

DESCRIPTION
CHROMENE COMPOUND

TECHNICAL FIELD

5 The present invention relates to a photochromic chromene compound, and use and an intermediate thereof. More specifically, it relates to a chromene compound which is useful as a photochromic compound for photochromic spectacle lenses, and use and an intermediate thereof.

10

BACKGROUND ART

 Photochromism is the reversible function of a certain compound that it changes its color swiftly upon exposure to light including ultraviolet light such as sunlight or light
15 from a mercury lamp and returns to its original color when it is put in the dark by stopping its exposure to light. A compound having this property is called "photochromic compound" and used as a material for photochromic plastic lenses.

20 For the photochromic compound used for this purpose, the following properties are required: (I) the degree of coloration at a visible light range before ultraviolet light is applied (to be referred to as "initial coloration" hereinafter) should be low, (II) the degree of coloration
25 upon exposure to ultraviolet light (to be referred to as "color optical density" hereinafter) should be high, (III) the speed from the time when the application of ultraviolet light is started to the time when the color optical density reaches saturation (to be referred to as "color development
30 sensitivity" hereinafter) should be high; (IV) the speed from the stoppage of the application of ultraviolet light to the time when the compound returns to its original state (to be referred to as "fading speed" hereinafter) should be high, (V) the repeat durability of this reversible function should

be high, and (VI) the solubility in a monomer composition which will become a host material after curing of the photochromic compound should be high so that its dispersibility in the host material in use becomes high.

5 As the photochromic compound which can satisfy these requirements, there are known chromene compounds having an indeno(2,1-f)naphtho(1,2-b)pyran structure as the basic skeleton (refer to a pamphlet of International Laid-Open WO99/15518 and a pamphlet of International Laid-Open
10 WO01/60811).

It is preferred that a photochromic plastic lens comprising the photochromic compound should develop a color of a neutral tint such as gray or brown. A color of a neutral tint is obtained by mixing together several different kinds
15 of photochromic compounds which develop different colors, for example, a yellow to red photochromic compound (yellow compound) having a maximum absorption at 430 to 530 nm and a purple to blue photochromic compound (blue compound) having a maximum absorption at 550 to 650 nm.

20 However, when color control is carried out by this method, various problems occur due to the difference in photochromic properties between the compounds which have been mixed together. For example, when the repeat durability of the yellow compound is lower than that of the blue compound
25 and the photochromic plastic lens is used for a long time, there occurs a problem that the developed color gradually changes to a color of a strong blue tint.

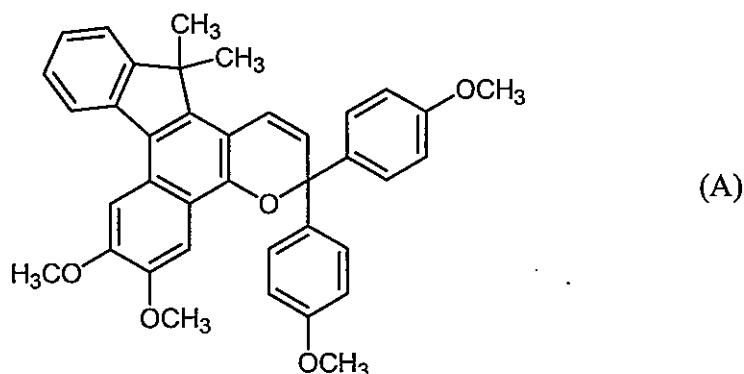
Further, when the color development sensitivity and fading speed of the yellow compound are lower than those of
30 the blue compound, there arises a problem that color during development has a strong blue tint and color during fading has a strong yellow tint.

It is considered that this problem can be solved by using a single compound which has two or more absorption

maximums at the time of exposure and develops a color of a neutral tint (double peak compound). It is known that the yellow compound is generally inferior to the blue compound in durability. Therefore, a compound having a higher yellow
 5 color optical density (having a maximum absorption wavelength at 430 to 530 nm) than the blue color optical density (having a maximum absorption wavelength at 550 to 650 nm) is desired as the double peak compound (the ratio of the yellow color optical density to the blue color optical
 10 density in the double peak compound may be referred to as "double peak characteristic" hereinafter).

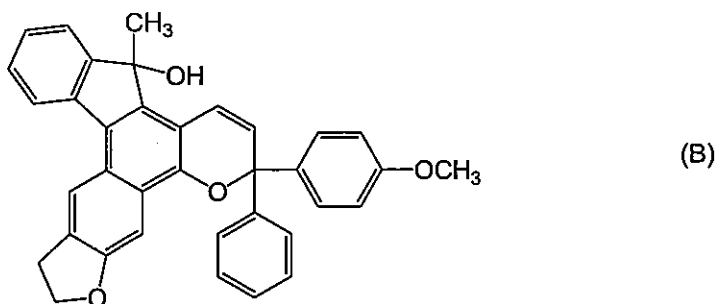
As the photochromic compound having two absorption maximums at the time of color development (double peak compound), there have been known compounds having an
 15 indeno(2,1-f)naphtho(1,2-b)pyran structure as the basic skeleton and represented by the following formulas (A) to (C).

However, these compounds have room for the improvement of the following points. That is, a chromene compound
 20 represented by the following formula (A) (refer to a pamphlet of International Laid-Open WO01/19813) has low color development sensitivity, low fading speed and low repeat durability though its double peak characteristic is high.

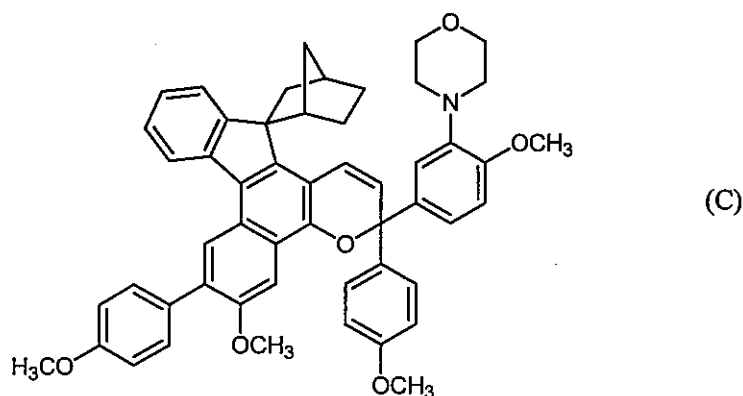


A chromene compound represented by the following
 25 formula (B) (refer to a pamphlet of International Laid-Open WO03/044022) has low double peak characteristic with a smaller absorption at 430 to 530 nm than an absorption at

550 to 650 nm.



A chromene compound represented by the following formula (C) (refer to a pamphlet of International Laid-Open WO05/028465) has large initial coloration as the end of its absorption spectrum (to be referred to as "absorption end" hereinafter) goes beyond 420 nm into the visible range though it has excellent double peak characteristic and practical levels of color optical density and fading speed.



10 DISCLOSURE OF THE INVENTION

It is therefore an object of the present invention to provide a chromene compound which develops a color of a neutral tint, has little initial coloration, high color optical density, high color development sensitivity, high fading speed and excellent durability of photochromic properties and can be dissolved in a monomer composition which will become the substrate of an optical article in a high concentration.

It is another object of the present invention to provide a novel naphthol compound for the manufacture of the chromene

compound of the present invention.

Other objects and advantages of the present invention will become apparent from the following description.

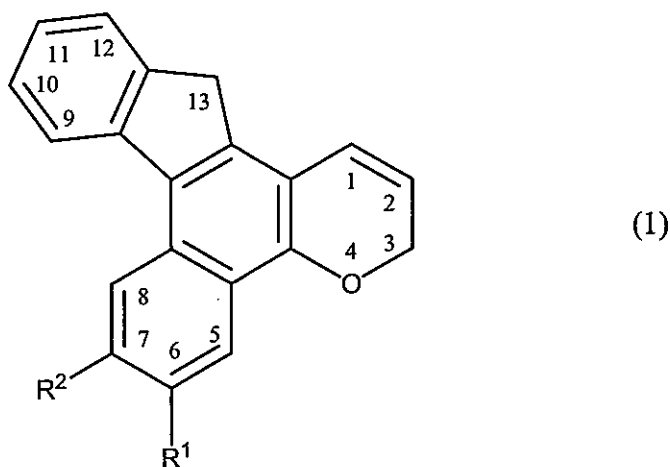
It is known that a compound having a substituent having
5 high electron donating ability bonded to the 6-position and
7-position of an indeno(2,1-f)naphtho(1,2-b)pyran
structure exhibits high double peak characteristic. The
substituent having high electron donating ability as used
herein is a substituent bonded to the 6-position and the
10 7-position via an oxygen atom or a nitrogen atom. However,
although the above compound has high double peak
characteristic, it has defects such as low fading speed,
large color development by heat at room temperature under
no exposure (this color development will be referred to as
15 "initial coloration by thermochromism" hereinafter) and low
durability. Particularly when the electron donating
abilities of the 6-position and 7-position substituents are
further increased, the above defects become more marked.

Then, the inventors of the present invention have
20 conducted intensive studies to solve the above problems and
have found that a chromene compound which has an aryl group
or heteroaryl group introduced into the 6-position and an
electron donor substituent having a Hammett constant σ_p of
not more than -0.1 introduced into the 7-position has
25 excellent characteristic properties such as fading speed,
initial coloration by thermochromism and durability while
retaining high double peak characteristic. Even when the
electron donating ability of the 7-position substituent is
increased, the obtained chromene compound is characterized
30 in that the reductions of fading speed, initial coloration
by thermochromism and durability are extremely small.
Further, the absorption end of the above compound is existent
at an appropriate range (not too short wavelength range and
not a visible range), the color development sensitivity is

high and the initial coloration due to the absorption end is little. Therefore, they could find a photochromic compound which satisfies all the requirements for a photochromic plastic lens material and accomplished the present invention. The Hammett constant σ_p is defined based on the Hammett equation that quantifies the electric effect of a substituent bonded to an π electron system on the basis of the dissociation constant K_a of p-substituted benzoic acid. A substituent having a σ_p of 0 is a hydrogen atom, and a substituent having a σ_p of less than 0 is a substituent having higher electron donating ability than a hydrogen atom.

Although the reason for obtaining such an unexpected effect is unknown, it is presumed that this is due to a resonance effect between the 6-position aryl group or heteroaryl group and the indeno(2,1-f)naphtho(1,2-b)pyran skeleton.

Firstly, the present invention is a chromene compound having a skeleton represented by the following formula (1).



In the above formula, R^1 is an aryl group or a heteroaryl group. R^2 is an electron donor group having a Hammett constant σ_p of not more than -0.1.

Secondly, the present invention is a photochromic curable composition comprising the above chromene compound of the present invention and polymerizable monomers.

Thirdly, the present invention is a photochromic optical article having a polymer molded product containing the chromene compound of the present invention dispersed therein as a constituent member.

5 In the fourth place, the present invention is an optical article having an optical substrate all or part of at least one surface of which is coated with a polymer film containing the chromene compound of the present invention dispersed therein as a constituent member.

10 In the fifth place, the present invention is a naphthol compound which is a raw material compound for the production of the chromene compound of the present invention.

BEST MODE FOR CARRYING OUT THE INVENTION

15 The chromene compound of the present invention has an indeno(2,1-f)naphtho(1,2-b)pyran structure represented by the above formula (1) as the basic skeleton. The chromene compound of the present invention has an aryl group or a heteroaryl group at the 6-position of the basic skeleton and
20 an electron donor group having a Hammett constant σ_p of not more than -0.1 at the 7-position, thereby making it possible to develop a dark color of a neutral tint by itself while retaining excellent photochromic properties. A description is first given of R^1 and R^2 in the formula (1).

25

$\langle R^1 \rangle$

R^1 which is a substituent bonded to the 6-position of the indeno(2,1-f)naphtho(1,2-b)pyran structure is an aryl group or a heteroaryl group.

30 The aryl group is preferably an aryl group having 6 to 14 carbon atoms. Preferred examples of the aryl group include phenyl group, 1-naphthyl group, 2-naphthyl group, 1-phenanthryl group, 2-phenanthryl group, 1-anthryl group and 9-anthryl group.

The heteroaryl group is preferably a heteroaryl group having 4 to 12 carbon atoms. The heteroaryl group is a group which forms a carbon-carbon bond together with the 6-position carbon atom. Preferred examples of the heteroaryl group
 5 include thienyl group, furyl group, pyrrolinyl group, pyridyl group, benzothienyl group, benzofuryl group and benzopyrrolinyl group.

The hydrogen atoms, preferably 1 to 4 hydrogen atoms of the above aryl group or the above heteroaryl group may
 10 be substituted by a hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to an aryl group or a heteroaryl group bonded thereto via the nitrogen atom, cyano group, nitro group, formyl group,
 15 hydroxycarbonyl group, alkylcarbonyl group, alkoxycarbonyl group, halogen atom, aralkyl group, aralkoxy group, aryl group or aryloxy group. A description is subsequently given of these substituents.

20 <substituent of R¹>

The alkyl group is preferably an alkyl group having 1 to 6 carbon atoms. Preferred examples of the alkyl group include methyl group, ethyl group, n-propyl group, isopropyl group, n-butyl group, sec-butyl group, tert-butyl group,
 25 pentyl group and hexyl group.

The haloalkyl group is preferably an alkyl group having 1 to 6 carbon atoms and substituted by a fluorine atom, chlorine atom or bromine atom. Preferred examples of the haloalkyl group include trifluoromethyl group,
 30 pentafluoroethyl group, chloromethyl group, 2-chloroethyl group and bromomethyl group.

The cycloalkyl group is preferably a cycloalkyl group having 3 to 8 carbon atoms. Preferred examples of the cycloalkyl group include cyclopropyl group, cyclobutyl group,

cyclopentyl group and cyclohexyl group.

The alkoxy group is preferably an alkoxy group having 1 to 6 carbon atoms. Preferred examples of the alkoxy group include methoxy group, ethoxy group, n-propoxy group,
5 isopropoxy group, n-butoxy group, sec-butoxy group and tert-butoxy group.

The amino group is not limited to amino group ($-NH_2$), and one or two hydrogen atoms thereof may be substituted. Examples of the substituent of the amino group include alkyl
10 group having 1 to 6 carbon atoms, alkoxy group having 1 to 6 carbon atoms, cycloalkyl group having 3 to 8 carbon atoms, aryl group having 6 to 10 carbon atoms and heteroaryl group having 4 to 12 carbon atoms. Examples of these substituents are the same as those enumerated for R^1 and its substituent.
15 Preferred examples of the amino group include amino group, methylamino group, dimethylamino group, ethylamino group, diethylamino group, phenylamino group and diphenylamino group.

Preferred examples of the heterocyclic group having
20 a ring member nitrogen atom and bonded to an aryl group or a heteroaryl group bonded thereto via the nitrogen atom include morpholino group, piperidino group, pyrrolidinyl group, piperazino group, N-methylpiperazino group and indolinyl group. Further, the heterocyclic group may have
25 a substituent having a Hammett constant σ_p of less than 0. Examples of the substituent include alkyl groups such as methyl group. Preferred examples of the heterocyclic group having a substituent include 2,6-dimethylmorpholino group, 2,6-dimethylpiperidino group and
30 2,2,6,6-tetramethylpiperidino group.

The alkylcarbonyl group is preferably an alkylcarbonyl group having 2 to 7 carbon atoms. Preferred examples thereof include acetyl group and ethylcarbonyl group.

The alkoxycarbonyl group is preferably an

alkoxycarbonyl group having 2 to 7 carbon atoms. Preferred examples thereof include methoxycarbonyl group and ethoxycarbonyl group.

Examples of the halogen atom are fluorine atom,
5 chlorine atom, bromine atom and iodine atom.

The aralkyl group is preferably an aralkyl group having 7 to 11 carbon atoms. Preferred examples of the aralkyl group include benzyl group, phenylethyl group, phenylpropyl group, phenylbutyl group and naphthylmethyl group.

10 The aralkoxy group is preferably an aralkoxy group having 7 to 11 carbon atoms. Preferred examples of the aralkoxy group include benzyloxy group and naphthylmethoxy group.

The aryl group is preferably an aryl group having 6
15 to 10 carbon atoms. Preferred examples of the aryl group include phenyl group, 1-naphthyl group and 2-naphthyl group.

The aryloxy group is preferably an aryloxy group having 6 to 10 carbon atoms. Preferred examples of the aryloxy group include phenoxy group, 1-naphthoxy group and 2-naphthoxy
20 group.

<preferred R^1 >

Out of the groups R^1 , an aryl group having 6 to 14 carbon atoms is preferred because it provides a compound having
25 excellent double peak characteristic. To obtain especially excellent double peak characteristic and high color optical density, 1 to 4 hydrogen atoms of the aryl group are substituted preferably by a substituent having a Hammett constant σ_p of -1.00 or more to less than 0, particularly
30 preferably by a substituent having a Hammett constant σ_p of -1.00 or more to less than -0.2. Stated more specifically, an aryl group substituted by at least one group selected from the group consisting of hydroxyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom

and bonded to an aryl group bonded thereto via the nitrogen atom, aralkoxy group and aryloxy group is such an example. An aryl group substituted by at least one group selected from the group consisting of hydroxyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to an aryl group bonded thereto via the nitrogen atom and aryloxy group is more preferred, and an aryl group substituted by at least one group selected from the group consisting of alkoxy group, amino group and heterocyclic group having a ring member nitrogen atom and bonded to an aryl group bonded thereto via the nitrogen atom is particularly preferred. Particularly preferred examples of the aryl group include 4-methoxyphenyl group, 2,4-dimethoxyphenyl group, 4-(N,N-dimethylamino)phenyl group and 4-morpholinophenyl group.

$\langle R^2 \rangle$

In the present invention, R^2 is an electron donor group having a Hammett constant σ_p of not more than -0.1. Examples of R^2 which is an electron donor group having a σ_p of not more than -0.1 include hydroxyl group ($\sigma_p = -0.37$), alkyl group, cycloalkyl group, alkoxy group, aryloxy group, aralkyl group, aralkoxy group, amino group and heterocyclic group having a ring member nitrogen atom and bonded to the 7-position carbon atom of a benzene ring bonded thereto via the nitrogen atom.

A detailed description is given of the above electron donor group having a σ_p of not more than -0.1.

The alkyl group is generally a group having a Hammett constant σ_p of -0.2 to -0.1. In the present invention, an alkyl group having 1 to 6 carbon atoms is particularly preferred. 1 to 13 hydrogen atoms, particularly preferably 1 to 4 hydrogen atoms of the alkyl group may be substituted by the above hydroxyl group, alkoxy group, amino group or

heterocyclic group having a ring member nitrogen atom and bonded to an alkyl group bonded thereto via the nitrogen atom described for the substituent of R^1 . The above heterocyclic group substituting the alkyl group is identical to the

5 heterocyclic group substituting the aryl group or the heteroaryl group described in <substituent of R^1 >. The substituent having a ring member nitrogen atom and bonded via the nitrogen atom is synonymous hereinbelow. Preferred examples of the alkyl group include methyl group ($\sigma_p = -0.10$),

10 ethyl group ($\sigma_p = -0.20$), n-propyl group ($\sigma_p = -0.12$), isopropyl group, n-butyl group, sec-butyl group, tert-butyl group ($\sigma_p = -0.15$), pentyl group and hexyl group. Preferred examples of the substituted alkyl group include hydroxymethyl group, methoxymethyl group,

15 N,N-dimethylaminomethyl group and morpholinomethyl group.

The above cycloalkyl group is generally a group having a σ_p of -0.2 to -0.1. In the present invention, a cycloalkyl group having 3 to 20 carbon atoms is particularly preferred. Further, 1 to 39 hydrogen atoms, particularly preferably 1

20 to 20 hydrogen atoms of the cycloalkyl group may be substituted by the above hydroxyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to a cycloalkyl group bonded thereto via the nitrogen atom or halogen atom described for the substituent

25 of R^1 . Preferred examples of the cycloalkyl group include cyclopropyl group, cyclobutyl group, cyclopentyl group and cyclohexyl group ($\sigma_p = -0.16$). Preferred examples of the substituted cycloalkyl group include 4-hydroxycyclohexyl group, 4-methoxycyclohexyl group and

30 4-morpholinocyclohexyl group.

The above alkoxy group is generally a group having a σ_p of -0.3 to -0.2. In the present invention, an alkoxy group having 1 to 15 carbon atoms is particularly preferred. Further, 1 to 31 hydrogen atoms, particularly preferably 1

to 10 hydrogen atoms of the alkoxy group may be substituted by the above hydroxyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to an alkoxy group bonded thereto via the nitrogen atom or halogen atom described for the substituent of R¹. Preferred examples of the alkoxy group include methoxy group ($\sigma_p = -0.28$), ethoxy group ($\sigma_p = -0.21$), n-propoxy group ($\sigma_p = -0.26$), isopropoxy group, n-butoxy group, sec-butoxy group, tert-butoxy group, cyclopropyloxy group, cyclobutyloxy group, cyclopentyloxy group, cyclohexyloxy group, norbornyloxy group, 1-adamantyloxy group and 2-adamantyloxy group. Examples of the substituted alkoxy group include methoxymethoxy group, N,N-dimethylaminomethoxy group and morpholinomethoxy group.

The above amino group is generally a group having a σ_p of -1.0 to -0.5. The preferred amino group may be either an amino group ($-\text{NH}_2$) ($\sigma_p = -0.66$) or a substituted amino group. The substituent of the amino group is selected from alkyl group having 1 to 6 carbon atoms, haloalkyl group having 1 to 6 carbon atoms, alkoxy group having 1 to 15 carbon atoms, cycloalkyl group having 3 to 15 carbon atoms, halogen atom, aryl group having 6 to 10 carbon atoms and heteroaryl group having 4 to 12 carbon atoms. Examples of the haloalkyl group, aryl group and heteroaryl group are the same as those enumerated for the substituent of R¹. Examples of the other groups are the same as those enumerated for the substituent of R². Preferred examples of the amino group having one or two substituents include monoalkylamino groups such as methylamino group ($\sigma_p = -0.77$) and ethylamino group; dialkylamino groups such as dimethylamino group ($\sigma_p = -0.83$) and diethylamino group; monoarylamino groups such as phenylamino group ($\sigma_p = -0.11$); diarylamino groups such as diphenylamino group; halogenoamino groups such as difluoroamino group; and haloalkylamino groups such as

bis(trifluoromethyl)amino group.

The heterocyclic group having a ring member nitrogen atom and bonded to the 7-position carbon atom via the nitrogen atom is generally a group having a σ_p of -1.0 to -0.4.

5 Preferred examples of the heterocyclic group include morpholino group ($\sigma_p = -0.50$), piperidino group ($\sigma_p = -0.83$), pyrrolidinyl group, piperazino group, N-methylpiperazino group and indolinyl group. Further, the heterocyclic group may have an alkyl group having 1 to 6 carbon atoms, haloalkyl group having 1 to 6 carbon atoms, alkoxy group having 1 to 10 15 carbon atoms, cycloalkyl group having 3 to 15 carbon atoms, halogen atom, aryl group having 6 to 10 carbon atoms or heteroaryl group having 4 to 12 carbon atoms as a substituent. Examples of the haloalkyl group, aryl group and heteroaryl group are the same as those enumerated for the substituent of R^1 . Examples of the other groups are the same as those enumerated for the substituent of R^2 . Examples of the substituent include alkyl groups such as methyl group. Examples of the heterocyclic group having a substituent 15 include 2,6-dimethylmorpholino group, 2,6-dimethylpiperidino group, 2,2,6,6-tetramethylpiperidino group, 2-fluoromorpholino group and 2,6-difluoromorpholino group. 20

The aryloxy group is generally a group having a σ_p of -0.5 to -0.2. In the present invention, an aryloxy group 25 having 6 to 10 carbon atoms is particularly preferred. Preferred examples of the aryloxy group include phenoxy group ($\sigma_p = -0.32$) and 1-naphthoxy group.

The aralkyl group is generally a group having a σ_p of not more than -0.1. In the present invention, an aralkyl 30 group having 7 to 11 carbon atoms is particularly preferred. Preferred examples of the aralkyl group include benzyl group, phenylethyl group, phenylpropyl group, phenylbutyl group and naphthylmethyl group.

The aralkoxy group generally is generally a group having a σ_p of not more than -0.1. In the present invention, an aralkoxy group having 7 to 11 carbon atoms is particularly preferred. Preferred examples of the aralkoxy group include
 5 benzyloxy group and naphthylmethoxy group.

One or more hydrogen atoms on the benzene ring of each of the aryloxy group, aralkyl group and aralkoxy group may be substituted by an alkyl group having 1 to 6 carbon atoms, cycloalkyl group having 3 to 15 carbon atoms, alkoxy group
 10 having 1 to 15 carbon atoms, amino group or heterocyclic group having a ring member nitrogen atom and bonded to a benzene ring bonded thereto via the nitrogen atom. Examples of these substituents are the same as those enumerated for R^2 . The aryloxy group, aralkyl group and aralkoxy group substituted
 15 by these substituents have a σ_p of not more than -0.1 as well.

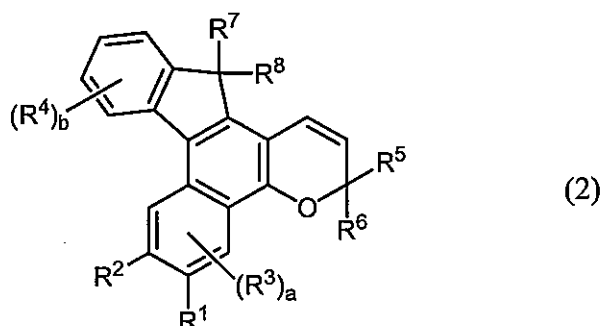
<preferred R^2 >

The group R^2 is preferably a substituent having a σ_p of not more than -0.2 because a combination of it and the
 20 above R^1 provides a compound having excellent double peak characteristic and high color optical density. R^2 is preferably selected from hydroxyl group, alkoxy group, aryloxy group, amino group and heterocyclic group having a ring member nitrogen atom and bonded to the 7-position carbon
 25 atom via the nitrogen atom. Preferred examples of R^2 include hydroxyl group, methoxy group, phenoxy group, morpholino group, piperidino group and dimethylamino group. R^2 is preferably a substituent having a σ_p of -0.6 to -0.2 because it reduces initial coloration by thermochromism and
 30 increases the fading speed. The substituent is more preferably an alkoxy group, aryloxy group, amino group or heterocyclic group having a ring member nitrogen atom and bonded to the 7-position carbon atom via the nitrogen atom, all of which have a σ_p of -0.6 to -0.2. The substituent is

particularly preferably a methoxy group, phenoxy group, difluoroamino group or morpholino group.

<preferred chromene compound>

- 5 Out of the chromene compounds of the present invention, a chromene compound represented by the following formula (2) is preferred as it develops a color of a neutral tint and has little initial coloration, high color optical density, high fading speed and high durability.



- 10 The substituents R^1 to R^8 of the chromene compound represented by the above formula (2) will be described hereinbelow.

< R^1 >

- 15 In the above formula (2), R^1 is an aryl group or a heteroaryl group. Examples of these groups are the same as those enumerated above. Preferred examples thereof are the same as above.

20 < R^2 >

In the above formula (2), R^2 is an electron donor group having a σ_p of not more than -0.1. Examples of R^2 are the same as those enumerated above. Preferred examples thereof are the same as above.

25

< R^3 and R^4 >

R^3 and R^4 are each independently a hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group,

amino group, heterocyclic group having a ring member nitrogen atom and bonded to a benzene ring bonded thereto via the nitrogen atom, cyano group, nitro group, formyl group, hydroxycarbonyl group, alkylcarbonyl group, alkoxycarbonyl group, halogen atom, aralkyl group, aralkoxy group, aryl group or aryloxy group.

Out of these, R^3 and R^4 are each preferably an alkyl group having 1 to 6 carbon atoms, haloalkyl group having 1 to 6 carbon atoms, cycloalkyl group having 3 to 15 carbon atoms, alkoxy group having 1 to 15 carbon atoms, amino group, heterocyclic group having a ring member nitrogen atom and bonded to a benzene ring bonded thereto via the nitrogen atom, alkylcarbonyl group having 2 to 7 carbon atoms, alkoxycarbonyl group having 2 to 7 carbon atoms, halogen atom, aralkyl group having 7 to 11 carbon atoms, aralkoxy group having 7 to 11 carbon atoms, aryl group having 6 to 10 carbon atoms or aryloxy group having 6 to 10 carbon atoms. Examples of R^3 and R^4 are the same as those enumerated for R^1 , the substituent of R^1 and R^2 .

R^3 particularly preferably has a stereoscopically small substituent to provide high fading speed. Therefore, particularly preferred R^3 is a hydrogen atom ("a" is 0).

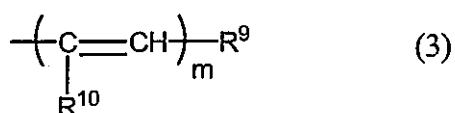
Meanwhile, R^4 is preferably a hydrogen atom ("b" is 0) or an electron absorbing group as a high fading speed is obtained. When the group R^4 is an electron absorbing group, the group R^4 is preferably bonded to the 11-position carbon atom to further accelerate the fading speed. The preferred electron absorbing group is a cyano group or a haloalkyl group having 1 to 6 carbon atoms, as exemplified by cyano group and trifluoromethyl group.

"a" is an integer of 0 to 2 and indicates the number of R^3 's. When "a" is 2, two R^3 's may be the same or different. "b" is an integer of 0 to 4 and indicates the number of R^4 's. When "b" is an integer of 2 to 4, a plurality of R^4 's may

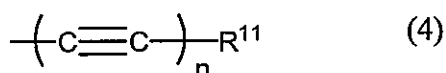
be the same or different. When there are a plurality of R^3 's and a plurality of R^4 's, preferred R^3 's and R^4 's are the same as those enumerated above.

5 $\langle R^5$ and $R^6 \rangle$

R^5 and R^6 are each independently a group represented by the following formula (3), group represented by the following formula (4), aryl group, heteroaryl group or alkyl group.



10



In the above formula (3), R^9 is an aryl group or a heteroaryl group. Examples of the aryl group and the heteroaryl group are the same as those enumerated for R^1 .

15 R^{10} is a hydrogen atom, alkyl group or halogen atom. Examples of the alkyl group include methyl group, ethyl group and propyl group. Examples of the halogen atom are fluorine atom, chlorine atom, bromine atom and iodine atom.

"m" is an integer of 1 to 3. "m" is preferably 1 from
20 the viewpoint of the acquisition of raw materials.

Preferred examples of the group represented by the above formula (3) include phenyl-ethenyl group,
(4-(N,N-dimethylamino)phenyl)-ethenyl group,
(4-morpholinophenyl)-ethenyl group,
25 (4-piperidinophenyl)-ethenyl group,
(4-methoxyphenyl)-ethenyl group,
(2-methoxyphenyl)-ethenyl group, phenyl-1-methylethenyl group,
(4-methoxyphenyl)-1-methylethenyl group,
phenyl-1-fluoroethenyl group,
30 (4-(N,N-dimethylamino)phenyl)-1-fluoroethenyl group,

2-thienyl-ethenyl group, 2-furyl-ethenyl group,
 2-(N-methyl)pyrrolinyl-ethenyl group,
 2-benzothienyl-ethenyl group, 2-benzofuranyl-ethenyl group
 and 2-(N-methyl)indolyl-ethenyl group.

5 In the above formula (4), R^{11} is an aryl group or a heteroaryl group. Examples of these groups are the same as those enumerated for R^9 . "n" is an integer of 1 to 3. "n" is preferably 1 from the viewpoint of the easy acquisition of raw materials.

10 Preferred examples of the group represented by the above formula (4) include phenyl-ethynyl group,
 (4-(N,N-dimethylamino)phenyl)-ethynyl group,
 (4-morpholinophenyl)-ethynyl group,
 (4-piperidinophenyl)-ethynyl group,
 15 (4-methoxyphenyl)-ethynyl group, (4-methylphenyl)-ethynyl group,
 (2-methoxyphenyl)-ethynyl group, 2-thienyl-ethynyl group,
 2-furyl-ethynyl group,
 2-(N-methyl)pyrrolinyl-ethynyl group,
 2-benzothienyl-ethynyl group, 2-benzofuranyl-ethynyl group
 20 and 2-(N-methyl)indolyl-ethynyl group.

Examples of the aryl group and the heteroaryl group represented by R^5 and R^6 are the same as those enumerated for R^1 . Examples of the alkyl group are the same as those enumerated for the substituent of R^1 .

25 R^5 and R^6 can be bonded together to form an aliphatic hydrocarbon ring together with the carbon atom bonded thereto.

Preferred examples of the aliphatic hydrocarbon ring include adamantane ring, bicyclononane ring, norbornane ring
 30 and fluorene ring.

To obtain excellent photochromic properties (double peak characteristic and fading speed), at least one of R^5 and R^6 , preferably both are each desirably an aryl group or a heteroaryl group. Further, at least one of R^5 and R^6 ,

preferably both are each desirably any one of the following groups (i) to (iv):

- (i) aryl group or heteroaryl group having an alkyl group or an alkoxy group as a substituent
- 5 (ii) aryl group or heteroaryl group having an amino group as a substituent
- (iii) aryl group or heteroaryl group having a heterocyclic group having a ring member nitrogen atom and bonded to an aryl group or a heteroaryl group via the
- 10 nitrogen atom as a substituent

In the above aryl groups (i) to (iii), the substitution positions and the total number of the substituents are not particularly limited. To obtain excellent photochromic properties, when the aryl group is a phenyl group, the

15 substitution position is preferably the 3-position or the 4-position and the number of the substituents is preferably 1 to 2. Examples of the aryl group include 4-methylphenyl group, 4-methoxyphenyl group, 3,4-dimethoxyphenyl group, 4-n-propoxyphenyl group, 4-(N,N-dimethylamino)phenyl group,

20 4-(N,N-diethylamino)phenyl group, 4-(N,N-diphenylamino)phenyl group, 4-morpholinophenyl group, 4-piperidinophenyl group, 3-(N,N-dimethylamino)phenyl group and 4-(2,6-dimethylpiperidino)phenyl group.

In the above heteroaryl groups (i) to (iii), the

25 substitution positions and the total number of the substituents are not particularly limited. The number of the substituents is preferably 1. Preferred examples of the heteroaryl group include 4-methoxythienyl group,

4-(N,N-dimethylamino)thienyl group, 4-methylfuryl group,

30 4-(N,N-diethylamino)furyl group, 4-(N,N-diphenylamino)thienyl group, 4-morpholinopyrrolinyl group, 6-piperidinobenzothienyl group and 6-(N,N-dimethylamino)benzofuryl group.

<R⁷ and R⁸>

R⁷ and R⁸ are each independently a hydrogen atom, hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, heterocyclic group having
5 a ring member nitrogen atom and bonded to the 13-position carbon atom via the nitrogen atom, cyano group, nitro group, formyl group, hydroxycarbonyl group, alkylcarbonyl group, alkoxy carbonyl group, halogen atom, aralkyl group, aralkoxy group, aryl group or aryloxy group.

10 Out of these, R⁷ and R⁸ are each preferably an alkyl group having 1 to 6 carbon atoms, haloalkyl group having 1 to 6 carbon atoms, cycloalkyl group having 3 to 15 carbon atoms, alkoxy group having 1 to 15 carbon atoms, amino group, heterocyclic group having a ring member nitrogen atom and
15 bonded to the 13-position carbon atom bonded thereto via the nitrogen atom, alkylcarbonyl group having 2 to 7 carbon atoms, alkoxy carbonyl group having 2 to 7 carbon atoms, halogen atom, aralkyl group having 7 to 11 carbon atoms, aralkoxy group having 7 to 11 carbon atoms, aryl group having 6 to 10 carbon
20 atoms or aryloxy group having 6 to 10 carbon atoms. Examples of R⁷ and R⁸ are the same as those enumerated for R¹, the substituent of R¹ and R².

R⁷ and R⁸ may be bonded together to form an aliphatic ring having 3 to 20 ring member carbon atoms, condensed
25 polycyclic ring having an aromatic ring or an aromatic hetero ring condensed to the above aliphatic ring, hetero ring having 3 to 20 ring member atoms, or condensed polycyclic ring having an aromatic ring or an aromatic hetero ring condensed to the above hetero ring together with the
30 13-position carbon atom bonded thereto.

Examples of the aliphatic ring having 3 to 20 ring member carbon atoms include cyclopentane ring, cyclohexane ring, cyclooctane ring, cycloheptane ring, norbornane ring, bicyclononane ring and adamantane ring.

Examples of the condensed polycyclic ring having an aromatic ring or an aromatic hetero ring condensed to the above aliphatic ring include phenanthrene ring.

5 Examples of the hetero ring having 3 to 20 ring member atoms include dihydrothiophene ring, dihydrofuran ring, tetrahydrofuran ring and dihydropyridine ring.

Examples of the condensed polycyclic ring having an aromatic ring or an aromatic hetero ring condensed to the above hetero ring include dihydrobenzofuran ring and
10 dihydrobenzothiophene ring.

<particularly preferred R^7 and R^8 >

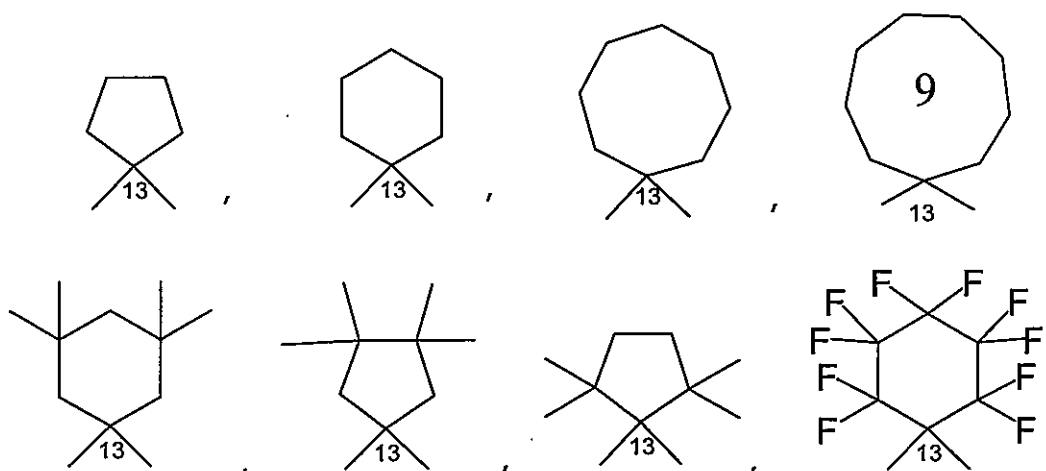
In the present invention, examples of substituents of R^7 and R^8 are each preferably a hydroxyl group, alkyl group
15 or alkoxy group, or form a ring together with the 13-position carbon atom bonded thereto. An example of the alkyl group is a methyl group and an example of the alkoxy group is a methoxy group. Out of these preferred substituents, R^7 and R^8 preferably form a ring together with the 13-position carbon
20 atom to accelerate the fading speed and reduce initial coloration by thermochromism while retaining high color optical density and double peak characteristic. R^7 and R^8 preferably form the above aliphatic ring or the above condensed polycyclic ring having an aromatic ring or an
25 aromatic hetero ring condensed to the above aliphatic ring as the fading speed becomes especially high. R^7 and R^8 particularly preferably form the above aliphatic ring as the fading speed becomes the highest and initial coloration by thermochromism reduces.

30 The particularly preferred aliphatic ring formed by R^7 and R^8 is an aliphatic hydrocarbon ring, and the aliphatic hydrocarbon ring preferably has 3 to 20 ring member carbon atoms. This aliphatic hydrocarbon ring may have at least one substituent selected from the group consisting of alkyl

group having 1 to 6 carbon atoms, haloalkyl group having 1 to 6 carbon atoms, cycloalkyl group having 3 to 15 carbon atoms, alkoxy group having 1 to 15 carbon atoms, amino group, aralkyl group having 7 to 11 carbon atoms, aryl group having 6 to 10 carbon atoms and halogen atom. This substituted aliphatic hydrocarbon ring is also preferred. Examples of the alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, aralkyl group, aryl group and halogen atom are the same as those enumerated for R^1 , the substituent of R^1 and R^2 .

More preferred examples of the aliphatic hydrocarbon ring include monocyclo rings such as cyclopentane ring, cyclohexane ring, cycloheptane ring, cyclooctane ring and cyclononane ring, bicyclo rings such as norbornane ring and bicyclononane ring, and tricyclo rings such as adamantane ring. Aliphatic hydrocarbon rings having at least one lower alkyl group with 4 or less carbon atoms such as methyl group are also preferred. Out of these, a monocyclo ring exhibits a particularly excellent effect as it reduces initial coloration by thermochromism while retaining high color optical density, high double peak characteristic and high fading speed.

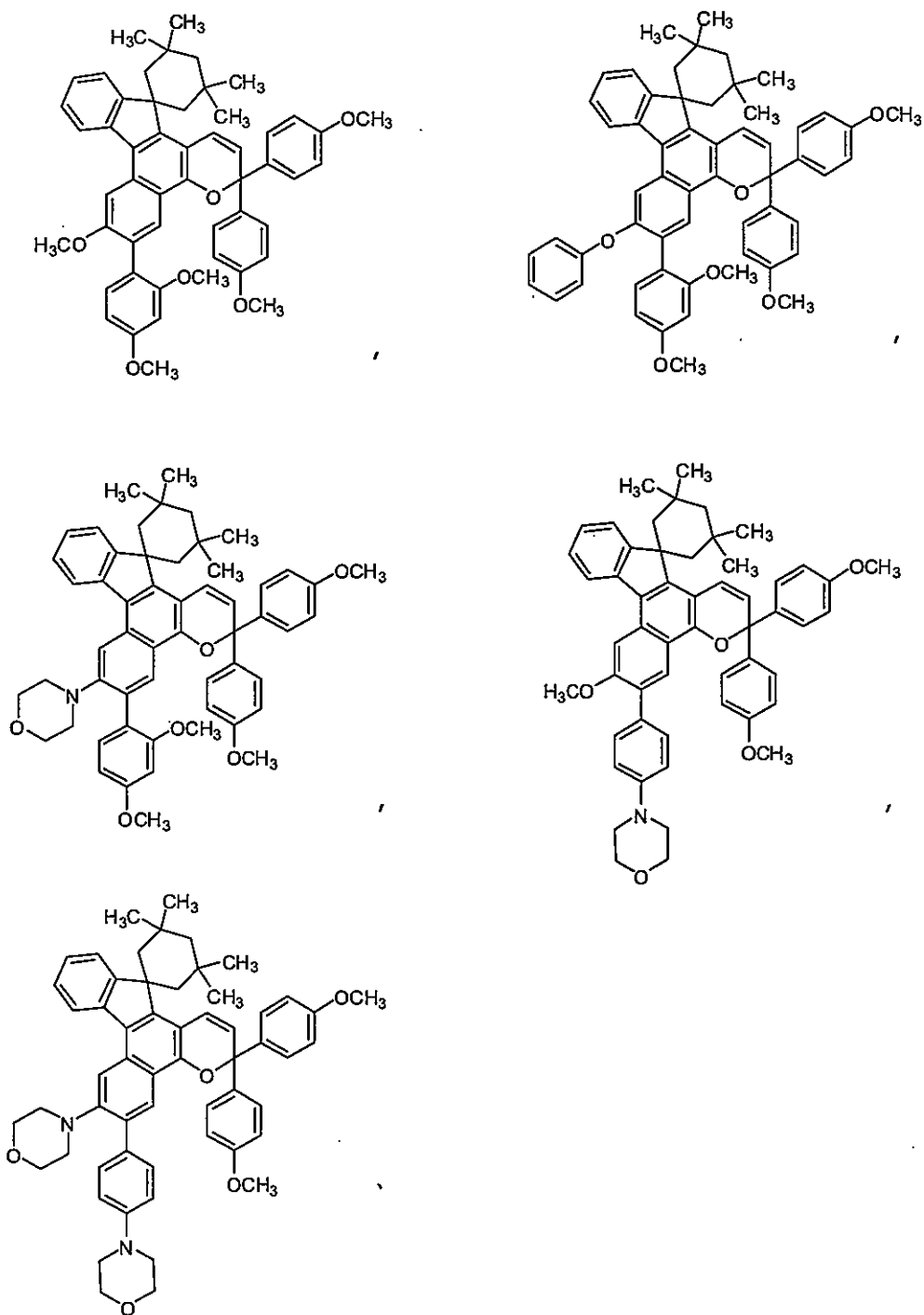
In the present invention, the most preferred examples of the ring formed by bonding together the groups R^7 and R^8 together with the 13-position carbon atom bonded thereto are rings represented by the following formulas. In the following formulas, the carbon atom at a position denoted by 13 is the 13-position carbon atom of the above pyran structure.



Out of the above monocyclo rings, cyclooctane ring,
 cyclononane ring and 3,3,5,5-tetramethylcyclohexane ring
 5 are most preferred.

(preferred examples of chromene compound)

In the present invention, particularly preferred
 examples of the chromene compound are the following
 10 compounds.



(identification of chromene compound)

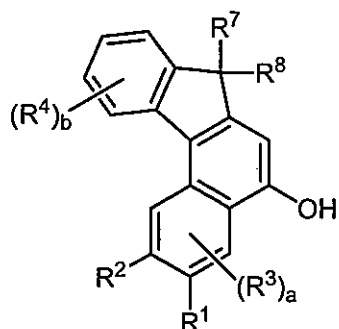
In general, the chromene compound of the present invention is existent as an achromatic, light yellow or light green solid or viscous liquid at normal temperature and normal pressure and can be confirmed by the following means (1) to (3).

- (1) When the proton nuclear magnetic resonance spectrum (^1H -NMR) of the chromene compound is measured, peaks based on an aromatic proton and the proton of an alkene appear at δ of around 5.0 to 9.0 ppm and peaks based on the protons of an alkyl group and an alkylene group appear at δ of around 1.0 to 4.0 ppm. By comparing these spectral intensities relatively, the number of the protons of each bond can be known.
- (2) The composition of a corresponding product can be determined by elemental analysis.
- (3) When the ^{13}C -nuclear magnetic resonance spectrum (^{13}C -NMR) of the chromene compound is measured, a peak based on the carbon of an aromatic hydrocarbon group appears at δ of around 110 to 160 ppm, peaks based on the carbons of an alkene and an alkyne appear at δ of around 80 to 140 ppm, and peaks based on the carbons of an alkyl group and an alkylene group appear at δ of around 20 to 80 ppm.

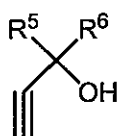
20 (production of chromene compound)

The chromene compound of the present invention may be produced by any synthesis method. For example, the chromene compound represented by the above formula (2) can be advantageously produced by the following method. In the following description, symbols in the formulas are as defined in the above formulas unless otherwise stated.

The chromene compound can be advantageously produced by reacting a naphthol compound represented by the following formula (5) with a propargyl alcohol compound represented by the following formula (6) in the presence of an acid catalyst.



(5)

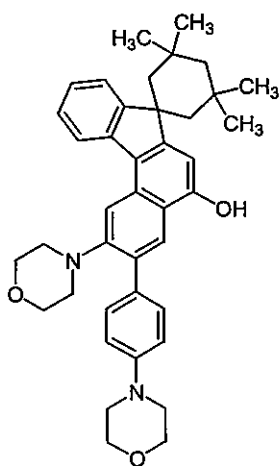
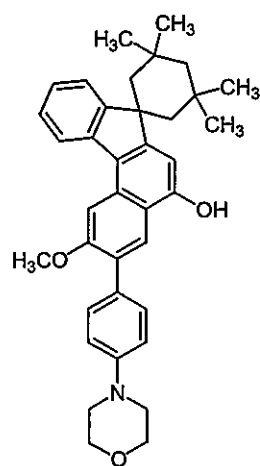
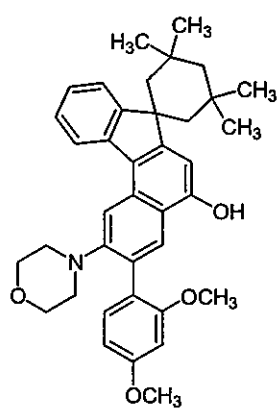
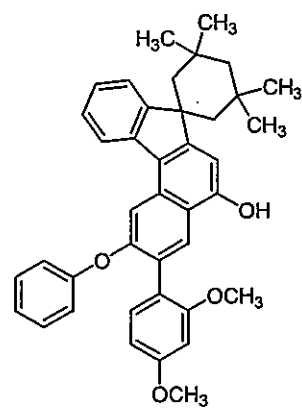
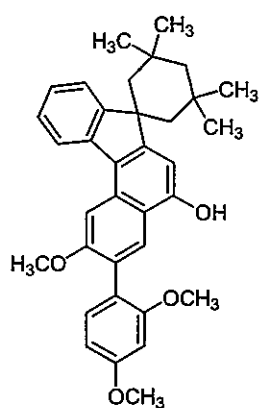


(6)

The reaction ratio of the naphthol compound to the propargyl alcohol compound is preferably selected from a range of 1:10 to 10:1 (molar ratio). The acid catalyst is preferably selected from sulfuric acid, benzenesulfonic acid, p-toluenesulfonic acid and acid alumina. The acid catalyst is preferably used in an amount of 0.1 to 10 parts by weight based on 100 parts by weight of the total of the naphthol compound and the propargyl alcohol compound. The reaction temperature is preferably 0 to 200°C. An aprotic organic solvent such as N-methylpyrrolidone, dimethyl formamide, tetrahydrofuran, benzene or toluene is preferably used as the solvent. The method of purifying the product obtained by the above reaction is not particularly limited. For example, the product is subjected to silica gel column purification and further purified by re-crystallization.

The naphthol compound represented by the above formula (5) is provided as a novel compound by the present invention.

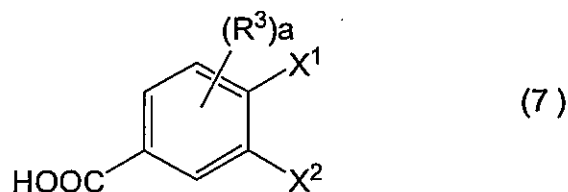
Preferred examples of the naphthol compound represented by the above formula (5) are compounds represented by the following formulas.



Ordinary naphthol compounds can be synthesized based on reaction methods described in research papers such as a pamphlet of International Laid-Open WO01/60881 and a pamphlet of International Laid-Open WO05/028465.

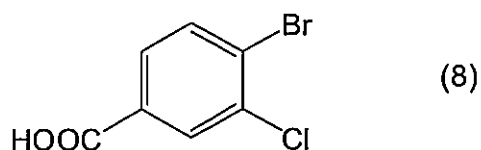
5 The naphthol compound represented by the above formula (5) can be synthesized as follows, for example.

First of all, a carboxylic acid represented by the following formula (7) may be purchased as a commercially available product or may be synthesized based on the
 10 following documents (R^3 and "a" are as defined in the above formula (2). X^1 is a chlorine atom, bromine atom, iodine atom or the same group as R^1 in the formula (2). X^2 is a chlorine atom, bromine atom, iodine atom or the same group as R^2 in the formula (2)).

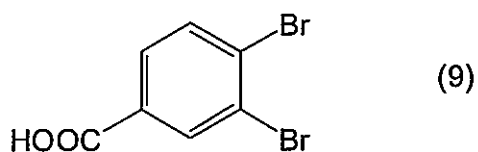


15

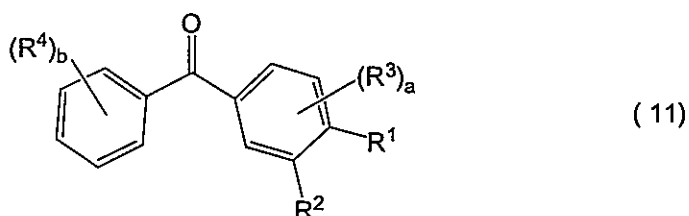
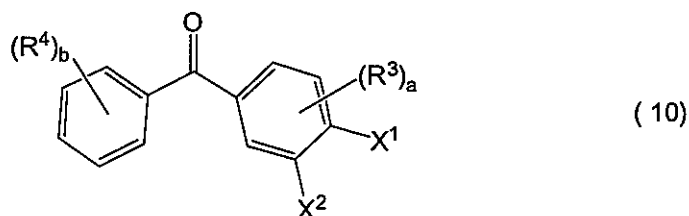
For example, a carboxylic acid represented by the following formula (8) can be purchased as a commercially available product.



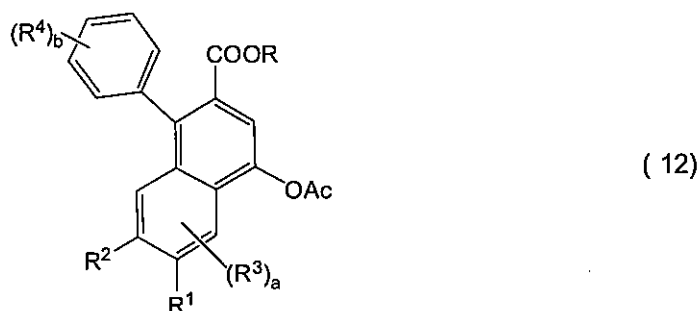
20 For example, a carboxylic acid represented by the following formula (9) can be synthesized based on a reaction method described in research papers such as Journal of the Chemical Society. 20-27; 1927.



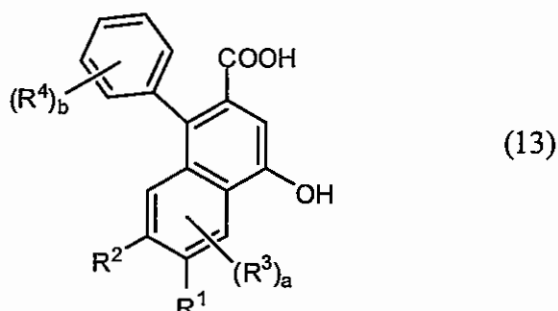
The compound (7) is converted into acid chloride by using thionyl chloride or oxalyl chloride, the acid chloride is reacted with a Grignard reagent to produce a compound
 5 represented by the following formula (10) (R^4 and "b" are as defined in the above formula (2)), and then when X^1 and X^2 are each a chlorine atom, bromine atom or iodine atom, they are converted into desired R^1 and R^2 by making use of a Suzuki-Miura reaction or a Buchwald-Hartwig cross-coupling
 10 reaction to obtain a compound represented by the following formula (11).



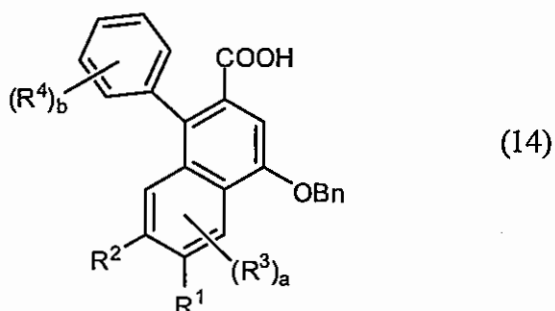
The above compound (11) is subjected to a Stobbe reaction
 15 and a cyclization reaction to obtain a compound represented by the following formula (12).



In the compound of the formula (12), R is a group derived from a diester compound used in the Stobbe reaction. Then, the compound (12) is hydrolyzed by using an alkali or acid to obtain a carboxylic acid represented by the following
 5 formula (13).

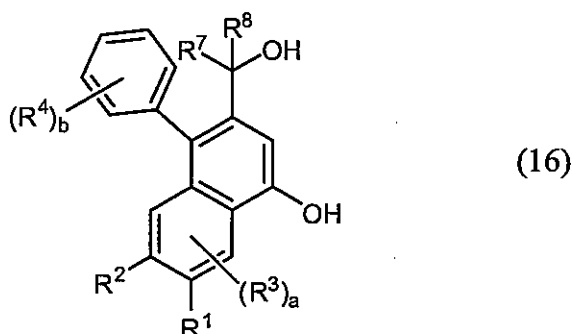
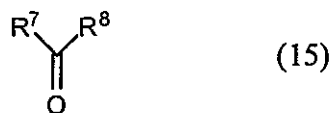


The carboxylic acid is benzylated by using a base such as potassium carbonate and benzyl chloride and then hydrolyzed by using an alkali or acid to obtain a benzyl protected carboxylic acid represented by the following formula (14).



10 The benzyl protected carboxylic acid is converted into an amine by a method such as Curtius rearrangement, Hofmann rearrangement or Lossen rearrangement, and a diazonium salt is prepared from the amine by a method known per se. This diazonium salt is converted into a bromide through a
 15 Sandmeyer reaction or the like, and the obtained bromide is reacted with magnesium or lithium to prepare an organic metal compound. This organic metal compound is reacted with a ketone represented by the following formula (15) (R^7 and R^8 are as defined in the above formula (2)) at -80 to 70°C in
 20 an organic solvent for 10 minutes to 4 hours and then subjected to a debenzylolation reaction with hydrogen and palladium carbon to obtain an alcohol represented by the following

formula (16).



5 The Friedel-Crafts reaction of this alcohol is carried out at 10 to 120°C for 10 minutes to 2 hours under a neutral to acid condition to synthesize a naphthol compound of interest represented by the above formula (5). In the above reaction, the reaction ratio of the above organic metal compound to
 10 the ketone represented by the above formula (15) is preferably selected from a range of 1:10 to 10:1 (molar ratio). The reaction temperature is preferably -80 to 70°C. An aprotic organic solvent such as diethyl ether, tetrahydrofuran, benzene or toluene is preferably used as
 15 the solvent. The Friedel-Crafts reaction of the alcohol represented by the above formula (16) under the neutral to acid condition is preferably carried out by using an acid catalyst such as acetic acid, hydrochloric acid, sulfuric acid, benzenesulfonic acid, p-toluenesulfonic acid or acid
 20 alumina. The acid catalyst is preferably used in an amount of 0.1 to 10 parts by weight based on 100 parts by weight of the alcohol of the above formula (16). For this reaction, an aprotic organic solvent such as tetrahydrofuran, benzene

or toluene is used.

The propargyl alcohol compound represented by the above formula (6) can be easily synthesized, for example, by reacting a ketone compound corresponding to the above
5 formula (6) with a metal acetylene compound such as lithium acetylide.

The chromene compound of the present invention which is synthesized as described above dissolves well in an ordinary organic solvent such as toluene, chloroform or
10 tetrahydrofuran. When the chromene compound represented by the above formula (1) is dissolved in this solvent, the obtained solution is generally almost achromatic and transparent and shows an excellent photochromic function that it develops a color swiftly upon exposure to sunlight
15 or ultraviolet light and reversibly returns to its original achromatic state swiftly by blocking the light.

(combination with another photochromic compound)

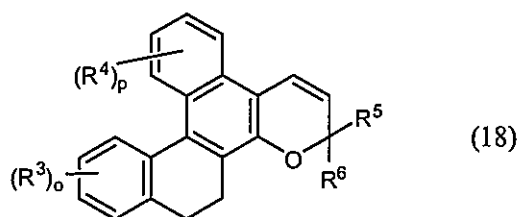
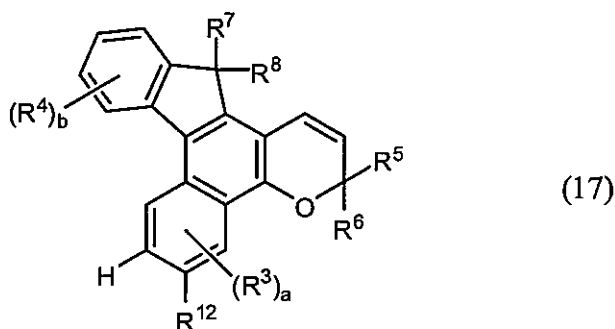
Although the chromene compound of the present
20 invention develops a color of a neutral tint by itself, it may be used in combination with another photochromic compound to obtain various colors required as a photochromic lens. Any known compound may be used without restrictions as the photochromic compound to be combined with. Examples of the
25 photochromic compound include fulgide, fulgimide, spirooxazine and chromene. Out of these, a chromene compound is particularly preferred because it can keep a color uniform at the time of color development and fading, can suppress a color shift at the time of color development due to the
30 deterioration of photochromic properties and further can reduce initial coloration.

That is, by combining the chromene compound of the present invention with another chromene compound which has high color development sensitivity, a high fading speed and

little initial coloration like the above chromene compound, a photochromic composition which keeps a color uniform at the time of color development and fading and provides high transparency can be obtained.

5 To provide high transparency, the chromene compound to be combined with preferably has a transmittance by thermochromism of not less than 75 % and an absorption end of an ultraviolet absorption curve at 380 to 430 nm. Further, a chromene compound having a transmittance by thermochromism
10 of not less than 85 % and an absorption end of an ultraviolet absorption curve at 380 to 420 nm is particularly preferred, and a chromene compound having a transmittance by thermochromism of not less than 88 % and an absorption end of an ultraviolet absorption curve at 380 to 410 nm is most
15 preferred. The transmittance by thermochromism and the absorption end of the ultraviolet absorption curve are values measured by methods described in the following examples.

These preferred chromene compounds to be combined with include chromene compounds represented by the following
20 formulas (17) and (18).



In the above formula (17), R^3 , R^4 , R^5 , R^6 , R^7 , R^8 , "a"

and "b" are as defined in the above formula (2), and R^{12} is a hydrogen atom, hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to a benzene ring bonded thereto via the nitrogen atom, cyano group, nitro group, formyl group, hydroxycarbonyl group, alkylcarbonyl group, alkoxycarbonyl group, halogen atom, aralkyl group, aralkoxy group, aryloxy group or aryl group. Specific examples of the chromene compound of the above formula (17) include compounds described in a pamphlet of International Laid-Open WO2001/60811.

In the above formula (18), R^3 , R^4 , R^5 and R^6 are as defined in the above formula (2), and "o" and "p" are each independently an integer of 0 to 4. Specific examples of the chromene compound of the above formula (18) include compounds described in a pamphlet of International Laid-Open WO2009/136668.

To obtain a photochromic composition comprising the chromene compound of the present invention and another photochromic compound, the ratio of these chromene compounds may be suitably determined according to a desired color. In this case, it is preferred that the amount of the chromene compound of the present invention or another chromene compound should be 0.001 to 10 parts by mass based on 100 parts by mass of the total of all the polymerizable monomers. Stated more specifically, more preferably, in the case of a thin film such as a coating film (for example, a thin film having a thickness of about 100 μm), color should be controlled by using 0.001 to 5.0 parts by mass of the chromene compound of the present invention and 0.001 to 5.0 parts by mass of another chromene compound based on 100 parts by mass of the coating film or all of the polymerizable monomers which provide the coating film. In the case of a thick cured material (having a thickness of 1 mm or more, for example),

color should be controlled by using 0.001 to 0.5 part by mass of the chromene compound of the present invention and 0.001 to 0.5 part by mass of another chromene compound based on 100 parts by mass of the thick cured material or all of the polymerizable monomers which provide the thick cured material.

(stabilizer to be combined with)

Although the chromene compound of the present invention has high durability as it is, its durability can be further enhanced by using the following ultraviolet absorbent, optical stabilizer or antioxidant. As the ultraviolet absorbent may be used known ultraviolet absorbents such as benzophenone-based compounds, benzotriazole-based compounds, cyanoacrylate-based compounds, triazine-based compounds and benzoate-based compounds. Cyanoacrylate-based compounds and benzophenone-based compounds are particularly preferred. When the above ultraviolet absorbent is used in an amount of 0.001 to 5 parts by mass based on 100 parts by mass of the total of all the polymerizable monomers including the chromene compound of the present invention, it produces an effect. Known hindered amines may be used as the optical stabilizer, and known hindered phenols may be used as the antioxidant. When the above optical stabilizer and antioxidant are each used in an amount of 0.01 to 10 parts by mass based on 100 parts by mass of the total of all the polymerizable monomers including the chromene compound of the present invention, they produce an effect.

(use of chromene compound)

A photochromic composition comprising the chromene compound of the present invention and a chromene compound represented by the above formula (1) (17) or (18) exhibits

the same photochromic properties even in a polymer solid matrix. The polymer solid matrix is not particularly limited if the chromene compound of the present invention can be uniformly dispersed therein. Examples of the polymer
5 compound optically preferred for the polymer solid matrix include thermoplastic resins such as methyl polyacrylate, ethyl polyacrylate, methyl polymethacrylate, ethyl polymethacrylate, polystyrene, polyacrylonitrile, polyvinyl alcohol, polyacrylamide,
10 poly(2-hydroxyethylmethacrylate), polydimethylsiloxane and polycarbonate.

A photochromic composition can also be prepared by mixing the photochromic composition comprising the chromene compound of the present invention and the chromene compound
15 represented by the above formula (1), (17) or (18) with various polymerizable monomers before polymerization to prepare a photochromic curable composition and polymerizing and curing it. That is, a cured material containing the photochromic composition uniformly dispersed therein can be
20 obtained by polymerizing and curing the photochromic curable composition comprising the photochromic composition of the present invention and various polymerizable monomers.

A photochromic curable composition which is prepared by mixing together the photochromic composition comprising
25 the chromene compound represented by the above formula (1), (17) or (18) with the following polymerizable monomers (A1), (A2) and (A3) and provides a cured material having an L scale Rockwell hardness of not less than 60 is particularly preferred because it exhibits excellent photochromic
30 properties such as high color optical density and high fading speed and obtains excellent substrate properties such as high hardness and high heat resistance:

(A1) a polymerizable monomer which has an L scale Rockwell hardness of a polymer obtained by homopolymerizing it of not

more than 40,

(A2) a trifunctional or higher functional radically polymerizable monomer which has an L scale Rockwell hardness of a polymer obtained by homopolymerizing it of not less than

5 60, and

(A3) a bifunctional radically polymerizable monomer having an L scale Rockwell hardness of a polymer obtained by homopolymerizing it of not less than 60.

Examples of the component (A1) include acrylate
10 compounds and methacrylate compounds such as glycidyl acrylate, glycidyl methacrylate, β -methylglycidyl methacrylate, bisphenol A-monoglycidyl ether-methacrylate, 4-glycidyloxy methacrylate, 3-(glycidyl-2-oxyethoxy)-2-hydroxypropyl methacrylate,
15 3-(glycidyloxy-1-isopropoxy)-2-hydroxypropyl acrylate and 3-glycidyloxy-2-hydroxypropyloxy)-2-hydroxypropyl acrylate, and polyalkylene glycol compounds such as polyethylene glycol diacrylate; examples of the component (A2) include polyacrylate and polymethacrylate compounds
20 such as trimethylolpropane trimethacrylate, urethane acrylates such as urethane oligomer tetramethacrylate, and polyester acrylates such as polyester oligomer hexaacrylate; and examples of the component (A3) include polyacrylate and polymethacrylate compounds such as ethylene glycol
25 diacrylate, diethylene glycol dimethacrylate, triethylene glycol dimethacrylate, tetraethylene glycol dimethacrylate, ethylene glycol bisglycidyl methacrylate, bisphenol A dimethacrylate,
2,2-bis(4-methacryloyloxyethoxyphenyl)propane and
30 2,2-bis(3,5-dibromo-4-methacryloyloxyethoxyphenyl)propane, all of which are polymerizable monomers described in a pamphlet of International Laid-Open WO2001/05854. The term "L scale Rockwell hardness" means hardness measured in accordance with JIS-B7726, and it can be easily judged

whether the above hardness condition is satisfied or not by measuring the homopolymer of each monomer.

Copolymers obtained by copolymerizing the above polymerizable monomers with polymerizable monofunctional monomers may also be used as the above polymer matrix. The polymerizable monofunctional monomers include unsaturated carboxylic acids such as acrylic acid, methacrylic acid and maleic anhydride; polyallyl compounds such as diallyl phthalate, diallyl terephthalate, diallyl isophthalate, diallyl tartarate, diallyl epoxysuccinate, diallyl fumarate, diallyl chlorendate, diallyl hexaphthalate, diallyl carbonate, allyl diglycol carbonate and trimethylolpropane triallyl carbonate; polythioacrylate and polythiomethacrylate compounds such as 1,2-bis(methacryloylthio)ethane, bis(2-acryloylthioethyl)ether and 1,4-bis(methacryloylthiomethyl)benzene; acrylate and methacrylate compounds such as methyl acrylate, methyl methacrylate, benzyl methacrylate, phenyl methacrylate and 2-hydroxyethyl methacrylate; fumarate compounds such as diethyl fumarate and diphenyl fumarate; thioacrylate and thiomethacrylate compounds such as methyl thioacrylate, benzyl thioacrylate and benzyl thiomethacrylate; and vinyl compounds such as styrene, chlorostyrene, methyl styrene, vinyl naphthalene, α -methylene dimer and bromostyrene. These monomers may be used alone or in combination of two or more, and the amount of the monomer may be suitably determined according to its use purpose.

The method of dispersing the chromene compound of the present invention into the above polymer solid matrix is not particularly limited, and commonly used methods may be employed. The methods include one in which the above thermoplastic resin and the chromene compound are kneaded together while they are molten to disperse the chromene

compound into the resin, one in which the chromene compound is dissolved in the above polymerizable monomers and a polymerization catalyst is added to polymerize the polymerizable monomers by heat or light so as to disperse the chromene compound into the resin, and one in which the surfaces of the above thermoplastic resin and the above thermosetting resin are dyed with the chromene compound to disperse the chromene compound into the resins.

10 (other applications of chromene compound of the present invention)

The chromene compound of the present invention can be used as a photochromic material in a wide range of fields such as recording materials as substitutes for silver halide photosensitive materials, copy materials, printing photosensitive materials, recording materials for cathode ray tubes, photosensitive materials for lasers and photosensitive materials for holography. The photochromic material comprising the chromene compound of the present invention may also be used as a photochromic plastic lens material, optical filter material, display material or material for actinometers and ornaments.

For instance, when the chromene compound of the present invention is used in a photochromic lens, a method in which uniform light control performance is obtained, for example, a method in which a polymer film containing the photochromic material of the present invention uniformly dispersed therein is sandwiched between lenses, a method in which the chromene compound of the present invention is dispersed into the above polymerizable monomers and the polymerizable monomers are polymerized by a predetermined technique, or a method in which the chromene compound of the present invention is dissolved in, for example, silicone oil, the resulting solution is impregnated into the surface of a lens

at 150 to 200°C over 10 to 60 minutes, and the surface is further coated with a curable substance to obtain a photochromic lens may be employed. Further, a method in which the above polymer film is formed on the surface of a lens and the surface is coated with a curable substance to
5 obtain a photochromic lens is also employed.

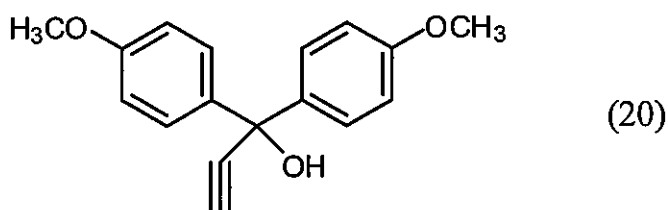
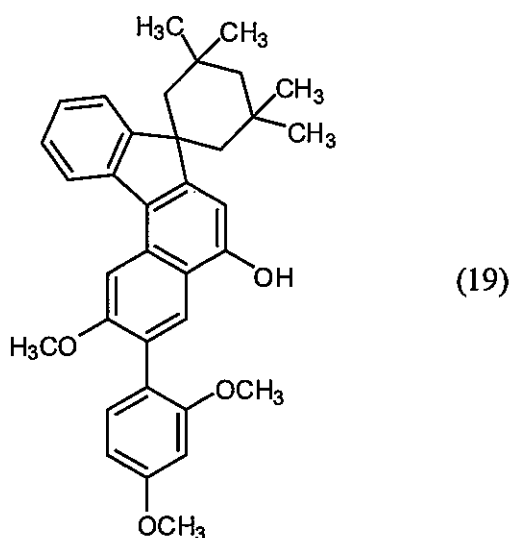
Further, a coating agent composed of a polymerization curable composition comprising the chromene compound of the present invention may be applied to the surface of a lens
10 substrate, and the coating film may be cured. At this point, the lens substrate may be subjected to a surface treatment with an alkaline solution or a plasma treatment in advance, and a primer may be further applied to improve adhesion between the substrate and the coating film (by carrying out
15 the above surface treatment or without the surface treatment).

Examples

The following examples are provided for the purpose
20 of further illustrating the present invention but are in no way to be taken as limiting.

Example 1

1.20 g (2.3 mmol) of a naphthol compound represented
25 by the following formula (19) and 0.80 g (3.0 mmol) of a propargyl alcohol compound represented by the following formula (20) were dissolved in 70 ml of toluene, 0.022 g of p-toluenesulfonic acid was further added to the resulting solution, and the obtained mixture was stirred under reflux
30 by heating for 1 hour.



After the reaction, the solvent was removed, and the obtained product was purified by chromatography on silica gel to
 5 obtain 1.35 g of a white powder product. The yield rate was 76 %.

The elemental analysis values of this product were 80.70 % of C, 6.79 % of H and 12.51 % of O which were almost equal to the calculated values of C₅₂H₅₂O₆ (C: 80.80 %, H: 6.78 %,
 10 O: 12.42 %).

When the proton nuclear magnetic resonance spectrum of the product was measured, it showed 18H peaks based on the methyl proton of a tetramethylcyclohexane ring and a methylene proton at δ of around 1.0 to 3.0 ppm, a 15H peak
 15 based on the methyl proton of a methoxy group at δ of around 2.3 to 4.5 ppm and 19H peaks based on an aromatic proton and the proton of an alkene at δ of around 5.6 to 9.0 ppm. Further, when the ¹³C-nuclear magnetic resonance spectrum was measured,

COC1=CC=C(C=C1)C2=C(C(=C(C=C2)OC)OC)C3=C(C=C(C=C3)OC)OC4=CC=C(C=C4)OC5=CC=C(C=C5)OC6=CC=C(C=C6)OC7=CC=C(C=C7)OC8=CC=C(C=C8)OC9=CC=C(C=C9)OC10=CC=C(C=C10)OC11=CC=C(C=C11)OC12=CC=C(C=C12)OC13=CC=C(C=C13)OC14=CC=C(C=C14)OC15=CC=C(C=C15)OC16=CC=C(C=C16)OC17=CC=C(C=C17)OC18=CC=C(C=C18)OC19=CC=C(C=C19)OC20=CC=C(C=C20)OC21=CC=C(C=C21)OC22=CC=C(C=C22)OC23=CC=C(C=C23)OC24=CC=C(C=C24)OC25=CC=C(C=C25)OC26=CC=C(C=C26)OC27=CC=C(C=C27)OC28=CC=C(C=C28)OC29=CC=C(C=C29)OC30=CC=C(C=C30)OC31=CC=C(C=C31)OC32=CC=C(C=C32)OC33=CC=C(C=C33)OC34=CC=C(C=C34)OC35=CC=C(C=C35)OC36=CC=C(C=C36)OC37=CC=C(C=C37)OC38=CC=C(C=C38)OC39=CC=C(C=C39)OC40=CC=C(C=C40)OC41=CC=C(C=C41)OC42=CC=C(C=C42)OC43=CC=C(C=C43)OC44=CC=C(C=C44)OC45=CC=C(C=C45)OC46=CC=C(C=C46)OC47=CC=C(C=C47)OC48=CC=C(C=C48)OC49=CC=C(C=C49)OC50=CC=C(C=C50)OC51=CC=C(C=C51)OC52=CC=C(C=C52)OC53=CC=C(C=C53)OC54=CC=C(C=C54)OC55=CC=C(C=C55)OC56=CC=C(C=C56)OC57=CC=C(C=C57)OC58=CC=C(C=C58)OC59=CC=C(C=C59)OC60=CC=C(C=C60)OC61=CC=C(C=C61)OC62=CC=C(C=C62)OC63=CC=C(C=C63)OC64=CC=C(C=C64)OC65=CC=C(C=C65)OC66=CC=C(C=C66)OC67=CC=C(C=C67)OC68=CC=C(C=C68)OC69=CC=C(C=C69)OC70=CC=C(C=C70)OC71=CC=C(C=C71)OC72=CC=C(C=C72)OC73=CC=C(C=C73)OC74=CC=C(C=C74)OC75=CC=C(C=C75)OC76=CC=C(C=C76)OC77=CC=C(C=C77)OC78=CC=C(C=C78)OC79=CC=C(C=C79)OC80=CC=C(C=C80)OC81=CC=C(C=C81)OC82=CC=C(C=C82)OC83=CC=C(C=C83)OC84=CC=C(C=C84)OC85=CC=C(C=C85)OC86=CC=C(C=C86)OC87=CC=C(C=C87)OC88=CC=C(C=C88)OC89=CC=C(C=C89)OC90=CC=C(C=C90)OC91=CC=C(C=C91)OC92=CC=C(C=C92)OC93=CC=C(C=C93)OC94=CC=C(C=C94)OC95=CC=C(C=C95)OC96=CC=C(C=C96)OC97=CC=C(C=C97)OC98=CC=C(C=C98)OC99=CC=C(C=C99)OC100=CC=C(C=C100)OC101=CC=C(C=C101)OC102=CC=C(C=C102)OC103=CC=C(C=C103)OC104=CC=C(C=C104)OC105=CC=C(C=C105)OC106=CC=C(C=C106)OC107=CC=C(C=C107)OC108=CC=C(C=C108)OC109=CC=C(C=C109)OC110=CC=C(C=C110)OC111=CC=C(C=C111)OC112=CC=C(C=C112)OC113=CC=C(C=C113)OC114=CC=C(C=C114)OC115=CC=C(C=C115)OC116=CC=C(C=C116)OC117=CC=C(C=C117)OC118=CC=C(C=C118)OC119=CC=C(C=C119)OC120=CC=C(C=C120)OC121=CC=C(C=C121)OC122=CC=C(C=C122)OC123=CC=C(C=C123)OC124=CC=C(C=C124)OC125=CC=C(C=C125)OC126=CC=C(C=C126)OC127=CC=C(C=C127)OC128=CC=C(C=C128)OC129=CC=C(C=C129)OC130=CC=C(C=C130)OC131=CC=C(C=C131)OC132=CC=C(C=C132)OC133=CC=C(C=C133)OC134=CC=C(C=C134)OC135=CC=C(C=C135)OC136=CC=C(C=C136)OC137=CC=C(C=C137)OC138=CC=C(C=C138)OC139=CC=C(C=C139)OC140=CC=C(C=C140)OC141=CC=C(C=C141)OC142=CC=C(C=C142)OC143=CC=C(C=C143)OC144=CC=C(C=C144)OC145=CC=C(C=C145)OC146=CC=C(C=C146)OC147=CC=C(C=C147)OC148=CC=C(C=C148)OC149=CC=C(C=C149)OC150=CC=C(C=C150)OC151=CC=C(C=C151)OC152=CC=C(C=C152)OC153=CC=C(C=C153)OC154=CC=C(C=C154)OC155=CC=C(C=C155)OC156=CC=C(C=C156)OC157=CC=C(C=C157)OC158=CC=C(C=C158)OC159=CC=C(C=C159)OC160=CC=C(C=C160)OC161=CC=C(C=C161)OC162=CC=C(C=C162)OC163=CC=C(C=C163)OC164=CC=C(C=C164)OC165=CC=C(C=C165)OC166=CC=C(C=C166)OC167=CC=C(C=C167)OC168=CC=C(C=C168)OC169=CC=C(C=C169)OC170=CC=C(C=C170)OC171=CC=C(C=C171)OC172=CC=C(C=C172)OC173=CC=C(C=C173)OC174=CC=C(C=C174)OC175=CC=C(C=C175)OC176=CC=C(C=C176)OC177=CC=C(C=C177)OC178=CC=C(C=C178)OC179=CC=C(C=C179)OC180=CC=C(C=C180)OC181=CC=C(C=C181)OC182=CC=C(C=C182)OC183=CC=C(C=C183)OC184=CC=C(C=C184)OC185=CC=C(C=C185)OC186=CC=C(C=C186)OC187=CC=C(C=C187)OC188=CC=C(C=C188)OC189=CC=C(C=C189)OC190=CC=C(C=C190)OC191=CC=C(C=C191)OC192=CC=C(C=C192)OC193=CC=C(C=C193)OC194=CC=C(C=C194)OC195=CC=C(C=C195)OC196=CC=C(C=C196)OC197=CC=C(C=C197)OC198=CC=C(C=C198)OC199=CC=C(C=C199)OC200=CC=C(C=C200)OC201=CC=C(C=C201)OC202=CC=C(C=C202)OC203=CC=C(C=C203)OC204=CC=C(C=C204)OC205=CC=C(C=C205)OC206=CC=C(C=C206)OC207=CC=C(C=C207)OC208=CC=C(C=C208)OC209=CC=C(C=C209)OC210=CC=C(C=C210)OC211=CC=C(C=C211)OC212=CC=C(C=C212)OC213=CC=C(C=C213)OC214=CC=C(C=C214)OC215=CC=C(C=C215)OC216=CC=C(C=C216)OC217=CC=C(C=C217)OC218=CC=C(C=C218)OC219=CC=C(C=C219)OC220=CC=C(C=C220)OC221=CC=C(C=C221)OC222=CC=C(C=C222)OC223=CC=C(C=C223)OC224=CC=C(C=C224)OC225=CC=C(C=C225)OC226=CC=C(C=C226)OC227=CC=C(C=C227)OC228=CC=C(C=C228)OC229=CC=C(C=C229)OC230=CC=C(C=C230)OC231=CC=C(C=C231)OC232=CC=C(C=C232)OC233=CC=C(C=C233)OC234=CC=C(C=C234)OC235=CC=C(C=C235)OC236=CC=C(C=C236)OC237=CC=C(C=C237)OC238=CC=C(C=C238)OC239=CC=C(C=C239)OC240=CC=C(C=C240)OC241=CC=C(C=C241)OC242=CC=C(C=C242)OC243=CC=C(C=C243)OC244=CC=C(C=C244)OC245=CC=C(C=C245)OC246=CC=C(C=C246)OC247=CC=C(C=C247)OC248=CC=C(C=C248)OC249=CC=C(C=C249)OC250=CC=C(C=C250)OC251=CC=C(C=C251)OC252=CC=C(C=C252)OC253=CC=C(C=C253)OC254=CC=C(C=C254)OC255=CC=C(C=C255)OC256=CC=C(C=C256)OC257=CC=C(C=C257)OC258=CC=C(C=C258)OC259=CC=C(C=C259)OC260=CC=C(C=C260)OC261=CC=C(C=C261)OC262=CC=C(C=C262)OC263=CC=C(C=C263)OC264=CC=C(C=C264)OC265=CC=C(C=C265)OC266=CC=C(C=C266)OC267=CC=C(C=C267)OC268=CC=C(C=C268)OC269=CC=C(C=C269)OC270=CC=C(C=C270)OC271=CC=C(C=C271)OC272=CC=C(C=C272)OC273=CC=C(C=C273)OC274=CC=C(C=C274)OC275=CC=C(C=C275)OC276=CC=C(C=C276)OC277=CC=C(C=C277)OC278=CC=C(C=C278)OC279=CC=C(C=C279)OC280=CC=C(C=C280)OC281=CC=C(C=C281)OC282=CC=C(C=C282)OC283=CC=C(C=C283)OC284=CC=C(C=C284)OC285=CC=C(C=C285)OC286=CC=C(C=C286)OC287=CC=C(C=C287)OC288=CC=C(C=C288)OC289=CC=C(C=C289)OC290=CC=C(C=C290)OC291=CC=C(C=C291)OC292=CC=C(C=C292)OC293=CC=C(C=C293)OC294=CC=C(C=C294)OC295=CC=C(C=C295)OC296=CC=C(C=C296)OC297=CC=C(C=C297)OC298=CC=C(C=C298)OC299=CC=C(C=C299)OC300=CC=C(C=C300)OC301=CC=C(C=C301)OC302=CC=C(C=C302)OC303=CC=C(C=C303)OC304=CC=C(C=C304)OC305=CC=C(C=C305)OC306=CC=C(C=C306)OC307=CC=C(C=C307)OC308=CC=C(C=C308)OC309=CC=C(C=C309)OC310=CC=C(C=C310)OC311=CC=C(C=C311)OC312=CC=C(C=C312)OC313=CC=C(C=C313)OC314=CC=C(C=C314)OC315=CC=C(C=C315)OC316=CC=C(C=C316)OC317=CC=C(C=C317)OC318=CC=C(C=C318)OC319=CC=C(C=C319)OC320=CC=C(C=C320)OC321=CC=C(C=C321)OC322=CC=C(C=C322)OC323=CC=C(C=C323)OC324=CC=C(C=C324)OC325=CC=C(C=C325)OC326=CC=C(C=C326)OC327=CC=C(C=C327)OC328=CC=C(C=C328)OC329=CC=C(C=C329)OC330=CC=C(C=C330)OC331=CC=C(C=C33

(21)

Chromene compounds shown in Table 1 (Examples 2 to 15) were synthesized in the same manner as in Example 1. When the structures of the obtained products were analyzed by using the same structure confirming means as in Example 1, it was confirmed that they were compounds represented by structural formulas shown in Table 1. Table 2 shows the elemental analysis values, calculated values obtained from the structural formulas of the compounds and characteristic ¹H-NMR spectra of these compounds.

Table 1

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
2				70
3				69
4				70
5				73

Table 1 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
6				71
7				75
8				75
9				72

Table 1 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
10				71
11				74
12				74
13				72

Table 1 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
14				70
15				73

Table 2

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
2	82.03	6.66	0.00	11.31	81.99	6.52	0.00	11.50	δ5.0-9.0 24H δ0.5-4.5 30H
3	79.89	6.89	1.67	11.55	79.78	6.94	1.69	11.59	δ5.0-9.0 19H δ0.5-4.5 38H
4	81.08	6.99	1.73	10.20	80.99	7.05	1.78	10.18	δ5.0-9.0 19H δ0.5-4.5 36H
5	82.44	6.99	0.00	10.58	82.51	6.92	0.00	10.57	δ5.0-9.0 19H δ0.5-4.5 33H
6	84.22	6.87	0.00	8.91	84.24	6.79	0.00	8.98	δ5.0-9.0 21H δ0.5-4.5 27H
7	85.02	6.71	0.00	8.27	85.01	6.61	0.00	8.39	δ5.0-9.0 23H δ0.5-4.5 27H
8	85.29	6.68	0.00	8.03	85.25	6.64	0.00	8.11	δ5.0-9.0 25H δ0.5-4.5 27H
9	81.19	6.99	1.71	10.11	81.27	6.95	1.76	10.02	δ5.0-9.0 20H δ0.5-4.5 35H
10	79.80	5.91	0.00	14.29	79.86	5.96	0.00	14.18	δ5.0-9.0 19H δ0.5-4.5 21H

Table 2 (continued)

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
11	77.98	5.54	0.00	16.48	77.86	5.64	0.00	16.50	δ5.0-9.0 19H δ0.5-4.5 19H
12	79.80	6.24	1.73	12.23	79.67	6.30	1.79	12.25	δ5.0-9.0 19H δ0.5-4.5 30H
13	76.27	5.52	0.00	-	76.35	5.49	0.00	8.30	δ5.0-9.0 19H δ0.5-4.5 23H
14	76.32	5.97	3.52	14.19	76.32	5.89	3.56	14.23	δ5.0-9.0 17H δ0.5-4.5 29H
15	82.04	6.66	0.00	11.30	82.02	6.60	0.00	11.38	δ5.0-9.0 19H δ0.5-4.5 27H

Examples 16 to 30

(evaluation of physical properties of photochromic plastic lens produced by coating method)

The chromene compound obtained in Example 1 was mixed
5 with a photopolymerization initiator and polymerizable monomers, the resulting mixture was applied to the surface of a lens substrate, and ultraviolet light was applied to polymerize the coating film on the surface of the lens substrate.

10 For a photochromic curable composition, a mixture of 50 parts by mass of 2,2-bis(4-methacryloyloxy-pentaethoxyphenyl)propane, 10 parts by mass of polyethylene glycol diacrylate (average molecular weight of 532), 10 parts by mass of
15 trimethylolpropane trimethacrylate, 10 parts by mass of polyester oligomer hexaacrylate (EB-1830 of Daicel UCB Co., Ltd.) and 10 parts by mass of glycidyl methacrylate as radically polymerizable monomers was used. 1 part by mass of the chromene compound obtained in Example 1 was added to
20 and fully mixed with 90 parts by mass of this mixture of the radically polymerizable monomers, and 0.3 part by mass of CGI1800 {a mixture of 1-hydroxycyclohexylphenyl ketone and bis(2,6-dimethoxybenzoyl)-2,4,4-trimethyl-pentylphosphine oxide (weight ratio of 3:1)} as a
25 photopolymerization initiator, 5 parts by mass of bis(1,2,2,6,6-pentamethyl-4-piperidyl)sebacate as a stabilizer, 3 parts by mass of ethylenebis(oxyethylene)bis[3-(5-tert-butyl-4-hydroxy-m-tolyl)propionate], 7 parts by mass of
30 γ -methacryloyloxypropyl trimethoxysilane as a silane coupling agent and 3 parts by mass of N-methyldiethanolamine were added to and fully mixed with the above mixture to obtain a photochromic curable composition.

Subsequently, about 2 g of the photochromic curable

composition obtained by the above method was applied to the surface of a lens substrate (CR39: allyl resin plastic lens; refractive index of 1.50) by using the 1H-DX2 spin coater of MIKASA Co., Ltd. This coated lens was irradiated with
 5 light from a metal halide lamp having an output of 120 mW/cm² in a nitrogen gas atmosphere for 3 minutes to cure the photochromic curable composition. Thus, an optical article (photochromic plastic lens) which was coated with a polymer film containing the cured chromene compound dispersed
 10 therein (thickness of polymer film: 40 μm) was manufactured.

The following photochromic properties of the obtained photochromic plastic lens were evaluated. The results obtained by using the chromene compound of Example 1 are shown in Table 3.

15 [1] Maximum absorption wavelength ($\lambda_{\max}$): This is the maximum absorption wavelength after color development obtained by means of the spectrophotometer (MCPD3000 instantaneous multi-channel photodetector) of Otsuka Electronics Co., Ltd. and used as an index of color at the time of color development.
 20 The maximum absorption wavelength is connected with color at the time of color development.

[2] Color optical density (A_0): This is the difference between absorbance $\{\epsilon(120)\}$ after 120 seconds of exposure and $\epsilon(0)$ under no exposure at the above maximum absorption wavelength
 25 and used as an index of color optical density. It can be said that as this value becomes larger, the photochromic properties become better.

[3] Double peak characteristic (A_Y/A_B): This is the ratio of color optical density (A_Y : value of $\lambda_{\max}$) at a yellow range
 30 (having a maximum absorption wavelength at 430 to 530 nm) and color optical density (A_B : value of $\lambda_{\max}$) at a blue range (having a maximum absorption wavelength at 550 to 650 nm) and used as an index of double peak characteristic.

[4] Fading half period [$\tau_{1/2}(\text{sec.})$]: time required for the

reduction of the absorbance at the above maximum absorption wavelength of a sample to $1/2$ of $\{\epsilon(120) - \epsilon(0)\}$ when exposure is stopped after 120 seconds of exposure and used as an index of fading speed. As this time becomes shorter, the fading speed becomes higher.

[5] Absorption end $\{\lambda_0\}$: After the photochromic plastic lens obtained under the above conditions is used as a sample and kept in the dark for one day, the ultraviolet light transmittance (T%) at 300 to 800 nm of the sample is measured with an ultraviolet visible spectrophotometer (UV-2550 of Shimadzu Corporation) at room temperature. A tangent line is drawn on the obtained ultraviolet light absorption curve to ensure that the transmittance (T%) of the ultraviolet light absorption curve passes a point of 50 % so as to obtain an absorption wavelength at which the transmittance (T%) of the tangent line becomes 0 as the absorption end (absorption end of the ultraviolet light spectrum) and used as an index of initial coloration. For example, in an optical article such as a spectacle lens, as this value becomes smaller, the initial coloration becomes weaker and the transparency under no exposure becomes higher.

[6] Thermochromism $\{T_0\}$: The photochromic plastic lens obtained under the above conditions is used as a sample and its transmittance (T%) at 300 to 800 nm is measured with an ultraviolet visible spectrophotometer (UV-2550 of Shimadzu Corporation) at room temperature. This is a transmittance at a wavelength at which the transmittance at 430 to 650 nm becomes minimal and used as an index of initial coloration. As this value becomes larger, the initial coloration becomes weaker and the transparency under no exposure becomes higher.

[7] Residual rate $(A_{50}/A_0 \times 100)$: The deterioration promotion test of the obtained photochromic plastic lens is carried out by using the X25 xenon weather meter of Suga Test Instruments Co., Ltd. for 50 hours. Thereafter, the above

color optical density is evaluated before and after the test by measuring the color optical density (A_0) before the test and the color optical density (A_{50}) after the test to obtain the ratio (A_{50}/A_0) of these values as residual rate which is
5 used as an index of color development durability. As the residual rate becomes higher, the color development durability becomes higher.

[8] color development sensitivity [$\epsilon(10)/\epsilon(120)$]: The photochromic plastic lens obtained under the above
10 conditions is used as a sample, and the ratio of color optical density $\{\epsilon(120)\}$ after 120 seconds of exposure to color optical density $\{\epsilon(10)\}$ after 10 seconds of exposure is calculated and used as an index of color development sensitivity. As this value becomes larger, the photochromic
15 plastic lens develops a dark color with a shorter time of exposure.

Photochromic plastic lenses were obtained and their photochromic properties were evaluated in the same manner as described above except that the chromene compounds
20 obtained in Examples 2 to 15 were used. The results are shown in Table 3. In Table 3, compound Nos. 1 to 15 are chromene compounds obtained in Examples Nos. 1 to 15, respectively. For example, the chromene compound obtained in Example 1 is expressed as Compound No. 1.

Table 3

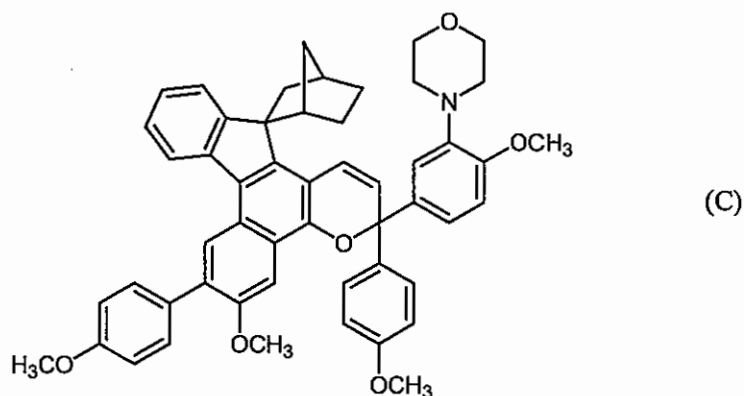
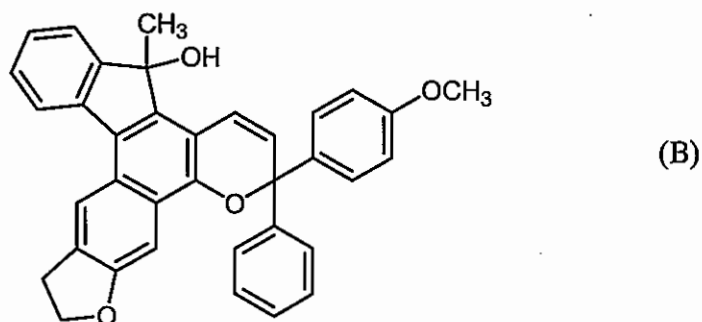
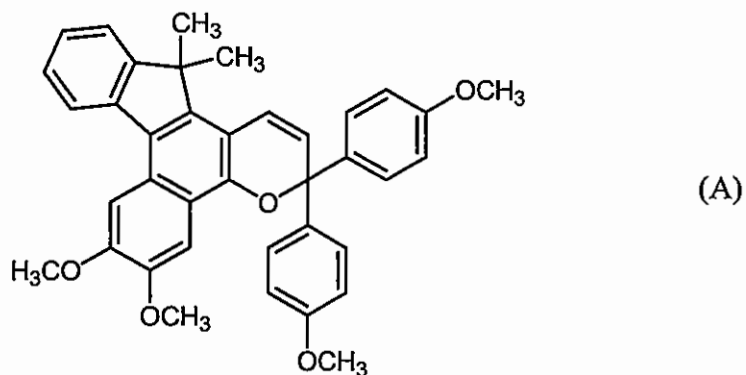
Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermochromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
16	1	457	0.60	1.21	65	405	89	92	0.27
		575	0.50		65		90	92	
17	2	459	0.65	1.30	66	413	88	91	0.32
		573	0.50		66		89	91	
18	3	473	0.74	1.45	67	414	87	87	0.32
		573	0.51		67		88	87	
19	4	477	0.89	1.75	75	418	85	85	0.35
		578	0.51		75		87	85	
20	5	443	0.68	1.00	50	411	90	91	0.31
		580	0.68		51		90	91	
21	6	453	0.51	1.03	55	403	90	90	0.26
		576	0.50		56		90	90	
22	7	455	0.56	1.10	56	412	90	91	0.30
		574	0.51		57		90	91	
23	8	458	0.53	1.03	57	408	90	90	0.28
		579	0.51		57		90	90	
24	9	460	0.66	1.30	66	408	89	92	0.29
		577	0.51		66		89	92	
25	10	453	0.72	1.20	120	405	82	82	0.25
		576	0.60		120		82	82	

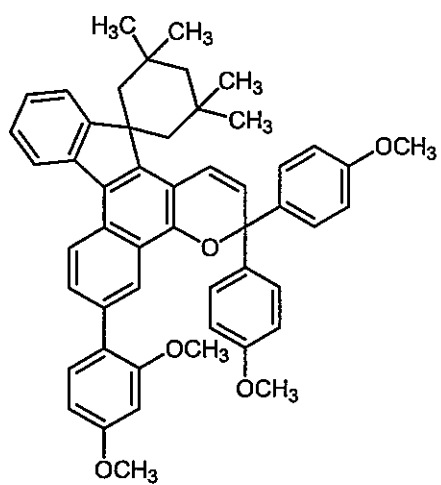
Table 3 (continued)

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermochromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
26	11	455	0.50	1.18	70	405	84	80	0.28
		576	0.42		70		84	80	
27	12	460	0.59	1.39	68	406	86	89	0.28
		565	0.42		68		87	88	
28	13	457	0.60	1.00	76	403	87	85	0.26
		575	0.60		76		88	85	
29	14	460	0.54	1.00	67	420	80	81	0.36
		573	0.54		67		80	81	
30	15	473	0.47	1.00	60	405	88	80	0.27
		578	0.47		60		89	80	

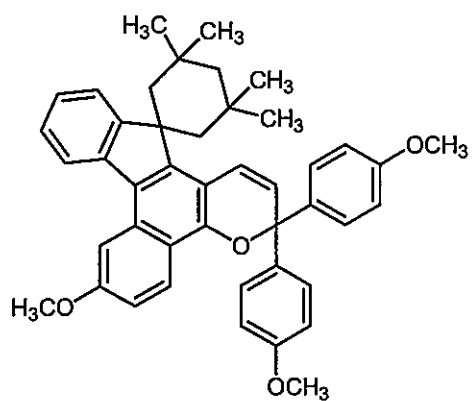
Comparative Examples 1 to 6

For comparison, photochromic plastic lenses were obtained and their characteristic properties were evaluated in the same manner as in Example 16 except that compounds represented by the following formulas (A) to (F) were used. The results are shown in Table 4.

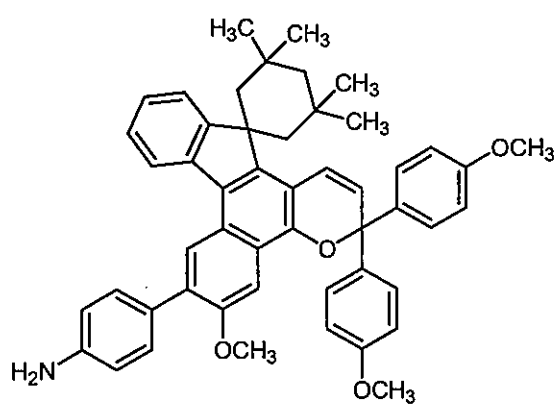




(D)



(E)



(F)

Table 4

Comparative Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak character- istic	Fading half period	initial coloration (absorption end)	Initial coloration (thermo- chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\epsilon(10)/\epsilon(120)$
1	A	457	0.69	1.56	195	397	67	76	0.20
		574	0.45		196		75	77	
2	B	455	0.30	0.94	83	410	77	35	0.28
		576	0.32		83		78	35	
3	C	458	0.44	1.20	68	422	84	85	0.36
		568	0.37		68		86	84	
4	D	433	0.50	0.80	40	415	90	87	0.33
		582	0.63		40		90	87	
5	E	456	0.39	0.70	92	385	89	89	0.20
		575	0.55		93		89	89	
6	F	463	0.52	1.30	78	428	83	80	0.36
		580	0.40		78		84	80	

It is understood that Examples 16 to 30 (compounds 1 to 15) which were obtained from the chromene compounds of the present invention exhibit high color optical density, high fading speed, little initial coloration, high repeat durability and high color development sensitivity as well as high double peak characteristic.

The chromene compound of the present invention having high double peak characteristic (A_Y/A_B) is preferred because a blue compound having excellent durability can be used for delicate color control. For example, A_Y/A_B is preferably not less than 1.00, more preferably not less than 1.10, much more preferably not less than 1.20, particularly preferably not less than 1.30.

The fading half period $\tau_{1/2}$ is preferably 50 or more to less than 130 seconds, more preferably 50 or more to less than 100 seconds, particularly preferably 50 or more to less than 80 seconds.

The transmittance by thermochromism is preferably not less than 80 %, more preferably not less than 83 %, particularly preferably not less than 85 %.

The absorption end is existent at preferably 400 to 420 nm, more preferably 405 to 420 nm, particularly preferably 405 to 415 nm from the viewpoints of initial coloration and color development sensitivity.

Although Comparative Example 1 (compound A) has high double peak characteristic, it has very low fading speed, low repeat durability and low color development sensitivity. In contrast to this, it is understood that Example 27 (compound 10) of the present invention has high fading speed and high repeat durability while retaining double peak characteristic.

Comparative Example 2 (compound B) has low double peak characteristic and also low repeat durability. In contrast to this, it is understood that Example 26 (compound 11) of

the present invention has high double characteristic and high repeat durability.

Although Comparative Example 3 (compound C) has high double peak characteristic and excellent repeat durability,
5 it has a problem such as large initial coloration due to the absorption end (it is colored yellow as its absorption end is existent at a visible range). In contrast to this, it is seen that Example 27 (compound 12) of the present invention has little initial coloration while retaining double peak
10 characteristic and repeat durability.

Comparative Example 4 (compound D) has an aryl group at the 6-position but no substituent having a Hammett constant σ_p of not more than -0.1 at the 7-position. In this case, high double peak characteristic cannot be obtained.

15 Although Comparative Example 5 (compound E) has a substituent with a Hammett constant σ_p of not more than -0.1 at the 7-position, it does not have an aryl group or a heteroaryl group at the 6-position. In this case, high double peak characteristic cannot be obtained.

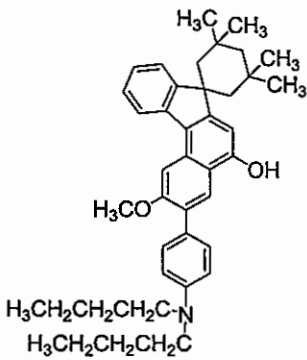
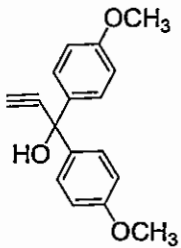
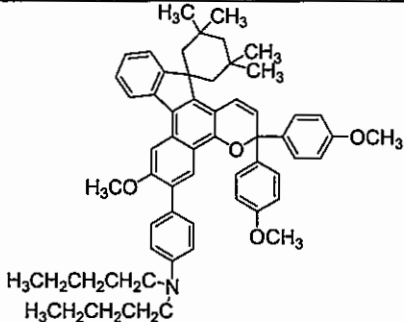
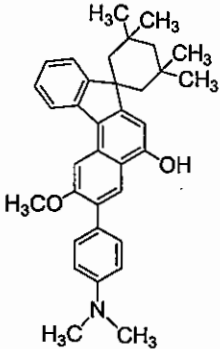
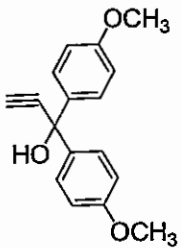
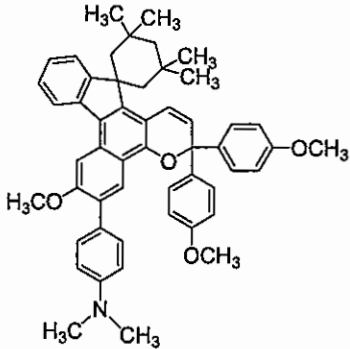
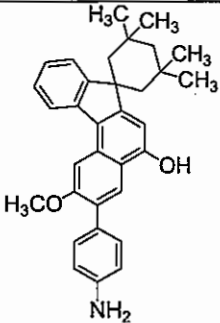
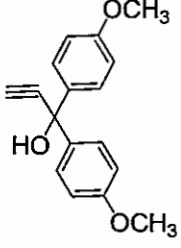
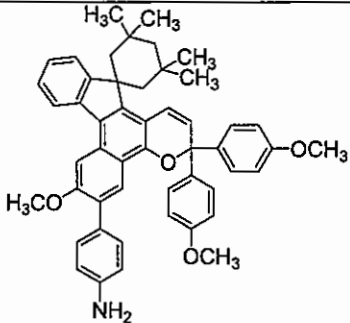
20 Although Comparative Example 6 (Compound F) has high double peak characteristic and excellent repeat durability, it has a problem such as large initial coloration due to the absorption end (it is colored yellow as its absorption end is existent at a visible range). In contrast to this, it
25 is seen that Example 92 (compound 33) of the present invention which will be described hereinafter has little initial coloration due to the absorption end while retaining double peak characteristic and repeat durability.

30 Examples 31 to 89

Chromene compounds shown in Table 5 were synthesized in the same manner as in Example 1. When the structures of the obtained chromene compounds were analyzed in the same manner as in Example 1, it was confirmed that they were

compounds represented by the structural formulas shown in Table 5. Table 6 shows the elemental analysis values and ^1H -NMR spectral values of the chromene compounds obtained in Examples. In Table 6, compound Nos. 31 to 89 are chromene compounds obtained in Examples 31 to 89, respectively.

Table 5

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
31	 H_3C CH_3 CH_3 CH_3 OH H_3CO $\text{H}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{C}-\text{N}$ $\text{H}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{C}$	 OCH_3 HO OCH_3	 H_3C CH_3 CH_3 CH_3 OCH_3 H_3CO $\text{H}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{C}-\text{N}$ $\text{H}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{C}$	67
32	 H_3C CH_3 CH_3 CH_3 OH H_3CO $\text{H}_3\text{C}-\text{N}-\text{CH}_3$	 OCH_3 HO OCH_3	 H_3C CH_3 CH_3 CH_3 OCH_3 H_3CO $\text{H}_3\text{C}-\text{N}-\text{CH}_3$	67
33	 H_3C CH_3 CH_3 CH_3 OH H_3CO NH_2	 OCH_3 HO OCH_3	 H_3C CH_3 CH_3 CH_3 OCH_3 H_3CO NH_2	55

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
34				56
35				72
36				67
37				66

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
38				64
39				63
40				67
41				65

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
42				69
43				67
44				60
45				63

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
46				62
47				54
48				65
49				54

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
50				65
51				66
52				67
53				62

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
54				66
55				66
56				65
57				64

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
58				70
59				69
60				66

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
61				66
62				65
63				67

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
64				70
65				60
66				63

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
67				64
68				52
69				71

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
70				69
71				68
72				69

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
73				66
74				67
75				70

Table 5 (continued)

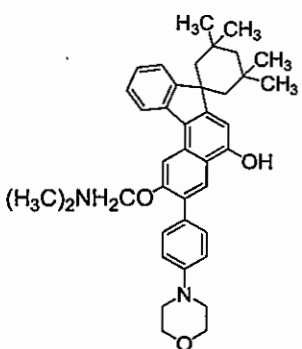
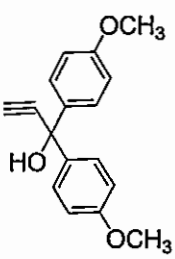
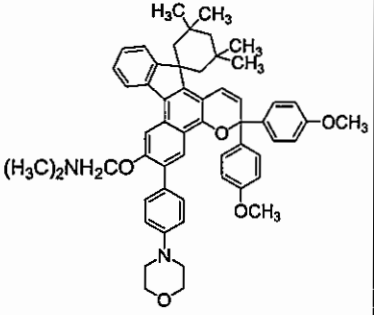
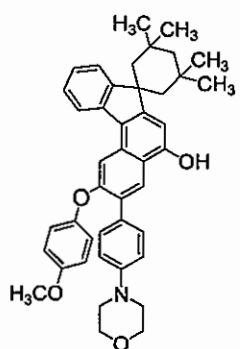
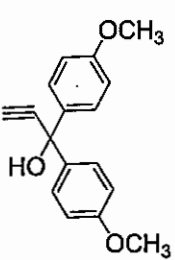
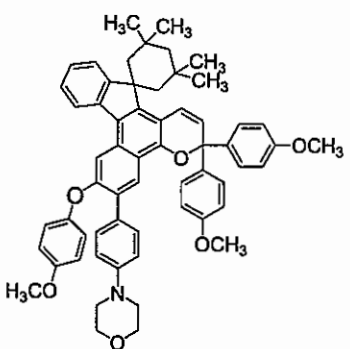
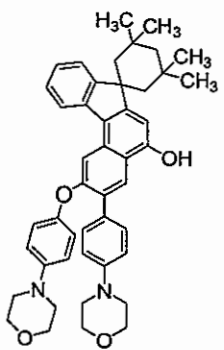
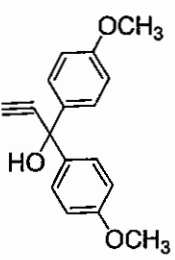
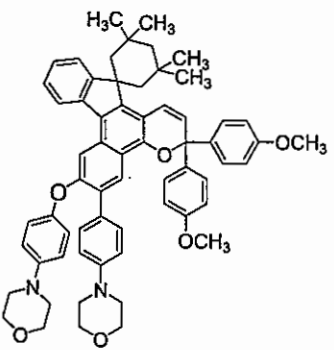
Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
76				67
77				66
78				67

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
79				71
80				70
81				67
82				70

Table 5 (continued)

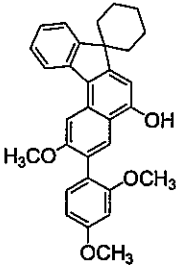
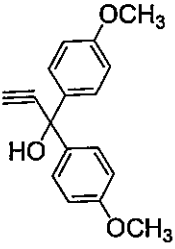
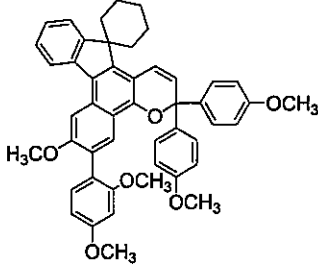
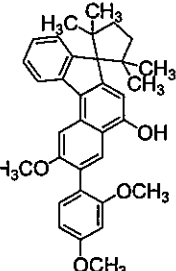
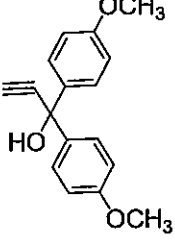
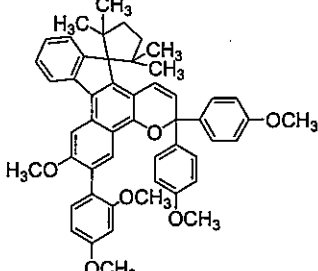
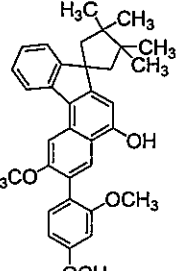
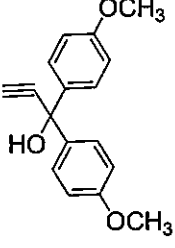
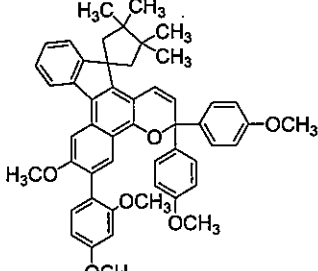
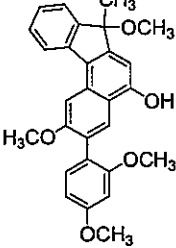
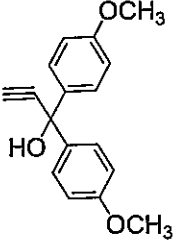
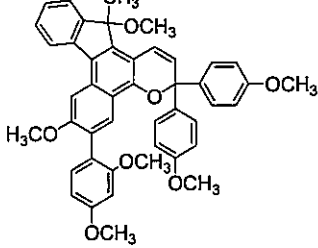
Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
83				68
84				69
85				70
86				72

Table 5 (continued)

Example No.	Raw materials		Product	Yield rate (%)
	Naphthol derivative	Propargyl alcohol derivative		
87				73
88				73
89				72

Table 6

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
31	82.99	7.77	1.61	7.63	82.92	7.80	1.67	7.62	δ5.0-9.0 20H δ0.5-4.5 45H
32	82.68	7.09	1.81	8.42	82.62	7.07	1.85	8.47	δ5.0-9.0 20H δ0.5-4.5 33H
33	82.41	6.77	1.90	8.92	82.50	6.78	1.92	8.79	δ5.0-9.0 20H δ0.5-4.5 29H
34	82.33	6.66	0.00	11.01	82.39	6.64	0.00	10.97	δ5.0-9.0 20H δ0.5-4.5 28H
35	82.55	6.77	0.00	10.68	82.45	6.78	0.00	10.77	δ5.0-9.0 20H δ0.5-4.5 30H
36	84.32	6.93	0.00	8.75	84.26	6.93	0.00	8.80	δ5.0-9.0 20H δ0.5-4.5 30H
37	82.11	6.49	0.00	—	82.16	6.48	0.00	8.76	δ5.0-9.0 20H δ0.5-4.5 27H
38	82.22	6.69	1.99	9.10	82.14	6.75	2.00	9.12	δ5.0-9.0 19H δ0.5-4.5 28H
39	80.11	6.55	0.00	—	80.19	6.45	0.00	8.90	δ5.0-9.0 19H δ0.5-4.5 27H
40	81.44	7.29	1.72	9.55	81.42	7.20	1.70	9.68	δ5.0-9.0 19H δ0.5-4.5 40H

Table 6 (continued)

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
41	81.50	7.33	1.62	9.55	81.49	7.32	1.67	9.52	δ5.0-9.0 19H δ0.5-4.5 42H
42	81.44	7.31	1.67	9.58	81.42	7.20	1.70	9.68	δ5.0-9.0 19H δ0.5-4.5 40H
43	82.31	6.72	1.66	9.31	82.39	6.68	1.63	9.30	δ5.0-9.0 23H δ0.5-4.5 34H
44	77.12	6.12	1.78	—	77.15	6.22	1.76	10.08	δ5.0-9.0 19H δ0.5-4.5 30H
45	71.31	5.46	1.55	—	71.21	5.52	1.57	8.95	δ5.0-9.0 19H δ0.5-4.5 30H
46	71.57	5.80	1.55	—	71.65	5.79	1.52	8.68	δ5.0-9.0 19H δ0.5-4.5 34H
47	80.77	6.58	0.00	12.65	80.71	6.64	0.00	12.65	δ5.0-9.0 19H δ0.5-4.5 31H
48	81.43	7.12	0.00	11.45	81.40	7.19	0.00	11.41	δ5.0-9.0 19H δ0.5-4.5 41H
49	81.34	7.09	0.00	11.57	81.32	7.07	0.00	11.61	δ5.0-9.0 19H δ0.5-4.5 39H
50	81.29	6.91	0.00	11.80	81.25	6.94	0.00	11.81	δ5.0-9.0 19H δ0.5-4.5 37H

Table 6 (continued)

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
51	81.99	7.23	0.00	10.78	82.03	7.22	0.00	10.75	δ5.0-9.0 19H δ0.5-4.5 45H
52	82.02	7.25	0.00	10.73	82.03	7.22	0.00	10.75	δ5.0-9.0 19H δ0.5-4.5 45H
53	81.59	7.02	0.00	11.39	81.66	7.09	0.00	11.25	δ5.0-9.0 19H δ0.5-4.5 41H
54	79.33	6.69	0.00	13.98	79.27	6.78	0.00	13.95	δ5.0-9.0 19H δ0.5-4.5 35H
55	79.52	7.05	1.70	11.73	79.48	7.04	1.72	11.76	δ5.0-9.0 19H δ0.5-4.5 38H
56	80.55	6.51	0.00	12.94	80.53	6.52	0.00	12.95	δ5.0-9.0 23H δ0.5-4.5 33H
57	79.59	6.66	1.50	12.25	79.62	6.68	1.52	12.17	δ5.0-9.0 23H δ0.5-4.5 38H
58	82.99	7.39	0.00	9.62	82.97	7.33	0.00	9.70	δ5.0-9.0 19H δ0.5-4.5 41H
59	81.43	7.24	3.44	7.89	81.45	7.21	3.45	7.89	δ5.0-9.0 20H δ0.5-4.5 38H
60	81.88	7.34	3.23	7.55	81.85	7.34	3.29	7.52	δ5.0-9.0 20H δ0.5-4.5 42H

Table 6 (continued)

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
61	81.90	7.41	3.23	7.46	81.91	7.46	3.24	7.40	δ5.0-9.0 20H δ0.5-4.5 44H
62	81.82	7.38	3.33	7.47	81.85	7.34	3.29	7.52	δ5.0-9.0 20H δ0.5-4.5 42H
63	82.69	6.88	3.21	7.22	82.77	6.83	3.16	7.23	δ5.0-9.0 24H δ0.5-4.5 36H
64	80.32	7.00	3.30	9.38	80.25	7.09	3.28	9.38	δ5.0-9.0 20H δ0.5-4.5 40H
65	77.73	6.45	3.38	—	77.73	6.40	3.42	7.81	δ5.0-9.0 20H δ0.5-4.5 32H
66	71.90	5.69	3.04	—	71.88	5.70	3.05	6.96	δ5.0-9.0 20H δ0.5-4.5 32H
67	72.30	5.99	2.87	—	72.29	5.96	2.96	6.76	δ5.0-9.0 20H δ0.5-4.5 36H
68	81.22	6.84	1.81	10.13	81.20	6.81	1.79	10.20	δ5.0-9.0 20H δ0.5-4.5 33H
69	81.89	7.32	1.61	9.18	81.82	7.33	1.62	9.24	δ5.0-9.0 20H δ0.5-4.5 43H
70	81.71	7.23	1.65	9.41	81.75	7.22	1.64	9.39	δ5.0-9.0 20H δ0.5-4.5 41H

Table 6 (continued)

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
71	81.67	7.12	1.66	9.55	81.69	7.10	1.67	9.55	δ5.0-9.0 20H δ0.5-4.5 39H
72	82.44	7.38	1.55	8.63	82.41	7.35	1.53	8.71	δ5.0-9.0 20H δ0.5-4.5 47H
73	82.44	7.41	1.52	8.63	82.41	7.35	1.53	8.71	δ5.0-9.0 20H δ0.5-4.5 47H
74	82.00	7.26	1.62	9.12	82.06	7.23	1.60	9.11	δ5.0-9.0 20H δ0.5-4.5 43H
75	79.76	6.97	1.66	11.61	79.78	6.94	1.69	11.59	δ5.0-9.0 20H δ0.5-4.5 37H
76	79.99	7.11	3.41	9.49	79.97	7.19	3.33	9.51	δ5.0-9.0 20H δ0.5-4.5 40H
77	80.99	6.66	1.54	10.81	80.96	6.68	1.57	10.78	δ5.0-9.0 24H δ0.5-4.5 35H
78	80.05	6.78	2.89	10.28	80.06	6.82	2.96	10.16	δ5.0-9.0 24H δ0.5-4.5 40H
79	83.34	7.45	1.66	7.55	83.36	7.47	1.65	7.53	δ5.0-9.0 20H δ0.5-4.5 43H
80	83.00	7.04	1.77	8.19	82.94	7.09	1.79	8.18	δ5.0-9.0 20H δ0.5-4.5 35H

Table 6 (continued)

Example No.	Elemental analysis values								¹ H-NMR (NMR)
	Experimental values				Calculated values				
	C	H	N	O	C	H	N	O	
81	80.77	6.67	0.00	12.56	80.71	6.64	0.00	12.65	δ5.0-9.0 19H δ0.5-4.5 31H
82	80.65	6.39	0.00	12.96	80.62	6.49	0.00	12.89	δ5.0-9.0 19H δ0.5-4.5 29H
83	80.44	6.21	0.00	13.35	80.42	6.19	0.00	13.39	δ5.0-9.0 19H δ0.5-4.5 25H
84	80.74	6.66	0.00	12.60	80.71	6.64	0.00	12.65	δ5.0-9.0 19H δ0.5-4.5 31H
85	80.67	6.68	0.00	12.65	80.71	6.64	0.00	12.65	δ5.0-9.0 19H δ0.5-4.5 31H
86	78.00	5.87	0.00	16.13	78.01	5.82	0.00	16.17	δ5.0-9.0 19H δ0.5-4.5 21H
87	82.54	6.97	0.00	10.49	82.51	6.92	0.00	10.57	δ5.0-9.0 19H δ0.5-4.5 33H
88	81.11	7.32	0.00	11.57	81.13	7.29	0.00	11.58	δ5.0-9.0 19H δ0.5-4.5 41H
89	81.24	7.54	0.00	11.22	81.27	7.53	0.00	11.20	δ5.0-9.0 19H δ0.5-4.5 45H

Examples 90 to 148

Photochromic plastic lenses were manufactured and their characteristic properties were evaluated in the same manner as in Example 16 except that the compounds obtained
5 in Examples 31 to 89 were used as chromene compounds. The results are shown in Table 7. In Table 7, compound Nos. 31 to 89 are chromene compounds obtained in Examples 31 to 89, respectively.

Table 7

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermo-chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
90	31	470	0.68	1.36	71	409	87	90	0.29
		582	0.50		71		88	90	
91	32	465	0.69	1.35	67	408	87	92	0.28
		581	0.51		67		88	92	
92	33	463	0.67	1.34	78	411	85	80	0.30
		580	0.50		78		86	80	
93	34	458	0.64	1.25	76	409	89	82	0.29
		576	0.51		76		89	82	
94	35	456	0.60	1.20	65	404	90	92	0.27
		574	0.50		65		90	92	
95	36	455	0.58	1.16	60	404	90	92	0.26
		573	0.50		60		90	92	
96	37	452	0.49	0.96	51	403	90	90	0.26
		570	0.51		51		90	90	
97	38	470	0.50	1.00	58	406	89	81	0.27
		580	0.50		58		89	81	
98	39	471	0.48	1.00	59	405	89	80	0.27
		578	0.48		59		89	80	
99	40	477	0.88	1.76	75	418	84	84	0.35
		578	0.50		75		86	84	

Table 7 (continued)

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermo-chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\epsilon(10)/\epsilon(120)$
100	41	470	0.70	1.37	73	418	85	85	0.34
		574	0.51		73		86	85	
101	42	469	0.67	1.34	70	417	87	85	0.34
		575	0.50		70		88	85	
102	43	467	0.64	1.31	68	418	87	85	0.35
		575	0.49		68		88	85	
103	44	460	0.67	1.31	67	409	88	85	0.29
		574	0.50		68		89	85	
104	45	459	0.63	1.24	66	406	89	88	0.28
		574	0.51		66		89	88	
105	46	463	0.72	1.41	69	412	88	91	0.30
		574	0.51		69		88	91	
106	47	465	0.68	1.33	96	415	82	79	0.30
		574	0.51		96		83	80	
107	48	459	0.59	1.22	65	408	89	86	0.28
		573	0.48		65		89	86	
108	49	459	0.60	1.28	69	409	89	86	0.29
		573	0.47		69		89	86	
109	50	459	0.59	1.23	68	408	89	86	0.29
		573	0.48		68		89	86	

Table 7 (continued)

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermo-chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
110	51	468	0.71	1.45	74	412	89	89	0.30
		575	0.49		74		90	89	
111	52	463	0.65	1.30	72	409	89	87	0.28
		575	0.50		72		90	87	
112	53	459	0.62	1.24	68	409	88	86	0.29
		573	0.50		68		89	86	
113	54	455	0.54	1.02	64	408	90	91	0.29
		573	0.53		64		90	91	
114	55	463	0.69	1.41	67	412	88	88	0.30
		575	0.49		67		89	88	
115	56	458	0.67	1.34	66	414	89	90	0.32
		575	0.47		66		89	90	
116	57	460	0.68	1.39	66	414	88	88	0.32
		575	0.49		66		89	88	
117	58	445	0.69	1.03	50	412	90	88	0.32
		579	0.67		51		90	88	
118	59	480	0.98	1.88	75	421	83	81	0.37
		573	0.51		75		85	81	
119	60	474	0.96	1.88	74	421	84	88	0.36
		577	0.51		74		86	88	

Table 7 (continued)

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermo-chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
120	61	473	0.77	1.54	75	421	85	85	0.36
		571	0.50		75		86	85	
121	62	472	0.74	1.45	72	420	87	85	0.36
		574	0.51		72		88	85	
122	63	470	0.70	1.40	71	420	87	85	0.36
		574	0.50		71		88	85	
123	64	475	0.81	1.59	67	417	87	87	0.35
		575	0.51		67		88	87	
124	65	463	0.73	1.43	68	412	87	85	0.31
		574	0.51		68		88	85	
125	66	462	0.69	1.35	67	409	87	88	0.30
		573	0.51		67		88	88	
126	67	466	0.79	1.55	70	415	86	90	0.32
		574	0.51		70		87	90	
127	68	468	0.77	1.51	100	418	80	79	0.33
		573	0.51		102		82	79	
128	69	462	0.65	1.33	69	411	89	85	0.31
		575	0.49		69		89	85	
129	70	462	0.66	1.35	70	411	89	85	0.30
		575	0.49		70		89	85	

Table 7 (continued)

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermo-chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
130	71	462	0.65	1.33	69	411	89	85	0.30
		575	0.49		69		89	85	
131	72	470	0.78	1.56	75	415	89	89	0.33
		573	0.50		75		90	89	
132	73	465	0.72	1.41	72	412	89	87	0.32
		575	0.51		72		90	87	
133	74	462	0.68	1.36	71	412	88	86	0.31
		575	0.50		71		89	87	
134	75	458	0.59	1.09	67	411	90	91	0.31
		575	0.54		68		90	91	
135	76	466	0.76	1.52	70	415	86	87	0.32
		575	0.50		70		87	87	
136	77	461	0.70	1.39	67	417	88	90	0.35
		573	0.50		67		89	90	
137	78	463	0.71	1.42	68	417	88	88	0.35
		572	0.50		68		89	88	
138	79	448	0.76	1.15	52	415	90	88	0.33
		578	0.66		52		90	88	
139	80	447	0.77	1.12	54	414	89	89	0.33
		580	0.69		54		90	89	

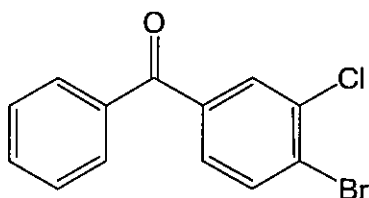
Table 7 (continued)

Example No.	Compound No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermo-chromism)	Residual rate	Color development sensitivity
		(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
140	81	457	0.75	1.20	105	405	87	90	0.25
		575	0.62		105		88	90	
141	82	457	0.82	1.22	108	405	87	90	0.25
		575	0.67		108		88	90	
142	83	457	0.83	1.22	151	405	85	90	0.22
		575	0.68		151		86	90	
143	84	457	0.55	1.20	66	404	89	87	0.26
		576	0.46		66		90	87	
144	85	456	0.54	1.20	67	404	89	87	0.27
		577	0.45		67		90	87	
145	86	456	0.50	1.18	71	405	84	82	0.27
		575	0.42		71		85	82	
146	87	449	0.75	1.25	105	405	88	85	0.25
		577	0.60		105		88	85	
147	88	457	0.59	1.20	67	405	89	91	0.27
		575	0.49		67		90	91	
148	89	457	0.58	1.21	68	405	89	91	0.27
		575	0.48		68		90	91	

Examples of the naphthol compound are given below.

Example 149

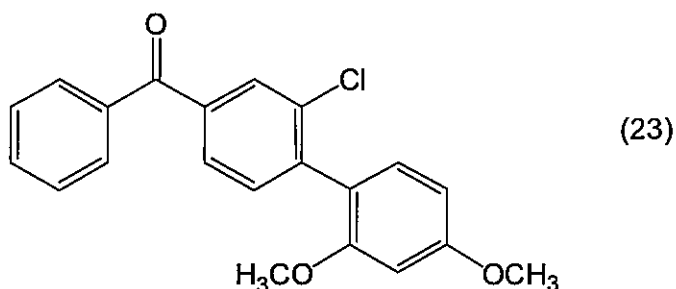
90.0 g (381.8 mmol) of a benzene compound represented by the above formula (8) was dissolved in 450 ml of
5 dichloromethane and cooled to 0°C. 148.8 g (1145.4 mmol) of oxalyl chloride and 4 ml of N,N-dimethylformamide were added dropwise to this solution. After the addition, the resulting mixture was heated to 25°C and stirred for 2 hours. After the reaction, the solvent and an excess of oxalyl
10 chloride were distilled off under reduced pressure. The obtained residue was dissolved in 450 ml of tetrahydrofuran and cooled to -50°C. 172 ml (343.6 mmol) of phenyl magnesium bromide (2.0 M diethyl ether solution) was added dropwise to this solution. After the addition, the resulting mixture
15 was heated to 25°C and stirred for 4 hours. After the reaction, 200 ml of toluene was added, the reaction product was washed in water, the solvent was removed, and the obtained product was purified by reslurrying with methanol to obtain a benzophenone derivative represented by the following
20 formula (22) as 73.3 g (248.1 mmol, yield rate of 65 %) of a white solid.



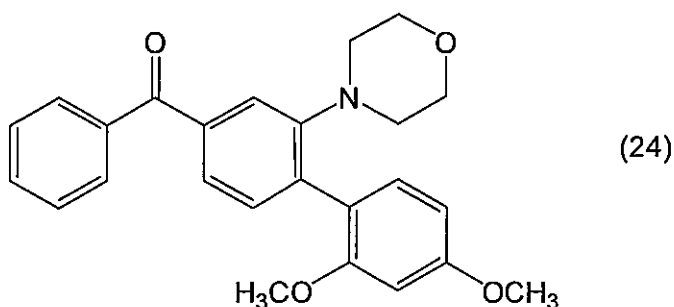
(22)

The benzophenone derivative of the above formula (22) and 67.7 g (372.1 mmol) of 2,4-dimethoxyphenylboronic acid
25 were dissolved in 370 ml of 1,2-dimethoxyethane, and 37 ml of ethanol and 790 ml of a 10 % sodium carbonate aqueous solution were added to this solution. The obtained solution was deaerated in a nitrogen gas stream, 0.287 g (0.248 mmol) of tetrakis(triphenylphosphine)palladium was added and
30 refluxed for 3 hours. After the reaction, 400 ml of toluene

was added, the reaction product was washed in water, the solvent was removed, and the obtained product was purified by reslurrying with methanol to obtain a compound represented by the following formula (23) as 91.9 g (243.1 mmol, yield rate of 98 %) of a white solid.

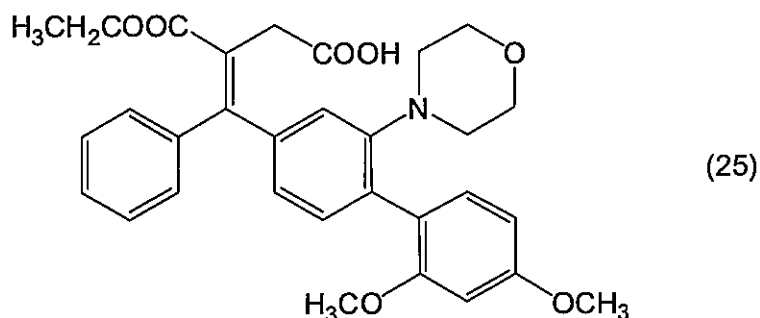


The compound of the above formula (23), 93.4 g (972.4 mmol) of sodium-*t*-butoxide, 5.5 g (24.3 mmol) of palladium acetate, 14.7 g (72.9 mmol) of tri-*t*-butyl phosphine and 63.6 g (729.3 mmol) of morpholine were dissolved in 920 ml of toluene and refluxed for 3 hours. After the reaction, the reaction product was washed in water, the solvent was removed, and the obtained product was purified by reslurrying with methanol to obtain a compound represented by the following formula (24) as 60.8 g (150.7 mmol, yield rate of 62 %) of a white solid.

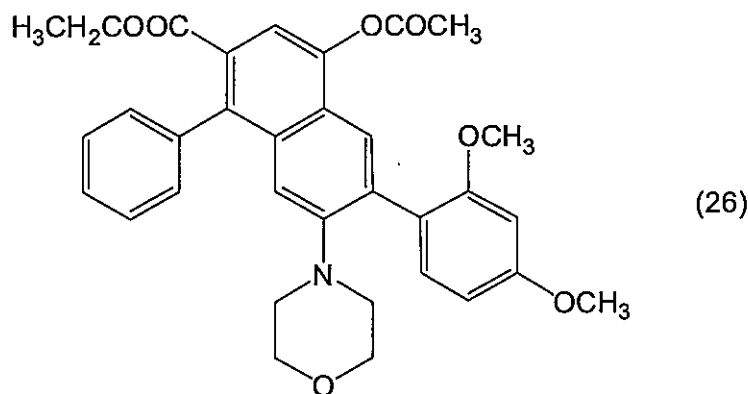


The compound of the above formula (24) and 30.2 g (173.3 mmol) of diethyl succinate were dissolved in 200 ml of tetrahydrofuran and heated to 55°C. A tetrahydrofuran solution (425 ml) of 19.4 g (173.3 mmol) of potassium-*t*-butoxide was added dropwise to this solution and stirred for 1 hour. After the reaction, 200 ml of toluene was added, the reaction product was washed with concentrated

hydrochloride acid and then with water, and the solvent was removed to obtain a compound represented by the following formula (25) as 80.1 g (150.7 mmol, yield rate of 100 %) of orange oil.



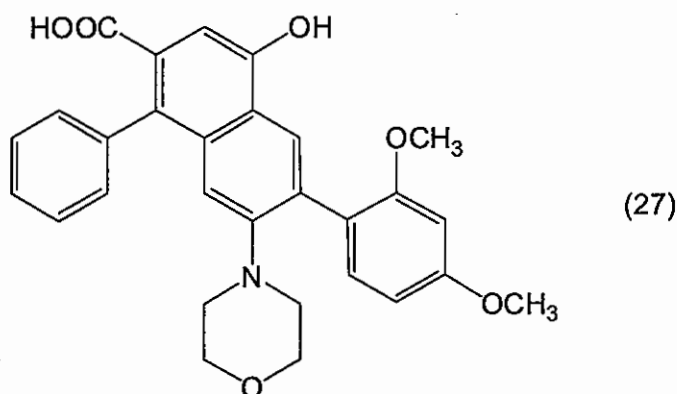
5 The compound of the above formula (25), 12.4 g (150.7 mmol) of sodium acetate and 76.9 g (75f0.4 mmol) of acetic anhydride were dissolved in 200 ml of toluene and refluxed for 3 hours. After the reaction, the reaction product was washed in water, the solvent was removed, and the obtained product was purified by recrystallization with ethyl acetate and acetonitrile to obtain a compound represented by the following formula (26) as 18.4 g (33.2 mmol, yield rate of 22 %) of an orange solid.



15 The compound of the above formula (26) was dispersed into 75 ml of methanol. 80 ml of an aqueous solution of 8.0 g (199.2 mmol) of sodium hydroxide was added to this solution and refluxed for 3 hours. After the reaction, the reaction product was washed with concentrated hydrochloric acid and then with water, the solvent was removed, and the obtained

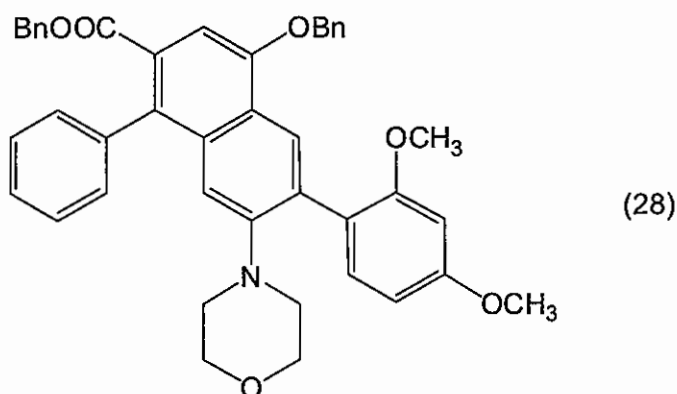
20

product was purified by reslurrying with toluene to obtain a carboxylic acid derivative represented by the following formula (27) as 15.1 g (31.2 mmol, yield rate of 94 %) of a yellow solid.



5

The carboxylic acid derivative of the above formula (27) and 8.7 g (68.6 mmol) of benzyl chloride were dissolved in 150 ml of N,N-dimethylformamide. 10.8 g (78.0 mmol) of potassium carbonate was added to this solution, heated to 60°C and stirred for 3 hours. After the reaction, 200 ml of toluene was added, the reaction product was washed in water, and the solvent was removed to obtain a compound represented by the following formula (28) as 20.3 g (30.6 mmol, yield rate of 98 %) of a yellow solid.

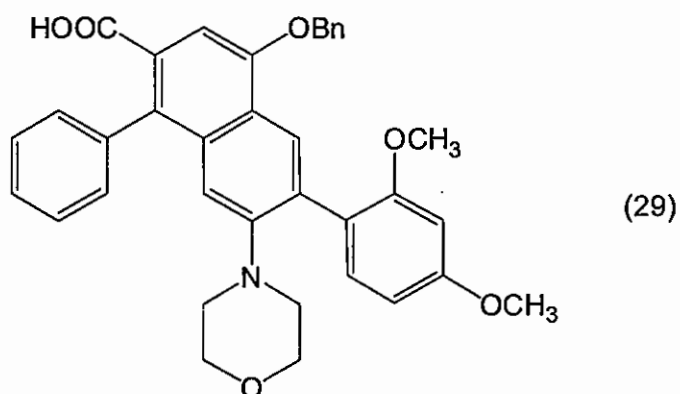


15

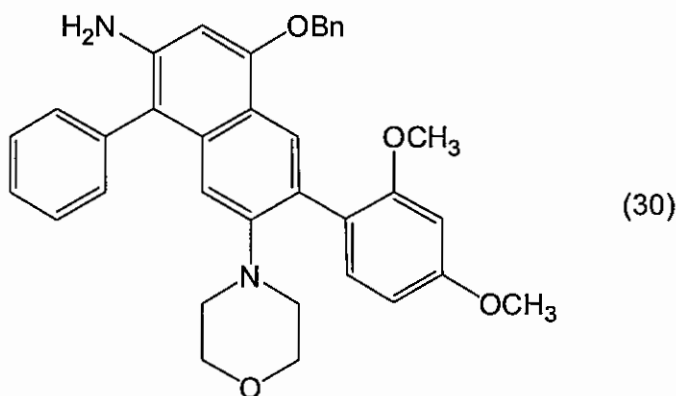
The compound of the above formula (28) was dispersed into 200 ml of isopropyl alcohol. 184 ml of an aqueous solution of 36.7 g (918.0 mmol) of sodium hydroxide was added to this solution and refluxed for 3 hours. After the reaction, 300 ml of ethyl acetate was added, the reaction product was

20

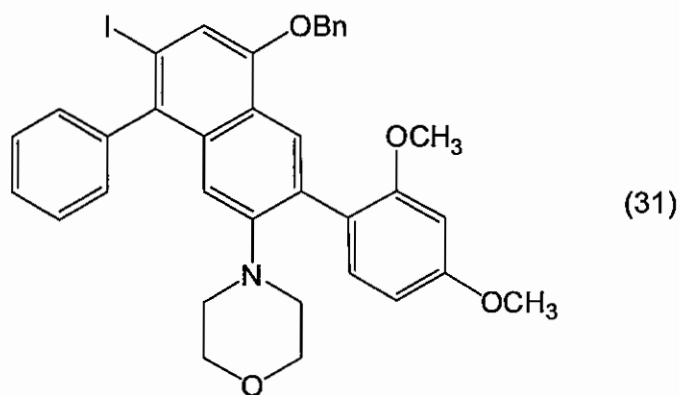
washed with concentrated hydrochloric acid and then with water, the solvent was removed, and the obtained product was purified by reslurrying with toluene to obtain a carboxylic acid derivative represented by the following formula (29) as 17.2 g (30.0 mmol, yield rate of 98 %) of a yellow solid.



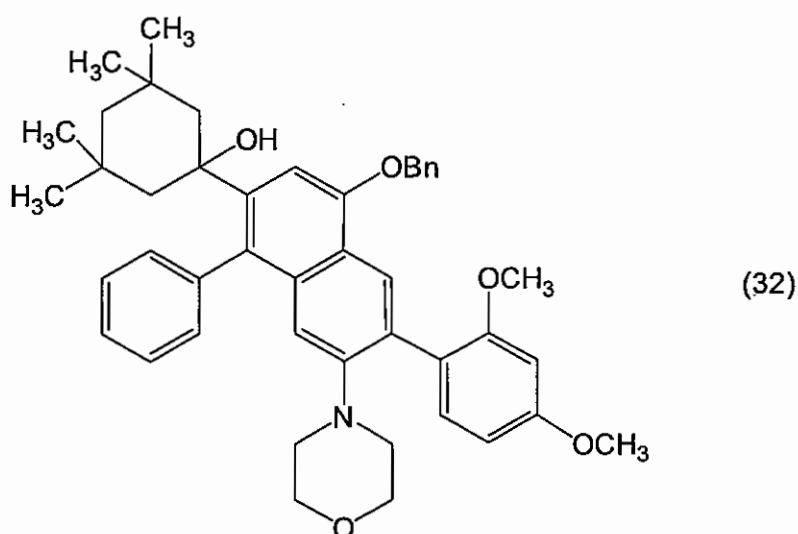
The compound of the above formula (29) was dispersed into 180 ml of toluene. 9.1 g (90.0 mmol) of triethylamine and 10.7 g (39.0 mmol) of diphenylphosphoryl azide were added to this solution and stirred at room temperature for 2 hours. 6.9 g (150.0 mmol) of ethanol was added to this solution to carry out a reaction at 70°C for 2 hours. 86 ml of ethanol was added to this solution, and then 16.8 g (300.0 mmol) of potassium hydroxide was added and refluxed for 3 hours. After the reaction, ethanol was distilled off at normal pressure, tetrahydrofuran was added, the reaction solution was washed in water, and the solvent was removed to obtain a compound represented by the following formula (30) as 14.4 g (26.4 mmol, yield rate of 88 %) of a yellow solid.



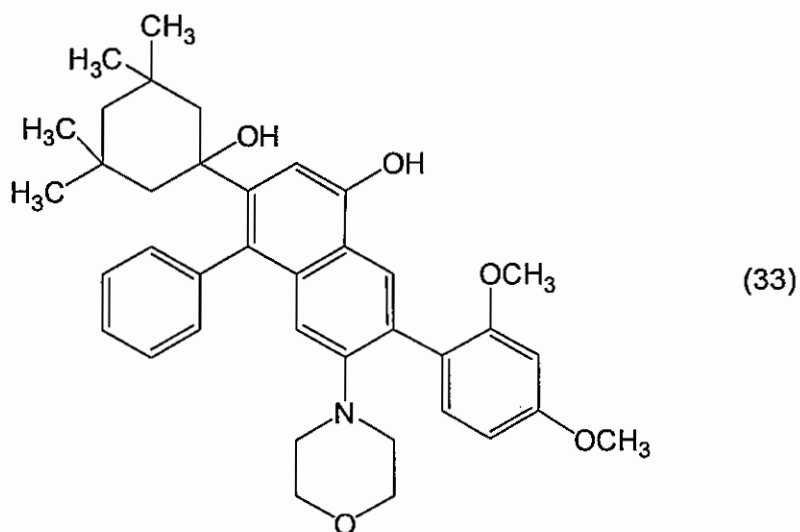
The compound of the above formula (30) was dispersed into 150 ml of acetonitrile, and 113.3 g (130.7 mmol) of a 6 % hydrochloric acid aqueous solution was added and cooled to 0 to 5°C. 8.2 g (39.6 mmol) of a 33 % sodium nitrite aqueous solution was added to this solution and stirred for 30 minutes. 21.9 g (132.0 mmol) of a 50 % potassium iodide aqueous solution was added to this solution and stirred at room temperature for 6 hours. After the reaction, toluene was added, the reaction product was washed in water, the solvent was removed, and the obtained product was purified by column chromatography to obtain a compound represented by the following formula (31) as 12.5 g (19.0 mmol, yield rate of 72 %) of a yellow solid.



The compound of the above formula (31) was dispersed into 375 ml of toluene and cooled to -50°C. 13.1 ml (20.9 mmol) of n-butyl lithium (1.6 M hexane solution) was added dropwise to this solution and stirred for 30 minutes. 7.3 g of a toluene solution of 3.7 g (23.8 mmol) of 3,3,5,5-tetramethylcyclohexanone was added dropwise to this solution and stirred at 0°C for 3 hours. After the reaction, toluene was added, the reaction product was washed in water, the solvent was removed, and the obtained product was purified by reslurrying with methanol to obtain a compound represented by the following formula (32) as 7.5 g (11.0 mmol, yield rate of 58 %) of a yellow solid.

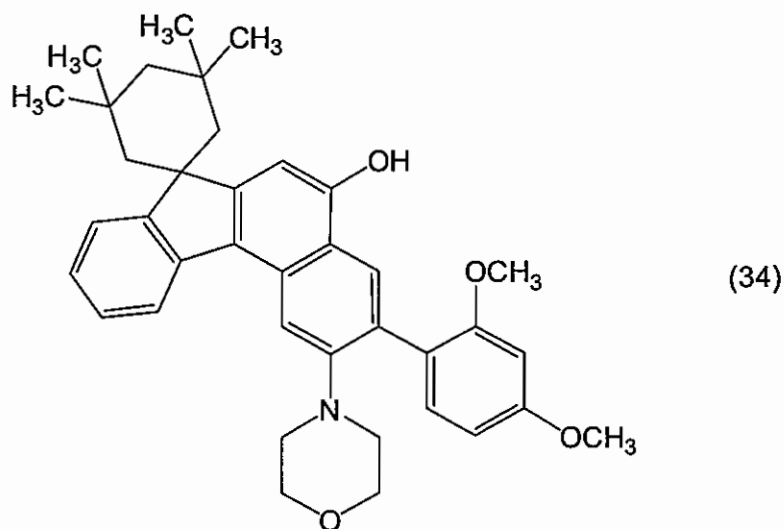


The compound of the above formula (32) was dissolved in 150 ml of tetrahydrofuran, and 2.8 g (44.0 mmol) of ammonium formate and 2.3 g of 5 % palladium carbide were added and stirred at room temperature for 8 hours. After the reaction, 50 ml of toluene was added, the reaction product was washed in water, the solvent was distilled off, and the obtained product was purified by reslurrying with toluene to obtain a compound represented by the following formula (33) as 6.0 g (10.1 mmol, yield rate of 92 %) of a yellow solid.



The compound of the above formula (33) was dissolved in 120 ml of toluene and heated to 90°C. 57.6 g (303.0 mmol) of p-toluenesulfonic acid monohydrate was added to this solution and refluxed for 4 hours. After the reaction, the reaction product was washed in water, the solvent was removed,

and the obtained product was purified by column chromatography to obtain a naphthol compound represented by the following formula (34) as 4.4 g (7.6 mmol, yield rate of 75 %) of a white solid.



5

The elemental analysis values of this product were 78.96 % of C, 7.54 % of H, 2.38 % of N and 11.12 % of O which were almost equal to the calculated values of $C_{38}H_{43}NO_4$ (C: 79.00 %, H: 7.50 %, N: 2.42 %, O: 11.08 %).

10

When the proton nuclear magnetic resonance spectrum of the product was measured, it showed a 32H peak based on an alkyl group at δ of around 0.5 to 4.5 ppm and 11H peaks based on a hydroxyl group and an aromatic proton at δ of around 5.0 to 9.0 ppm

15

Further, when the ^{13}C -nuclear magnetic resonance spectrum was measured, it showed a peak based on the carbon of an aromatic ring at δ of around 110 to 160 ppm and a peak based on the carbon of an alkyl group at δ of around 20 to 80 ppm.

20

It was confirmed from these results that the isolated product was a compound represented by the above formula (34).

This compound is a naphthol compound used in the above Example 3.

25 Examples 150 to 219

Naphthol compounds shown in the tables below were synthesized in the same manner as in Example 149. When the structures of the obtained products were analyzed by using the same structure confirming means as in Example 149, it
5 was confirmed that they were naphthol compounds used in Examples shown in Table 7. Table 8 shows the elemental analysis values, calculated values obtained from the structural formulas of the compounds and characteristic $^1\text{H-NMR}$ spectra of these compounds.

Table 8

Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
150	1	80.34	7.51	0.00	12.15	80.43	7.33	0.00	12.24	δ5.0-9.0 16H δ0.5-4.5 24H
151	2	82.09	6.87	0.00	11.04	82.16	6.89	0.00	10.94	δ5.0-9.0 16H δ0.5-4.5 24H
152	4	80.77	7.86	2.79	8.78	80.71	7.71	2.61	8.96	δ5.0-9.0 11H δ0.5-4.5 30H
153	5	83.01	7.54	0.00	9.45	82.97	7.56	0.00	9.47	δ5.0-9.0 11H δ0.5-4.5 25H
154	6	85.57	7.36	0.00	7.07	85.68	7.41	0.00	6.92	δ5.0-9.0 13H δ0.5-4.5 21H
155	7	86.64	7.16	0.00	6.20	86.68	7.08	0.00	6.24	δ5.0-9.0 15H δ0.5-4.5 21H
156	8	86.87	7.05	0.00	6.08	86.95	7.11	0.00	5.94	δ5.0-9.0 17H δ0.5-4.5 21H
157	9	81.07	7.53	2.49	8.91	81.13	7.54	2.56	8.76	δ5.0-9.0 11H δ0.5-4.5 30H
158	10	78.77	6.16	0.00	15.07	78.85	6.14	0.00	15.01	δ5.0-9.0 11H δ0.5-4.5 15H
159	11	75.87	5.69	0.00	18.44	75.68	5.65	0.00	18.67	δ5.0-9.0 11H δ0.5-4.5 13H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

Table 8 (continued)

Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
160	12	83.14	6.38	0.00	10.48	83.01	6.29	0.00	10.70	δ5.0-9.0 12H δ0.5-4.5 17H
161	13	73.98	5.49	0.00	-	73.83	5.42	0.00	6.15	δ5.0-9.0 11H δ0.5-4.5 17H
162	14	74.77	5.68	3.05	16.50	74.83	5.65	2.91	16.61	δ5.0-9.0 8H δ0.5-4.5 19H
163	15	82.24	7.22	0.00	10.54	82.27	7.13	0.00	10.61	δ5.0-9.0 11H δ0.5-4.5 21H
164	31	83.44	8.79	2.39	5.38	83.49	8.71	2.37	5.42	δ5.0-9.0 12H δ0.5-4.5 39H
165	32	83.28	7.82	2.68	6.22	83.13	7.77	2.77	6.33	δ5.0-9.0 12H δ0.5-4.5 27H
166	33	82.74	7.41	2.99	6.86	82.98	7.39	2.93	6.70	δ5.0-9.0 12H δ0.5-4.5 23H
167	34	82.66	7.29	0.00	10.05	82.81	7.16	0.00	10.03	δ5.0-9.0 12H δ0.5-4.5 22H
168	35	82.79	7.46	0.00	9.75	82.89	7.37	0.00	9.74	δ5.0-9.0 12H δ0.5-4.5 24H
169	36	85.61	7.79	0.00	6.60	85.67	7.61	0.00	6.71	δ5.0-9.0 12H δ0.5-4.5 24H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

Table 8 (continued)

Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
170	37	82.39	7.04	0.00	-	82.47	6.92	0.00	6.66	δ5.0-9.0 12H δ0.5-4.5 21H
171	38	82.59	7.38	3.21	6.92	82.45	7.37	3.10	7.09	δ5.0-9.0 11H δ0.5-4.5 22H
172	39	79.51	6.69	0.00	-	79.45	6.88	0.00	6.83	δ5.0-9.0 11H δ0.5-4.5 21H
173	40	81.39	7.90	2.46	8.25	81.35	7.88	2.43	8.34	δ5.0-9.0 11H δ0.5-4.5 34H
174	41	81.45	8.11	2.45	7.99	81.46	8.03	2.37	8.14	δ5.0-9.0 11H δ0.5-4.5 36H
175	42	81.42	7.95	2.36	8.27	81.35	7.88	2.43	8.34	δ5.0-9.0 11H δ0.5-4.5 34H
176	43	82.64	7.09	2.21	8.06	82.72	7.11	2.30	7.87	δ5.0-9.0 15H δ0.5-4.5 28H
177	44	75.01	6.54	2.46	-	75.12	6.49	2.58	8.83	δ5.0-9.0 11H δ0.5-4.5 24H
178	45	67.20	5.51	2.34	-	67.18	5.48	2.18	7.46	δ5.0-9.0 11H δ0.5-4.5 24H
179	46	67.99	5.89	2.04	-	67.95	5.85	2.09	7.15	δ5.0-9.0 11H δ0.5-4.5 28H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

Table 8 (continued)

Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
180	47	80.14	7.09	0.00	12.77	80.28	7.13	0.00	12.58	δ5.0-9.0 12H δ0.5-4.5 24H
181	48	81.26	7.99	0.00	10.75	81.32	7.85	0.00	10.83	δ5.0-9.0 11H δ0.5-4.5 35H
182	49	81.16	7.87	0.00	10.97	81.21	7.69	0.00	11.10	δ5.0-9.0 11H δ0.5-4.5 33H
183	50	80.98	7.44	0.00	11.58	81.10	7.52	0.00	11.37	δ5.0-9.0 11H δ0.5-4.5 31H
184	51	82.35	7.81	0.00	9.84	82.21	7.84	0.00	9.96	δ5.0-9.0 11H δ0.5-4.5 39H
185	52	82.16	7.97	0.00	9.87	82.21	7.84	0.00	9.96	δ5.0-9.0 11H δ0.5-4.5 39H
186	53	81.55	7.81	0.00	10.64	81.69	7.69	0.00	10.62	δ5.0-9.0 11H δ0.5-4.5 35H
187	54	78.26	7.40	0.00	14.34	78.23	7.29	0.00	14.47	δ5.0-9.0 11H δ0.5-4.5 35H
188	55	78.45	7.71	2.54	11.30	78.55	7.66	2.48	11.31	δ5.0-9.0 11H δ0.5-4.5 32H
189	56	79.94	6.94	0.00	13.12	80.10	6.89	0.00	13.01	δ5.0-9.0 15H δ0.5-4.5 27H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

Table 8 (continued)

Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
190	57	78.78	7.10	2.25	11.87	78.89	7.07	2.09	11.94	δ5.0-9.0 15H δ0.5-4.5 32H
191	58	83.45	8.14	0.00	8.41	83.58	8.07	0.00	8.35	δ5.0-9.0 11H δ0.5-4.5 35H
192	59	81.24	7.99	5.13	5.64	81.39	7.91	5.00	5.71	δ5.0-9.0 12H δ0.5-4.5 32H
193	60	81.84	8.12	4.75	5.29	81.96	8.05	4.66	5.33	δ5.0-9.0 12H δ0.5-4.5 36H
194	61	81.96	8.31	4.67	5.06	82.04	8.20	4.56	5.20	δ5.0-9.0 12H δ0.5-4.5 38H
195	62	82.03	7.97	4.54	5.46	81.96	8.05	4.66	5.33	δ5.0-9.0 12H δ0.5-4.5 36H
196	63	83.21	7.42	4.37	5.00	83.24	7.30	4.41	5.04	δ5.0-9.0 16H δ0.5-4.5 30H
197	64	79.82	7.65	4.71	7.82	79.70	7.69	4.65	7.96	δ5.0-9.0 12H δ0.5-4.5 34H
198	65	76.06	6.81	5.01	-	76.03	6.74	4.93	5.63	δ5.0-9.0 12H δ0.5-4.5 26H
199	66	68.31	5.82	4.31	-	68.25	5.73	4.19	4.79	δ5.0-9.0 12H δ0.5-4.5 26H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

Table 8 (continued)

Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
200	67	68.85	6.15	4.04	-	68.95	6.08	4.02	.59	δ5.0-9.0 12H δ0.5-4.5 30H
201	68	80.99	7.42	2.71	8.88	81.02	7.37	2.62	8.99	δ5.0-9.0 13H δ0.5-4.5 26H
202	69	81.78	8.10	2.19	7.93	81.91	8.02	2.27	7.79	δ5.0-9.0 12H δ0.5-4.5 37H
203	70	81.93	7.91	2.46	7.70	81.83	7.87	2.33	7.98	δ5.0-9.0 12H δ0.5-4.5 35H
204	71	81.87	7.90	2.41	7.82	81.73	7.72	2.38	8.17	δ5.0-9.0 12H δ0.5-4.5 33H
205	72	82.69	7.95	1.99	7.37	82.72	8.00	2.10	7.19	δ5.0-9.0 12H δ0.5-4.5 41H
206	73	82.79	8.05	2.07	7.09	82.72	8.00	2.10	7.19	δ5.0-9.0 12H δ0.5-4.5 41H
207	74	82.39	7.91	2.34	7.36	82.26	7.87	2.23	7.64	δ5.0-9.0 12H δ0.5-4.5 37H
208	75	79.10	7.46	2.51	10.93	79.00	7.50	2.42	11.08	δ5.0-9.0 12H δ0.5-4.5 31H
209	76	79.34	7.89	4.86	7.91	79.29	7.85	4.74	8.12	δ5.0-9.0 12H δ0.5-4.5 34H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

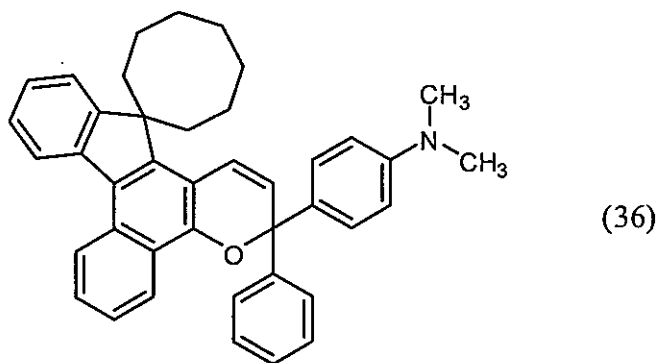
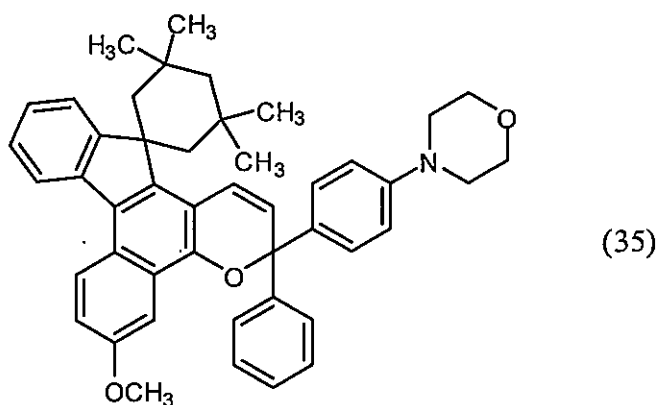
Table 8 (continued)

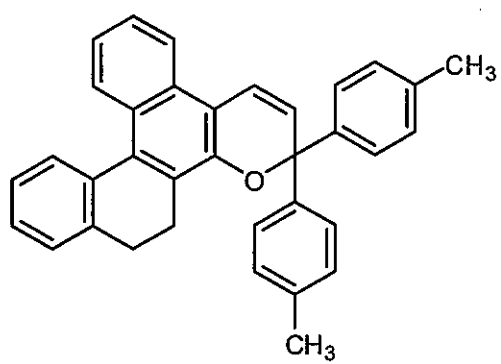
Example No.	Example No. of chromene compounds*	Elemental analysis values								¹ H-NMR (NMR)
		Experimental values				Calculated values				
		C	H	N	O	C	H	N	O	
210	77	80.64	7.14	2.24	9.98	80.72	7.09	2.19	10.00	δ5.0-9.0 16H δ0.5-4.5 29H
211	78	79.54	7.29	3.97	9.20	79.51	7.25	4.03	9.21	δ5.0-9.0 16H δ0.5-4.5 34H
212	79	84.21	8.16	2.46	5.17	84.10	8.23	2.34	5.33	δ5.0-9.0 12H δ0.5-4.5 37H
213	80	83.56	7.85	2.75	5.84	83.58	7.77	2.63	6.02	δ5.0-9.0 12H δ0.5-4.5 29H
214	81	80.21	7.25	0.00	12.54	80.28	7.13	0.00	12.58	δ5.0-9.0 11H δ0.5-4.5 25H
215	82	80.04	6.91	0.00	13.05	80.13	6.93	0.00	12.94	δ5.0-9.0 11H δ0.5-4.5 23H
216	83	79.68	6.64	0.00	13.68	79.80	6.48	0.00	13.72	δ5.0-9.0 11H δ0.5-4.5 19H
217	84	80.25	7.21	0.00	12.54	80.28	7.13	0.00	12.58	δ5.0-9.0 11H δ0.5-4.5 25H
218	85	80.26	7.16	0.00	12.58	80.28	7.13	0.00	12.58	δ5.0-9.0 11H δ0.5-4.5 25H
219	86	76.14	5.79	0.00	18.07	76.00	5.92	0.00	18.08	δ5.0-9.0 11H δ0.5-4.5 15H

*Examples of chromene compounds produced by using the naphthol compounds of Examples.

Examples 220 to 222

Photochromic plastic lenses were manufactured and their characteristic properties were evaluated in the same manner as in Example 18 except that the chromene compound
5 (chromene compound No.1) of Example 1 of the present invention was mixed with each of the following chromene compounds (35), (36) and (37) in a ratio shown in Table 9. The results are shown in Table 11.





(37)

Table 9

Example No.	Compound No.	Photochromic compound				Color
		1	54	55	56	
220	Amount (parts by mass)	2.0	0.2	-	-	gray
221		2.5	-	0.4	-	gray
222		2.0	-	0.1	0.2	brown

Table 10

Example No.	$\lambda_{\max}$	Color optical density	Double peak characteristic	Fading half period	Initial coloration (absorption end)	Initial coloration (thermochromism)	Residual rate	Color development sensitivity
	(nm)	A_0	A_Y/A_B	$\tau_{1/2}$ (sec)	(nm)	(%)	$(A_{50}/A_0) \times 100$	$\varepsilon(10)/\varepsilon(120)$
220	463	1.01	1.03	66	411	89	90	0.29
	576	0.98		66		89	91	
221	457	1.09	1.00	68	410	89	90	0.28
	578	1.09		68		89	89	
222	456	1.08	1.54	68	408	88	89	0.28
	578	0.70		68		89	89	

As shown in Table 10, the photochromic plastic lenses which were obtained by curing the chromene compositions of the present invention had a transmittance by thermochromism of not less than 88 %. Further, as its absorption end is
5 existent at 405 to 415 nm, they had little initial coloration and high color development sensitivity.

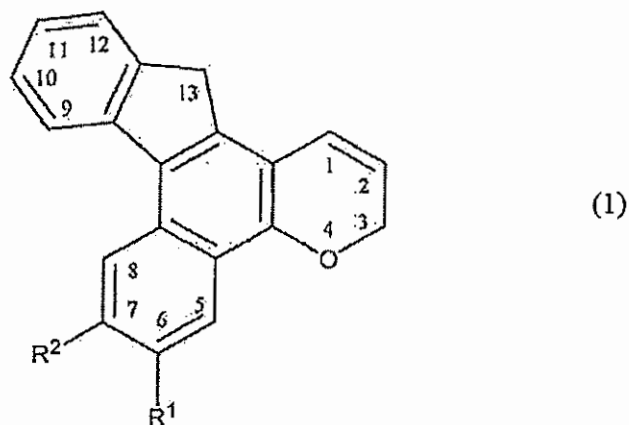
Effect of the Invention

The chromene compound of the present invention
10 develops a color of a neutral tint and has little initial coloration, high color development sensitivity, high color optical density and a high fading speed even when it is dispersed into a solution or a polymer solid matrix as well as excellent durability.

15 Therefore, a photochromic lens manufactured by using the chromene compound of the present invention exhibits such excellent photochromic properties that it develops a dark color of a neutral tint swiftly when it moves outside and returns to its original color swiftly when it returns inside
20 from outside and has high durability that it can be used for a long time.

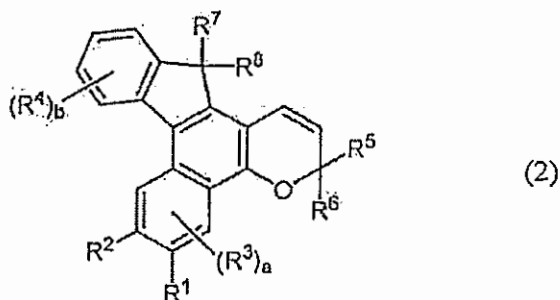
THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A chromene compound having a skeleton represented by the following formula (1):



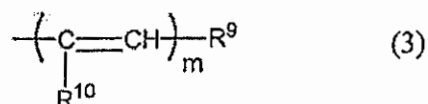
wherein R^1 is an aryl group or a heteroaryl group, and R^2 is an electron donor group having a Hammett constant σ_p of not more than -0.1.

2. The chromene compound according to claim 1 which is represented by the following formula (2):



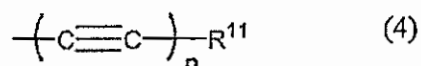
wherein R^1 and R^2 are as defined in the above formula (1), R^3 and R^4 are each independently a hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to a benzene ring bonded thereto via the nitrogen atom, cyano group, nitro group, formyl group, hydroxycarbonyl group, alkylcarbonyl group, alkoxycarbonyl group, halogen atom, aralkyl group, aralkoxy group, aryl group or aryloxy group, R^5

and R^6 are each independently a group represented by the following formula (3):



wherein R^9 is an aryl group or heteroaryl group, R^{10} is a hydrogen atom, alkyl group or halogen atom, and m is an integer of 1 to 3,

group represented by the following formula (4):



wherein R^{11} is an aryl group or heteroaryl group, and n is an integer of 1 to 3,

aryl group, heteroaryl group or alkyl group, R^5 and R^6 may be bonded together to form an aliphatic hydrocarbon ring together with the carbon atom bonded thereto, R^7 and R^8 are each independently a hydrogen atom, hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to the 13-position carbon atom via the nitrogen atom, cyano group, nitro group, formyl group, hydroxycarbonyl group, alkylcarbonyl group, alkoxy carbonyl group, halogen atom, aralkyl group, aralkoxy group, aryl group or aryloxy group, R^7 and R^8 may be bonded together to form an aliphatic ring having 3 to 20 ring member carbon atoms, condensed polycyclic ring having an aromatic ring or an aromatic hetero ring condensed to the aliphatic ring, hetero ring having 3 to 20 ring member atoms, or condensed polycyclic ring having an aromatic ring or an aromatic hetero ring condensed to the hetero ring, together with the 13-position carbon atom bonded thereto, "a" is an integer of 0 to 2, and b is an integer of 0 to 4, with the proviso that when "a" is 2, two R^3 's may be the same or different and when b is 2 to 4, a plurality of R^4 's may be the same or different.

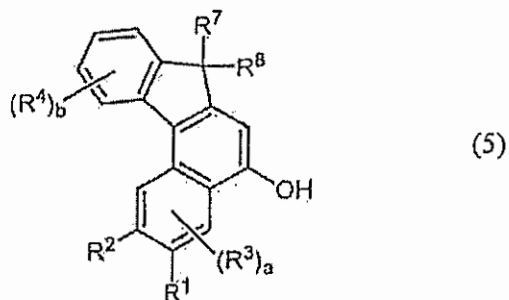
3. The chromene compound according to claim 2, wherein R^1 is an aryl group having 6 to 14 carbon atoms, a heteroaryl group having 4 to 12 carbon atoms, or an aryl group having 6 to 14 carbon atoms or a heteroaryl group having 4 to 12 carbon atoms substituted by at least one substituent selected from the group consisting of hydroxyl group, alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, heterocyclic group having a ring member nitrogen atom and bonded to a benzene ring bonded thereto via the nitrogen atom, cyano group, nitro group, formyl group, hydroxycarbonyl group, alkylcarbonyl group, alkoxy carbonyl group, halogen atom, aralkyl group, aryl group and aryloxy group.
4. The chromene compound according to claim 2 or claim 3, wherein R^2 is a hydroxyl group, alkyl group, cycloalkyl group, alkoxy group, aryloxy group, amino group or heterocyclic group having a ring member nitrogen atom and bonded to the 7-position carbon atom via the nitrogen atom.
5. The chromene compound according to any one of claims 2 to 4, wherein R^7 and R^8 are bonded together to form an aliphatic hydrocarbon ring together with the 13-position carbon atom, and the aliphatic hydrocarbon ring has 3 to 20 ring member carbon atoms and may have at least one substituent selected from the group consisting of alkyl group, haloalkyl group, cycloalkyl group, alkoxy group, amino group, aralkyl group, aryl group and halogen atom.
6. The chromene compound according to claim 5, wherein the aliphatic hydrocarbon ring is a cyclohexane ring substituted by an alkyl group having 1 to 4 carbon atoms.
7. A photochromic curable composition comprising the chromene

compound of any one of claims 1 to 6 and a polymerizable monomer.

8. A photochromic optical article having a polymer molded product containing the chromene compound of any one of claims 1 to 6 dispersed in the polymer molded product as a constituent member.

9. An optical article having an optical substrate all or part of at least one surface of which is coated with a polymer film containing the chromene compound of any one of claims 1 to 6 dispersed in the polymer film as a constituent member.

10. A naphthol compound represented by the following formula (5):



wherein R^1 , R^2 , R^3 , a , R^4 , b , R^7 and R^8 are as defined in the above formula (2).

11. A chromene compound according to claim 1, substantially as hereinbefore described, with reference to any one of the Examples; excluding Comparative Examples.

12. A naphthol compound according to claim 10, substantially as hereinbefore described, with reference to any one of the Examples; excluding Comparative Examples.