52.2 kg/m ³)	2.1163 lb/ft ³ (33.8 kg/m ³)	2.6063 lb/ft ³ (41.6 kg/m ³)
Compressive Strength	26.1 psi (1.80x10 ⁵ Pa)	26.1 psi (1.80x10 ⁵ Pa)	29.6 psi (2.04x10 ⁵ Pa)	37.4 psi (2.58x10 ⁵ Pa)	41.3 psi (2.85x10 ⁵ Pa)	38.9 psi (2.68x10 ⁵ Pa)	21.0 psi (1.45x10 ⁵ Pa)	30.6 psi (2.11x10 ⁵ Pa)
Dimensional Stability* (vol. change)	2.97	0.80	0.12	-0.62	-0.19	1.16	0.66	0.04
Peak Heat Release Rate	229	247	212	223	193	178	189	179
R-value	7.66/inch	7.33/inch	7.86/inch	8.05/inch	7.83/inch	8.10/inch	8.17/inch	8.50/inch
	1.325 m ² K/W	1.268 m ² K/W	1.359 m ² K/W	1.392 m ² K/W	1.354 m ² K/W	1.401 m ² K/W	1.413 m ² K/W	1.470 m ² K/W
Predicted Flame Spread Index	18.7	24.3	18.0	16.6	16.2	15.1	18.0	14.0
Predicted Smoke Index	29	25	24	12	19	8	26	28

*Dimensional stability was measured at 70°C for 14 days at 95% RH.

TABLE C-4

Example 5 - Run	23	24	25	26	27	28	29	30
E-300	--	--	--	--	--	1.94 wt%	0.47 wt%	--
BHEDS	6.87 wt%	6.90 wt%	4.17 wt%	22.17 wt%	5.34 wt%	--	--	4.15 wt%
RB-79	8.52 wt%	8.55 wt%	5.61 wt%	1.08 wt%	--	11.40 wt%	--	11.67 wt%
DBAA	--	--	--	3.61 wt%	17.42 wt%	--	9.50 wt%	3.31 wt%
Br ₃ neopentylOH	5.72 wt%	5.75 wt%	14.10 wt%	--	1.12 wt%	8.22 wt%	10.13 wt%	0.54 wt%
Density	2.2463 lb/ft ³ (35.9 kg/m ³)	2.2063 lb/ft ³ (35.2 kg/m ³)	2.32 lb/ft ³ (37.1 kg/m ³)	3.72 lb/ft ³ (59.6 kg/m ³)	2.01 lb/ft ³ (32.2 kg/m ³)	2.12 lb/ft ³ (34.0 kg/m ³)	2.01 lb/ft ³ (32.2 kg/m ³)	2.25 lb/ft ³ (36.0 kg/m ³)
Compressive Strength	26.9 psi (1.85x10 ⁵ Pa)	23.5 psi (1.62x10 ⁵ Pa)	27.7 psi (1.91x10 ⁵ Pa)	23.3 psi (1.61x10 ⁵ Pa)	12.8 psi (0.88x10 ⁵ Pa)	20.5 psi (1.41x10 ⁵ Pa)	17.5 psi (1.71x10 ⁵ Pa)	24.3 psi (1.68x10 ⁵ Pa)
Dimensional Stability* (vol. change)	4.41	1.04	-1.75	-38.45	-18.63	0.52	2.72	2.08
Peak Heat Release Rate	230	214	204	221	177	209	203	222
R-value	7.96/inch	8.18/inch	8.16/inch	6.72/inch	7.60/inch	7.59/inch	8.0/inch	7.95/inch
	1.377 m ² K/W	1.415 m ² K/W	1.411 m ² K/W	1.162 m ² K/W	1.314 m ² K/W	1.313 m ² K/W	1.383 m ² K/W	1.375 m ² K/W
Predicted Flame Spread Index	19.3	18.6	17.5	18.4	18.2	19.9	17.2	18.7
Predicted Smoke Index	38	34	32	18	39	45	50	34

*Dimensional stability was measured at 70°C for 14 days at 95% RH.

TABLE C-5

Example 5 - Run	31	32	33	35	34	36	37	38
E-300	9.88 wt%	9.79 wt%	6.48 wt%	8.89 wt%	7.97 wt%	0.19 wt%	4.20 wt%	2.97 wt%
BHEDS	10.20 wt%	10.11 wt%	5.42 wt%	3.35 wt%	0.03 wt%	0.84 wt%	2.28 wt%	1.67 wt%
RB-79	0.94 wt%	0.94 wt%	7.57 wt%	--	6.71 wt%	10.17 wt%	5.09 wt%	3.32 wt%
DBAA	--	--	--	3.95 wt%	6.80 wt%	9.46 wt%	4.83 wt%	3.30 wt%
Br ₃ neopentyIOH	--	--	--	3.47 wt%	--	--	7.31 wt%	2.15 wt%
Density	2.21 lb/ft ³ (35.4 kg/m ³)	2.28 lb/ft ³ (36.5 kg/m ³)	2.51 lb/ft ³ (40.2 kg/m ³)	2.26 lb/ft ³ (36.2 kg/m ³)	2.13 lb/ft ³ (34.1 kg/m ³)	2.07 lb/ft ³ (33.2 kg/m ³)	2.33 lb/ft ³ (37.3 kg/m ³)	2.19 lb/ft ³ (35.1 kg/m ³)
Compressive Strength	26.5 psi (1.83x10 ⁵ Pa)	28.1 psi (1.94x10 ⁵ Pa)	28.4 psi (1.96x10 ⁵ Pa)	28.7 psi (1.98x10 ⁵ Pa)	20.5 psi (1.41x10 ⁵ Pa)	20.5 psi (1.41x10 ⁵ Pa)	27.0 psi (1.86x10 ⁵ Pa)	27.4 psi (1.89x10 ⁵ Pa)
Dimensional Stability* (vol. change)	0.91	0.67	1.08	3.25	1.58	0.39	-3.21	-3.99
Peak Heat Release Rate	246	245	210	230	208	215	209	203
R-value	7.61/inch	7.79/inch	7.95/inch	7.57/inch	7.68/inch	7.79/inch	8.07/inch	7.77/inch
	1.316 m ² K/W	1.347 m ² K/W	1.375 m ² K/W	1.309 m ² K/W	1.328 m ² K/W	1.347 m ² K/W	1.396 m ² K/W	1.344 m ² K/W
Predicted Flame Spread Index	21.6	21.3	16.3	18.6	17.2	22.3	16.2	17.2
Predicted Smoke Index	30	19	22	23	29	41	34	15

*Dimensional stability was measured at 70°C for 14 days at 95% RH.

[0095] Additional embodiments of this invention include, without limitation:

[0096] A) A flame retardant composition comprised of or formed from components comprising at least one isocyanate-reactive sulfur-containing compound and at least one isocyanate-reactive brominated flame retardant, with the proviso that when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, the composition also comprises another brominated flame retardant, another sulfur-containing compound, tris(1-chloro-2-propyl)phosphate, and/or a surface-modified montmorillonite nanoclay.

[0097] B) A flame retardant composition as in A) wherein the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, and/or a brominated aromatic diester diol.

[0098] C) A flame retardant composition as in A) wherein the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine, wherein the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, wherein the composition further comprises tris(1-chloro-2-propyl)phosphate, and optionally a surface-modified montmorillonite nanoclay, and wherein:

the sulfur-containing aromatic diamine is in the range of about 0.5 wt% to about 10 wt%;

the brominated aromatic diester diol is in the range of about 5 wt% to about 30 wt%;
and

tris(1-chloro-2-propyl) phosphate is in the range of about 50 wt% to about 90 wt%;

and optionally a surface-modified montmorillonite nanoclay is in the range of about 0.5 wt% to about 5 wt%,

wherein the wt% are based on the total weight of the composition.

[0099] D) A flame retardant composition as in any of A)-C) wherein the sulfur-containing aromatic diamine is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine.

[0100] E) A formulation comprising at least one polyol, at least one blowing agent, at least one catalyst, at least one surfactant, at least one isocyanate-reactive sulfur-containing compound, and at least one isocyanate-reactive brominated flame retardant, with the proviso that when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is a

brominated aromatic diester diol, the composition also comprises another brominated flame retardant, another sulfur-containing compound, tris(1-chloro-2-propyl)phosphate, and/or a surface-modified montmorillonite nanoclay.

[0101] F) A formulation as in E) wherein:

the polyol is a polyether polyol and/or a polyester polyol;

the polyol has a functionality of about 3 to about 7; and/or

the blowing agent is water, 1,1,1,3,3-pentafluoropropane, *trans*-1-chloro-3,3,3-trifluoropropene, and/or 1,2-bis(trifluoromethyl)ethene.

[0102] G) A formulation as in any of E)-F) wherein

the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine which is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine, in an amount of about 1 wt% to about 20 wt%, based on the total weight of the formulation, or a disulfide in an amount of about 1 wt% to about 15 wt%, based on the total weight of the formulation; and

the isocyanate-reactive brominated flame retardant is selected from the group consisting of brominated aromatic diester diols, 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, dibromoneopentyl glycol and tetrabromobenzenedimethanol, in an amount of about 1 wt% to about 25 wt%, based on the total weight of the formulation.

[0103] H) A formulation as in any of E)-G) wherein the isocyanate-reactive brominated flame retardant is a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol.

[0104] I) A formulation as in H) further comprising tris(1-chloro-2-propyl)phosphate in an amount of about 20 wt% to about 45 wt%, based on the total weight of the formulation; and optionally a montmorillonite clay surface modified with 0.5 to 5 wt% aminopropyltriethoxysilane and 15 to 35 wt% octadecylamine, in an amount of about 0.5 wt% to about 5 wt%, based on the total weight of the formulation.

[0105] J) A formulation as in any of E)-F) wherein the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol, and

the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine in the range of about 2 wt% to about 15 wt% and 2,3-dibromoallyl alcohol is in the range of about 4 wt% to about 20 wt%; or

the isocyanate-reactive sulfur-containing compound is a disulfide in the range of about 3 wt% to about 12 wt% and 2,3-dibromoallyl alcohol is in the range of about 5 wt% to about 20 wt%,

wherein the wt% are based on the total weight of the composition.

[0106] Components referred to by chemical name or formula anywhere in the specification or claims hereof, whether referred to in the singular or plural, are identified as they exist prior to coming into contact with another substance referred to by chemical name or chemical type (*e.g.*, another component, a solvent, or *etc.*). It matters not what chemical changes, transformations and/or reactions, if any, take place in the resulting mixture or solution as such changes, transformations, and/or reactions are the natural result of bringing the specified components together under the conditions called for pursuant to this disclosure. Thus the components are identified as ingredients to be brought together in connection with performing a desired operation or in forming a desired composition. Also, even though the claims hereinafter may refer to substances, components and/or ingredients in the present tense ("comprises", "is", *etc.*), the reference is to the substance, component or ingredient as it existed at the time just before it was first contacted, blended or mixed with one or more other substances, components and/or ingredients in accordance with the present disclosure. The fact that a substance, component or ingredient may have lost its original identity through a chemical reaction or transformation during the course of contacting, blending or mixing operations, if conducted in accordance with this disclosure and with ordinary skill of a chemist, is thus of no practical concern.

[0107] The invention may comprise, consist, or consist essentially of the materials and/or procedures recited herein.

[0108] As used herein, the term "about" modifying the quantity of an ingredient in the compositions of the invention or employed in the methods of the invention refers to variation in the numerical quantity that can occur, for example, through typical measuring and liquid handling procedures used for making concentrates or use solutions in the real world; through inadvertent error in these procedures; through differences in the manufacture, source, or purity of the ingredients employed to make the compositions or carry out the methods; and the like. The term about also encompasses amounts that differ due to different equilibrium conditions for a composition resulting from a particular initial mixture. Whether or not modified by the term "about", the claims include equivalents to the quantities.

[0109] Except as may be expressly otherwise indicated, the article "a" or "an" if and as used herein is not intended to limit, and should not be construed as limiting, the description or a claim to a single element to which the article refers. Rather, the article "a" or "an" if and as used herein is intended to cover one or more such elements, unless the text expressly indicates otherwise.

[0110] This invention is susceptible to considerable variation in its practice. Therefore the foregoing description is not intended to limit, and should not be construed as limiting, the invention to the particular exemplifications presented hereinabove.

CLAIMS

1. A flame retardant composition comprised of or formed from components comprising at least one isocyanate-reactive sulfur-containing compound selected from sulfur-containing aromatic diamines and disulfides and at least one isocyanate-reactive brominated flame retardant selected from brominated aromatic diester diols, 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, dibromoneopentyl glycol and tetrabromobenzenedimethanol, with the provisos that
when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine,
the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, 2,3- dibromoallyl alcohol, and/or tribromoneopentyl alcohol, and
when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, the composition also comprises another brominated flame retardant, another sulfur-containing compound, tris(1-chloro-2-propyl)phosphate, and/or a surface-modified montmorillonite nanoclay.
2. A flame retardant composition as in Claim 1 wherein the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol.
3. A flame retardant composition as in Claim 1 wherein
when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine,
the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol or tribromoneopentyl alcohol;
when the isocyanate-reactive sulfur-containing compound is a disulfide, the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, or a brominated aromatic diester diol.
4. A flame retardant composition as in Claim 1 wherein the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, wherein the composition further comprises tris(1-chloro-2-propyl)phosphate, and optionally a surface-modified montmorillonite nanoclay.

5. A flame retardant composition as in Claim 4 wherein the surface-modified montmorillonite nanoclay, when present, is a montmorillonite clay surface modified with 0.5 to 5 wt% aminopropyltriethoxysilane and 15 to 35 wt% octadecylamine.

6. A flame retardant composition as in any of Claims 1 or 4-5 wherein the brominated aromatic diester diol is a mixed ester of tetrabromophthalic anhydride with diethylene glycol and propylene glycol.

7. A flame retardant composition as in Claim 3 wherein
when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol, the sulfur-containing aromatic diamine is in the range of 10 wt% to 45 wt%, and 2,3-dibromoallyl alcohol is in the range of 50 wt% to 80 wt%;

when the isocyanate-reactive sulfur-containing compound is a disulfide, and the isocyanate-reactive brominated flame retardant is

2,3-dibromoallyl alcohol, the disulfide is in the range of 10 wt% to 55 wt%, and 2,3-dibromoallyl alcohol is in the range of 45 wt% to 90 wt%;

tribromoneopentyl alcohol, the disulfide is in the range of 25 wt% to 75 wt%, and tribromoneopentyl alcohol is in the range of 25 wt% to 75 wt%; or

a brominated aromatic diester diol, the disulfide is in the range of 10 wt% to 60 wt%, and the brominated aromatic diester diol is in the range of 35 wt% to 90 wt%;

wherein the wt% are based on the total weight of the composition.

8. A flame retardant composition as in any of Claims 2-3 or 7 wherein the isocyanate-reactive sulfur-containing compound is bis(2-hydroxyethyl)disulfide.

9. A formulation comprising at least one polyol, at least one blowing agent, at least one catalyst, at least one surfactant, at least one isocyanate-reactive sulfur-containing compound selected from sulfur-containing aromatic diamines and disulfides, and at least one isocyanate-reactive brominated flame retardant selected from brominated aromatic diester diols, 2,3-

dibromoallyl alcohol, tribromoneopentyl alcohol, dibromoneopentyl glycol and tetrabromobenzenedimethanol, with the provisos that

when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine, the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, 2,3-dibromoallyl alcohol, and/or tribromoneopentyl alcohol, and

when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, the composition also comprises another brominated flame retardant, another sulfur-containing compound, tris(1-chloro-2-propyl)phosphate, and/or a surface-modified montmorillonite nanoclay

10. A formulation as in Claim 9 wherein the polyol is a polyether polyol and/or a polyester polyol.

11. A formulation as in Claim 9 wherein the polyol has a functionality of 3 to 7.

12. A formulation as in Claim 9 wherein the blowing agent is water, 1,1,1,3,3-pentafluoropropane, *trans*-1-chloro-3,3,3-trifluoropropene, and/or 1,2-bis(trifluoromethyl)ethene.

13. A formulation as in Claim 9 wherein the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol.

14. A formulation as in Claim 9 wherein the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine, the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, wherein the formulation further comprises tris(1-chloro-2-propyl)phosphate; and optionally a montmorillonite clay surface modified with 0.5 to 5 wt% aminopropyltriethoxysilane and 15 to 35 wt% octadecylamine.

15. A formulation as in any of Claims 9-12 wherein the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol;

the isocyanate-reactive sulfur-containing compound is a disulfide, and the isocyanate-reactive brominated flame retardant is 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, and/or a brominated aromatic diester diol.

16. A formulation as in any of Claims 13-15 wherein the sulfur-containing aromatic diamine is a mixture of 3,5-dimethylthio-toluene-2,4-diamine and 3,5-dimethylthio-toluene-2,6-diamine, and/or the disulfide is bis(2-hydroxyethyl)disulfide.

17. A rigid polyurethane foam formed from components comprising a polyisocyanate and a formulation as in any of Claims 9-12 or 13-16.

18. A process for forming a rigid polyurethane foam, which process comprises contacting A) a polyisocyanate, and B) a formulation formed from at least one polyol, at least one blowing agent, at least one catalyst, at least one surfactant, at least one isocyanate-reactive sulfur-containing compound selected from sulfur-containing aromatic diamines and disulfides and at least one isocyanate-reactive brominated flame retardant selected from brominated aromatic diester diols, 2,3-dibromoallyl alcohol, tribromoneopentyl alcohol, dibromoneopentyl glycol and tetrabromobenzenedimethanol, to form a mixture, with the provisos that

when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine, the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, 2,3-dibromoallyl alcohol, and/or tribromoneopentyl alcohol, and

when the isocyanate-reactive sulfur-containing compound is a sulfur-containing aromatic diamine and the isocyanate-reactive brominated flame retardant is a brominated aromatic diester diol, the composition also comprises another brominated flame retardant, another sulfur-containing compound, tris(1-chloro-2-propyl)phosphate, and/or a surface-modified montmorillonite nanoclay; and

allowing the mixture to cure to form a rigid polyurethane foam.

19. A process as in Claim 18 wherein A) and B) are in amounts such that the Isocyanate Index of the mixture is 85 to 1000, and wherein a rigid polyurethane foam is formed.