

PROCESS FOR PRODUCING CONJUGATED DIENE-BASED POLYMER,
CONJUGATED DIENE-BASED POLYMER, AND CONJUGATED
DIENE-BASED POLYMER COMPOSITION

5 Background of the Invention

1. Field of the Invention

The present invention is filed claiming the priority of Japanese Patent Application No. 2011-011715 filed on January 24, 2011 under the Paris Convention, the entire content of which is incorporated herein by
10 reference.

The present invention relates to a process for producing a conjugated diene-based polymer, a conjugated diene-based polymer, and a conjugated diene-based polymer composition.

15 2. Description of the Related Art

In recent years, with an increase in concern about environmental problems, requirements of fuel cost saving properties on an automobile have been increasing, and a rubber composition used in tires for automobiles has also been required to be excellent in fuel cost saving properties. As a rubber
20 composition for automobile tires, a rubber composition containing a conjugated diene-based polymer such as polybutadiene or a butadiene-styrene copolymer, and a reinforcing agent is used.

For example, as a polymer enhancing fuel cost saving properties and a polymer composition having good fuel cost saving properties, a polymer
25 obtained by living anion polymerization of butadiene, styrene and bis(diethylamino)methylvinylsilane using alkylolithium as a polymerization initiator, and a polymer composition containing the polymer and silica are proposed in JP-A 2010-77386. A polymer obtained by adding alkylolithium and hexamethyleneimine to butadiene and styrene, and polymerizing this is
30 proposed in JP-A 9-110942.

Summary of the Invention

However, polymer compositions using the above conventional conjugated diene-based polymer were not necessarily sufficiently
5 satisfactory in fuel cost-saving properties.

Under such circumstances, an object of the present invention is to provide a process for producing a conjugated diene-based polymer from which a polymer composition excellent in fuel cost saving properties can be obtained, a conjugated diene-based polymer obtained by the process, and a
10 polymer composition containing the conjugated diene-based polymer and a reinforcing agent.

A first aspect of the present invention relates to a process for producing a conjugated diene-based polymer comprising polymerizing a monomer component comprising a conjugated diene compound and a
15 silicon-containing vinyl compound using the following compounds (I) and (II), as a polymerization initiator component,

(I) an organic alkali metal compound

(II) a compound represented by the following formula (1):



20 wherein R^{11} and R^{12} represent a hydrocarbyl group having 1 to 20 carbon atoms optionally having a substituent.

A second aspect of the present invention relates to a conjugated diene-based polymer produced by the above-mentioned production process.

A third aspect of the present invention relates to a conjugated
25 diene-based polymer composition comprising the above-mentioned conjugated diene-based polymer and a reinforcing agent, wherein the content of the reinforcing agent is 10 parts by weight to 150 parts by weight per 100 parts by weight of the conjugated diene-based polymer.

According to the present invention, there can be provided a process for producing a conjugated diene-based polymer from which a polymer composition excellent in fuel cost saving properties can be obtained, a conjugated diene-based polymer obtained by the process, and a polymer composition containing the conjugated diene-based polymer and a reinforcing agent.

Detailed Description of the Invention

Herein, a hydrocarbyl group represents a monovalent group obtained by removing one hydrogen atom from a hydrocarbon. A hydrocarbylene group represents a divalent group obtained by removing two hydrogen atoms from a hydrocarbon. A hydrocarbyloxy group represents a monovalent group having a structure in which a hydrogen atom of a hydroxy group is replaced with a hydrocarbyl group. A substituted amino group represents a group having a structure in which at least one hydrogen atom of an amino group is replaced with a monovalent atom other than a hydrogen atom or a monovalent group, or a group having a structure in which two hydrogen atoms of an amino group are replaced with a divalent group. A hydrocarbyl group having a substituent (hereinafter, referred to as substituted hydrocarbyl group in some cases) represents a monovalent group having a structure in which at least one hydrogen atom of a hydrocarbyl group is replaced with a substituent. A hydrocarbylene group having a hetero atom (hereinafter, referred to as hetero atom-containing hydrocarbylene group in some cases) represents a divalent group having a structure in which a carbon atom other than the carbon atom from which a hydrogen atom has been removed, and/or a hydrogen atom, of a hydrocarbylene group, is replaced with a group having a hetero atom (an atom other than a carbon atom and a hydrogen atom).

The process for producing a conjugated diene-based polymer of the present invention allows a monomer component comprising a conjugated

diene compound and a silicon-containing vinyl compound to be polymerized using the following compounds (I) and (II) as a polymerization initiator component.

(I) Organic alkali metal compound

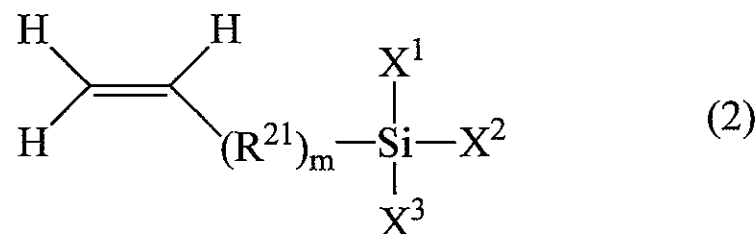
5 (II) Compound represented by the following formula (1):



(wherein R^{11} and R^{12} represent a hydrocarbyl group having 1 to 20 carbon atoms optionally having a substituent.)

Examples of the conjugated diene compound include 1,3-butadiene, 10 isoprene, 1,3-pentadiene, 2,3-dimethyl-1,3-butadiene, and 1,3-hexadiene, and preferably 1,3-butadiene or isoprene.

The silicon-containing vinyl compound is preferably a compound represented by the following formula (2):



(wherein m is 0 or 1, R^{21} represents a hydrocarbylene group, and X^1 , X^2 and 15 X^3 represent a substituted amino group, a hydrocarbyloxy group, or a hydrocarbyl group optionally having a substituent.)

In the formula (2), m is 0 or 1, and preferably 0.

Examples of the hydrocarbylene group in R^{21} include an alkylene group, an alkenediyl group, an arylene group, and a group in which an 20 arylene group and an alkylene group are bonded. Examples of the alkylene group include a methylene group, an ethylene group, and a trimethylene group. Examples of the alkenediyl group include a vinylene group and an ethylene-1,1-diyl group. Examples of the arylene group include a phenylene

group, a naphthylene group, and a biphenylene group. Examples of the group in which an arylene group and an alkylene group are bonded include a group in which a phenylene group and a methylene group are bonded, and a group in which a phenylene group and an ethylene group are bonded.

5 R²¹ is preferably an arylene group and more preferably a phenylene group.

 In the formula (2), X¹, X² and X³ represent a substituted amino group, a hydrocarbyloxy group, or a hydrocarbyl group optionally having a substituent. Preferably, at least one of X¹, X² and X³ is a substituted amino
10 group, and more preferably, two of X¹, X² and X³ are a substituted amino group.

 The substituted amino group in X¹, X² and X³ is preferably a group represented by the following formula (2-A).



15 (R²² and R²³ represent a hydrocarbyl group optionally having a substituent, or a trihydrocarbylsilyl group, or R²² and R²³ are bonded to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom.)

 The hydrocarbyl group optionally having a substituent in R²² and R²³
20 is a hydrocarbyl group or a substituted hydrocarbyl group. Examples of the substituted hydrocarbyl group include a substituted hydrocarbyl group in which the substituent is a hydrocarbyloxy group. Examples of the hydrocarbyl group include chain alkyl groups such as a methyl group, an ethyl group, a n-propyl group, an isopropyl group, a n-butyl group, an
25 isobutyl group, a sec-butyl group, a tert-butyl group, a n-pentyl group, a n-hexyl group, and a n-octyl group; cyclic alkyl groups such as a cyclopentyl group and a cyclohexyl group; and aryl groups such as a phenyl group, a benzyl group, and a naphthyl group, and preferably an alkyl group, more

preferably a chain alkyl group, and further preferably a methyl group, an ethyl group, a n-propyl group, and a n-butyl group. Examples of the substituted hydrocarbyl group in which the substituent is a hydrocarbyloxy group include alkoxyalkyl groups such as a methoxymethyl group, an ethoxymethyl group, and a methoxyethyl group; and aryloxyalkyl groups such as a phenoxymethyl group.

Examples of the trihydrocarbylsilyl group in R^{22} and R^{23} include trialkylsilyl groups such as a trimethylsilyl group, a triethylsilyl group, and a tert-butyldimethylsilyl group.

The hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom in R^{22} and R^{23} is a hydrocarbylene group, or a hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom and/or an oxygen atom. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom and/or an oxygen atom include a hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom, and a hetero atom-containing hydrocarbylene group in which the hetero atom is an oxygen atom. Examples of the hydrocarbylene group include alkylene groups such as a trimethylene group, a tetramethylene group, a pentamethylene group, a hexamethylene group, a heptamethylene group, an octamethylene group, a decamethylene group, a dodecamethylene group, and a 2,2,4-trimethylhexane-1,6-diyl group; and alkenediyl groups such as a pent-2-ene-1,5-diyl group. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom include a group represented by -CH=N-CH=CH- and a group represented by $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is an oxygen atom include a group represented by $\text{-CH}_2\text{-CH}_2\text{-O-CH}_2\text{-CH}_2\text{-}$.

It is preferable that R^{22} and R^{23} are an alkyl group, or R^{22} and R^{23} are bonded to form an alkylene group, it is more preferable to form an alkyl

group, and it is further preferable to form a methyl group or an ethyl group.

Examples of a substituted amino group in which R^{22} and R^{23} are a hydrocarbyl group, of the substituted amino groups represented by the formula (2-A), include dialkylamino groups such as a dimethylamino group, a diethylamino group, an ethylmethylamino group, a di-n-propylamino group, a diisopropylamino group, a di-n-butylamino group, a diisobutylamino group, a di-sec-butylamino group, and a di-tert-butylamino group; and diarylamino groups such as a diphenylamino group, and preferably a dialkylamino group, and more preferably a dimethylamino group, a diethylamino group, a di-n-propylamino group, and a di-n-butylamino group. Examples of the substituted amino group in which R^{22} and R^{23} are bonded to form a substituted hydrocarbyl group in which the substituent is a hydrocarbyloxy group include di(alkoxyalkyl)amino groups such as a di(methoxymethyl)amino group and a di(ethoxymethyl)amino group. Examples of the substituted amino group in which R^{22} and R^{23} are a trihydrocarbylsilyl group include trialkylsilyl group-containing amino groups such as a bis(trimethylsilyl)amino group, a bis(tert-butyl dimethylsilyl)amino group, and a N-trimethylsilyl-N-methylamino group.

Examples of a substituted amino group in which R^{22} and R^{23} are bonded to form a hydrocarbylene group, of the substituted amino groups represented by the formula (2-A), include 1-alkyleneimino groups such as a 1-trimethyleneimino group, a 1-pyrrolidinyl group, a 1-piperidinyl group, a 1-hexamethyleneimino group, a 1-heptamethyleneimino group, a 1-octamethyleneimino group, a 1-decamethyleneimino group, and a 1-dodecamethyleneimino group. Examples of the substituted amino group in which R^{22} and R^{23} are bonded to form a hetero atom-containing hydrocarbyl group in which the hetero atom is a nitrogen atom include a 1-imidazolyl group and a 4,5-dihydro-1-imidazolyl group. Examples of the substituted amino group in which R^{22} and R^{23} are bonded to form a hetero

atom-containing hydrocarbylene group in which the hetero atom is an oxygen atom include a morpholino group.

As the substituted amino group represented by the formula (2-A), a dialkylamino group or a 1-alkyleneimino group is preferable, a dialkylamino group is more preferable, and a dimethylamino group, a diethylamino group,
5 a di-n-propylamino group, and a di-n-butylamino group are further preferable.

Examples of the hydrocarbyloxy group in X^1 , X^2 and X^3 include alkoxy groups such as a methoxy group, an ethoxy group, a n-propoxy group,
10 an isopropoxy group, a n-butoxy group, a sec-butoxy group, and a tert-butoxy group; and aryloxy groups such as a phenoxy group and a benzyloxy group.

The hydrocarbyl group optionally having a substituent in X^1 , X^2 and X^3 is a hydrocarbyl group or a substituted hydrocarbyl group. Examples of the substituted hydrocarbyl group include a substituted hydrocarbyl group
15 in which the substituent is a hydrocarbyloxy group. Examples of the hydrocarbyl group include alkyl groups such as a methyl group, an ethyl group, a n-propyl group, an isopropyl group, a n-butyl group, a sec-butyl group, and a tert-butyl group; and aryl groups such as a phenyl group, a 4-methyl-1-phenyl group, and a benzyl group. Examples of the substituted
20 hydrocarbyl group in which the substituent is a hydrocarbyloxy group include alkoxyalkyl groups such as a methoxymethyl group, an ethoxymethyl group, and an ethoxyethyl group. Among them, an alkyl group is preferable, and an alkyl group having 1 to 10 carbon atoms is more preferable.

25 Examples of a compound in which one of X^1 , X^2 and X^3 is a substituted amino group and m is 0, of the silicon-containing vinyl compounds represented by the formula (2), include:

(dialkylamino)dialkylvinylsilanes such as
(dimethylamino)dimethylvinylsilane,
30 (ethylmethylamino)dimethylvinylsilane,

(di-n-propylamino)dimethylvinylsilane,
(diisopropylamino)dimethylvinylsilane, (dimethylamino)diethylvinylsilane,
(ethylmethylamino)diethylvinylsilane, (di-n-propylamino)diethylvinylsilane,
and (diisopropylamino)diethylvinylsilane;

5 [bis(trialkylsilyl)amino]dialkylvinylsilanes such as
[bis(trimethylsilyl)amino]dimethylvinylsilane,
[bis(t-butyltrimethylsilyl)amino]dimethylvinylsilane,
[bis(trimethylsilyl)amino]diethylvinylsilane, and
[bis(t-butyltrimethylsilyl)amino]diethylvinylsilane;

10 (dialkylamino)di(alkoxyalkyl)vinylsilanes such as
(dimethylamino)di(methoxymethyl)vinylsilane,
(dimethylamino)di(2-methoxyethyl)vinylsilane,
(dimethylamino)di(ethoxymethyl)vinylsilane,
(dimethylamino)di(2-ethoxyethyl)vinylsilane,
15 (diethylamino)di(methoxymethyl)vinylsilane,
(diethylamino)di(2-methoxyethyl)vinylsilane,
(diethylamino)di(ethoxymethyl)vinylsilane, and
(diethylamino)di(2-ethoxyethyl)vinylsilane; and

 cyclic aminodialkylvinylsilane compounds such as
20 1-pyrrolidinyl dimethylvinylsilane, 1-piperidinyl dimethylvinylsilane,
1-hexamethyleneiminodimethylvinylsilane,
4,5-dihydro-1-imidazolyl dimethylvinylsilane, and
morpholinodimethylvinylsilane.

 Examples of a compound in which one of X¹, X² and X³ is a
25 substituted amino group and m is 1, of the silicon-containing vinyl
compounds represented by the formula (2), include:

 (dialkylamino)dialkylvinylphenylsilanes such as
(dimethylamino)dimethyl-4-vinylphenylsilane,
(dimethylamino)dimethyl-3-vinylphenylsilane,
30 (diethylamino)dimethyl-4-vinylphenylsilane,

(diethylamino)dimethyl-3-vinylphenylsilane,
 (di-n-propylamino)dimethyl-4-vinylphenylsilane,
 (di-n-propylamino)dimethyl-3-vinylphenylsilane,
 (di-n-butylamino)dimethyl-4-vinylphenylsilane,
 5 (di-n-butylamino)dimethyl-3-vinylphenylsilane,
 (dimethylamino)diethyl-4-vinylphenylsilane,
 (dimethylamino)diethyl-3-vinylphenylsilane,
 (diethylamino)diethyl-4-vinylphenylsilane,
 (diethylamino)diethyl-3-vinylphenylsilane,
 10 (di-n-propylamino)diethyl-4-vinylphenylsilane,
 (di-n-propylamino)diethyl-3-vinylphenylsilane,
 (di-n-butylamino)diethyl-4-vinylphenylsilane, and
 (di-n-butylamino)diethyl-3-vinylphenylsilane.

Examples of a compound in which two of X¹, X² and X³ are a
 15 substituted amino group and m is 0, of the silicon-containing vinyl
 compounds represented by the formula (2), include:

bis(dialkylamino)alkylvinylsilanes such as
 bis(dimethylamino)methylvinylsilane, bis(diethylamino)methylvinylsilane,
 bis(di-n-propylamino)methylvinylsilane,
 20 bis(di-n-butylamino)methylvinylsilane, bis(dimethylamino)ethylvinylsilane,
 bis(diethylamino)ethylvinylsilane, bis(di-n-propylamino)ethylvinylsilane,
 and bis(di-n-butylamino)ethylvinylsilane;

bis[bis(trialkylsilyl)amino]alkylvinylsilanes such as
 bis[bis(trimethylsilyl)amino]methylvinylsilane,
 25 bis[bis(tert-butyl dimethyl)amino]methylvinylsilane,
 bis[bis(trimethylsilyl)amino]ethylvinylsilane, and
 bis[bis(tert-butyl dimethyl)amino]ethylvinylsilane;

bis(dialkylamino)alkoxyalkylvinylsilanes such as
 bis(dimethylamino)methoxymethylvinylsilane,
 30 bis(dimethylamino)(2-methoxyethyl)vinylsilane,

bis(dimethylamino)ethoxymethylvinylsilane,
 bis(dimethylamino)(2-ethoxyethyl)vinylsilane,
 bis(diethylamino)ethoxymethylvinylsilane,
 bis(diethylamino)(2-methoxyethyl)vinylsilane,
 5 bis(diethylamino)ethoxymethylvinylsilane, and
 bis(dimethylamino)(2-ethoxyethyl)vinylsilane; and
 bis(cyclic amino)alkylvinylsilane compounds such as
 bis(1-pyrrolidinyl)methylvinylsilane, bis(1-piperidinyl)methylvinylsilane,
 bis(1-hexamethyleneimino)methylvinylsilane,
 10 bis(4,5-dihydro-1-imidazolyl)methylvinylsilane, and
 bis(morpholino)methylvinylsilane.

Examples of a compound in which two of X^1 , X^2 and X^3 are a
 substituted amino group and m is 1, of the silicon-containing vinyl
 compounds represented by the formula (2), include:

15 bis(dialkylamino)alkylvinylphenylsilanes such as
 bis(dimethylamino)methyl-4-vinylphenylsilane,
 bis(dimethylamino)methyl-3-vinylphenylsilane,
 bis(diethylamino)methyl-4-vinylphenylsilane,
 bis(diethylamino)methyl-3-vinylphenylsilane,
 20 bis(di-n-propylamino)methyl-4-vinylphenylsilane,
 bis(di-n-propylamino)methyl-3-vinylphenylsilane,
 bis(di-n-butylamino)methyl-4-vinylphenylsilane,
 bis(di-n-butylamino)methyl-3-vinylphenylsilane,
 bis(dimethylamino)ethyl-4-vinylphenylsilane,
 25 bis(dimethylamino)ethyl-3-vinylphenylsilane,
 bis(diethylamino)ethyl-4-vinylphenylsilane,
 bis(diethylamino)ethyl-3-vinylphenylsilane,
 bis(di-n-propylamino)ethyl-4-vinylphenylsilane,
 bis(di-n-propylamino)ethyl-3-vinylphenylsilane,
 30 bis(di-n-butylamino)ethyl-4-vinylphenylsilane, and

bis(di-n-butylamino)ethyl-3-vinylphenylsilane.

Examples of a compound in which three of X^1 , X^2 and X^3 are a substituted amino group and m is 0, of the silicon-containing vinyl compounds represented by the formula (2), include:

5 tris(dialkylamino)vinylsilanes such as
tris(dimethylamino)vinylsilane, tris(diethylamino)vinylsilane,
tris(di-n-propylamino)vinylsilane, and tris(di-n-butylamino)vinylsilane.

Examples of a compound in which three of X^1 , X^2 and X^3 are a substituted amino group and m is 1, of the silicon-containing vinyl
10 compounds represented by the formula (2), include:

 tris(dialkylamino)vinylphenylsilanes such as
tris(dimethylamino)-4-vinylphenylsilane,
tris(dimethylamino)-3-vinylphenylsilane,
tris(diethylamino)-4-vinylphenylsilane,
15 tris(diethylamino)-3-vinylphenylsilane,
tris(di-n-propylamino)-4-vinylphenylsilane,
tris(di-n-propylamino)-3-vinylphenylsilane,
tris(di-n-butylamino)-4-vinylphenylsilane, and
tris(di-n-butylamino)-3-vinylphenylsilane.

20 Examples of a compound in which X^1 , X^2 and X^3 are not a substituted amino group and m is 0, of the silicon-containing vinyl compounds represented by the formula (2), include:

 trialkoxyvinylsilanes such as trimethoxyvinylsilane,
triethoxyvinylsilane, and tripropoxyvinylsilane; dialkoxyalkylvinylsilanes
25 such as methyldimethoxyvinylsilane and methyldiethoxyvinylsilane;
dialkoxyarylvinylsilanes such as di(tert-pentoxy)phenylvinylsilane and
di(tert-butoxy)phenylvinylsilane; monoalkoxydialkylvinylsilanes such as
dimethylmethoxyvinylsilane; monoalkoxydiarylvinylsilanes such as
tert-butoxydiphenylvinylsilane and tert-pentoxydiphenylvinylsilane;
30 monoalkoxyalkylarylvinylsilanes such as

tert-butoxymethylphenylvinylsilane and tert-butoxyethylphenylvinylsilane; and substituted alkoxyvinylsilane compounds such as tris(β -methoxyethoxy)vinylsilane.

Further, examples of the silicon-containing vinyl compound include
5 bis(trialkylsilyl)aminostyrenes such as
4-N,N-bis(trimethylsilyl)aminostyrene and
3-N,N-bis(trimethylsilyl)aminostyrene; and
bis(trialkylsilyl)aminoalkylstyrenes such as
4-bis(trimethylsilyl)aminomethylstyrene,
10 3-bis(trimethylsilyl)aminomethylstyrene,
4-[2-bis(trimethylsilyl)aminoethyl]styrene, and
3-[2-bis(trimethylsilyl)aminoethyl]styrene.

The silicon-containing vinyl compound is preferably a compound represented by the formula (2), more preferably a compound in which m in
15 the formula (2) is 0, further preferably a compound in which two of X^1 , X^2 and X^3 in the formula (2) are a dialkylamino group, and particularly preferably a compound in which one of X^1 , X^2 and X^3 in the formula (2) is an alkyl group.

A compound which is particularly preferable as the silicon-containing
20 vinyl compound is bis(dimethylamino)methylvinylsilane,
bis(diethylamino)methylvinylsilane, bis(di-n-propylamino)methylvinylsilane,
or bis(di-n-butylamino)methylvinylsilane.

In addition, in a monomer unit based on the compound represented by the formula (2), a group represented by X^1 , X^2 and X^3 may be a hydroxyl
25 group through hydrolysis or the like.

In the present invention, in order to enhance fuel cost saving properties, the amount of the silicon-containing vinyl compound used is preferably 0.01 wt% or more, more preferably 0.02 wt% or more, and further preferably 0.05 wt% or more per 100 wt% of the total amount of monomer
30 components used in polymerization. In order to enhance economical

properties and to increase tensile strength at break, the amount used is preferably 20 wt% or less, more preferably 2 wt% or less, and further preferably 1 wt% or less.

In the present invention, in order to enhance tensile strength at break, it is preferable that polymerization is performed using an aromatic vinyl compound as a monomer component, in addition to the conjugated diene compound and the silicon-containing vinyl compound. Examples of the aromatic vinyl compound include styrene, α -methylstyrene, vinyltoluene, vinylnaphthalene, divinylbenzene, trivinylbenzene, and divinyl-naphthalene, and preferably styrene.

The amount of the aromatic vinyl compound used is 0 wt% or more (the amount of the conjugated diene compound used is 100 wt% or less), preferably 10 wt% or more (the amount of the conjugated diene compound used is 90 wt% or less), and more preferably 15 wt% or more (the content of the conjugated diene compound is 85 wt% or less), per 100 wt% of the total amount of the conjugated diene compound and the aromatic vinyl compound. Further, in order to enhance fuel cost saving properties, the content of the aromatic vinyl compound is preferably 50 wt% or less (the content of the conjugated diene compound is 50 wt% or more), and more preferably 45 wt% or less (the content of the conjugated diene compound is 55 wt% or more).

The compound (I) is an organic alkali metal compound. Examples of the organic alkali metal compound include an organic lithium compound, an organic sodium compound, an organic potassium compound, and an organic cesium compound. Examples of the organic lithium compound include alkyllithium compounds such as methyllithium, ethyllithium, n-propyllithium, isopropyllithium, n-butyllithium, isobutyllithium, sec-butyllithium, tert-butyllithium, n-hexyllithium, and n-octyllithium; alkenyllithium compounds such as vinyl-lithium, and propenyllithium; aryllithium compounds such as phenyllithium, benzyllithium, tolyllithium, and lithium naphthyride; alkylenedilithium compounds such as

tetramethylenedilithium, pentamethylenedilithium, hexamethylenedilithium, and decamethylenedilithium; and lithium naphthalenide and lithium biphenylide. Examples of the organic sodium compound include sodium naphthalenide, and sodium biphenylide.

- 5 Examples of the organic potassium compound include potassium naphthalenide. The compound (I) is preferably an organic lithium compound, more preferably an alkyl lithium compound having 1 to 20 carbon atoms, further preferably n-butyllithium, sec-butyllithium, or tert-butyllithium.

- 10 The compound (II) is a compound represented by the following formula (1).



(wherein R¹¹ and R¹² represent a hydrocarbyl group having 1 to 20 carbon atoms optionally having a substituent.)

- 15 In the formula (1), the hydrocarbyl group having 1 to 20 carbon atoms optionally having a substituent is a hydrocarbyl group having 1 to 20 carbon atoms or a substituted hydrocarbyl group having 1 to 20 carbon atoms. Examples of the substituted hydrocarbyl group having 1 to 20 carbon atoms include a substituted hydrocarbyl group having 1 to 20 having a hydrocarbyloxy group as a substituent, a substituted hydrocarbyl group having 1 to 20 carbon atoms having a substituted amino group as a substituent, a substituted hydrocarbyl group having 1 to 20 carbon atoms having a trialkylsilyl group as a substituent, and a substituted hydrocarbyl group having 1 to 20 carbon atoms having a trialkoxysilyl group as a substituent.
- 20
- 25

Examples of the hydrocarbyl group having 1 to 20 carbon atoms include chain-like alkyl groups such as a methyl group, an ethyl group, a n-propyl group, an isopropyl group, a n-butyl group, an isobutyl group, a

sec-butyl group, a tert-butyl group, a n-hexyl group, a n-octyl group, and a n-dodecyl group; cyclic alkyl groups such as a cyclopentyl group and a cyclohexyl group; aryl groups such as a phenyl group, a tolyl group, a xylyl group, a benzyl group, and a naphthyl group. Examples of the substituted hydrocarbyl group having 1 to 20 carbon atoms having a hydrocarbyloxy group as a substituent include alkoxyalkyl groups such as a methoxymethyl group, an ethoxymethyl group, a methoxyethyl group, and an ethoxyethyl group. Examples of the substituted hydrocarbyl group having 1 to 20 carbon atoms having a substituted amino group as a substituent include dialkylaminoalkyl groups such as a dimethylaminomethyl group and a diethylaminomethyl group. Examples of the substituted hydrocarbyl groups having 1 to 20 carbon atoms having a trialkylsilyl group as a substituent include trialkylsilylalkyl groups such as a trimethylsilylmethyl group, a 2-trimethylsilylethyl group, and a 3-trimethylsilylpropyl group. Examples of the substituted hydrocarbyl group having 1 to 20 carbon atoms having a trialkoxysilyl group as a substituent include trialkoxysilylalkyl groups such as a trimethoxysilylmethyl group, a 2-trimethoxysilylethyl group and a 3-trimethoxysilylpropyl group.

R^{11} and R^{12} are preferably a hydrocarbyl group having 1 to 20 carbon atoms, more preferably an alkyl group having 1 to 10 carbon atoms, further preferably an ethyl group, a n-propyl group, an isopropyl group, or a n-butyl group.

Examples of a compound in which R^{11} and R^{12} are a hydrocarbyl group having 1 to 20 carbon atoms, of the compound represented by the formula (1), include dialkylamines such as dimethylamine, diethylamine, methylethylamine, di-n-propylamine, diisopropylamine, di-n-butylamine, diisobutylamine, di-sec-butylamine, di-tert-butylamine, di-n-hexylamine, di-n-octylamine, and dicyclohexylamine; alkylarylamines such as N-methylaniline, N-ethylaniline, and N-methyl-N-benzylamine; diarylamines such as diphenylamine.

Examples of a compound in which at least one of R^{11} and R^{12} are a substituted hydrocarbyl group having 1 to 20 carbon atoms, of the compound represented by the formula (1), include di(alkoxyalkyl)amines such as di(methoxymethyl)amine, di(ethoxymethyl)amine, di(2-methoxyethyl)amine, and di(2-ethoxyethyl)amine; bis(dialkylaminoalkyl)amines such as bis(dimethylaminomethyl)amine; trialkylsilylalkyl group-containing amine compounds such as trimethylsilylpropylmethylaniline; trialkoxysilylalkyl group-containing amine compounds such as trimethoxysilylpropylmethylaniline.

The compound represented by the formula (1) is preferably a compound in which R^{11} and R^{12} are a hydrocarbyl group having 1 to 20 carbon atoms, more preferably a compound in which R^{11} and R^{12} are an alkyl group having 1 to 10 carbon atoms, further preferably diethylamine, di-n-propylamine, diisopropylamine, or di-n-butylamine.

In the present invention, it is preferable that the compounds (I) and (II) are added to a solution containing at least one monomer component and using a hydrocarbon as a solvent, in an order of the compound (I) and the compound (II), and the monomer component comprising a conjugated diene compound and a silicon-containing vinyl compound is polymerized.

Preferably, after the compound (I) is added to the solution, while a polymerization conversion rate of a monomer component is 5 wt% or less, the compound (II) is added to the solution. The polymerization conversion rate is a value letting an amount of a monomer component used in the polymerization in the present process to be 100 wt%.

Examples of a monomer component contained in a solution using a hydrocarbon as a solvent, to which the compound (I) is added, include a conjugated diene compound, a silicon-containing vinyl compound, and an aromatic vinyl compound, preferably a conjugated diene compound.

A concentration of the monomer component in the solution using a hydrocarbon as a solvent is preferably 1 wt% to 50 wt%, more preferably 5

wt% to 30 wt%.

It is preferable that the addition amount of the compound (I) of the present process is 0.01 mmol to 15 mmol per 100 g of the monomer component used in polymerization.

5 In the present process, the amount of the compound (II) which is added while the polymerization conversion rate of the monomer component is 5 wt% or less is preferably 0.5 mol to 2.0 mol, more preferably 0.8 mol to 1.5 mol based on 1 mol of the addition amount of the compound (I).

10 After the polymerization conversion rate of the monomer component exceeds 5 wt%, the compound (II) may be added. The addition amount of the compound (II) after the polymerization conversion rate of the monomer component exceeds 5 wt% is preferably 0.5 mol or less based on 1 mol of the addition amount of the compound (I).

15 After the compound (II) is added to a solution using a hydrocarbon as a solvent, the monomer component may be further added to the solution.

20 A hydrocarbon used in preparing a solution using the hydrocarbon as a solvent is a compound which does not inactivate the compound (I), and examples thereof include aliphatic hydrocarbons, aromatic hydrocarbons, and alicyclic hydrocarbons. Examples of the aliphatic hydrocarbon include propane, n-butane, iso-butane, n-pentane, iso-pentane, n-hexane, n-heptane, and n-octane. Examples of the aromatic hydrocarbon include benzene, toluene, xylene, and ethylbenzene. Examples of the alicyclic hydrocarbon include cyclopentane and cyclohexane. The hydrocarbon solvent may be a mixture of various components such as industrial hexane. It is preferably a
25 hydrocarbon having 2 to 12 carbon atoms.

30 The polymerization reaction may be performed in the presence of an agent for adjusting the vinyl bonding amount in a conjugated diene unit, or an agent for adjusting distribution of a conjugated diene unit and a monomer unit based on a monomer other than conjugated diene in a conjugated diene-based polymer chain (hereinafter, collectively referred to as "adjusting

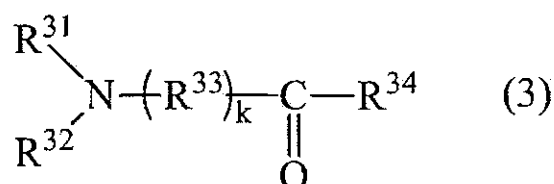
agent"). Examples of the agent include ether compounds, tertiary amine compounds, and phosphine compounds. Examples of the ether compound include cyclic ethers such as tetrahydrofuran, tetrahydropyran, and 1,4-dioxane; aliphatic monoethers such as diethyl ether and dibutyl ether; 5 aliphatic diethers such as ethylene glycol dimethyl ether, ethylene glycol diethyl ether, ethylene glycol dibutyl ether, diethylene glycol diethyl ether, and diethylene glycol dibutyl ether; and aromatic ethers such as diphenyl ether and anisole. Examples of the tertiary amine compound include triethylamine, tripropylamine, tributylamine, 10 N,N,N',N'-tetramethylethylenediamine, N,N-diethylaniline, pyridine, and quinoline. Examples of the phosphine compound include trimethylphosphine, triethylphosphine, and triphenylphosphine. One or more kinds of them are used.

The polymerization temperature in the present invention is usually 15 25°C to 100°C, preferably 35°C to 90°C, and further preferably 50°C to 80°C. The polymerization time is usually 10 minutes to 5 hours.

In the process for producing a conjugated diene-based polymer of the present invention, a compound containing a nitrogen atom and/or a silicon atom may be reacted with an active end of a polymer produced by 20 polymerization.

Preferable examples of the compound containing a nitrogen atom and/or a silicon atom include compounds containing a nitrogen atom and a carbonyl group.

As the compound containing a nitrogen atom and a carbonyl group, a 25 compound represented by the following formula (3) is preferable.



(in the formula (3), R³¹ and R³² may be bonded, or R³¹ and R³⁴ may be bonded,

R^{31} represents a hydrocarbyl group optionally having a substituent, or is bonded with R^{32} to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, or is bonded with R^{34} to represent a divalent group, R^{32} represents a hydrocarbyl group optionally having a substituent, or is bonded with R^{31} to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, and R^{34} represents a hydrocarbyl group optionally having a substituent, or a hydrogen atom, or is bonded with R^{31} to represent a divalent group. R^{33} represents a divalent group, and k represents 0 or 1.)

10 In the formula (3), the hydrocarbyl group optionally having a substituent in R^{31} , R^{32} and R^{34} is a hydrocarbyl group or a substituted hydrocarbyl group. Examples of the substituted hydrocarbyl group include a substituted hydrocarbyl group in which the substituent is a hydrocarbyloxy group, and a substituted hydrocarbyl group in which the substituent is a substituted amino group. Examples of the hydrocarbyl group include alkyl groups such as a methyl group, an ethyl group, a n-propyl group, an isopropyl group, and a n-butyl group; alkenyl groups such as a vinyl group, an allyl group, and an isopropenyl group; and aryl groups such as a phenyl group. Examples of the substituted hydrocarbyl group in which the substituent is a hydrocarbyloxy group include alkoxyalkyl groups such as a methoxymethyl group, an ethoxymethyl group, and an ethoxyethyl group. Examples of the substituted hydrocarbyl group in which the substituent is a substituted amino group include (N,N-dialkylamino)alkyl groups such as a 2-(N,N-dimethylamino)ethyl group, a 2-(N,N-diethylamino)ethyl group, a 3-(N,N-dimethylamino)propyl group, and a 3-(N,N-diethylamino)propyl group; (N,N-dialkylamino)aryl groups such as a 4-(N,N-dimethylamino)phenyl group, a 3-(N,N-dimethylamino)phenyl group, a 4-(N,N-diethylamino)phenyl group, and a 3-(N,N-diethylamino)phenyl group; (N,N-dialkylamino)alkylaryl groups such as a 4-(N,N-dimethylamino)methylphenyl group and a

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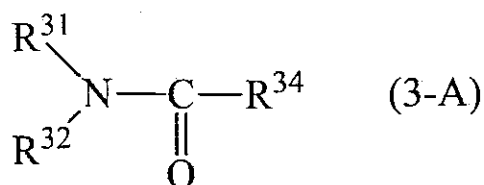
4-[2-(N,N-dimethylamino)ethyl]phenyl group; cyclic amino group-containing alkyl groups such as a 3-(1-pyrrolidinyl)propyl group, a 3-(1-piperidinyl)propyl group, and a 3-(1-imidazolyl)propyl group; cyclic amino group-containing aryl groups such as a 4-(1-pyrrolidinyl)phenyl group, a 4-(1-piperidinyl)phenyl group, and a 4-(1-imidazolyl)phenyl group; and cyclic amino group-containing alkylaryl groups such as a 4-[2-(1-pyrrolidinyl)ethyl]phenyl group, a 4-[2-(1-piperidinyl)ethyl]phenyl group, and a 4-[2-(1-imidazolyl)ethyl]phenyl group.

In the formula (3), the hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, formed by bonding of R^{31} and R^{32} , is a hydrocarbylene group or a hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom and/or an oxygen atom. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom and/or an oxygen atom include a hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom and a hetero atom-containing hydrocarbylene group in which the hetero atom is an oxygen atom. Examples of the hydrocarbylene group include alkylene groups such as a trimethylene group, a tetramethylene group, a pentamethylene group, a hexamethylene group, and a 2,2,4-trimethylhexane-1,6-diyl group; and arylene groups such as a 1,4-phenylene group. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom include a group represented by -CH=N-CH=CH- and a group represented by $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is an oxygen atom include a group represented by $\text{-(CH}_2\text{)}_s\text{-O-(CH}_2\text{)}_t\text{-}$ (s and t are an integer of 1 or more).

In the formula (3), examples of the divalent group formed by bonding of R^{31} and R^{34} , and the divalent group of R^{33} include a hydrocarbylene group, a hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom, a hetero atom-containing hydrocarbylene group in which the

hetero atom is an oxygen atom, a group in which a hydrocarbylene group and an oxygen atom are bonded, and a group in which a hydrocarbylene group and a group represented by -NR^{35} (R^{35} represents a hydrocarbyl group or a hydrogen atom) are bonded. Examples of the hydrocarbylene group include
 5 alkylene groups such as a trimethylene group, a tetramethylene group, a pentamethylene group, a hexamethylene group, and a 2,2,4-trimethylhexane-1,6-diyl group; and arylene groups such as a 1,4-phenylene group. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is a nitrogen atom include a
 10 group represented by -CH=N-CH=CH- and a group represented by $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$. Examples of the hetero atom-containing hydrocarbylene group in which the hetero atom is an oxygen atom include a group represented by $\text{-(CH}_2\text{)}_s\text{-O-(CH}_2\text{)}_t\text{-}$ (s and t are an integer of 1 or more). Examples of the group in which a hydrocarbylene group and an oxygen atom
 15 are bonded include a group represented by $\text{-(CH}_2\text{)}_r\text{-O-}$ (r represents an integer of 1 or more). Examples of the group in which a hydrocarbylene group and a group represented by -NR^{35} (R^{35} represents a hydrocarbyl group or a nitrogen atom) are bonded include a group represented by $\text{-(CH}_2\text{)}_p\text{-NR}^{35}$ (R^{35} represents a hydrocarbyl group having 1 to 6 carbon atoms, or a
 20 hydrogen atom, and p represents an integer of 1 or more).

Examples of a preferable compound represented by the formula (3) include a compound represented by (3-A) in which k is 0 and R^{34} is a hydrocarbyl group optionally having a substituent or a hydrogen atom.



25 (in the formula (3-A), R^{31} and R^{32} may be bonded, R^{31} represents a hydrocarbyl group optionally having a substituent, or is bonded with R^{32} to represent a hydrocarbylene group optionally having, as a hetero atom, a

nitrogen atom and/or an oxygen atom, R^{32} represents a hydrocarbyl group optionally having a substituent, or is bonded with R^{31} to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, and R^{34} represents a hydrocarbyl group optionally
5 having a substituent or a hydrogen atom.)

In the formula (3-A), description and exemplification of the hydrocarbyl group optionally having a substituent in R^{31} , R^{32} and R^{34} , and the hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, formed by bonding of R^{31} and R^{32} , are the same
10 as those stated in the description of the formula (3).

In the formula (3-A), R^{31} is preferably a hydrocarbyl group having 1 to 10 carbon atoms, or is bonded with R^{32} to form a hydrocarbylene group having 3 to 10 carbon atoms or a hetero atom-containing hydrocarbylene group having 3 to 10 carbon atoms in which the hetero atom is a nitrogen
15 atom. R^{31} is more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, or is bonded with R^{32} to form an alkylene group having 3 to 10 carbon atoms, a group represented by $-\text{CH}=\text{N}-\text{CH}=\text{CH}-$, or a group represented by $-\text{CH}=\text{N}-\text{CH}_2-\text{CH}_2-$. R^{31} is further preferably an alkyl group having 1 to 6 carbon atoms. R^{31} is
20 particularly preferably a methyl group or an ethyl group.

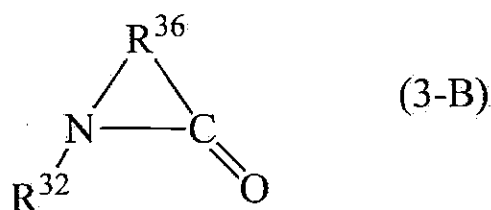
In the formula (3-A), R^{32} is preferably a hydrocarbyl group having 1 to 10 carbon atoms, or is bonded with R^{31} to form a hydrocarbylene group having 3 to 10 carbon atoms or a hetero atom-containing hydrocarbylene group having 3 to 10 carbon atoms in which the hetero atom is a nitrogen
25 atom. R^{32} is more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, or is bonded with R^{31} to form an alkylene group having 3 to 10 carbon atoms, a group represented by $-\text{CH}=\text{N}-\text{CH}=\text{CH}-$, or a group represented by $-\text{CH}=\text{N}-\text{CH}_2-\text{CH}_2-$. R^{32} is further preferably an alkyl group having 1 to 6 carbon atoms. R^{32} is
30 particularly preferably a methyl group or an ethyl group.

In the formula (3-A), R^{34} is preferably a hydrocarbyl group or a hydrogen atom, more preferably a hydrocarbyl group having 1 to 10 carbon atoms or a hydrogen atom, further preferably an alkyl group having 1 to 6 carbon atoms or a hydrogen atom, and particularly preferably a hydrogen atom, a methyl group or an ethyl group.

Examples of a compound in which R^{34} is a hydrocarbyl group, of the compounds represented by the formula (3-A), include N,N-dihydrocarbylacetamides such as N,N-dimethylacetamide, N,N-diethylacetamide, and N-methyl-N-ethylacetamide; N,N-dihydrocarbylacrylamides such as N,N-dimethylacrylamide, N,N-diethylacrylamide, and N-methyl-N-ethylacrylamide; and N,N-dihydrocarbylmethacrylamides such as N,N-dimethylmethacrylamide, N,N-diethylmethacrylamide, and N-methyl-N-ethylmethacrylamide.

Examples of a compound in which R^{34} is a hydrogen atom, of the compounds represented by the formula (3-A), include N,N-dihydrocarbylformamides such as N,N-dimethylformamide, N,N-diethylformamide, and N-methyl-N-ethylformamide.

Examples of a preferable compound represented by the formula (3) include a compound represented by (3-B) in which k is 0 and R^{34} is bonded with R^{31} to form a divalent group.



(in the formula (3-B), R^{32} represents a hydrocarbyl group optionally having a substituent, R^{36} represents a group in which a hydrocarbylene group and a group represented by $\cdot NR^{35}$ are bonded, or a hydrocarbylene group, wherein R^{35} represents a hydrocarbyl group or a hydrogen atom. A nitrogen atom to which R^{35} is bonded is bonded with a carbon atom of $C=O$.)

In the formula (3-B), explanation and exemplification of a

hydrocarbyl group optionally having a substituent of R^{32} are the same as those stated in explanation of the formula (3).

In the formula (3-B), examples of the hydrocarbylene group in R^{36} include alkylene groups such as a trimethylene group, a tetramethylene group, a pentamethylene group, a hexamethylene group, and a 2,2,4-trimethylhexane-1,6-diyl group; and arylene groups such as a 1,4-phenylene group. Examples of the group in which a hydrocarbylene group and a group represented by $\cdot NR^{35}$ (R^{35} represents a hydrocarbyl group or a hydrogen atom) are bonded in R^{36} include a group represented by $-(CH_2)_p \cdot NR^{35}$ (R^{35} represents a hydrocarbyl group or a hydrogen atom, and p represents an integer of 1 or more).

In the formula (3-B), R^{32} is preferably a hydrocarbyl group having 1 to 10 carbon atoms, more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, further preferably an alkyl group having 1 to 6 carbon atoms or a phenyl group, particularly preferably a methyl group, an ethyl group, or a phenyl group.

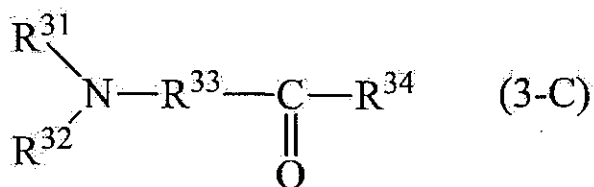
In the formula (3-B), R^{36} is preferably a hydrocarbylene group having 1 to 10 carbon atoms, or a group in which a hydrocarbylene group having 1 to 10 carbon atoms and a group represented by $\cdot NR^{35}$ (R^{35} represents a hydrocarbyl group having 1 to 10 carbon atoms or a hydrogen atom) are bonded, more preferably an alkylene group having 3 to 6 carbon atoms or a group represented by $\cdot (CH_2)_p \cdot NR^{35}$ (R^{35} represents a hydrocarbyl group having 1 to 10 carbon atoms, and p represents an integer of 2 to 5), and further preferably a trimethylene group, a tetramethylene group, a pentamethylene group, or a group represented by $\cdot (CH_2)_2 \cdot N(CH_3) \cdot$.

Examples of a compound in which R^{36} is a hydrocarbylene group, of the compounds represented by the formula (3-B), include N-hydrocarbyl- β -propiolactams such as N-methyl- β -propiolactam and N-phenyl- β -propiolactam; N-hydrocarbyl-2-pyrrolidones such as N-methyl-2-pyrrolidone, N-vinyl-2-pyrrolidone, N-phenyl-2-pyrrolidone,

N-tert-butyl-2-pyrrolidone, and N-methyl-5-methyl-2-pyrrolidone;
 N-hydrocarbyl-2-piperidones such as N-methyl-2-piperidone,
 N-vinyl-2-piperidone, and N-phenyl-2-piperidone;
 N-hydrocarbyl- ϵ -caprolactams such as N-methyl- ϵ -caprolactam and
 5 N-phenyl- ϵ -caprolactam; N-hydrocarbyl- ω -laurylactams such as
 N-methyl- ω -laurylactam and N-vinyl- ω -laurylactam. The compound is
 preferably a compound in which R^{36} is an alkylene group having 3 to 6
 carbon atoms and R^{32} is an alkyl group having 1 to 6 carbon atoms or a
 phenyl group, more preferably a compound in which R^{36} is a trimethylene
 10 group, a tetramethylene group, or a pentamethylene group, and R^{32} is a
 methyl group, an ethyl group, or a phenyl group, and further preferably
 N-phenyl-2-pyrrolidone, or N-methyl- ϵ -caprolactam.

Examples of a compound in which R^{36} is a group in which a
 hydrocarbylene group and a group represented by $\cdot NR^{35}\cdot$ (R^{35} is a
 15 hydrocarbyl group or a hydrogen atom) are bonded, of the compounds
 represented by the formula (3-B), include
 1,3-dihydrocarbyl-2-imidazolidinones such as
 1,3-dimethyl-2-imidazolidinone, 1,3-diethyl-2-imidazolidinone,
 1,3-divinyl-2-imidazolidinone, and 1-methyl-3-ethyl-2-imidazolidinone. The
 20 compound is preferably a compound in which R^{36} is a group represented by
 $\cdot (CH_2)_p \cdot NR^{35}\cdot$ (R^{35} is a hydrocarbyl group having 1 to 10 carbon atoms, and p
 represents an integer of 2 to 5) and R^{32} is an alkyl group having 1 to 6 carbon
 atoms or a phenyl group, more preferably a compound in which R^{36} is a group
 represented by $\cdot (CH_2)_2 \cdot N(CH_3)\cdot$ and R^{32} is a methyl group or an ethyl group,
 25 and further preferably 1,3-dimethyl-2-imidazolidinone.

Examples of a preferable compound represented by the formula (3)
 include a compound represented by the following formula (3-C) in which k is
 1 and R^{33} is a hydrocarbylene group.



(in the formula (3-C), R³¹ and R³² may be bonded, R³¹ represents a hydrocarbyl group optionally having a substituent, or is bonded with R³² to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, R³² represents a hydrocarbyl group optionally having a substituent, or is bonded with R³¹ to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, R³³ represents a hydrocarbylene group, and R³⁴ represents a hydrocarbyl group optionally having a substituent.)

In the formula (3-C), description and exemplification of the hydrocarbyl group optionally having a substituent in R³¹, R³² and R³⁴, the hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, formed by bonding of R³¹ and R³², and the hydrocarbylene group in R³³ are the same as those stated in the description of the formula (3).

In the formula (3-C), R³³ is preferably a hydrocarbylene group having 1 to 10 carbon atoms, more preferably an alkylene group having 1 to 10 carbon atoms or an arylene group having 6 to 10 carbon atoms, further preferably an alkylene group having 1 to 6 carbon atoms or a phenylene group, and particularly preferably an ethylene group, a trimethylene group, or a 1,4-phenylene group.

In the formula (3-C), R³⁴ is preferably a hydrocarbyl group having 1 to 10 carbon atoms, or a substituted hydrocarbyl group having 3 to 10 carbon atoms in which the substituent is a dialkylamino group, more preferably an alkyl group having 1 to 6 carbon atoms, an aryl group having 6 to 10 carbon atoms, a dialkylaminoalkyl group having 3 to 6 carbon atoms or a dialkylaminoaryl group having 8 to 10 carbon atoms, and further preferably

a methyl group, an ethyl group, a dialkylaminomethyl group having 3 to 6 carbon atoms, a dialkylaminoethyl group having 4 to 6 carbon atoms, a phenyl group, or a dialkylaminophenyl group having 8 to 10 carbon atoms.

In the formula (3-C), R^{31} is preferably a hydrocarbyl group having 1
5 to 10 carbon atoms, or is bonded with R^{32} to form a hydrocarbylene group having 3 to 10 carbon atoms, or a hetero atom-containing hydrocarbylene group having 3 to 10 carbon atoms in which the hetero atom is a nitrogen atom, more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, or is bonded with R^{32} to form an alkylene
10 group having 3 to 10 carbon atoms, a group represented by -CH=N-CH=CH- , a group represented by $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$, or a group represented by $\text{-(CH}_2\text{)}_2\text{-O-(CH}_2\text{)}_2\text{-}$, further preferably an alkyl group having 1 to 6 carbon atoms, or is bonded with R^{32} to form an alkylene group having 3 to 6 carbon atoms, a group represented by -CH=N-CH=CH- , or a group represented by
15 $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$, and particularly preferably a methyl group or an ethyl group, or is bonded with R^{32} to form a tetramethylene group, a hexamethylene group, or a group represented by -CH=N-CH=CH- .

In the formula (3-C), R^{32} is preferably a hydrocarbyl group having 1
to 10 carbon atoms, or is bonded with R^{31} to form a hydrocarbylene group
20 having 3 to 10 carbon atoms, or a hetero atom-containing hydrocarbylene group having 3 to 10 carbon atoms in which the hetero atom is a nitrogen atom, more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, or is bonded with R^{31} to form an alkylene group having 3 to 10 carbon atoms, a group represented by -CH=N-CH=CH- ,
25 a group represented by $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$, or a group represented by $\text{-(CH}_2\text{)}_2\text{-O-(CH}_2\text{)}_2\text{-}$, further preferably an alkyl group having 1 to 6 carbon atoms, or is bonded with R^{31} to form an alkylene group having 3 to 6 carbon atoms, a group represented by -CH=N-CH=CH- , or a group represented by $\text{-CH=N-CH}_2\text{-CH}_2\text{-}$, and particularly preferably a methyl group or an ethyl
30 group, or is bonded with R^{31} to form a tetramethylene group, a

hexamethylene group, or a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$.

Examples of a compound in which R^{33} is an arylene group and R^{34} is an alkyl group, of the compounds represented by the formula (3-C), include 4-(N,N-dihydrocarbylamino)acetophenones such as

5 4-(N,N-dimethylamino)acetophenone,

4-(N-methyl-N-ethylamino)acetophenone, and

4-(N,N-diethylamino)acetophenone; 4-cyclic amino acetophenone compounds such as 4'-(imidazol-1-yl)acetophenone. Among them, a 4-cyclic amino acetophenone compound is preferable, and 4'-(imidazol-1-yl)acetophenone is
10 more preferable.

Examples of a compound in which R^{33} is an arylene group and R^{34} is an aryl group or a substituted aryl group, of the compounds represented by the formula (3-C), include bis(dihydrocarbylaminoalkyl)ketones such as

1,7-bis(methylethylamino)-4-heptanone and

15 1,3-bis(diphenylamino)-2-propanone; 4-(dihydrocarbylamino)benzophenones such as 4-N,N-dimethylaminobenzophenone,

4-N,N-diethylaminobenzophenone, 4-N,N-di-*t*-butylaminobenzophenone, and 4-N,N-diphenylaminobenzophenone; and

4,4'-bis(dihydrocarbylamino)benzophenones such as

20 4,4'-bis(dimethylamino)benzophenone, 4,4'-bis(diethylamino)benzophenone, and 4,4'-bis(diphenylamino)benzophenone. Among them, a compound in

which R^{31} and R^{32} are an alkyl group having 1 to 6 carbon atoms, R^{33} is a phenylene group, and R^{34} is a phenyl group or a dialkylaminophenyl group having 8 to 10 carbon atoms is preferable, and

25 4-N,N-dimethylaminobenzophenone, 4-N,N-diethylaminobenzophenone,

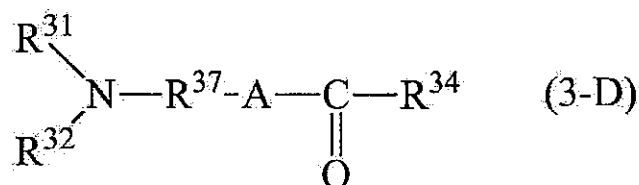
4,4'-bis(dimethylamino)benzophenone, and

4,4'-bis(diethylamino)benzophenone are more preferable.

Examples of a preferable compound represented by the formula (3) include a compound represented by the following formula (3-D) in which k is

30 1 and R^{33} is a group in which a hydrocarbylene group and an oxygen atom

are bonded, or a group in which a hydrocarbylene group and a group represented by -NR^{35} (R^{35} represents a hydrocarbyl group or a hydrogen atom) are bonded.



5 (in the formula (3-D), R^{31} and R^{32} may be bonded, R^{31} represents a hydrocarbyl group optionally having a substituent, or is bonded with R^{32} to represent a hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, R^{32} represents a hydrocarbyl group optionally having a substituent, or is bonded with R^{31} to represent a
10 hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, R^{37} represents a hydrocarbylene group, A represents an oxygen atom or -NR^{35} , R^{35} represents a hydrocarbylene group or a hydrogen atom, and R^{34} represents a hydrocarbyl group optionally having a substituent.)

15 In the formula (3-D), description and exemplification of the hydrocarbyl group optionally having a substituent in R^{31} , R^{33} and R^{34} , and the hydrocarbylene group optionally having, as a hetero atom, a nitrogen atom and/or an oxygen atom, formed by bonding of R^{31} and R^{32} , are the same as those stated in the description of the formula (3).

20 In the formula (3-D), A is preferably an oxygen atom or a group represented by -NR^{35} (R^{35} is a hydrocarbylene group having 1 to 5 carbon atoms or a hydrogen atom), more preferably an oxygen atom or a group represented by -NH- , and further preferably a group represented by -NH- .

In the formula (3-D), examples of the hydrocarbylene group in R^{37}
25 include alkylene groups such as a trimethylene group, a tetramethylene group, a pentamethylene group, a hexamethylene group, and a 2,2,4-trimethylhexane-1,6-diyl group; arylene groups such as a

1,4-phenylene group.

In the formula (3-D), R^{34} is preferably a hydrocarbyl group having 1 to 10 carbon atoms, more preferably an alkenyl group having 2 to 5 carbon atoms, further preferably a vinyl group or an isopropenyl group, and particularly preferably a vinyl group.

In the formula (3-D), R^{37} is preferably a hydrocarbylene group having 1 to 10 carbon atoms, more preferably an alkylene group having 1 to 6 carbon atoms, further preferably an ethylene group or a trimethylene group, and particularly preferably a trimethylene group.

In the formula (3-D), R^{31} is preferably a hydrocarbyl group having 1 to 10 carbon atoms, or is bonded with R^{32} to form a hydrocarbylene group having 3 to 10 carbon atoms, or a hetero atom-containing hydrocarbylene group having 3 to 10 carbon atoms in which the hetero atom is a nitrogen atom, more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, or is bonded with R^{32} to form an alkylene group having 3 to 10 carbon atoms, a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$, a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}_2\cdot\text{CH}_2\cdot$, or a group represented by $\cdot(\text{CH}_2)_2\cdot\text{O}\cdot(\text{CH}_2)_2\cdot$, further preferably an alkyl group having 1 to 6 carbon atoms, or is bonded with R^{32} to form an alkylene group having 3 to 6 carbon atoms, a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$, or a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}_2\cdot\text{CH}_2\cdot$, and particularly preferably a methyl group or an ethyl group, or is bonded with R^{32} to form a tetramethylene group, a hexamethylene group, or a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$.

In the formula (3-D), R^{32} is preferably a hydrocarbyl group having 1 to 10 carbon atoms, or is bonded with R^{31} to form a hydrocarbylene group having 3 to 10 carbon atoms, or a hetero atom-containing hydrocarbylene group having 3 to 10 carbon atoms in which the hetero atom is a nitrogen atom, more preferably an alkyl group having 1 to 10 carbon atoms or an aryl group having 6 to 10 carbon atoms, or is bonded with R^{31} to form an alkylene group having 3 to 10 carbon atoms, a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$,

a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}_2\cdot\text{CH}_2\cdot$, or a group represented by $\cdot(\text{CH}_2)_2\cdot\text{O}\cdot(\text{CH}_2)_2\cdot$, further preferably an alkyl group having 1 to 6 carbon atoms, or is bonded with R^{31} to form an alkylene group having 3 to 6 carbon atoms, a group represented by $-\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$, or a group represented by
5 $\cdot\text{CH}=\text{N}\cdot\text{CH}_2\cdot\text{CH}_2\cdot$, and particularly preferably a methyl group or an ethyl group, or is bonded with R^{31} to form a tetramethylene group, a hexamethylene group, or a group represented by $\cdot\text{CH}=\text{N}\cdot\text{CH}=\text{CH}\cdot$.

Examples of a compound in which A is an oxygen atom, of the compounds represented by the formula (3-D), include:

10 2-(dihydrocarbylamino)ethyl acrylates such as
2-(dimethylamino)ethyl acrylate and 2-(diethylamino)ethyl acrylate;
3-(dihydrocarbylamino)propyl acrylates such as 3-(dimethylamino)propyl
acrylate; 2-(dihydrocarbylamino)ethyl methacrylates such as
2-(dimethylamino)ethyl methacrylate and 2-(diethylamino)ethyl
15 methacrylate; 3-(dihydrocarbylamino)propyl methacrylates such as
3-(dimethylamino)propyl methacrylate. As the compound in which A is an
oxygen atom, a compound in which R^{31} and R^{32} are an alkyl group having 1
to 6 carbon atoms, R^{34} is a vinyl group or an isopropenyl group, and R^{37} is an
ethylene group or a trimethylene group is preferable, and a compound in
20 which R^{31} and R^{32} are a methyl group or an ethyl group, R^{34} is a vinyl group,
and R^{37} is a trimethylene group is more preferable.

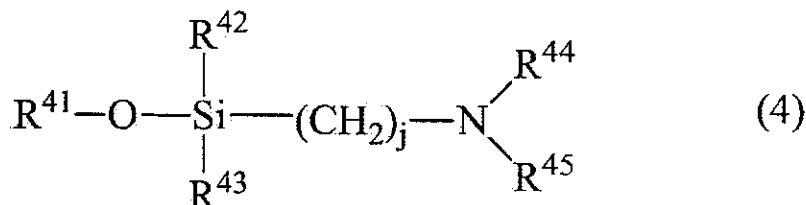
Examples of a compound in which A is a group represented by $\cdot\text{NR}^{35}\cdot$
(R^{35} is a hydrocarbylene group or a hydrogen atom), of the compounds
represented by the formula (3-D), include:

25 N-(2-dihydrocarbylaminoethyl)acrylamides such as
N-(2-dimethylaminoethyl)acrylamide and
N-(2-diethylaminoethyl)acrylamide;
N-(3-dihydrocarbylaminoethyl)acrylamides such as
N-(3-dimethylaminopropyl)acrylamide and
30 N-(3-diethylaminopropyl)acrylamide;

N-(4-dihydrocarbylaminobutyl)acrylamides such as
 N-(4-dimethylaminobutyl)acrylamide and
 N-(4-diethylaminobutyl)acrylamide;
 N-(2-dihydrocarbylaminoethyl)methacrylamides such as
 5 N-(2-dimethylaminoethyl)methacrylamide and
 N-(2-diethylaminoethyl)methacrylamide;
 N-(3-dihydrocarbylaminopropyl)methacrylamides such as
 N-(3-dimethylaminopropyl)methacrylamide and
 N-(3-diethylaminopropyl)methacrylamide;
 10 N-(4-dihydrocarbylaminobutyl)methacrylamides such as
 N-(4-dimethylaminobutyl)methacrylamide and
 N-(4-diethylaminobutyl)methacrylamide. Among them, a compound in
 which A is a group represented by $\cdot\text{NH}\cdot$, R^{31} and R^{32} are an alkyl group
 having 1 to 6 carbon atoms, R^{34} is a vinyl group or an isopropenyl group, and
 15 R^{37} is an ethylene group or a trimethylene group is preferable, and a
 compound in which A is a group represented by $\cdot\text{NH}\cdot$, R^{31} and R^{32} are a
 methyl group or a methyl group, R^{34} is a vinyl group, and R^{37} is a
 trimethylene group is more preferable.

Examples of the compound containing a nitrogen atom and/or a
 20 silicon atom include also a compound containing an alkoxysilyl group, in
 addition to the aforementioned compounds.

As the compound containing an alkoxysilyl group, a compound
 containing a nitrogen atom and an alkoxysilyl group is preferable, and
 examples of the compound include a compound represented by the following
 25 formula (4).



(in the formula (4), R^{44} and R^{45} may be bound, R^{41} represents a hydrocarbyl

group, R^{42} and R^{43} represent a hydrocarbyl group or a hydrocarbyloxy group, R^{44} represents a hydrocarbyl group optionally having a substituent, or a trihydrocarbylsilyl group, or is bound with R^{45} to represent a hydrocarbylene group optionally having, as a hetero atom, at least one atom selected from an atomic group consisting of a silicon atom, a nitrogen atom and an oxygen atom, R^{45} represents a hydrocarbyl group optionally having a substituent, or a trihydrocarbylsilyl group, or is bound with R^{44} to represent a hydrocarbylene group optionally having, as a hetero atom, at least one atom selected from an atomic group consisting of a silicon atom, a nitrogen atom and an oxygen atom, and j represents an integer of 1 to 5.)

In the formula (4), the hydrocarbyl group optionally having a substituent is a hydrocarbyl group or a substituted hydrocarbyl group.

In the formula (4), examples of the hydrocarbyl group include alkyl groups such as a methyl group, an ethyl group, a n-propyl group, an isopropyl group, and a n-butyl group; alkenyl groups such as a vinyl group, an allyl group, and an isopropenyl group; aryl groups such as a phenyl group, preferably an alkyl group, more preferably a methyl or an ethyl group. Examples of the substituted hydrocarbyl group include oxacycloalkyl groups such as an oxiranyl group, a tetrahydrofuranyl group etc., preferably a tetrahydrofuranyl.

Herein, the oxacycloalkyl group represents a group in which CH_2 on an alicycle of a cycloalkyl group is replaced with an oxygen atom.

Examples of the hydrocarbyloxy group include, as a hydrocarbyloxy group, alkoxy groups such as a methoxy group, an ethoxy group, a n-propoxy group, an isopropoxy group, a n-butoxy group, a sec-butoxy group, and a tert-butoxy group; aryloxy groups such as a phenoxy group, and a benzyloxy group, preferably an alkoxy group, more preferably a methoxy group or an ethoxy group.

Examples of the trihydrocarbylsilyl group include a trimethylsilyl group, a tert-butyl-dimethylsilyl group, preferably a trimethylsilyl group.

The hydrocarbylene group optionally having, as a hetero atom, at least one atom selected from an atomic group consisting of a silicon atom, a nitrogen atom and an oxygen atom is a hydrocarbylene group, or a hetero atom-containing hydrocarbylene group in which a hetero atom is at least one atom selected from an atomic group consisting of a silicon atom, a nitrogen atom and an oxygen atom. Examples of the hetero atom-containing hydrocarbylene group in which a hetero atom is at least one atom selected from an atomic group consisting of a silicon atom, a nitrogen atom and an oxygen atom include a hetero atom-containing hydrocarbylene group in which a hetero atom is a silicon atom, a hetero atom-containing hydrocarbylene group in which a hetero atom is a nitrogen atom, and a hetero atom-containing hydrocarbylene group in which a hetero atom is an oxygen atom. Examples of the hydrocarbylene group include alkylene groups such as a tetramethylene group, a pentamethylene group, a hexamethylene group, and a 2,2,4-trimethylhexane-1,5-diyl group and, among them, an alkylene group having 4 to 7 carbon atoms is preferable, and a pentamethylene group or a hexamethylene group is particularly preferable. Examples of the hetero atom-containing hydrocarbylene group in which a hetero atom is a silicon atom include a group represented by $-\text{Si}(\text{CH}_3)_2\text{-CH}_2\text{-CH}_2\text{-Si}(\text{CH}_3)_2-$. Examples of the hetero atom-containing hydrocarbylene group in which a hetero atom is a nitrogen atom include a group represented by $-\text{CH}=\text{N-CH=CH-}$, or a group represented by $-\text{CH}=\text{N-CH}_2\text{-CH}_2-$. Examples of the hetero atom-containing hydrocarbylene group in which a hetero atom is an oxygen atom include a group represented by $-\text{CH}_2\text{-CH}_2\text{-O-CH}_2\text{-CH}_2-$.

In the formula (4), R^{41} is preferably an alkyl group having 1 to 4 carbon atoms, more preferably a methyl group or an ethyl group. R^{42} and R^{43} are preferably a hydrocarbyloxy group, more preferably an alkoxy group having 1 to 4 carbon atoms, further preferably a methoxy group or an ethoxy group. R^{44} and R^{45} are preferably a hydrocarbyl group, more preferably an

alkyl group having 1 to 4 carbon atoms, further preferably a methyl group or an ethyl group. And, j is preferably an integer of 2 to 4.

Examples of the compound represented by the formula (4) include [(dialkylamino)alkyl]alkoxysilane compounds such as

- 5 [3-(dimethylamino)propyl]triethoxysilane,
[3-(dimethylamino)propyl]trimethoxysilane,
[3-(diethylamino)propyl]triethoxysilane,
[3-(diethylamino)propyl]trimethoxysilane,
[3-(dimethylamino)propyl]methyldiethoxysilane,
10 [2-(dimethylamino)ethyl]triethoxysilane, and
[2-(dimethylamino)ethyl]trimethoxysilane; cyclic aminoalkylalkoxysilane compounds such as (1-hexamethyleneiminomethyl)trimethoxysilane,
[3-(1-hexamethyleneimino)propyl]triethoxysilane,
N-(3-triethoxysilylpropyl)-4,5-dihydroimidazole, and
15 N-(3-trimethoxysilylpropyl)-4,5-imidazole;
{[di(tetrahydrofuranyl)amino]alkyl}alkoxysilane compounds such as
{3-[di(tetrahydrofuranyl)amino]propyl}trimethoxysilane,
{3-[di(tetrahydrofuranyl)amino]propyl}triethoxysilane etc.;
[N,N-bis(trialkylsilyl)aminoalkyl]alkylalkoxysilane compounds such as
20 {3-[N,N-bis(trimethylsilyl)amino]propyl}methyldimethoxysilane, and
{3-[N,N-bis(trimethylsilyl)amino]propyl}methyldiethoxysilane. A
compound in which R⁴¹ is an alkyl group having 1 to 4 carbon atoms, R⁴² and
R⁴³ are an alkoxy group having 1 to 4 carbon atoms, R⁴⁴ and R⁴⁵ are an alkyl
group having 1 to 4 carbon atoms, and j is an integer of 2 to 4 is more
25 preferable, and [3-(dimethylamino)propyl]triethoxysilane,
[3-(dimethylamino)propyl]trimethoxysilane,
[3-(diethylamino)propyl]triethoxysilane, and
[3-(diethylamino)propyl]trimethoxysilane are more preferable.

- Examples of the compound containing an alkoxysilyl group include,
30 in addition to the aforementioned compounds containing a nitrogen atom...

and an alkoxysilyl group, tetraalkoxysilanes such as tetramethoxysilane, tetraethoxysilane and tetra-n-propoxysilane; trialkoxyhydrocarbylsilanes such as methyltrimethoxysilane, methyltriethoxysilane, ethyltrimethoxysilane, and phenyltrimethoxysilane; trialkoxyhalosilanes
5 such as trimethoxychlorosilane, triethoxychlorosilane, and tri-n-propoxychlorosilane; dialkoxydihydrocarbylsilanes such as dimethoxydimethylsilane, diethoxydimethylsilane, and dimethoxydiethylsilane; dialkoxydihalosilanes such as dimethoxydichlorosilane, diethoxydichlorosilane, and
10 di-n-propoxydichlorosilane; monoalkoxytrihydrocarbylsilanes such as methoxytrimethylsilane; monoalkoxytrihalosilanes such as methoxytrichlorosilane, and ethoxytrichlorosilane; (glycidoxyalkyl)alkylalkoxysilane compounds such as 2-glycidoxyethyltrimethoxysilane, 2-glycidoxyethyltriethoxysilane,
15 (2-glycidoxyethyl)methyldimethoxysilane, 3-glycidoxypropyltrimethoxysilane, 3-glycidoxypropyltriethoxysilane, and (3-glycidoxypropyl)methyldimethoxysilane; (3,4-epoxycyclohexyl)alkylalkoxysilane compounds such as 2-(3,4-epoxycyclohexyl)ethyltrimethoxysilane,
20 2-(3,4-epoxycyclohexyl)ethyltriethoxysilane; [(3,4-epoxycyclohexyl)alkyl]alkylalkoxysilane compounds such as [2-(3,4-epoxycyclohexyl)ethyl]methyldimethoxysilane; alkoxysilylalkylsuccinic acid anhydrides such as 3-trimethoxysilylpropylsuccinic acid anhydride, and
25 3-triethoxysilylpropylsuccinic acid anhydride; (methacryloyloxyalkyl)alkoxysilane compounds such as 3-methacryloyloxypropyltrimethoxysilane, and 3-methacryloyloxypropyltriethoxysilane.

And, the compound containing an alkoxysilyl group may contain a
30 nitrogen atom and a group represented by $>\text{C}=\text{O}$. Examples of the

compound containing an alkoxysilyl group, and containing a nitrogen atom and a group represented by >C=O include

tris[(alkoxysilyl)alkyl]isocyanurate compounds such as

tris[3-(trimethoxysilyl)propyl]isocyanurate,

5 tris[3-(triethoxysilyl)propyl]isocyanurate,

tris[3-(tripropoxysilyl)propyl]isocyanurate, and

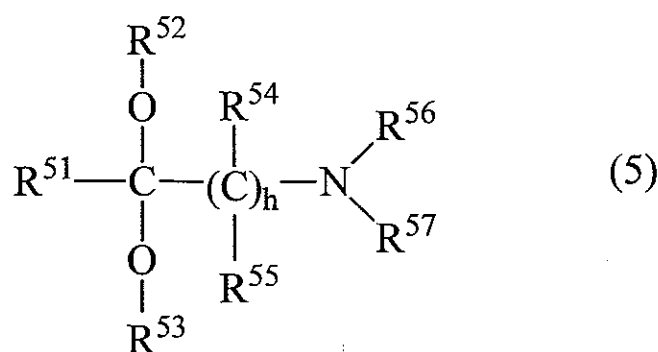
tris[3-(tributoxysilyl)propyl]isocyanurate. Among them,

tris[3-(trialkoxysilyl)propyl]isocyanurate is preferable,

10 tris[3-(trialkoxysilyl)propyl]isocyanurate in which an alkoxy group is an alkoxy group having 1 to 4 carbon atoms is more preferable, and

tris[3-(trimethoxysilyl)propyl]isocyanurate is further preferable.

In addition to the aforementioned compounds, preferable examples of the compound containing a nitrogen atom and/or a silicon atom include a compound represented by the following formula (5):



15

(in the formula (5), R⁵¹ represents a hydrogen atom, a hydrocarbyl group or a hydrocarbyloxy group, R⁵² and R⁵³ represent a hydrocarbyl group. And, h represents an integer of 0 to 10, R⁵⁴ and R⁵⁵ each represent a hydrogen atom or a hydrocarbyl group, when there are a plurality of R⁵⁴s, the plurality of R⁵⁴s may be the same as, or different from one another and, when there are a plurality of R⁵⁵s, the plurality of R⁵⁵s may be the same as, or different from one another. R⁵⁶ and R⁵⁷ each represent a hydrocarbyl group optionally having a substituent, or a trihydrocarbylsilyl group, or R⁵⁶ and R⁵⁷ are bound to represent a hydrocarbylene group optionally having, as a hetero atom, at

least one atom selected from an atomic group consisting of a silicon atom, a nitrogen atom and an oxygen atom.)

R⁵¹ represents a hydrogen atom, a hydrocarbyl group or a hydrocarbyloxy group. The hydrocarbyl group is preferably a hydrocarbyl group having 1 to 4 carbon atoms, more preferably an alkyl group having 1 to 4 carbon atoms, further preferably a methyl group or an ethyl group. The hydrocarbyloxy group is preferably a hydrocarbyloxy group having 1 to 4 carbon atoms, more preferably an alkoxy group having 1 to 4 carbon atoms, further preferably a methoxy group or an ethoxy group. Among them, preferable is a hydrogen atom.

R⁵² and R⁵³ represent a hydrocarbyl group. The hydrocarbyl group is preferably a hydrocarbyl group having 1 to 4 carbon atoms, more preferably an alkyl group having 1 to 4 carbon atoms, further preferably a methyl group or an ethyl group. R⁵² and R⁵³ may be the same group, or may be different groups.

And, h represents an integer of 0 to 10, preferably 3 or less, more preferably 0.

R⁵⁴ and R⁵⁵ each represent a hydrogen atom or a hydrocarbyl group, when there are a plurality of R⁵⁴s, the plurality of R⁵⁴s may be the same as, or different from one another and, when there are a plurality of R⁵⁵s, the plurality of R⁵⁵s may be the same as, or different from one another. The hydrocarbyl group is preferably a hydrocarbyl group having 1 to 4 carbon atoms, more preferably an alkyl group having 1 to 4 carbon atoms, further preferably a methyl group or an ethyl group.

R⁵⁶ and R⁵⁷ each represent a hydrocarbyl group optionally having a substituent, or a trihydrocarbylsilyl group. The hydrocarbyl group optionally having a substituent is a hydrocarbyl group or a substituted hydrocarbyl group. The hydrocarbyl group is preferably a hydrocarbyl group having 1 to 4 carbon atoms. Examples of the substituted hydrocarbyl group include substituted hydrocarbyl groups in which a substituent is a

substituted amino group, such as a N,N-dimethylaminomethyl group, a
2-N,N-dimethylaminoethyl group, and a 3-N,N-dimethylaminopropyl group;
substituted hydrocarbyl groups in which a substituent is a hydrocarbyloxy
group, such as a methoxymethyl group, a methoxyethyl group, and an
5 ethoxyethyl group. Examples of the trihydrocarbylsilyl group include a
trimethylsilyl group and a tert-butyl-dimethylsilyl group, preferably a
trimethylsilyl group. Among them, preferable is a hydrocarbyl group, more
preferable is a hydrocarbyl group having 1 to 4 carbon atoms, further
preferably an alkyl group having 1 to 4 carbon atoms, and particularly
10 preferable is a methyl group or an ethyl group.

R^{56} and R^{57} may be bound to be a hydrocarbylene group optionally
having, as a hetero atom, at least one atom selected from the group
consisting of a silicon atom, a nitrogen atom and an oxygen atom.
Examples of the hydrocarbylene group include alkylene groups such as a
15 tetramethylene group, a pentamethylene group, a hexamethylene group, and
a 2,2,4-trimethylhexane-1,6-diyl group; alkenediyl groups such as a
pentane-2-ene-1,5-idyl group, preferably an alkylene group, more preferably
an alkylene group having 4 to 7 carbon atoms. Examples of a hetero
atom-containing hydrocarbylene group in which a hetero atom is a silicon
20 atom include a group represented by $-\text{Si}(\text{CH}_3)_2\text{-CH}_2\text{-CH}_2\text{-Si}(\text{CH}_3)_2-$.
Examples of a hetero atom-containing hydrocarbylene group in which a
hetero atom is a nitrogen atom include a group represented by
 $-\text{CH}=\text{N}-\text{HC}=\text{CH}-$, and a group represented by $-\text{CH}=\text{N}-\text{CH}_2\text{-CH}_2-$. Examples
of a hetero atom-containing hydrocarbylene group in which a hetero atom is
25 an oxygen atom include a group represented by $-\text{CH}_2\text{-CH}_2\text{-O-CH}_2\text{-CH}_2-$.
Among them, preferable is a hydrocarbylene group, more preferable is an
alkylene group having 4 to 7 carbon atoms, further preferable is a
tetramethylene group, a pentamethylene group, or a hexamethylene group.

Examples of the compound represented by the formula (5) include
30 N,N-dialkylformamide dialkyl acetals such as N,N-dimethylformamide

dimethyl acetal, N,N-diethylformamide dimethyl acetal,
N,N-dimethylformamide diethyl acetal, and N,N-diethylformamide diethyl
acetal; N,N-dialkylacetamide dialkyl acetals such as N,N-dimethylacetamide
dimethyl acetal, N,N-diethylacetamide dimethyl acetal,
5 N,N-dimethylacetamide diethyl acetal, and N,N-diethylacetamide diethyl
acetal.

The compound represented by the formula (5) is preferably a
compound in which h is 3 or less, R⁵¹ is a hydrogen atom, and R⁵², R⁵³, R⁵⁴,
R⁵⁵, R⁵⁶ and R⁵⁷ are an alkyl group having 1 to 4 carbon atoms. More
10 preferable is a compound in which h is 0, R⁵¹ is a hydrogen atom, and R⁵², R⁵³,
R⁵⁶ and R⁵⁷ are an alkyl group having 1 to 4 carbon atoms. Particularly
preferable is N,N-dimethylformamide dimethyl acetal,
N,N-diethylformamide dimethyl acetal, N,N-dimethylformamide diethyl
acetal, or N,N-diethylformamide diethyl acetal.

15 A reaction of an active end of a polymer produced by adding the
following compounds (I) and (II) to a monomer component in an order of the
compound (I) and the compound the (II), and polymerizing the monomer
component (it is thought that an active end of the polymer has an alkali
metal derived from an organic alkali metal compound of the compound (I)),
20 and the compound containing a nitrogen atom and/or silicon atom is
performed by adding the compound containing a nitrogen atom and/or a
silicon atom to a polymerization solution, and mixing a polymer and the
compound containing a nitrogen atom and/or a silicon atom in the solution.
The amount of the compound containing the nitrogen atom and/or a silicon
25 atom to be added to the polymerization solution is usually 0.1 mol to 3 mol,
preferably 0.5 mol to 2 mol, and more preferably 0.7 mol to 1.5 mol per 1 mol
of the organic alkali metal compound of the compound (I).

A temperature at which a polymer and the compound containing a
nitrogen atom and/or a silicon atom are mixed is 25°C to 100°C, preferably
30 35°C to 90°C, further preferably 50°C to 80°C. A contact time is 60 seconds

to 5 hours, preferably 5 minutes to 1 hour.

In the process of the present invention, a coupling agent may be added to a solution containing a conjugated diene-based polymer using a hydrocarbon as a solvent, at the time point from initiation of polymerization of a monomer, to recovery of a polymer described later. Examples of the coupling agent include a compound represented by the following formula (6).



(wherein R^{61} represents an alkyl group, an alkenyl group, a cycloalkenyl group or an aryl group, M represents a silicon atom or a tin atom, L represents a halogen atom or a hydrocarbyloxy group, and a represents an integer of 0 to 2.)

Examples of the coupling agent represented by the formula (6) include silicon tetrachloride, methyltrichlorosilane, dimethyldichlorosilane, trimethylchlorosilane, tin tetrachloride, methyltrichlorotin, dimethyldichlorotin, trimethylchlorotin, tetramethoxysilane, methyltrimethoxysilane, dimethoxydimethylsilane, methyltriethoxysilane, ethyltrimethoxysilane, dimethoxydiethylsilane, diethoxydimethylsilane, tetraethoxysilane, ethyltriethoxysilane, and diethoxydiethylsilane.

An addition amount of the coupling agent, in order to enhance processability of the conjugated diene-based polymer, is preferably 0.03 mol or more, more preferably 0.05 mol or more, per 1 mol of the alkali metal derived from an alkali metal catalyst. And, in order to enhance fuel cost saving properties, the addition amount is preferably 0.4 mol or less, more preferably 0.3 mol or less.

In the process of the present invention, an unreacted active end may be treated with an alcohol such as methanol and isopropyl alcohol before recovery of a polymer described later is performed.

As a method of recovering a conjugated diene-based polymer from a solution containing a conjugated diene-based polymer using a hydrocarbon as a solvent, the known method can be used, and examples thereof include

(A) a method of adding a coagulant to a solution containing a conjugated diene-based polymer, and (B) a method of adding a steam to a solution containing a conjugated diene-based polymer. The recovered conjugated diene-based polymer may be dried with the known dryer such as a band
5 dryer and an extrusion-type dryer.

The conjugated-diene-based polymer of the present invention is a conjugated diene-based polymer produced by the aforementioned process.

A Mooney viscosity (ML_{1+4}) of the conjugated diene-based polymer of the present invention, in order to enhance a tensile breakage strength, is
10 preferably 10 or more, more preferably 20 or more. And, in order to enhance processability, the Mooney viscosity is preferably 200 or less, more preferably 150 or less. The Mooney viscosity (ML_{1+4}) is measured at 100°C according to JIS K6300 (1994).

A molecular weight distribution of the conjugated diene-based
15 polymer of the present invention, in order to enhance fuel cost saving properties, is preferably 1 to 5, more preferably 1 to 2. A molecular weight distribution is obtained by measuring a number average molecular weight (M_n) and a weight average molecular weight (M_w) by a gel permeation chromatography (GPC) method, and dividing M_w with M_n .

20 A content of a monomer unit based on a silicon-containing vinyl compound, in order to enhance fuel cost saving properties, is preferably 0.01 wt% or more, more preferably 0.02 wt% or more, further preferably 0.05 wt% or more, per 100 wt% of the conjugated diene-based polymer. In order to enhance economical property, and increase a tensile breakage strength, the
25 content is preferably 20 wt% or less, more preferably 2 wt% or less, further preferably 1 wt% or less.

It is preferable that the conjugated diene-based polymer of the present invention, in order to enhance a tensile breakage strength, contains a monomer unit based on an aromatic vinyl compound, in addition to a
30 monomer unit based on the conjugated diene compound and a monomer unit

based on the silicon-containing vinyl compound. Examples of the aromatic vinyl compound include styrene, α -methylstyrene, vinyltoluene, vinylnaphthalene, divinylbenzene, trivinylbenzene, and divinyl-naphthalene, preferably styrene.

5 A content of the aromatic vinyl compound unit is 0 wt% or more (content of the conjugated diene compound unit is 100 wt% or less), preferably 10 wt% or more (content of the conjugated diene compound unit is 90 wt% or less), more preferably 15 wt% or more (content of the conjugated diene compound unit is 85 wt% or less), per 100 wt% of a total amount of the
10 conjugated diene compound unit and the aromatic vinyl compound unit. And, in order to enhance fuel cost saving properties, a content of the aromatic vinyl compound unit is preferably 50 wt% or less (content of the conjugated diene compound unit is 50 wt% or more), more preferably 45 wt% or less (content of the conjugated diene compound unit is 55 wt% or more).

15 A vinyl bond amount of the conjugated diene-based polymer of the present invention, in order to enhance fuel cost saving properties, is preferably 80 mol% or less, more preferably 70 mol% or less, based on 100 mol% of a content of a conjugated diene unit. And, in order to enhance gripping property, the vinyl bond amount is preferably 10 mol% or more,
20 more preferably 15 mol% or more, further preferably 20 mol% or more, particularly preferably 40 mol% or more. The vinyl bond amount is obtained from an absorption intensity around 910 cm^{-1} which is an absorption peak of a vinyl group, by an infrared spectrometric method.

 The conjugated diene-based polymer of the present invention can be
25 used as a conjugated diene-based polymer composition by incorporating other polymer components and additives.

 Examples of other polymer component include a styrene-butadiene copolymer rubber, a polybutadiene rubber, a butadiene-isoprene copolymer rubber, and a butyl rubber. And, examples also include a natural rubber, an
30 ethylene-propylene copolymer, and an ethylene-octene copolymer. One or

more kinds of these polymer components are used.

When other polymer components are incorporated into the conjugated diene-based polymer of the present invention, an incorporation amount of the conjugated diene-based polymer of the present invention, in
5 order to enhance fuel cost saving properties, is preferably 10 wt% or more, more preferably 20 wt% or more, based on 100 wt% of a total incorporation amount of polymer components (including an incorporation amount of the conjugated diene-based polymer).

As the additive, the known additives can be used, and vulcanizing
10 agents such as sulfur; vulcanizing accelerators such as thiazole-based vulcanizing accelerator, thiuram-based vulcanizing accelerator, a sulfenamide-based vulcanizing accelerator, and a guanidine-based vulcanizing accelerator; vulcanizing activating agents such as stearic acid and zinc oxide; organic peroxides such as dicumyl peroxide, ditertiarybutyl
15 peroxide; reinforcing agents such as silica, and carbon black; fillers such as calcium carbonate, talc, alumina, clay, aluminum hydroxide, and mica; silane coupling agents; extender oils; processing aids; aging preventing agents; lubricants can be exemplified.

Examples of the sulfur include powder sulfur, precipitated sulfur,
20 colloidal sulfur, insoluble sulfur, and highly dispersible sulfur. An incorporation amount of sulfur is preferably 0.1 part by weight to 15 parts by weight, more preferably 0.3 part by weight to 10 parts by weight, further preferably 0.5 part by weight to 5 parts by weight, per 100 parts by weight of the polymer component.

25 Examples of the vulcanizing accelerator include thiazole-based vulcanizing accelerators such as 2-mercaptobenzothiazole, dibenzothiazyl disulfide, N-cyclohexyl-2-benzothiazylsulfenamide etc.; thiuram-based vulcanizing accelerators such as tetramethylthiuram monosulfide and tetramethylthiuram disulfide; sulfenamide-based vulcanizing accelerators
30 such as N-cyclohexyl-2-benzothiazolesulfenamide,

N-tert-butyl-2-benzothiazolesulfenamide,
N-oxyethylene-2-benzothiazolesulfenamide,
N-oxyethylene-2-benzothiazolesulfenamide, and
N,N'-diisopropyl-2-benzothiazolesulfenamide; guanidine-based vulcanizing
5 accelerators such as diphenylguanidine, diorthotolylguanidine, and
orthotolylbiguanidine. An incorporation amount of the vulcanizing
accelerator is preferably 0.1 part by weight to 5 parts by weight, more
preferably 0.2 part by weight to 3 parts by weight, per 100 parts by weight of
the polymer component.

10 Examples of the silica include dry silica (silicic acid anhydride), wet
silica (hydrous silicic acid), colloidal silica, precipitated silica, calcium
silicate, and aluminum silicate. One or more kinds of them can be used. A
BET specific surface area of silica is preferably 50 m²/g to 250 m²/g. The
BET specific surface area is measured according to ASTM D1993-03. As a
15 commercially available product, trade name Ultrasil VN3-G manufactured
by Degussa, trade name VN3, AQ, ER, and RS-150 manufactured by Tosoh
Silica Corporation, and trade name Zeosil 1115MP, 1165MP etc.
manufactured by Rhodia can be used.

 Examples of the carbon black include furnace black, acetylene black,
20 thermal black, channel black, and graphite. As the carbon black, channel
carbon black such as EPC, MPC and CC; furnace carbon black such as SAF,
ISAF, HAF, MAF, FEF, SRF, GPF, APF, FF, CF, SCF and ECF; thermal
carbon black such as FT and MT; acetylene carbon black are exemplified.
One or more kinds of them can be used.

25 A nitrogen adsorption specific surface area (N₂SA) of carbon black is
preferably 5 m²/g to 200 m²/g, and dibutyl phthalate (DBP) absorption
amount of carbon black is preferably 5 ml/100 g to 300 ml/100 g. The
nitrogen adsorption specific surface area is measured according to ASTM
D4820-93. The DBP absorption amount is measured according to ASTM
30 D2414-93. As a commercially available product, Diablock N339

manufactured by Mitsubishi Chemical Corporation, trade name SEAST 6, SEAST 7HM, and SEAST KH manufactured by Tokai Carbon Co., Ltd., trade name CK 3, Special Black 4A manufactured by Degussa, etc. can be used.

When formulated into a conjugated diene-based polymer composition
5 in which a reinforcing agent is incorporated into the conjugated diene-based polymer of the present invention, an incorporation amount of the reinforcing agent is preferably 10 parts by weight to 150 parts by weight, per 100 parts by weight of an incorporation amount of the conjugated diene-based polymer of the present invention. And, the incorporation amount, in order to
10 enhance abrasion resistance and a strength, is more preferably 20 parts by weight or more, further preferably 30 parts by weight or more. And, in order to enhance reinforcing property, the incorporation amount is more preferably 120 parts by weight or less, further preferably 100 parts by weight or less.

15 When formulated into a conjugated diene-based polymer composition in which a reinforcing agent is incorporated into the conjugated diene-based polymer of the present invention, in order to enhance fuel cost saving properties, it is preferable to use silica as the reinforcing agent. An incorporation amount of silica is preferably 50 parts by weight or more, more
20 preferably 70 parts by weight or more, based on 100 parts by weight of a total incorporation amount of the reinforcing agent.

And, a weight ratio of a content of silica used as the reinforcing agent and a content of carbon black (content of silica : a content of carbon black) is preferably 2 : 1 to 50 : 1. The weight ratio, in order to enhance fuel cost
25 saving properties, and enhance reinforcing property, is more preferably 5 : 1 to 20 : 1.

Examples of the silane coupling agent include vinyltrichlorosilane, vinyltriethoxysilane, vinyltris(β -methoxyethoxy)silane,
 β -(3,4-epoxycyclohexyl)ethyltrimethoxysilane,
30 γ -glycidoxypropyltrimethoxysilane, γ -methacryloxypropyltrimethoxysilane,

N-(β -aminoethyl)- γ -aminopropyltrimethoxysilane,
N-(β -aminoethyl)- γ -aminopropylmethyldimethoxysilane,
N-phenyl- γ -aminopropyltrimethoxysilane, γ -chloropropyltrimethoxysilane,
 γ -mercaptopropyltrimethoxysilane, γ -aminopropyltriethoxysilane,
5 bis(3-(triethoxysilyl)propyl) disulfide, bis(3-(triethoxysilyl)propyl)
tetrasulfide, γ -trimethoxysilylpropyldimethylthiocarbamyl tetrasulfide, and
 γ -trimethoxysilylpropylbenzothiazyl tetrasulfide. One or more kinds of
them are used. As a commercially available product, trade name Si69, Si75
etc. manufactured by Degussa can be used.

10 When formulated into a conjugated diene-based polymer composition
in which the silane coupling agent is incorporated into the conjugated
diene-based polymer of the present invention, an incorporation amount of
the silane coupling agent is preferably 1 part by weight to 20 parts by weight,
more preferably 2 parts by weight to 15 parts by weight, further preferably 5
15 parts by weight to 10 parts by weight, per 100 parts by weight of silica.

Examples of the extender oil include aromatic-based mineral oils
(viscosity gravity constant (V.G.C. value) 0.900 to 1.049), naphthene-based
mineral oils (V.G.C. value 0.850 to 0.899), paraffin-based mineral oils (V.G.C.
value 0.790 to 0.849). A polycyclic aromatic content of the extender oil is
20 preferably less than 3 wt%, more preferably less than 1 wt%. The polycyclic
aromatic content is measured according to the British Institute of Petroleum
346/92 Method. And, an aromatic compound content (CA) of the extender
oil is preferably 20 wt% or more. One or more kinds of these extender oils
are used.

25 As a method for producing a conjugated diene-based polymer
composition by incorporating other polymer components and additives into
the conjugated diene-based polymer of the present invention, the known
method, for example, a method of kneading each component with the known
mixing machine such as a roll and Banbury can be used.

30 As the kneading condition, when additives other than the

vulcanizing agent, and the vulcanizing accelerator are incorporated, a kneading temperature is usually 50°C to 200°C, preferably 80°C to 190°C, and a kneading time is usually 30 seconds to 30 minutes, preferably 1 minute to 30 minutes. When the vulcanizing agent and the vulcanizing accelerator are incorporated, a kneading temperature is usually 100°C or lower, preferably room temperature to 80°C. And, a composition in which the vulcanizing agent and the vulcanizing accelerator are incorporated is usually used by performing vulcanizing treatment such as press vulcanization. A vulcanizing temperature is usually 120°C to 200°C, preferably 140°C to 180°C.

The conjugated diene-based polymer composition of the present invention is excellent in fuel cost saving properties and a tensile breakage strength, and is suitably used in tires.

Examples

The evaluation of physical properties was performed by the following methods.

1. Mooney viscosity (ML_{1+4})

According to JIS K6300 (1994), the Mooney viscosity of a polymer was measured at 100°C.

2. Vinyl bonding amount (unit: mol%)

The vinyl bonding amount of a polymer was obtained from the absorption intensity around 910 cm^{-1} , which is an absorption peak of a vinyl group, by an infrared spectrometric method.

3. Content of styrene unit (unit: wt%)

According to JIS K6383 (1995), the content of a styrene unit in a polymer was obtained from a refractive index.

4. Molecular weight distribution (M_w/M_n)

A weight average molecular weight (M_w) and a number average molecular weight (M_n) were measured under the following conditions (1) to.

(8) by a gel permeation chromatography (GPC) method, and the molecular weight distribution (M_w/M_n) of a polymer was obtained.

(1) Apparatus: HLC-8220, manufactured by Tosoh Corporation

(2) Separation column: TSKgel SuperHM-H (two in series), manufactured by
5 Tosoh Corporation

(3) Measuring temperature: 40°C

(4) Carrier: tetrahydrofuran

(5) Flow rate: 0.6 mL/minute

(6) Injection amount: 5 μ L

10 (7) Detector: differential refraction

(8) Molecular weight standard: standard polystyrene

5. Fuel cost saving properties

A strip-like test piece having a width of 1 mm or 2 mm and a length of 40 mm was punched out from a sheet-like vulcanization molded article, and
15 was subjected to a test. For measurement, loss tangent ($\tan\delta$ (70°C)) of a test piece at a temperature of 70°C was measured with a viscoelasticity measuring apparatus (manufactured by Ueshima Seisakusho Co., Ltd.) under the conditions of a strain of 1% and a frequency of 10 Hz. As this value is smaller, fuel cost saving properties are more excellent.

20 6. Tensile strength at break (TB, unit: MPa)

According to JIS K6251, a stress at which the test piece is broken was measured at a tensile rate of 500 mm/minute using a No. 3 shape dumbbell test piece.

Example 1

25 The interior of a polymerization reactor made of stainless steel, equipped with a stirring device, and having an internal volume of 20 L was washed and dried, and replaced with dry nitrogen. Then, 10.2 kg of industrial hexane (density 680 kg/m³), 608 g of 1,3-butadiene, 192 g of styrene, 6.1 ml of tetrahydrofuran, and 5.3 ml of ethylene glycol diethyl ether
30 were placed into the polymerization reactor. Then, in order to detoxify

impurities causing inactivation of a polymerization initiator in advance, a small amount of a solution of n-butyllithium in n-hexane as a scavenger was placed into the polymerization reactor.

Into the polymerization reactor was placed 2.74 g of
5 bis(diethylamino)methylvinylsilane. Then, a n-hexane solution of
n-butyllithium (content of n-butyllithium: 17.2 mmol) as a polymerization
initiator was placed into the polymerization reactor, thereafter, 2.23 g (1.01
mol per 1 mol of n-butyllithium) of di-n-butylamine was immediately placed,
and a polymerization reaction was initiated. The copolymerization reaction
10 of 1,3-butadiene, styrene and bis(diethylamino)methylvinylsilane was
performed for 3 hours at a stirring rate of 130 rpm and a temperature in the
polymerization reactor of 65°C, while 1,3-butadiene and styrene were
continuously supplied into the polymerization reactor. The amounts of
1,3-butadiene and styrene supplied after initiation of the polymerization
15 reaction were 912 g and 288 g, respectively. The amount of
bis(diethylamino)methylvinylsilane placed was 0.14 wt% in the total amount
of monomers which had been placed or supplied into the polymerization
reactor.

To the polymer solution was added 20 ml of a hexane solution
20 containing 1.2 ml of methanol, and the polymer solution was stirred for 5
minutes. Then, to the polymer solution were added 8.0 g of
2-tert-butyl-6-(3-tert-butyl-2-hydroxy-5-methylbenzyl)-4-methylphenyl
acrylate (trade name: Sumilizer GM, manufactured by Sumitomo Chemical
Co., Ltd.) and 4.0 g of pentaerythrityltetrakis(3-laurylthiopropionate) (trade
25 name: Sumilizer TP-D, manufactured by Sumitomo Chemical Co., Ltd.).
Then, the polymerization solution was allowed to stand under room
temperature for 24 hours, and the solvent was evaporated to obtain a
polymer. Thereafter, the resulting polymer was further dried at 55°C for 12
hours under reduced pressure. The evaluation results of the polymer are
30 shown in Table 1.

One hundred parts by weight of the resulting polymer, 78.4 parts by weight of silica (trade name: Ultrasil VN3-G, manufactured by Degussa), 6.4 parts by weight of a silane coupling agent (trade name: Si69, manufactured by Degussa), 6.4 parts by weight of carbon black (trade name: Diablack N339, manufactured by Mitsubishi Chemical Corporation), 47.6 parts by weight of an extender oil (trade name: JOMO Process NC-140, manufactured by Japan Energy Corporation), 1.5 parts by weight of an anti-aging agent (trade name: Antigene 3C, manufactured by Sumitomo Chemical Co., Ltd.), 2 parts by weight of stearic acid, 2 parts by weight of zinc flower, 1 part by weight of a vulcanization accelerator (trade name: Soxinol CZ, manufactured by Sumitomo Chemical Co., Ltd.), 1 part by weight of a vulcanization accelerator (trade name: Soxinol D, manufactured by Sumitomo Chemical Co., Ltd.), 1.5 parts by weight of a wax (trade name: Sunnoc N, manufactured by Ouchi Shinko Chemical Industrial Co., Ltd.), and 1.4 parts by weight of sulfur were kneaded with Laboplast Mill to prepare a polymer composition. The resulting polymer composition was molded into a sheet with a 6 inch roll, and the sheet was heated at 160°C for 45 minutes for vulcanization to prepare a vulcanized sheet. The evaluation results of physical properties of the vulcanized sheet are shown in Table 1.

20 Comparative Example 1

The interior of a polymerization reactor made of stainless steel, equipped with a stirring device, and having an internal volume of 20 L was washed and dried, and replaced with dry nitrogen. Then, 10.2 kg of industrial hexane (density 680 kg/m³), 608 g of 1,3-butadiene, 192 g of styrene, 6.1 ml of tetrahydrofuran, and 4.4 ml of ethylene glycol diethyl ether were placed into the polymerization reactor. Then, in order to detoxify impurities causing inactivation of a polymerization initiator in advance, a small amount of a solution of n-butyllithium in n-hexane as a scavenger was placed into the polymerization reactor.

30 Into the polymerization reactor was placed 2.63 g of

bis(diethylamino)methylvinylsilane, thereafter, a solution of n-butyllithium in n-hexane (content of n-butyllithium: 12.3 mmol) as a polymerization initiator component was placed into the polymerization reactor, and a polymerization reaction was initiated. The copolymerization reaction of 1,3-butadiene, styrene and bis(diethylamino)methylvinylsilane was performed for 3 hours at a stirring rate of 130 rpm and a temperature in the polymerization reactor of 65°C, while 1,3-butadiene and styrene were continuously supplied into the polymerization reactor. The amounts of 1,3-butadiene and styrene supplied after initiation of the polymerization reaction were 912 g and 288 g, respectively. The amount of bis(diethylamino)methylvinylsilane placed was 0.13 wt% in the total amount of monomers which had been placed or supplied into the polymerization reactor.

To the polymer solution was added 20 ml of a hexane solution containing 0.8 ml of methanol, and the polymer solution was stirred for 5 minutes. Then, to the polymerization solution were added 8.0 g of 2-tert-butyl-6-(3-tert-butyl-2-hydroxy-5-methylbenzyl)-4-methylphenyl acrylate (trade name: Sumilizer GM manufactured by Sumitomo Chemical Co., Ltd.), and 4.0 g of pentaerythrityltetrakis(3-laurylthiopropionate) (trade name: Sumilizer TP-D manufactured by Sumitomo Chemical Co., Ltd.). Then, the polymerization solution was allowed to stand under room temperature for 24 hours, and the solvent was evaporated to obtain a polymer. Thereafter, the resulting polymer was further dried at 55°C for 12 hours under reduced pressure. The evaluation results of the polymer are shown in Table 1.

One hundred parts by weight of the resulting polymer, 78.4 parts by weight of silica (trade name: Ultrasil VN3-G, manufactured by Degussa), 6.4 parts by weight of a silane coupling agent (trade name: Si69, manufactured by Degussa), 6.4 parts by weight of carbon black (trade name: Diablack N339, manufactured by Mitsubishi Chemical Corporation), 47.6 parts by weight of

an extender oil (trade name: JOMO Process NC-140, manufactured by Japan Energy Corporation), 1.5 parts by weight of an anti-aging agent (trade name: Antigene 3C, manufactured by Sumitomo Chemical Co., Ltd.), 2 parts by weight of stearic acid, 2 parts by weight of zinc flower, 1 part by weight of a
5 vulcanization accelerator (trade name: Soxinol CZ, manufactured by Sumitomo Chemical Co., Ltd.), 1 part by weight of a vulcanization accelerator (trade name: Soxinol D, manufactured by Sumitomo Chemical Co., Ltd.), 1.5 parts by weight of a wax (trade name: Sunnoc N, manufactured by Ouchi Shinko Chemical Industrial Co., Ltd.), and 1.4 parts
10 by weight of sulfur were kneaded with Laboplast Mill to prepare a polymer composition. The resulting polymer composition was molded into a sheet with a 6 inch roll, and the sheet was heated at 160°C for 45 minutes for vulcanization to prepare a vulcanized sheet. The evaluation results of physical properties of the vulcanized sheet are shown in Table 1.

15 Comparative Example 2

The interior of a polymerization reactor made of stainless steel, equipped with a stirring device, and having an internal volume of 20 L was washed and dried, and replaced with dry nitrogen. Then, 10.2 kg of industrial hexane (density 680 kg/m³), 608 g of 1,3-butadiene, 192 g of
20 styrene, 6.1 ml of tetrahydrofuran, and 6.1 ml of ethylene glycol diethyl ether were placed into the polymerization reactor. Then, in order to detoxify impurities causing inactivation of a polymerization initiator in advance, a small amount of a solution of n-butyllithium in n-hexane as a scavenger was placed into the polymerization reactor.

25 A n-hexane solution of n-butyllithium (content of n-butyllithium: 16.4 mmol) as a polymerization initiator was added into the polymerization reactor, thereafter, 2.12 g (1.01 mol per 1 mol of n-butyllithium) of di-n-butylamine was placed, and a polymerization reaction was initiated. The copolymerization reaction of 1,3-butadiene and styrene was performed
30 for 3 hours at a stirring rate of 130 rpm and a temperature in the

polymerization reactor of 65°C, while 1,3-butadiene and styrene were continuously supplied into the polymerization reactor. The amounts of 1,3-butadiene and styrene supplied after initiation of the polymerization reaction were 912 g and 288 g, respectively.

5 To the polymer solution was added 20 ml of a hexane solution containing 0.8 ml of methanol, and the polymer solution was stirred for 5 minutes. Then, to the polymerization solution were added 8.0 g of 2-tert-butyl-6-(3-tert-butyl-2-hydroxy-5-methylbenzyl)-4-methylphenyl acrylate (trade name: Sumilizer GM manufactured by Sumitomo Chemical
10 Co., Ltd.) and 4.0 g of pentaerythrityltetrakis(3-laurylthiopropionate) (trade name: Sumilizer TP-D manufactured by Sumitomo Chemical Co., Ltd.). Then, the polymerization solution was allowed to stand under room temperature for 24 hours, and the solvent was evaporated to obtain a polymer. Thereafter, the resulting polymer was further dried at 55°C for 12
15 hours under reduced pressure. The evaluation results of the polymer are shown in Table 1.

One hundred parts by weight of the resulting polymer, 78.4 parts by weight of silica (trade name: Ultrasil VN3-G, manufactured by Degussa), 6.4 parts by weight of a silane coupling agent (trade name: Si69, manufactured
20 by Degussa), 6.4 parts by weight of carbon black (trade name: Diablock N339, manufactured by Mitsubishi Chemical Corporation), 47.6 parts by weight of an extender oil (trade name: JOMO Process NC-140, manufactured by Japan Energy Corporation), 1.5 parts by weight of an anti-aging agent (trade name: Antigene 3C, manufactured by Sumitomo Chemical Co., Ltd.), 2 parts by
25 weight of stearic acid, 2 parts by weight of zinc flower, 1 part by weight of a vulcanization accelerator (trade name: Soxinol CZ, manufactured by Sumitomo Chemical Co., Ltd.), 1 part by weight of a vulcanization accelerator (trade name: Soxinol D, manufactured by Sumitomo Chemical Co., Ltd.), 1.5 parts by weight of a wax (trade name: Sunnoc N,
30 manufactured by Ouchi Shinko Chemical Industrial Co., Ltd.), and 1.4 parts

by weight of sulfur were kneaded with Laboplast Mill to prepare a polymer composition. The resulting polymer composition was molded into a sheet with a 6 inch roll, and the sheet was heated at 160°C for 45 minutes for vulcanization to prepare a vulcanized sheet. The evaluation results of physical properties of the vulcanized sheet are shown in Table 1.

[Table 1]

		Example 1	Comparative Example 1	Comparative Example 2
Mooney viscosity	-	46.2	40.9	45.9
Vinyl bonding amount	mol%	57.5	57.6	58.7
Content of styrene unit	wt%	23.9	24.4	23.7
Molecular weight distribution	-	1.40	1.09	1.48
Fuel cost saving properties tanδ (70°C)	-	0.126	0.141	0.214
Tensile strength at break	MPa	15.3	14.3	13.7

Example 2

The interior of a polymerization reactor made of stainless, equipped with a stirring device, having an internal volume of 20 L was washed and dried, and replaced with dry nitrogen. Then, 10.2 kg of industrial hexane (density 680 kg/m³), 608 g of 1,3-butadiene, 192 g of styrene, 6.1 ml of tetrahydrofuran, and 5.3 ml of ethylene glycol diethyl ether were placed into the polymerization reactor. Then, in order to detoxify impurities acting on inactivation of a polymerization initiator in advance, a hexane solution of a small amount of n-butyllithium as a scavenger was placed into the polymerization reactor.

Into the polymerization reactor was placed 2.74 g of bis(diethylamino)methylvinylsilane. Then, a n-hexane solution of

n-butyllithium (content of n-butyllithium: 17.6 mmol) as a polymerization initiator was placed into the polymerization reactor, thereafter, 2.28 g (1.01 mol per 1 mol of n-butyllithium) of di-n-butylamine was immediately placed, and a polymerization reaction was initiated. A copolymerization reaction of 1,3-butadiene and styrene was performed for 3 hours at a stirring speed of 130 rpm and a temperature in the polymerization reactor of 65°C, while 1,3-butadiene and styrene were continuously supplied into the polymerization reactor. Amounts of 1,3-butadiene and styrene supplied after initiation of a polymerization reaction were 912 g and 288 g, respectively. A placement amount of bis(diethylamino)methylvinylsilane in a total amount of monomers which had been placed or supplied into the polymerization reactor was 0.14 wt%.

Then, the resulting polymerization solution was stirred at a stirring rate of 130 rpm, 17.1 mmol of N-(3-dimethylaminopropyl)acrylamide was added to the polymerization solution, and the mixture was stirred for 15 minutes.

To a polymerization solution was added 20 ml of a hexane solution containing 1.2 ml of methanol, and the polymerization solution was stirred for 5 minutes. Then, to the polymerization solution were added 8.0 g of 2-tert-butyl-6-(3-tert-butyl-2-hydroxy-5-methylbenzyl)-4-methylphenyl acrylate (trade name: Sumilizer GM manufactured by Sumitomo Chemical Co., Ltd.) and 4.0 g of pentaerythrityltetrakis(3-laurylthiopropionate) (trade name: Sumilizer TP-D manufactured by Sumitomo Chemical Co., Ltd.). Then, the polymerization solution was allowed to stand under room temperature for 24 hours, and the solvent was evaporated to obtain a polymer. Thereafter, the resulting polymer was further dried at 55°C for 12 hours under reduced pressure. The results of assessment of the polymer are shown in Table 2.

One hundred parts by weight of the resulting polymer, 78.4 parts by weight of silica (trade name: Ultrasil VN3-G manufactured by Degussa), 6.4

parts by weight of a silane coupling agent (trade name: Si69 manufactured by Degussa), 6.4 parts by weight of carbon black (trade name: Diablock N339 manufactured by Mitsubishi Chemical Corporation), 47.6 parts by weight of an extender oil (trade name: JOMO Process NC-140 manufactured by Japan Energy Corporation), 1.5 parts by weight of an aging preventing agent (trade name: Antigene 3C manufactured by Sumitomo Chemical Co., Ltd.), 2 parts by weight of stearic acid, 2 parts by weight of zinc flower, 1 part by weight of a vulcanizing accelerator (trade name: Soxinol CZ manufactured by Sumitomo Chemical Co., Ltd.), 1 part by weight of a vulcanizing accelerator (trade name: Soxinol D manufactured by Sumitomo Chemical Co., Ltd.), 1.5 parts by weight of a wax (trade name: Sunnoc N manufactured by Ouchi Shinko Chemical Industrial Co., Ltd.), and 1.4 parts by weight of sulfur were kneaded with Laboplast Mill to prepare a polymer composition. The resulting polymer composition was molded into a sheet with a 6 inch roll, and the sheet was heated at 160°C for 45 minutes to vulcanize it, to prepare a vulcanized sheet. The results of physical property assessment of the vulcanized sheet are shown in Table 2.

Example 3

The interior of a polymerization reactor made of stainless steel, equipped with a stirring device, and having an internal volume of 20 L was washed and dried, and replaced with dry nitrogen. Then, 10.2 kg of industrial hexane (density 680 kg/m³), 608 g of 1,3-butadiene, 192 g of styrene, 6.1 ml of tetrahydrofuran, and 5.3 ml of ethylene glycol diethyl ether were placed into the polymerization reactor. Then, in order to detoxify impurities causing inactivation of a polymerization initiator in advance, a small amount of a solution of n-butyllithium in n-hexane as a scavenger was placed into the polymerization reactor.

Into the polymerization reactor was placed 2.74 g of bis(diethylamino)methylvinylsilane. Then, a n-hexane solution of n-butyllithium (content of n-butyllithium: 16.9 mmol) as a polymerization

initiator was placed into the polymerization reactor, thereafter, 2.18 g (1.01 mol per 1 mol of n-butyllithium) of di-n-butylamine was placed, and a polymerization reaction was initiated. The copolymerization reaction of 1,3-butadiene, styrene and bis(diethylamino)methylvinylsilane was
5 performed for 3 hours at a stirring rate of 130 rpm and a temperature in the polymerization reactor of 65°C, while 1,3-butadiene and styrene were continuously supplied into the polymerization reactor. The amounts of 1,3-butadiene and styrene supplied after initiation of the polymerization reaction were 912 g and 288 g, respectively. The amount of
10 bis(diethylamino)methylvinylsilane placed was 0.14 wt% in the total amount of monomers which had been placed or supplied into the polymerization reactor.

Then, the resulting polymerization solution was stirred at a stirring speed of 130 rpm, 16.9 mmol of [3-(diethylamino)propyl]trimethoxysilane
15 was added to the polymerization solution, and the mixture was stirred for 15 minutes.

To the polymer solution was added 20 ml of a hexane solution containing 1.2 ml of methanol, and the polymer solution was stirred for 5 minutes. Then, to the polymerization solution were added 8.0 g of
20 2-tert-butyl-6-(3-tert-butyl-2-hydroxy-5-methylbenzyl)-4-methylphenyl acrylate (trade name: Sumilizer GM manufactured by Sumitomo Chemical Co., Ltd.) and 4.0 g of pentaerythrityltetrakis(3-laurylthiopropionate) (trade name: Sumilizer TP-D manufactured by Sumitomo Chemical Co., Ltd.), then, the polymerization solution was allowed to stand under room temperature
25 for 24 hours, and the solvent was evaporated to obtain a polymer. Thereafter, the resulting polymer was further dried at 55°C for 12 hours under reduced pressure. The evaluation results of the polymer are shown in Table 2.

One hundred parts by weight of the resulting polymer, 78.4 parts by
30 weight of silica (trade name: Ultrasil VN3-G, manufactured by Degussa), 6.4

parts by weight of a silane coupling agent (trade name: Si69, manufactured by Degussa), 6.4 parts by weight of carbon black (trade name: Diablock N339, manufactured by Mitsubishi Chemical Corporation), 47.6 parts by weight of an extender oil (trade name: JOMO Process NC-140, manufactured by Japan Energy Corporation), 1.5 parts by weight of an anti-aging agent (trade name: Antigene 3C, manufactured by Sumitomo Chemical Co., Ltd.), 2 parts by weight of stearic acid, 2 parts by weight of zinc flower, 1 part by weight of a vulcanization accelerator (trade name: Soxinol CZ, manufactured by Sumitomo Chemical Co., Ltd.), 1 part by weight of a vulcanization accelerator (trade name: Soxinol D, manufactured by Sumitomo Chemical Co., Ltd.), 1.5 parts by weight of a wax (trade name: Sunnoc N, manufactured by Ouchi Shinko Chemical Industrial Co., Ltd.), and 1.4 parts by weight of sulfur were kneaded with Laboplast Mill to prepare a polymer composition. The resulting polymer composition was molded into a sheet with a 6 inch roll, and the sheet was heated at 160°C for 45 minutes for vulcanization to prepare a vulcanized sheet. The evaluation results of physical properties of the vulcanized sheet are shown in Table 2.

[Table 2]

		Example 2	Example 3
Mooney viscosity	-	40.0	49.4
Vinyl bonding amount	mol%	56.9	55.6
Content of styrene unit	wt%	23.4	23.8
Molecular weight distribution	-	1.44	1.38
Fuel cost saving properties tanδ (70°C)	-	0.122	0.128
Tensile strength at break	MPa	15.8	14.5

What is claimed is:

1. A process for producing a conjugated diene-based polymer comprising polymerizing a monomer component comprising a conjugated diene compound and a silicon-containing vinyl compound using the following compounds (I) and (II), as a polymerization initiator component,
5 (I) an organic alkali metal compound
(II) a compound represented by the following formula (I)



wherein R^{11} and R^{12} represent a hydrocarbyl group having 1 to 20 carbon
10 atoms optionally having a substituent.

2. The process for producing a conjugated diene-based polymer according to claim 1, wherein the compounds (I) and (II) are added to a solution containing at least one monomer component and using a
15 hydrocarbon as a solvent, in an order of the compound (I) and the compound (II), and the monomer component comprising a conjugated diene compound and a silicon-containing vinyl compound is polymerized.

3. The process for producing a conjugated diene-based polymer
20 according to claim 2, wherein the compound (II) is added to the solution, while a polymerization conversion rate of the monomer component is 5 wt% or less.

4. The process for producing a conjugated diene-based polymer
25 according to claim 3, wherein an amount of the compound (II) which is added while a polymerization conversion rate of the monomer component is 5 wt% or less is 0.5 mol to 2.0 mol based on 1 mol of the addition amount of the compound (I).

5. The process for producing a conjugated diene-based polymer according to claim 1, wherein a compound containing a nitrogen atom and/or a silicon atom is allowed to react with an active end of a polymer produced by polymerization.

6. The process for producing a conjugated diene-based polymer according to claim 5, wherein the compound containing a nitrogen atom and/or a silicon atom is a compound containing a nitrogen atom and a carbonyl group.

7. A conjugated diene-based polymer produced by the process according to any one of claims 1 to 6.

8. A conjugated diene-based polymer composition comprising the conjugated diene-based polymer according to claim 7 and a reinforcing agent, wherein the content of the reinforcing agent is 10 parts by weight to 150 parts by weight, per 100 parts by weight of the conjugated diene-based polymer.