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IMPACT-RESISTANT GRAFT COPOLYMER AND
THERMOPLASTIC RESIN COMPOSITION CONTAINING SAME

FIELD OF THE INVENTION AND RELATED ART

5 The present invention relates to a novel graft
copolymer and a thermoplastic resin composition
containing the same. More particularly, the present
invention relates to a graft copolymer comprising as a
trunk component a rubber copolymer of butadiene with a
10 biphenyl derivative or a naphthalene derivative which
has a high refractive index and a low glass transition
temperature, and also a thermoplastic resin composition
containing the graft copolymer.

 The graft copolymer according to the present
15 invention may be blended with a various thermoplastic
resin including a vinyl chloride-base resin to provide
a resin composition having excellent transparency and
impact resistance. The graft copolymer per se can
constitute a thermoplastic resin excellent in
20 transparency and impact resistance when it has a
relatively low content of the rubber polymer.

 There have been practically used various
thermoplastic resin compositions provided with various
performances inclusive of impact resistance by mixing a
25 graft copolymer obtained by graft-polymerizing a rigid
resin-forming monomer such as styrene and methyl
methacrylate onto a rubber polymer as a trunk

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component.

In order to enhance the impact resistance-improving effect by blending with a graft copolymer, it is necessary to sufficiently lower the glass transition
5 temperature of the rubber component in the graft copolymer.

Butadiene-styrene copolymer rubber, which has been commercially widely used, results in a lower refractive index if the glass transition temperature is
10 lowered. Thus, if a graft copolymer containing as a trunk component such a rubber having low glass transition temperature and refractive index is blended with a thermoplastic resin, the resulting thermoplastic resin composition is provided with an improved impact
15 resistance but can also have a lowered transparency. Such a difficulty is encountered not only with vinyl chloride resin but also with many other thermoplastic resins.

A butadiene-styrene copolymer rubber can have
20 a higher refractive index by increasing the styrene proportion but is simultaneously caused to have an elevated glass transition temperature to result in a smaller impact resistance-improving effect, thus giving rise to an improper balance of the two properties.

25

SUMMARY OF THE INVENTION

An object of the present invention is to



provide a graft copolymer comprising a vinyl monomer graft-polymerized onto a rubber polymer having a low glass transition temperature and also a high refractive index.

5 A more specific object of the present invention is to provide a graft copolymer which provides a composition excellent in impact resistance and transparency when blended with a various thermoplastic resin, and also such a thermoplastic
10 resin composition.

 Another object of the present invention is to provide a graft copolymer which per se constitute a thermoplastic resin excellent in transparency and impact resistance at a relatively low rubber polymer
15 content.

 According to our study, it has been found possible to obtain an objective graft copolymer by using a biphenyl derivative or a naphthalene derivative as a copolymerizing monomer in place of styrene and
20 copolymerizing it with butadiene to form a rubber polymer having a high refractive index and also a low glass transition temperature and by effecting graft copolymerization by using the rubber polymer as a trunk component.

25 Thus, according to the present invention, there is provided a graft copolymer, comprising: 5 - 90 wt. parts of a rubber polymer and 10 - 95 wt. parts of

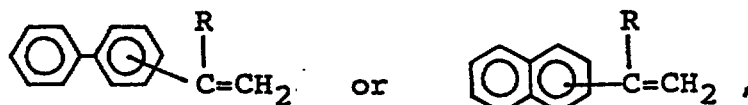


a vinyl monomer graft-polymerized onto the rubber polymer; said rubber polymer comprising 40 - 99 wt. % of butadiene and 1 - 60 wt. % of an aromatic polycyclic vinyl monomer represented by the following formula (I)

5 or (II):

Formula (I)

Formula (II)



wherein R denotes a hydrogen atom or a methyl group.

10 The present invention further provides a thermoplastic resin composition comprising a mixture of the above-mentioned graft copolymer and a thermoplastic resin such as a vinyl chloride resin and styrene-acrylonitrile copolymer resin.

15 The above mentioned and other objects and features of the invention will be better understood upon consideration of the following detailed description concluding with specific examples.

20 DETAILED DESCRIPTION OF THE INVENTION

The graft copolymer of the present invention will be described in further detail.

[Graft Copolymer]

Rubber polymer

25 The rubber polymer constituting the trunk polymer of the graft copolymer may preferably be a butadiene-based rubber polymer obtained by emulsion



polymerization in a known manner of a monomer mixture comprising 40 - 99wt. %, preferably 45 - 90 wt. %, more preferably 50 - 90 wt. %, of butadiene and 1 - 60 wt. %, preferably 10 - 55 wt. %, more preferably 10 - 50
5 wt. %, of an aromatic polycyclic vinyl monomer represented by the formula (I) or (II).

Examples of the aromatic polycyclic vinyl monomer represented by the formula (I) or (II) and copolymerized with butadiene may include: vinylbiphenyl
10 compounds, such as 4-isopropenylbiphenyl, 3-isopropenylbiphenyl and 4-vinylbiphenyl; vinyl-naphthalene compounds, such as 2-isopropenylnaphthalene and 2-vinylnaphthalene; and alkyl(preferably $C_1 - C_3$)-substituted derivatives and halogen-substituted
15 derivatives of the above.

If the content of the aromatic polycyclic vinyl monomer is below 1 wt. %, it is impossible to effectively increase the refractive index of the resulting rubber polymer. Such a rubber polymer is not
20 desirable as a trunk polymer because the resulting graft copolymer is caused to have a large difference in refractive index between the trunk polymer and the grafting component in the graft copolymer, thus lacking uniformity of the refractive index of the graft
25 copolymer per se. On the other hand, a proportion exceeding 60 wt. % of the aromatic polycyclic vinyl monomer is not preferred because the resulting rubber



polymer is caused to have an elevated glass transition temperature close to room temperature, thus losing rubbery properties.

The rubber polymer having a composition within
5 the above-described range may have a refractive index n_D at 23 °C in the range of 1.52 - 1.60, preferably 1.53 - 1.59, and a glass transition temperature in the range of -70 °C to +10 °C, preferably -70 °C to ± 0 °C. A refractive index below 1.52 is not substantially
10 different from that of polybutadiene and a refractive index exceeding 1.60 is accompanied with an increase in glass transition temperature. Accordingly, it is desired that the rubber polymer for the graft copolymer of the present invention has a refractive index and a
15 glass transition temperature within the above described ranges.

When the aromatic polycyclic vinyl monomers according to the formulae (I) and (II) are compared with each other, both are excellent in the effect of
20 increasing the refractive index of the rubber polymer while suppressing the increase in glass transition temperature but the one represented by the formula (II) can result in a graft copolymer possibly containing a very slight amount of the non-reacted monomer which can
25 be volatilized to generate an odor when the graft copolymer is dried or heated for processing or molding. On the other hand, in the case of using a monomer



represented by the formula (I), no order is generated from the resulting graft copolymer on heating even if a slight amount of the non-reacted monomer remains therein after the polymerization. For this reason, the graft copolymer obtained by using the monomer represented by the formula (I) may be rather preferred as a thermoplastic resin or an ingredient of a thermoplastic resin composition blended with a various thermoplastic resin.

10 Another vinyl monomer copolymerizable with the aromatic polycyclic vinyl monomer can be used together with the aromatic polycyclic vinyl monomer within an extent not deviating from the object of the present invention. Examples of such another vinyl monomer may include: aromatic vinyl compounds, such as styrene and
15 -methylstyrene; vinyl cyanides, such as acrylonitrile and methacrylonitrile; acrylic acid, methacrylic acid; alkyl acrylates, such as ethyl acrylate, butyl acrylate, and ethylhexyl acrylate; and alkyl
20 methacrylates, such as methyl methacrylate, ethyl methacrylate and butyl methacrylate. In case of using such another vinyl monomer, it is desired to use such another vinyl monomer in an amount of at most 59 wt. %, particularly 1 - 40 wt. %, of the total amount of the
25 monomers (i.e., butadiene + the aromatic polycyclic vinyl monomer + such another vinyl monomer) so as to replace a portion of the aromatic polycyclic vinyl



monomer while retaining the above-mentioned lower limit of the aromatic polycyclic vinyl monomer.

It is also possible to use a polyfunctional monomer copolymerizable with the aromatic polycyclic vinyl monomer and butadiene, as desired, to provide a crosslinked rubber polymer. The polyfunctional monomer may be used in an amount of at most 10 wt. %, preferably 0.1 - 5 wt. %, of the total monomer amount excluding the polyfunctional monomer. An amount exceeding 10 wt. % is not preferred because the resulting rubber polymer is caused to have an elevated glass transition temperature and a poor elastomeric property, thus lowering the impact resistance-imparting performance of the graft copolymer.

Examples of the polyfunctional monomer may include: aromatic polyfunctional vinyl compounds, such as divinylbenzene and divinyltoluene; di- and tri-methacrylates and di- and tri-acrylates of polyhydric alcohols, such as ethylene glycol dimethacrylate, triethylene glycol dimethacrylate, and 1,3-butanediol diacrylate; and allyl compounds, such as diallyl maleate, diallyl phthalate and allyl methacrylate. The above are not exhaustive and it is generally possible to use a compound having two or more double bonds in its molecule and copolymerizable with the aromatic polycyclic vinyl monomer and also butadiene. It is also possible to use a chain transfer agent in an



amount up to 5 wt. % of the total monomer amount so as to adjust the gel content of the resulting rubber polymer. The chain transfer agent may for example be a known one ordinarily used in emulsion polymerization, such as octyl mercaptan, dodecyl mercaptan or lauryl mercaptan.

The rubber polymer latex may ordinarily be prepared to have an average particle size in the range of 50 - 800 nm.

Too small an average particle size of the rubber polymer latex results in a small impact resistance-imparting effect, and reversely too large an average particle size leads to a lowering in transparency and surface gloss of a molded product from the resulting thermoplastic resin composition. Thus, they are not preferred either.

The average particle size of the rubber polymer latex may be appropriately adjusted into a desired range by controlling the kinds and amounts of the emulsifier and initiator used in emulsion polymerization and the polymerization temperature. Alternatively, it is also possible to prepare a rubber polymer latex having an average particle size of 30 - 200 nm first and then adding thereto a coagulant to cause agglomeration, thereby providing a desired average particle size. The coagulant may appropriately be an ordinarily used electrolyte including, for



example, inorganic acids, such as hydrochloric acid and sulfuric acid; organic acids, such as acetic acid, malic acid and maleic acid; and salts, such as sodium chloride, calcium chloride and magnesium chloride.

5 Grafting component

The vinyl monomer graft-polymerized onto the rubber polymer in the present invention may suitably be one providing polymerized units which have a good compatibility with a thermoplastic resin to which the
10 graft copolymer is added so as to easily and uniformly disperse the rubber polymer within the thermoplastic resin and provide a sufficient bonding between the thermoplastic resin phase and the rubber polymer phase.

The grafting monomer component may for example
15 be selected from the following group of monomers so that the graft copolymer according to the present invention may be applicable to not only a single particular thermoplastic resin but also various thermoplastic resins having different refractive
20 indexes.

Thus, the monomer group may include: aromatic vinyl compounds, such as styrene and α -methylstyrene, vinyl cyanides, such as acrylonitrile and methacrylonitrile; acrylic acid, methacrylic acid;
25 alkyl acrylates, such as methyl acrylate, ethyl acrylate and butyl acrylate; alkyl methacrylates, such as methyl methacrylate, ethyl methacrylate and butyl



methacrylate; maleimide monomers, such as maleimide and N-phenyl-maleimide; maleic acid, maleic anhydride and their derivatives; and aromatic polycyclic vinyl monomers represented by the above-mentioned formulae (I) and (II). At least one species of the monomers may be used singly or in mixture. These aromatic polycyclic vinyl monomers are also effective as a grafting component to provide a graft copolymer having a high refractive index owing to the grafting component. Particularly, 3-isopropenylbiphenyl may be preferably used. Another copolymerizable monomer may include a polyfunctional monomer identical to those used in the rubber polymer.

Graft copolymerization

The graft copolymer according to the present invention may be produced by graft-polymerizing 10 - 95 wt. parts of a vinyl monomer (or mixture) in the presence of 5 - 90 wt. parts (giving a total of 100 weights parts with the vinyl monomer (mixture)) of a rubber polymer comprising 40 - 99 wt. % of butadiene and 1 - 60 wt. % of an aromatic polycyclic vinyl monomer.

More specifically, the vinyl monomer (mixture) may be graft-polymerized in the presence of a rubber polymer latex in an amount of 10 - 95 wt. parts, preferably 15 - 50 wt. parts, more preferably 20 - 40 wt. parts, with respect to 5 - 90 wt. parts, preferably



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50 - 85 wt. parts, more preferably 60 - 80 wt. parts, of the rubber polymer. As the graft polymerization is performed at a conversion of substantially 100 %, the resultant graft copolymer is provided with

5 substantially the same composition as described above.

If the rubber polymer content is below 5 wt. parts, the graft copolymer lacks in flexibility and rubbery property, thus failing to show an excellent impact resistance. On the other hand, if the rubber

10 polymer content exceeds 90 wt. parts, the graft copolymer is caused to have a low heat resistance and is liable to be in a lump form so that it becomes difficult to uniformly blend the graft copolymer with various thermoplastic resins.

15 It is particularly preferred that the rubber polymer content is 50 - 85 wt. parts when the graft copolymer is used as an impact resistance-improver to be blended with another thermoplastic resin.

On the other hand, in order to obtain a graft

20 copolymer which is used as a thermoplastic resin by itself, it is preferred to graft-polymerize 50 - 95 wt. parts, particularly 60 - 90 wt. parts, of the vinyl monomer (mixture) onto 5 - 50 wt. parts, particularly 10 - 40 wt. parts, of the rubber polymer.

25 The vinyl monomer (mixture) to be graft-polymerized onto the rubber polymer may be added into the reaction system at one time, separately in several



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times or continuously for polymerization. In the case where the vinyl monomer (mixture) is added in plural stages for the graft polymerization, the monomer compositions in the respective stages may be the same or different.

It is possible to add a polyfunctional monomer, if desired, to the vinyl monomer (mixture) as mentioned above. The amount may preferably be at most 3 wt. % of the vinyl monomer mixture. Above 3 wt. %, the impact resistance is lowered.

The graft copolymer according to the present invention comprises the above-mentioned rubber polymer as a trunk polymer and a random (co)polymer of the vinyl monomer (mixture) grafted as side branches onto the rubber polymer so as to provide a graft ratio (as defined hereinafter) of 5 - 55 %, preferably 10 - 45 %. A graft ratio of below 5 % results in a lower compatibility with a thermoplastic resin and a lower impact resistance-imparting effect. On the other hand, it is difficult to obtain a graft copolymer having a graft ratio exceeding 55 % and is thus un-economical.

[Utility]

According to the present invention, it is possible to obtain a novel graft copolymer comprising as the trunk polymer a rubber polymer having a large refractive index and also a low glass transition temperature. Such a novel graft copolymer is useful as



a polymer to be blended with a various thermoplastic resin for imparting an impact resistance without impairing the transparency. The graft copolymer may be particularly advantageously blended with a

5 thermoplastic resin rich in transparency, such as a vinyl chloride resin inclusive of polyvinyl chloride and chlorinated polyvinylchloride, polystyrene, styrene-acrylonitrile copolymer, α -methylstyrene-acrylonitrile copolymer, styrene-acrylonitrile-methyl

10 methacrylate copolymer, styrene-methyl methacrylate copolymer, polyester such as polyethylene terephthalate, or polycarbonate.

In order to provide a thermoplastic resin composition with a good transparency, the thermoplastic

15 resin may preferably have a refractive index which is equal to or differs by at most ± 0.005 from that of the graft copolymer.

In this case, the graft copolymer according to the present invention may preferably be used in an

20 amount of 2 - 50 wt. parts with 50 - 98 wt. parts (giving a total of 100 wt. parts with the graft copolymer) of a thermoplastic resin.

On the other hand, the graft copolymer, according to the present invention may be used for

25 various purposes as a thermoplastic resin excellent in transparency as well as in impact resistance by controlling the rubber polymer content therein.



[Examples]

Hereinbelow, the present invention will be explained based on Examples and Comparative Examples.

The physical properties described were
5 measured in the following manner.

Refractive index (n_D)

1) Rubber polymer

A cast film is prepared from a rubber polymer latex, purified by dipping in methyl alcohol and dried
10 under vacuum for 24 hours at room temperature to form a sample film (of about 200 microns in thickness), the refractive index of which is measured at 23 °C by using an Abbe's refractometer.

2) Graft copolymer

15 A graft copolymer resin is hot-pressed at 200 °C to form a film (of about 50 microns in thickness), the refractive index of which is measured at 23 °C by using an Abbe's refractometer.

Glass transition temperature (T_g)

20 An about 200 micron-thick hot-pressed film of a graft copolymer was subjected to a viscoelasticity test using a tester ("Rheovibron DDV-II-EA", mfd. by Orientec K.K.) at a frequency of 110 Hz and a temperature-raising rate of 2 °C/min to measure
25 temperatures giving maximum peaks appearing in a loss modulus-temperature curve, of which temperatures the lowest one is regarded as the glass transition



temperature of the rubber polymer in the graft copolymer.

Average particle size in latex

The average particle size of a rubber polymer
5 or graft copolymer in a latex form is measured by using
a submicron particle size analyzer ("Coulter Counter
N4", mfd. by Coulter Electronics Co.).

Graft ratio and Graft efficiency

"Graft ratio" is defined as a ratio of the
10 amount of a grafting component actually grafted onto a
rubber polymer to the amount of the rubber polymer.

"Graft efficiency" is a ratio of the amount of
a grafting component actually grafted onto a rubber
polymer to the amount of a grafting monomer (mixture)
15 used in the graft polymerization.

A sample graft copolymer is washed with methyl
alcohol and dried under vacuum for 24 hours at room
temperature, followed by addition of methyl ethyl
ketone and 3 hours of stirring at 70 °C. Then, the
20 mixture is cooled to 4 °C and then subjected to
centrifugation for 1.5 hours under a centrifugal force
of 49,000 G to be separated into a methyl ethyl ketone-
soluble fraction and a methyl ethyl ketone-insoluble
fraction, followed by drying.

25 Then, the methyl ethyl ketone-insoluble
fraction is weighed.

In this way, the methyl ethyl ketone-insoluble



fraction weight, the rubber polymer weight and the grafting monomer weight are obtained. From these results, the graft ratio and the graft efficiency are calculated based on the following equations.

5 Graft ratio (%) = [(methyl ethyl ketone-insoluble fraction weight - rubber polymer weight)/(rubber polymer weight)] x 100.

 Graft efficiency (%) = [(methyl ethyl ketone-insoluble fraction weight - rubber polymer weight)/(grafting monomer weight)] x 100.

 Herein, the amount of the monomers used for the rubber polymer polymerization is used as the rubber polymer weight since the polymerization conversion is substantially 100 %. Further, the polymerization
15 conversion of the monomer for the graft polymerization is also substantially 100 %. (Thus, [graft copolymer weight] $\simeq$ [rubber polymer weight] + [grafting monomer weight]). A difference between 100 % and the graft efficiency corresponds to the methyl ethyl ketone-
20 soluble polymer fraction (i.e., the non-grafted polymer fraction).

Properties of polyvinyl chloride resin composition

1. Transparency

 A sample graft copolymer is blended with other
25 ingredients according to a prescription shown below, and the blend is kneaded for 3 min. on rollers heated at a surface temperature of 180 °C and, after 3 min of



preheating in a hot press having a hot plate temperature of 200 °C, hot-pressed for 2 min under a load of 150 kg/cm² to be molded into a 3 mm-thick plate. From the plate, a test piece measuring 50 mm-
5 long and 50 mm-wide is cut out and subjected to measurement of a parallel light transmittance and a haze value according to JIS K7105 (1981).

(Prescription)

	Polyvinyl chloride resin	100 wt.part(s)
10	(average degree of polymerization = 700)	
	Octyltin-type stabilizer	2.0 "
	Higher alcohol lubricant	0.8 "
	Higher fatty acid ester lubricant	0.2 "
	Polymer processing aid	1.0 "
15	Graft copolymer	10 "

2. Charpy impact strength

A 3 mm-thick plate is prepared in the same manner described above for measurement of transparency. In this case, however, in addition to a composition
20 containing 10 wt. parts of a graft copolymer as described above, a composition containing 12. wt. parts of a graft copolymer is prepared in some cases.

From these plate products, V-notched test pieces (No. 5 test specimen according to JIS K7111
25 (1984)) are cut out.

The measurement is performed at 23 °C and 10 °C according to JIS K7111 (1984).



The results are represented by ordinary Charpy impact strength values as well as a ductile breakage percent given in parentheses as shown in Table 2B hereinafter which is a proportion of broken test piece
5 samples causing a ductile breakage that the test piece is not broken into completely separate two fragments but such two fragments are kept connected while the broken part is stretched.

Example 1

10 A stainless steel-made autoclave equipped with a stirrer was charged with the following composition of materials, followed by nitrogen aeration, gas-evacuation and heating to 80 °C.

	4-Isopropenylbiphenyl	9.75 wt.part(s)
15	(crystal, purity 99.5 %)	
	Divinylbenzene	0.262 "
	(purity 57.2 %)	
	Diisopropylbenzene hydroperoxide	0.150 "
	(purity 50 %)	
20	Sodium pyrophosphate	0.125 "
	Disodium ethylenediamine-tetraacetate	0.00375 "
	Ferrous sulfate	0.00225 "
	Potassium oleate aqueous solution	2.58 "
25	(15.5 %)	
	Deionized water	200 "

After the temperature within the autoclave



reached 80°C, 65.25 wt. parts of 1,3-butadiene was added to dissolve the 4-isopropenylbiphenyl crystal within the autoclave with the butadiene. Thereafter, 0.6 wt. part of sodium formaldehyde sulfoxylate aqueous solution (5 %) was added to initiate emulsion polymerization. After 4 hours from the commencement of polymerization, 2.5 wt. parts of potassium oleate aqueous solution was post-added. During a period after further 1 hour (after 5 hours from the commencement of polymerization), 7.5 wt. parts of t-butyl hydroperoxide aqueous solution (5 %) and 7.5 wt. parts of sodium formaldehyde sulfoxylate aqueous solution (5 %) were intermittently post-added. The polymerization conversion after 11 hours from the commencement of polymerization was almost 100 %. The resultant rubber polymer latex showed an average particle size of 160 nm.

The rubber polymer showed a refractive index n_D at 23 °C of 1.5372.

The thus obtained latex was cooled to 60 °C, and the following monomer mixture and polymerization aids were added thereto, followed by 3 hours of graft polymerization at 60 °C.

Methyl methacrylate	10.5 wt.part(s)
Butyl acrylate	2.0 "
t-Butyl hydroperoxide aqueous solution (5 %)	3.0 "



Sodium formaldehyde sulfoxylate

aqueous solution (5 %)

3.0 wt.part(s)

Then, the following monomer and polymerization
aids were added to the system, followed by 4 hours of
5 graft polymerization at 60 °C.

Styrene

12.5 wt.part(s)

t-Butyl hydroperoxide aqueous

solution (5 %)

4.0 "

Sodium formaldehyde sulfoxylate

10 aqueous solution (5 %)

4.0 "

The resultant graft copolymer latex showed an
average particle size of 170 nm.

After adding an antioxidant emulsion, the
latex was subjected to acid precipitation with
15 hydrochloric acid aqueous solution, dewatering, washing
with water and drying to obtain a graft copolymer in
powder form. The rubber polymer in the graft copolymer
showed a glass transition temperature of -53 °C, and
the graft ratio and graft efficiency of the grafting
20 component in the graft copolymer were 31.1 % and 93.2
%, respectively.

Examples 2 - 5

Emulsion polymerization was separately
performed in the same manner as in Example 1 except
25 that the amount of 4-isopropenylbiphenyl was changed to
15.0 wt. parts (Example 2), 18.75 wt. parts (Example
3), 22.5 wt. parts (Example 4) and 30.0 wt. parts



(Example 5), the amount of 1,3-butadiene was changed to 60.0 wt. parts (Example 2), 56.25 wt. parts (Example 3), 52.5 wt. parts (Example 4) and 45.0 wt. parts (Example 5), and the amount of potassium oleate aqueous solution before the commencement of polymerization was changed to 2.90 wt. parts (Example 2), 3.2 wt. parts (Examples 3 and 4) and 3.0 wt. parts (Example 5), respectively.

The properties of the resultant rubber polymers and graft copolymers are inclusively shown in Table 2A appearing hereinafter.

Example 6

A rubber polymer latex was prepared in the same manner as in Example 5, and the following monomer mixture and polymerization aids were added thereto, followed by 5 hours of graft polymerization at 60 °C.

	Methyl methacrylate	6.25 wt.part(s)
	3-Isopropylbiphenyl	6.25 "
	t-Butyl hydroperoxide aqueous	
20	solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate	
	aqueous solution (5 %)	3.0 "

Then, the following mixture was added to the system, followed by 6 hours of graft polymerization at 60 °C.

	Methyl methacrylate	6.25 wt.part(s)
	3-Isopropenylbiphenyl	6.25 "



t-Butyl hydroperoxide aqueous

solution (5 %)

3.0 wt.part(s)

Sodium formaldehyde sulfoxylate

aqueous solution (5 %)

3.0 "

5 The properties of the resultant rubber polymer
and graft copolymer are also shown in Table 2A.

Example 7

Emulsion polymerization was performed in the
same manner as in Example 1 except that the charged
10 amounts of 4-isopropenylbiphenyl, 1,3-butadiene,
divinylbenzene and potassium oleate aqueous solution
before the commencement of polymerization were changed
to 10.5, 64.5, 0 and 3.13 wt. parts, respectively.

The properties of the resultant rubber polymer
15 and graft copolymer are also shown in Table 2A.

Example 8

A rubber polymer latex was prepared in the
same manner as in Example 1 except that the charged
amounts of divinylbenzene and potassium oleate aqueous
20 solution before the commencement of polymerization were
changed to 0 and 4.84 wt. parts, respectively, and the
emulsion polymerization time was changed to 5 hours.

The polymerization conversion of the monomers
was almost 100 %, and the resultant rubber polymer
25 latex showed an average particle size of 100 nm.

The latex was cooled to 60 °C, and thereafter
7.2 wt. parts of 1 %-dialkyl sulfosuccinate aqueous



solution and then about 4 wt. parts of 7.5 %-acetic acid aqueous solution were added thereto for agglomeration for size-enlargement of rubber particles in the latex to provide an average particle size of 190
5 nm.

Thereafter, two staged of graft polymerization were performed in the same manner as in Example 1.

The properties of the rubber polymer and resultant graft copolymer are shown in Table 2A.

10 Example 9

A stainless steel-made autoclave equipped with a stirrer was charged with the following composition of materials, followed by nitrogen aeration, gas- evacuation and heating to 80 °C.

15	3-Isopropenylbiphenyl	10.5 wt.part(s)
	(liquid, purity 99.5 %)	
	Diisopropylbenzene hydroperoxide	0.150 "
	(purity 50 %)	
	Sodium pyrophosphate	0.125 "
20	Disodium ethylenediamine- tetraacetate	0.00375 "
	Ferrous sulfate	0.00225 "
	Potassium oleate aqueous solution	2.58 "
	(15.5 %)	
25	Deionized water	200 "

After the temperature within the autoclave reached 80°C, 64.5 wt. parts of 1,3-butadiene was



added to sufficiently mix the 3-isopropenylbiphenyl with the butadiene. Thereafter, 0.6 wt. part of sodium formaldehyde sulfoxylate aqueous solution (5 %) was added to initiate emulsion polymerization. After 2
5 hours from the commencement of polymerization, 2.3 wt. parts of potassium oleate aqueous solution (15.5 %) was post-added. During a period after 2.25 hours from the commencement of polymerization, 5.0 wt. parts of t-butyl hydroperoxide aqueous solution (5 %) and 5.0 wt.
10 parts of sodium formaldehyde sulfoxylate aqueous solution (5 %) were intermittently post-added. The polymerization conversion after 5 hours from the commencement of polymerization was almost 100 %.

The thus obtained latex was cooled to 60 °C,
15 and two stages of graft polymerization were performed in the same manner as in Example 1.

The properties of the resultant rubber polymer and graft copolymer are also shown in Table 2A.

Example 10

20 A stainless steel-made autoclave equipped with a stirrer was charged with the following composition of materials, followed by nitrogen aeration, gas-evacuation and heating to 80 °C.

3-Isopropenylbiphenyl	11.7 wt.part(s)
25 (purity 99.5 %)	
t-Dodecyl mercaptan	0.2 "



	Diisopropylbenzene hydroperoxide	0.150 wt.part(s)
	(purity 50 %)	
	Sodium pyrophosphate	0.125 "
	Disodium ethylenediamine-	
5	tetraacetate	0.00375 "
	Ferrous sulfate	0.00225 "
	Potassium oleate aqueous solution	0.50 "
	(15.5 %)	
	Deionized water	200 "

- 10 After the temperature within the autoclave reached 80°C, 53.3 wt. parts of 1,3-butadiene was added to mix the 3-isopropenylbiphenyl within the autoclave with the butadiene. Thereafter, 0.6 wt. part of sodium formaldehyde sulfoxylate aqueous solution (5
- 15 %) was added to initiate emulsion polymerization. After 15 hours from the commencement of polymerization, 2.1 wt. parts of potassium oleate aqueous solution (15.5 %) was post-added. During a period after 20
- 20 hours from the commencement of polymerization, 1.8 wt. parts of t-butyl hydroperoxide aqueous solution (5 %) and 1.8 wt. parts of sodium formaldehyde sulfoxylate aqueous solution (5 %) were intermittently post-added. The polymerization conversion after 35 hours from the commencement of polymerization was almost 100 %.
- 25 The resultant latex was cooled to 60 °C, and the following monomer mixture and polymerization aids were added thereto, followed by 4 hours of graft



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polymerization.

	Methyl methacrylate	10.5 wt.part(s)
	Styrene	5.0 "
	3-Isopropenylbiphenyl	2.0 "
5	t-Butyl hydroperoxide aqueous solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	3.0 "

Then, the following monomers and polymerization
10 aids were added to the system, followed by 4 hours of
a second stage graft polymerization at 60 °C.

	Methyl methacrylate	10.5 wt.part(s)
	Styrene	5.0 "
	3-Isopropenylbiphenyl	2.0 "
15	t-Butyl hydroperoxide aqueous solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	3.0 "

The properties of the resultant rubber polymer
20 and graft copolymer are also shown in Table 2A.

Example 11

Emulsion polymerization was performed in the
same manner as in Example 1 except that the 9.75 wt.
parts of 4-isopropenylbiphenyl was replaced by 9.75 wt.
25 parts of 2-isopropenylnaphthalene (crystal, purity 99.8
%), the amount of potassium oleate aqueous solution was
changed to 2.90 wt. parts and the amount of _____



divinylbenzene was changed to zero.

The properties of the resultant rubber polymer and graft copolymer are also shown in Table 2.

Example 12

5 A pressure-resistant glass vessel was charged with the following monomers and polymerization aids and subjected to 12 hours of emulsion polymerization under stirring at 60 °C.

	1,3-Butadiene	63.75 wt.part(s)
10	4-Vinylbiphenyl (crystal, purity 98 %)	11.25 "
	Divinylbenzene (purity 57.2 %)	0.262 "
	Diisopropylbenzene hydroperoxide (purity 50 %)	0.25 "
15	Sodium pyrophosphate	0.10 "
	Disodium ethylenediamine- tetraacetate	0.00375 "
	Ferrous sulfate	0.00225 "
20	Potassium oleate aqueous solution (15.5 %)	2.10 "
	Deionized water	200 "

The polymerization conversion to the resultant rubber polymer was almost 100 %.

25 To the rubber polymer latex, the following monomers and polymerization aids were added, followed by 2.5 hours of graft polymerization at 60 °C.



	Methyl methacrylate	10.5 wt.part(s)
	Butyl acrylate	2.0 "
	t-Butyl hydroperoxide aqueous solution (5 %)	2.0 "
5	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	2.4 "

Then, the following monomer and polymerization aids were added to the system, followed by 3 hours of graft polymerization at 60 °C.

10	Styrene	12.5 wt.part(s)
	t-Butyl hydroperoxide aqueous solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	4.0 "

15 The properties of the resultant rubber polymer and graft copolymer are also shown in Table 2A.

Example 13

A rubber polymer latex was prepared through 20 hours of emulsion polymerization at 60 °C in a similar manner as in Example 12 with the proviso that the 11.25 wt. parts of 4-vinylbiphenyl was replaced by 11.25 wt. parts of 2-vinylnaphthalene (crystal, purity 98 %), the amount of diisopropylbenzene hydroperoxide was changed to 0.30 wt. part, the amount of potassium oleate aqueous solution was changed to 4.50 wt. parts, and the other polymerization aids were the same as in Example 12.



The resultant rubber polymer latex was subjected to the same two stages of graft polymerization as in Example 12.

The properties of the resultant rubber polymer and graft copolymer are also shown in Table 2A.

Example 14

Emulsion polymerization was performed in the same manner as in Example 1 except that the amounts of the 4-isopropenylbiphenyl, 1,3-butadiene and divinylnbenzene were changed to 7.0, 64.0 and 0 wt. part(s), respectively, 4.0 wt. parts of styrene was used anew, and the amount of potassium oleate aqueous solution before the commencement of polymerization was changed to 2.90 wt. parts.

The properties of the resultant rubber polymer and graft copolymer are shown in Table 2A.

Example 15

Emulsion polymerization was performed in the same manner as in Example 1 except that the amounts of the 4-isopropenylbiphenyl, 1,3-butadiene and divinylnbenzene were changed to 6.5, 62.0 and 0 wt. part(s), respectively, 6.5 wt. parts of 3-isopropenylbiphenyl was used anew, and the amount of potassium oleate aqueous solution before the commencement of polymerization was changed to 2.90 wt. parts.

The properties of the resultant rubber polymer and graft copolymer are shown in Table 2A.



Comparative Example 1

A stainless steel autoclave was charged with the following composition of monomers and polymerization aids including styrene instead of the 4-isopropenylbiphenyl used in Example 1 and subjected to emulsion polymerization at 80 °C.

	1,3-Butadiene	56.50	wt.part(s)
	Styrene	18.50	"
	Divinylbenzene	0.262	"
10	(purity 57.2 %)		
	Diisopropylbenzene hydroperoxide	0.150	"
	(purity 50 %)		
	Sodium pyrophosphate	0.125	"
	Disodium ethylenediamine-		
15	tetraacetate	0.00375	"
	Ferrous sulfate	0.00225	"
	Potassium oleate aqueous solution	0.84	"
	(15.5 %)		
	Deionized water	180	"

After 4 hours from the commencement of polymerization, 4.8 wt. parts of potassium oleate aqueous solution (15.5 %) was added. During a period after 5 hours from the commencement of polymerization, 1.0 wt. parts of t-butyl hydroperoxide aqueous solution (5 %) and 1.0 wt. parts of sodium formaldehyde sulfoxylate aqueous solution (5 %) were intermittently post-added. The polymerization conversion after 8



hours from the commencement of polymerization was almost 100 %.

The resultant butadiene-styrene copolymer latex was cooled to 60 °C and then subjected to two-
5 stages of graft polymerization by using the same compositions of monomers and polymerization aids as used in Example 1.

The properties of the resultant rubber polymer and graft copolymer are also shown in Table 2A.

10 Comparative Examples 2 - 4

Emulsion polymerization was started at 60 °C in the same manner as in Example 1 except that the amount of 1,3-butadiene and styrene was changed to 57.75 and 17.25 wt. parts (Comparative Example 2), 45.0
15 and 30.0 wt. parts (Comparative Example 3) and 37.5 and 37.5 wt. parts (Comparative Example 4), respectively.

After 3 hours from the commencement of polymerization, 3.8 wt. parts of potassium oleate
20 aqueous solution (15.5 %) was post-added. From 4 hours after the commencement of polymerization, 1.0 wt. part of t-butyl hydroperoxide aqueous solution (5 %) and 1.0 wt. part of sodium formaldehyde sulfoxylate aqueous solution (5 %) were added intermittently. The
25 polymerization conversion after 7 hours from the commencement of polymerization was almost 100 %.

Each of the three types of rubber polymer



latexes was subjected to two stages of graft polymerization in the same manner as in Example 1.

The properties of the resultant rubber polymers and graft copolymers are also shown in Table 2A.

Comparative Example 5

Emulsion polymerization for preparing a graft copolymer was performed in the same manner as in Example 10 except that the amount of 3-butadiene was changed to 49.4 wt. parts and the 1,3-isopropenyl-biphenyl was replaced by 15.6 wt. parts of styrene.

The properties of the resultant rubber polymer and graft copolymer are also shown in Table 2A.

Further, the compositions of the graft copolymers prepared in the above Examples and Comparative Examples are inclusively shown in Table 1.

Further, among the graft copolymers thus prepared, some graft copolymers having a refractive index close to that of polyvinylchloride resin were respectively mixed with polyvinyl chloride to obtain polyvinyl chloride resin compositions, and the properties (Charpy impact strengths and transparencies) of the resultant compositions were measured in the above-described manner. The results are shown in Table 2B.

(Evaluation)

The refractive indexes and glass transition



temperatures of rubber polymers obtained by
copolymerizing 4-isopropenylbiphenyl or styrene with
1,3-butadiene are shown at Examples 1 - 5 and
Comparative Examples 1 - 4 in Table 2A. In view of
5 these data in comparison, it is clear that the rubber
polymers obtained by using 4-isopropenylbiphenyl as a
comonomer (Examples 1 - 5) provided lower glass
transition temperatures than those of butadiene-styrene
copolymer rubbers (Comparative Examples 1 - 4) at
10 comparable refractive index levels.

It is also clear that the rubber polymers
comprising copolymers of 3-isopropenylbiphenyl
(Examples 9 and 10), 2-isopropenylnaphthalene (Example
11), 4-vinylbiphenyl (Example 12) and 2-
15 vinylnaphthalene (Example 13), respectively, with 1,3-
butadiene also provided lower glass transition
temperatures than those of butadiene-styrene copolymer
rubbers at comparable refractive index levels.

In view of Examples 5 and 6 using an identical
20 rubber polymer comprising a 1,3-butadiene/4-
isopropenylbiphenyl copolymer in comparison, the graft
copolymer obtained by using 3-isopropenylbiphenyl as a
grafting component (Example 6) provided a higher
refractive index and unexpectedly a lower glass
25 transition temperature of the rubber polymer portion
than the graft copolymer obtained without using such an
aromatic polycyclic vinyl monomer.



In this way, if the monomer represented by the formula (I) or (II) is used in both the rubber component and grafting component, it is possible to effectively increase the refractive index compared with the increase in glass transition temperature of the rubber polymer.

Further, in view of Example 10 and Comparative Example 5 using grafting components of the same composition including 3-isopropenylbiphenyl, it is clear that the graft copolymer obtained by using 3-isopropenylbiphenyl also in the rubber polymer (Example 10) provided a lower glass transition temperature of the rubber polymer and also higher refractive indexes of the rubber polymer and graft copolymer than the graft copolymer obtained by using styrene instead thereof (Comparative Example 5).

Example 16

A rubber polymer latex was prepared in the same manner as in Example 8 except that the charged amount of potassium oleate aqueous solution before the commencement of polymerization was changed to 4.0 wt. parts.

The polymerization conversion of the monomers was almost 100 %, and the average particle size of the rubber polymer latex was 110 nm.

The resultant rubber polymer latex was cooled to 60 °C, and the following mixture was added thereto,



followed by 6 hours of emulsion polymerization at 60 °C.

	Methyl methacrylate	12.5 wt.part(s)
	Styrene	12.5 "
5	t-Butyl hydroperoxide aqueous solution (5 %)	4.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	4.0 "

After 3 hours from the commencement of the graft polymerization, the following aqueous solutions were post-added.

	t-Butyl hydroperoxide aqueous solution (5 %)	4.0 wt.part(s)
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	4.0 "

The compositions and properties of the resultant rubber polymer and graft copolymer are shown in Tables 3 and 4, respectively, appearing hereinafter.

Example 17

A rubber polymer latex was prepared by emulsion polymerization in the same manner as in Example 16.

The resultant rubber polymer latex was cooled to 60 °C, and the following mixture of monomers and polymerization aids was added thereto, followed by 4.5 hours of graft polymerization at 60 °C.

Acrylonitrile	5.0 wt.part(s)
---------------	----------------



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	Styrene	7.5 wt.part(s)
	t-Butylhydroperoxide aqueous solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate	
5	aqueous solution (5 %)	3.0 "

Subsequently, the following monomer mixture and polymerization aids were added to the system, followed by 6 hours of second-stage graft polymerization.

10	Acrylonitrile	5.0 wt.part(s)
	Styrene	7.5 "
	t-Butylhydroperoxide aqueous solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate	
15	aqueous solution (5 %)	3.0 "

The compositions and properties of the resultant rubber polymer and graft copolymer are also shown in Tables 3 and 4.

Example 18

20 A rubber polymer latex was prepared by emulsion polymerization in the same manner as in Example 16 except that the amounts of 4-isopropenylbiphenyl, 1,3-butadiene and potassium oleate aqueous solution added before polymerization were
25 changed to 10.4 wt. parts, 69.6 wt. parts and 4.3 wt. parts, respectively.

The resultant rubber polymer latex was cooled



to 60 °C; and the following mixture was added thereto,
followed by 7.5 hours of graft polymerization at 60 °C.

	Acrylonitrile	8.0 wt.part(s)
	Styrene	12.0 "
5	t-Butyl hydroperoxide aqueous solution (5 %)	3.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	3.0 "

After 3 hours from the commencement of the
10 graft polymerization, the following aqueous solutions
were post-added.

	t-Butyl hydroperoxide aqueous solution (5 %)	4.0 wt.part(s)
15	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	4.0 "

The compositions and properties of the
resultant rubber polymer and graft copolymer are also
shown in Tables 3 and 4.

From the results of Examples 16 - 18 shown in
20 Tables 3 and 4, the characteristics of the graft
copolymer according to the present invention that the
rubber polymer and the graft copolymer are provided
with a high refractive index while retaining a low
glass transition temperature of the rubber polymer,
25 explained with reference to Examples 1 - 15, were
commonly attained with respect to a one-stage graft
copolymer (Example 16), a two-stage graft copolymer



containing acrylonitrile in the grafting components (Example 17) and a one-stage graft copolymer containing acrylonitrile in the grafting component (Example 18).

Example 19

5 A rubber polymer latex was prepared by emulsion polymerization in the same manner as in Example 9 except that the charged amounts of 3-isopropenylbiphenyl, 1,3-butadiene and potassium oleate aqueous solution added before polymerization were
10 changed to 26.25 wt. parts, 48.75 wt. parts and 0.93 wt. parts, respectively. The resultant rubber polymer latex showed an average particle size of 210 nm.

 The rubber polymer latex was cooled, weighed in 77.5 wt. parts so as to provide 20 wt. parts of the
15 rubber content, and then charged into a stainless steel-made autoclave equipped with a stirrer together with the following mixture, followed by aeration with nitrogen and heating to 60 °C.

	Deionized water	140 wt.part(s)
20	Diisopropylbenzene hydroperoxide (purity 50 %)	0.15 "
	Sodium pyrophosphate	0.08 "
	Disodium ethylenediamine- tetraacetate	0.003 "
25	Ferrous sulfate	0.0018 "
	Potassium oleate aqueous solution (15.5 %)	3.2 "



After the temperature within the autoclave reached 60 °C, 23 wt. parts of acrylonitrile and 57 wt. parts of styrene were added, and then 0.6 wt. part of sodium formaldehyde sulfoxylate aqueous solution (5 %) was added to start graft polymerization. From 9 hours after the commencement of the graft polymerization, the following aqueous solution was post-added intermittently.

10	t-Butyl hydroperoxide aqueous solution (5 %)	4.0 wt.part(s)
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	4.0 wt.part(s)

15 An antioxidant emulsion was added to the latex after 12 hours of the graft polymerization, followed by acid precipitation with hydrochloric acid aqueous solution, de-watering, washing with water and drying to obtain a powdery graft copolymer.

The thus-prepared powdery graft copolymer having a rubber content of 20 wt. % was kneaded for 3 min. on rollers having a surface temperature of 175 °C. The resultant milled sheet was preheated for 2 min. and then molded under a load of 150 kg/cm² for 1 min. by means of a hot press having a hot plate temperature of 200 °C to be molded into a 2 mm-thick plate product. A test piece measuring 50 mm-long and 50 mm-wide was cut out from the plate product and subjected to measurement of a parallel light transmittance and a haze value



similarly as in the case of a polyvinyl chloride resin composition.

Further, a No. 5 test specimen (with a V-notch) according to JIS K-7111 (1984) was cut out from the 2 mm-thick plate product and subjected to a Charpy impact test at 23 °C. Further, a No. 1 E.D test specimen (without a V-notch) was similarly cut out and subjected to a Charpy impact test at 0 °C.

Comparative Example 6

10 A rubber polymer latex was prepared in the same manner as in Comparative Example 1 except that the charged amounts of 1,3-butadiene, styrene, divinylbenzene, deionized water and potassium oleate aqueous solution added before polymerization were
15 changed to 33.75 wt. parts, 41.25 wt. parts, 0 wt. part, 200 wt. parts, and 0.81 wt. part, respectively. The resultant rubber polymer latex showed an average particle size of 200 nm.

The resultant rubber polymer latex was cooled,
20 weighed in 77.5 wt. parts so as to provide 20 wt. parts of the rubber content and then subjected to graft copolymerization in the same manner as in Example 19 to provide a graft copolymer latex containing 20 wt. parts of the rubber content. The latex was treated in the
25 same manner as in Example 19 to obtain a powdery graft copolymer.

The compositions of the rubber polymers and



graft copolymers prepared in Example 19 and Comparative Example 6 are shown in Table 3, and the properties thereof and of molded samples from the graft copolymers are shown in Table 4.

5 (Evaluation)

From the comparison of Example 19 and Comparison Example 6, it is clear that the rubber polymer containing 3-isopropenylbiphenyl according to the present invention (Example 19) showed a remarkably
10 lower glass transition temperature than the butadiene-styrene copolymer (Comparative Example 6) at an identical refractive index level. Further, the graft copolymer obtained in Comparative Example 6 was very brittle at a low temperature, whereas the graft
15 copolymer obtained in Example 19 showed an excellent impact resistance even at a low temperature.

Example 20

A stainless steel-made autoclave equipped with a stirrer was charged with the following composition of
20 starting materials, followed by closing, nitrogen-aeration and evacuation.

3-Isopropenylbiphenyl	28.0 wt.part(s)
t-Dodecyl mercaptan	0.14 "
Diisopropylbenzene hydroperoxide	0.21 "
25 (50 %)	
Sodium pyrophosphate	0.125 "



	Disodium ethylenediamine-		
	tetraacetate	0.00375 wt.part(s)	
	Ferrous sulfate	0.00225	"
	Sodium formaldehyde sulfoxylate	0.03	"
5	Sodium dodecyl-diphenyl-ether-		
	disulfonate aqueous solution	0.13	"
	(50 %)		
	De-ionized water	200	"

Then, 42.0 wt. parts of 1,3-butadiene was
10 supplied, and the autoclave was externally heated to 80
°C to start emulsion polymerization.

From 3 hours after the commencement of
polymerization, 1.2 wt. parts of t-butyl hydroperoxide
aqueous solution (5 %) and 1.2 wt. parts of sodium
15 formaldehyde sulfoxylate aqueous solution (5 %) were
post-added intermittently in 15 hours. Further, at 7
hours after the commencement of polymerization, 1.0 wt.
part of sodium dodecyl-diphenyl-ether-disulfonate
aqueous solution (50 %) was added so as to retain the
20 stability of emulsion polymer particles within the
autoclave.

After 18 hours of reaction, the pressure
within the autoclave was lowered to the atmospheric
pressure by venting, and then the latex within the
25 autoclave was cooled to 60 °C.

The resultant rubber polymer showed an average
particle size of 200 nm in its latex form and showed a



refractive index n_D at 23 °C of 1.568.

To the rubber polymer thus obtained, the following monomers and polymerization aids were added to effect 2.5 hours of graft polymerization at 60 °C.

5	Styrene	11.25 wt.part(s)
	Acrylonitrile	3.75 "
	t-Butyl hydroperoxide aqueous solution (5 %)	1.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	1.0 "
10		

Incidentally, the t-butyl hydroperoxide aqueous solution and sodium formaldehyde sulfoxylate aqueous solution were added intermittently in 5 times at an interval of 30 min.

15 Then, the following monomers and polymerization aids were added to effect 6 hours of second-stage graft polymerization at 60 °C.

	Styrene	11.25 wt.part(s)
	Acrylonitrile	3.50 "
20	Methyl methacrylate	0.25 "
	t-Butyl hydroperoxide aqueous solution (5 %)	1.0 "
	Sodium formaldehyde sulfoxylate aqueous solution (5 %)	1.0 "

25 Similarly, the t-butyl hydroperoxide aqueous solution and sodium formaldehyde sulfoxylate aqueous solution were added intermittently in 5 times at an



Further, at 4 hours after the commencement of the second stage-graft polymerization, the following polymerization aids were added.

The resultant graft copolymer latex showed an average particle size of 220 nm.

The rubber polymer component in the graft copolymer showed a glass transition temperature of -26°C , and the graft copolymer showed a refractive index n_D at 23°C of 1.569 in its sheet form.

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press having a hot plate temperature of 180 °C to be shaped into a 3 mm-thick plate product. A test piece measuring 50 mm-long and 50 mm-wide was cut out from the plate product and subjected to measurement of a parallel light transmittance and a haze value. Further, a No. 5 test specimen (with a V-notch) according to JIS K-7111 (1984) was cut out from the plate product and subjected to a Charpy impact test at 23 °C.

10 Comparative Example 7

A rubber polymer was prepared by emulsion polymerization in the same manner as in Example 20 except that 39.2 wt. parts of styrene was used instead of the 3-isopropenylbiphenyl and the amount of 1,3-butadiene was changed to 30.8 wt. parts.

The resultant rubber polymer showed an average particle size of 210 nm in its latex form and a refractive index n_D^{23} of 1.568 in its sheet form.

20 The rubber polymer latex obtained above was subjected to two stages of graft polymerization in the same manner as in Example 20.

The resultant graft copolymer showed an average particle size of 230 nm in its latex form and a refractive index n_D^{23} of 1.569 in its sheet form. The rubber polymer component in the graft copolymer showed a glass transition temperature of +4 °C.

In this way, a graft copolymer having



refractive indexes of its rubber component and itself which were identical to those of the graft copolymer in Example 20, was obtained in a powdery form.

20 wt. parts of the thus obtained graft
5 copolymer was blended with 80 wt. parts of the same acrylonitrile-styrene copolymer resin as used in Example 20 to prepare a 3 mm-thick plate product, which was similarly subjected to evaluation of impact resistance and transparency as in Example 20.

10 The compositions of the rubber polymers and graft copolymers prepared in Example 20 and Comparative Example 7 are shown in Table 5, and the properties thereof and of molded samples from the graft copolymers are shown in Table 6.

15 In Table 6, the properties of a molded sample prepared from the commercially available styrene-acrylonitrile copolymer alone are also shown for reference.

From the comparison of Example 20 and
20 Comparative Example 7, the graft copolymer containing 3-isopropenylbiphenyl in its rubber polymer component according to the present invention (Example 20) provided a much better impact resistance-improving effect than the corresponding graft copolymer using
25 styrene in its rubber polymer component (Comparative Example 7) with respect to styrene-acrylonitrile copolymer resin while retaining a good transparency.



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level.

As described hereinabove, the graft copolymer according to the present invention is characterized by its high refractive index as well as a low glass

5 transition temperature of its rubber component.

Accordingly, the graft copolymer is suitable for use as an impact resistance modifier to provide a

thermoplastic resin composition with excellent

transparency by mixing with various thermoplastic

10 resins inclusive of vinyl chloride resin and styrene-

acrylonitrile copolymer resin. Further, the graft

copolymer is also useful as a transparent thermoplastic

resin with excellent impact resistance suitable for

various purposes.

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Table 1 Composition of Graft Copolymer

	Rubber polymer components** (wt.parts)					1st graft components** (wt.parts)				2nd graft components** (wt.parts)		
	BD	comonomer		DVB	t-DM	MMA	BA	ST	3-IPB	MMA	ST	3-IPB
Ex. 1	65.25	4-IPB	9.75	0.262	---	10.5	2.0	---	---	---	12.5	---
2	60.0	4-IPB	15.0	0.262	---	10.5	2.0	---	---	---	12.5	---
3	56.25	4-IPB	18.75	0.262	---	10.5	2.0	---	---	---	12.5	---
4	52.5	4-IPB	22.5	0.262	---	10.5	2.0	---	---	---	12.5	---
5	45.0	4-IPB	30.0	0.262	---	10.5	2.0	---	---	---	12.5	---
6	45.0	4-IPB	30.0	0.262	---	6.25	---	---	6.25	6.25	---	6.25
7	64.5	4-IPB	10.5	---	---	10.5	2.0	---	---	---	12.5	---
8	65.25	4-IPB	9.75	---	---	10.5	2.0	---	---	---	12.5	---
9	64.5	3-IPB	10.5	---	---	10.5	2.0	---	---	---	12.5	---
10	53.3	3-IPB	11.7	---	0.2	10.5	---	5.0	2.0	10.5	5.0	2.0
11	65.25	2-IPN	9.75	---	---	10.5	2.0	---	---	---	12.5	---
12	63.75	4-VB	11.25	0.262	---	10.5	2.0	---	---	---	12.5	---
13	63.75	2-VN	11.25	0.262	---	10.5	2.0	---	---	---	12.5	---
14	64.0	4-IPB	7.0	---	---	10.5	2.0	---	---	---	12.5	---
15	62.0	4-IPB	6.5	---	---	10.5	2.0	---	---	---	12.5	---
Comp. Ex. 1	56.5		ST 18.5	0.262	---	10.5	2.0	---	---	---	12.5	---
2	57.75		ST 17.25	0.262	---	10.5	2.0	---	---	---	12.5	---
3	45.0		ST 30.0	0.262	---	10.5	2.0	---	---	---	12.5	---
4	37.5		ST 37.5	0.262	---	10.5	2.0	---	---	---	12.5	---
5	49.4		ST 15.6	---	0.2	10.5	---	5.0	2.0	10.5	5.0	2.0

** The respective monomer components are represented by their abbreviations as shown in the following page.

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Abbreviations in Table 1

- 1) BD: 1,3-butadiene
2) 4-IPB: 4-isopropenylbiphenyl
3) 3-IPB: 3-isopropenylbiphenyl
4) 2-IPN: 2-isopropenyl naphthalene
5) 4-VB: 4-vinylbiphenyl
6) 2-VN: 2-vinylnaphthalene
7) ST: styrene
8) DVB: divinylbenzene
9) t-DM: tertiary-dodecyl mercaptan
10) MMA: methyl methacrylate
11) BA: butyl acrylate

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Table 2A Properties of Graft Copolymer

	Refractive index (n_D^{23})		Tg (°C) ²⁾	Average particle size (nm)		Graft rate (%)	Graft efficiency (%)
	R.P. ¹⁾	G.C. ¹⁾		R.P.	G.C.		
Ex. 1	1.5372	1.5402	-53	160	170	31.1	93.2
2	1.5467	1.5472	-41	130	140	31.1	93.3
3	1.5537	1.5518	-35	130	140		
4	1.5598	1.5555	-29	140	150	31.0	93.0
5	1.5762	1.5670	-2	150	160		
6	1.5762	1.5721	-12	150	160		
7	1.5366	1.5389	-52	170	180		
8	1.5361	1.5388	-52	100(190) ³⁾	210		
9	1.5371	1.5392	-51	110	120	29.7	89.2
10	1.5403	1.5416	-55	300	350		
11	1.5384	1.5400	-49	120	130		
12	1.5367	1.5386	-57	110	120		
13	1.5370	1.5401	-56	120	130		
14	1.5361	1.5377	-53	130	140		
15	1.5362	1.5388	-51	120	130		
Comp.Ex. 1	1.5350	1.5397	-42	170	185		
2	1.5340	1.5384	-48	110	120		
3	1.5505	1.5482	-23	100	110		
4	1.5599	1.5547	-8	90	100		
5	1.5394	1.5406	-44	260	320		

1) R.P.: rubber polymer
G.C.: graft copolymer

2) Tg: glass transition temperature

3) The value in the parentheses represents the average particle size after size enlargement by coagulation.



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Table 2B Properties of Polyvinyl Chloride Composition

	Charpy impact strength** (kg.cm/cm ²)				Transparency	
	Formulation A ¹⁾		Formulation B ²⁾		Formulation A	
	23°C	10°C	23°C	10°C	Tp (%)	H (%)
Ex. 1	142(100%)	49(20%)			85.8	2.3
7	119(100%)	46(20%)			84.5	2.6
8	145(100%)	123(100%)			81.8	3.8
9			116(100%)	100(100%)	85.2	1.9
11			125(100%)	107(100%)	86.1	2.2
12			73(100%)	71(100%)	83.5	2.6
13			72(100%)	71(100%)	84.6	2.5
14			109(100%)		82.3	3.5
15			126(100%)		85.0	2.6
Comp.Ex. 1	109(100%)	20(0%)			84.2	2.6
2			49(60%)	39(40%)	83.0	2.8

** The values in the parentheses represent the ductile breakage percent.

- 1) Formulation A contained 10 wt. parts of the graft copolymer.
- 2) Formulation B contained 12 wt. parts of the graft copolymer.

Table 3

	Rubber polymer components** (wt.parts)				1st graft component** (wt.parts)			2nd graft component** (wt.parts)		
	BD	4-IPB	3-IPB	ST	MMA	AN	ST	MMA	AN	ST
Ex. 16	65.25	9.75	--	--	12.5	--	12.5	--	--	--
17	65.25	9.75	--	--	--	5.0	7.5	--	5.0	7.5
18	69.6	10.4	--	--	--	8.0	12.0	--	--	--
19	13.0	--	7.0	--	--	23.0	57.0	--	--	--
Comp.Ex. 6	9.0	--	--	11.0	--	23.0	57.0	--	--	--

** The abbreviations representing the monomers have the same meaning as in Table 1.



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Table 4

	Properties of graft copolymer					Properties of shaped samples		
	Refractive index (n_D^{23})		Tg (°C)	Average particle size (nm)		Charpy impact strength (kg.cm/cm ²)		Transparency
	R.P.	G.C.	R.P.	R.P.	G.C.	No.5 test specimen(23°C)	No.1 E.D. test specimen(0°C)	Tp (%) H (%)
Ex. 16	1.5371	1.5392	-52	110	120	--	--	--
17	1.5369	1.5421	-54	110	120	--	--	--
18	1.5366	1.5409	-55	120	130	--	--	--
19	1.5650	1.5649	-25	210	350	5.6	not broken	71.5 4.5
Comp. Ex. 6	1.5667	1.5662	+3	200	330	2.1	21.1 (broken)	72.2 3.6

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Table 5

	Rubber polymer components** (wt.parts)			1st graft component** (wt.parts)			2nd graft component** (wt.parts)		
	BD	3-IPB	ST	MMA	AN	ST	MMA	AN	ST
Ex. 20	42.0	28.0	--	--	3.75	11.25	0.25	3.50	11.25
Comp.Ex. 7	30.8	--	39.2	--	3.75	11.25	0.25	3.50	11.25

** The abbreviations representing the monomers have the same meanings as in Table 1.

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Table 6

	Properties of graft copolymer					Properties of shaped samples		
	Refractive index (n_D^{23})		Tg (°C)	Average particle size (nm)		Charpy impact strength (kg.cm/cm ²)	Transparency	
	R.P.	G.C.	R.P.	R.P.	G.C.		Tp (%)	H (%)
Ex.20	1.568	1.569	-26	200	220	3.0	81.1	2.9
Comp. Ex. 7	1.568	1.569	+4	210	230	1.1	77.3	7.2
No graft copolymer added						1.1	85.1	3.6

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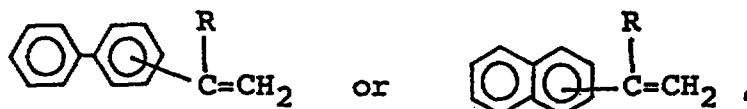
WHAT IS CLAIMED IS:

1. A graft copolymer, comprising: 5 - 90 wt. parts of a rubber polymer and 10 - 95 wt. parts of a vinyl monomer graft-polymerized onto the rubber polymer; said rubber polymer comprising 40 - 99 wt. % of butadiene and 1 - 60 wt. % of an aromatic polycyclic vinyl monomer represented by the following formula (I) or (II):

Formula (I)

Formula (II)

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wherein R denotes a hydrogen atom or a methyl group.

2. A graft copolymer according to Claim 1, wherein said rubber polymer shows a refractive index n_D^{23} of 1.52 to 1.60 at 23 °C, and a glass transition temperature of -70 °C to +10 °C.

3. A graft copolymer according to Claim 1 or 2, wherein said vinyl monomer comprising at least one member selected from the group consisting of alkyl methacrylates, alkyl acrylates, aromatic vinyl compounds, vinyl cyanides and mixtures of these, monomers with other vinyl monomers copolymerizable therewith.

4. A graft copolymer according to Claim 1 or 2,





wherein said vinyl monomer comprises at least one member selected from the group consisting of methyl methacrylate, styrene, acrylonitrile and butyl acrylate.

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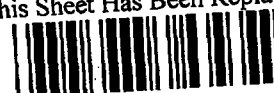
5. A graft copolymer according to Claim 1 or 2, wherein said vinyl monomer comprises an aromatic polycyclic vinyl monomer represented by the formula (I) or (II).

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6. A graft copolymer according to any one of Claims 1 - 5, wherein said aromatic polycyclic vinyl monomer represented by the formula (I) comprises at least one of 4-isopropenylbiphenyl and 3-isopropenyl-
15 biphenyl.

7. A graft copolymer according to any one of Claims 1 - 6, wherein said aromatic polycyclic vinyl monomer represented by the formula (II) comprises 2-
20 isopropenylnaphthalene.

8. A graft copolymer according to any one of Claims 1 - 7, which has been obtained by graft polymerization of the vinyl monomer in the presence of
25 the rubber polymer in its latex form having an average particle size of 50 - 800 nm.





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9. A graft copolymer according to any one of Claims 1 - 8, which has a graft ratio of 5 - 55 %.

5 10. A graft copolymer according to any one of Claims 1 - 9, wherein 15 - 50 wt. parts of the vinyl monomer is graft-polymerized onto 50 - 85 wt. parts of the rubber polymer.

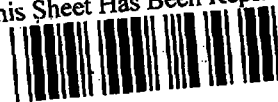
10 11. A graft copolymer according to any one of Claims 1 - 9, wherein 50 - 95 wt. parts of the vinyl monomer is graft-polymerized onto 5 - 50 wt. parts of the rubber polymer.

15 12. A thermoplastic resin composition comprising a mixture of a thermoplastic resin and a graft copolymer according to any one of Claims 1 to 11.

20 13. A thermoplastic resin composition according to Claim 12, which comprises 50 - 98 wt. parts of the thermoplastic resin and 2 - 50 wt. parts of the graft copolymer.

25 14. A thermoplastic resin composition according to Claim 12; wherein said graft copolymer comprises 50 - 85 wt. parts of the rubber polymer and 15 - 50 wt. parts of the vinyl monomer graft-polymerized onto the rubber polymer.

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15. A thermoplastic resin composition according to any one of Claims 12 - 14, wherein the thermoplastic resin comprises a vinyl chloride resin.

5 16. A thermoplastic resin composition according to any one of Claims 12 - 14, wherein the thermoplastic resin comprises a styrene-acrylonitrile copolymer resin.

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