

INDUSTRIAL PROCESS FOR PRODUCTION OF AROMATIC CARBONATE

Technical Field

The present invention relates to an industrial process for the production of an aromatic carbonate. More particularly, the present invention relates to an industrial process for producing a large amount of the aromatic carbonate useful as a raw material of a transesterification method polycarbonate, by subjecting a starting material containing a dialkyl carbonate and an aromatic monohydroxy compound to transesterification in a continuous multi-stage distillation column in which a catalyst is present, while efficiently separating out an alcohol from a large amount of a low boiling point reaction mixture containing the by-produced alcohol.

Background Art

An aromatic carbonate is important as a raw material for the production of an aromatic polycarbonate which is the most widely used as engineering plastic, without using toxic phosgene. As a process for producing an aromatic carbonate, a process of reacting an aromatic monohydroxy compound with phosgene has been known from long ago, and has also been the subject of a variety of studies in recent years. However, this process has the problem of using phosgene, and in addition chlorinated impurities which are difficult to separate out are present in the aromatic carbonate produced using this process, and hence this aromatic carbonate cannot be used as the raw material for the production of aromatic polycarbonate. Because, such chlorinated impurities markedly inhibit the polymerization reaction in the transesterification method which is carried out in the presence of an extremely small amount of a basic catalyst; for example, even if such chlorinated impurities are present in an amount of only 1 ppm, the polymerization hardly proceed at all. To

make the aromatic carbonate capable of using as a raw material of the transesterification method polycarbonate, troublesome multi-stage separation/purification processes such as enough washing with a dilute aqueous alkaline solution and hot water, oil/water separation, distillation and so on are required. Furthermore, the yield of the aromatic carbonate decreases due to hydrolysis loss and distillation loss during this separation/purification processes. Therefore, there are many problems in carrying out this method economically on an industrial scale.

On the other hand, a process for producing aromatic carbonates through transesterification reactions between a dialkyl carbonate and an aromatic monohydroxy compound is also known. However, such transesterification reactions are all equilibrium reactions. Since the equilibriums are biased extremely toward the original system and the reaction rates are slow, there have been great difficulties in producing the aromatic carbonates industrially in large amounts using this method. Several proposals have been made to improve the above difficulties, but most of these have related to development of a catalyst to increase the reaction rate. Many metal compounds have been proposed as catalysts for this type of transesterification reaction. For example, Lewis acids such as transition metal halides and Lewis acid-forming compounds (see Patent Document 1: Japanese Patent Application Laid-Open No. 51-105032; Patent Document 1-2: Japanese Patent Application Laid-Open No. 56-123948; Patent Document 1-3: Japanese Patent Application Laid-Open No. 56-123949 (corresponding to West German Patent Application No. 2528412, British Patent No. 1499530, and U.S. Patent No. 4182726); Patent Document 1-4: Japanese Patent Application Laid-Open No. 51-75044 (corresponding to West German Patent Application No. 2552907, and U.S. Patent No. 4045464)), tin compounds such as organotin alkoxides and organotin oxides

(see Patent Document 2-1: Japanese Patent Application Laid-Open No. 54-48733 (corresponding to West German Patent Application No. 2736062); Patent Document 2-2: Japanese Patent Application Laid-Open No. 54-63023; Patent Document 2-3: Japanese Patent Application Laid-Open No. 60-169444 (corresponding to U.S. Patent No. 4554110); Patent Document 2-4: Japanese Patent Application Laid-Open No. 60-169445 (corresponding to U.S. Patent No. 4552704); Patent Document 2-5: Japanese Patent Application Laid-Open No. 62-277345; Patent Document 2-6: Japanese Patent Application Laid-Open No. 1-265063), salts and alkoxides of alkali metals and alkaline earth metals (see Patent Document 3: Japanese Patent Application Laid-Open No. 56-25138), lead compounds (see Patent Document 4-1: Japanese Patent Application Laid-Open No. 57-176932; Patent Document 4-2: Japanese Patent Application Laid-Open No. 1-93560), complexes of metals such as copper, iron and zirconium (see Patent Document 5: Japanese Patent Application Laid-Open No. 57-183745), titanate acid esters (see Patent Document 6-1: Japanese Patent Application Laid-Open No. 58-185536 (corresponding to U.S. Patent No. 4410464); Patent Document 6-2: Japanese Patent Application Laid-Open No. 1-265062), mixtures of a Lewis acid and a protonic acid (see Patent Document 7: Japanese Patent Application Laid-Open No. 60-173016 (corresponding to U.S. Patent No. 4609501)), compounds of Sc, Mo, Mn, Bi, Te or the like (see Patent Document 8: Japanese Patent Application Laid-Open No. 1-265064), ferric acetate (see Patent Document 9: Japanese Patent Application Laid-Open No. 61-172852), and so on have been proposed. However, the problem of the disadvantageous equilibrium cannot be solved merely by developing the catalyst, and hence there are very many issues to be solved including the reaction system in order to provide a process for industrial production aiming for mass production.

Attempts have also been made to devise a reaction system so as to bias the

equilibrium toward the product system as much as possible, and thus improve the yield of the aromatic carbonates. For example, for the reaction between dimethyl carbonate and phenol, there have been proposed a method in which by-produced methanol is distilled off by azeotropy together with an azeotrope-forming agent

5 (See Patent Document 10: Japanese Patent Application Laid-Open No. 54-48732 (corresponding to West German Patent Application No. 736063, and U.S. Patent No. 4252737)), and a method in which the methanol produced as the by-product is removed by being absorbed onto a molecular sieve (See Patent Document 11: Japanese Patent Application Laid-Open No. 58-185536 (corresponding to U.S.

10 Patent No. 410464)). Moreover, a method has also been proposed in which, using an apparatus in which a distillation column is provided on the top of a reactor, an alcohol produced as the by-product in the reaction is separated off from the reaction mixture, and at the same time an unreacted starting material that evaporates is separated off by distillation (See Patent Documents 12-1: examples in Japanese

15 Patent Application Laid-Open No. 56-123948 (corresponding to U.S. Patent No. 4182726); Patent Document 12-2; examples in Japanese Patent Application Laid-Open No. 56-25138; Patent Document 12-3: examples in Japanese Patent Application Laid-Open No. 60-169444 (corresponding to U.S. Patent No. 4554110); Patent Document 12-4: examples in Japanese Patent Application Laid-Open No.

20 60-169445 (corresponding to U.S. Patent No. 4552704); Patent Document 12-5: examples in Japanese Patent Application Laid-Open No. 60-173016 (corresponding to U.S. Patent No. 4609501); Patent Document 12-6: examples in Japanese Patent Application Laid-Open No. 61-172852; Patent Document 12-7: examples in Japanese Patent Application Laid-Open No. 61-291545; Patent Document 12-7:

25 examples in Japanese Patent Application Laid-Open No. 62-277345)).

However, these reaction systems are basically batch system or switchover

system. Because, there is the limitation in the improvement of the reaction rate through the catalyst development for such a transesterification reaction, and the reaction rate is still slow, it has been thought that the batch system is preferable to a continuous system. Of these, a continuous stirring tank reactor (CSTR) system in which a distillation column is provided on the top of the reactor has been proposed as the continuous system, but there are problems such as the reaction rate being slow, and a gas-liquid interface in the reactor being small, based on the volume of the liquid. Hence it is not possible to make the conversion high. Accordingly, it is difficult to attain the object of producing the aromatic carbonate continuously in large amounts stably for a prolonged period of time by means of these above-mentioned methods, and many issues remain to be resolved before economical industrial implementation is possible.

The present inventors have developed reactive distillation methods in which such a transesterification reaction is carried out in a continuous multi-stage distillation column simultaneously with separation by distillation, and have been the first in the world to disclose that such a reactive distillation system is useful for such a transesterification reaction, for example, a reactive distillation method in which a dialkyl carbonate and an aromatic hydroxy compound are continuously fed into the multi-stage distillation column, the reaction is carried out continuously inside the column in which a catalyst is present, while continuously withdrawing a low boiling point component containing an alcohol produced as a by-product by distillation and continuously withdrawing a component containing a produced alkyl aryl carbonate from a lower portion of the column (See Patent Document 13: Japanese Patent Application Laid-Open No. 3-291257), a reactive distillation method in which an alkyl aryl carbonate is continuously fed into the multi-stage distillation column, the reaction is carried out continuously inside the column in which a catalyst is present, while

continuously withdrawing by distillation a low boiling point component containing a dialkyl carbonate produced as a by-product and continuously withdrawing a component containing a produced diaryl carbonate from a lower portion of the column (See Patent Document 14: Japanese Patent Application Laid-Open No.

5 4-9358), a reactive distillation method in which these reactions are carried out using two continuous multi-stage distillation columns, and hence a diaryl carbonate is produced continuously while efficiently recycling a dialkyl carbonate produced as a by-product (See Patent Document 15: Japanese Patent Application Laid-Open No. 4-211038), and a reactive distillation method in which a dialkyl carbonate and an
10 aromatic hydroxy compound or the like are continuously fed into the multi-stage distillation column, and a liquid that flows down through the column is withdrawn from a side outlet provided at an intermediate stage and/or a lowermost stage of the distillation column, and is introduced into a reactor provided outside the distillation column so as to bring about reaction, and is then introduced back through a
15 circulating inlet provided at a stage above the stage where the outlet is provided, whereby reaction is carried out in both the reactor and the distillation column (See Patent Documents 16-1: Japanese Patent Application Laid-Open No. 4-224547; Patent Document 16-2: Japanese Patent Application Laid-Open No. 4-230242; Patent Document 16-3: Japanese Patent Application Laid-open No. 4-235951).

20 These reactive distillation methods proposed by the present inventors are the first to enable aromatic carbonates to be produced continuously and efficiently, and many similar reactive distillation systems based on the above disclosures have been proposed thereafter (See Patent Documents 17 to 32: Patent Document 17: International Publication No. 00/18720 (corresponding to U.S. Patent No. 5362901),
25 Patent Document 18: Italian Patent No. 01255746, Patent Document 19: Japanese Patent Application Laid-Open No. 6-9506 (corresponding to European Patent No.

0560159, and U.S. Patent No. 5282965), Patent Document 20: Japanese Patent Application Laid-Open No. 6-41022 (corresponding to European Patent No. 0572870, and U.S. Patent No. 5362901), Patent Documents 21-1: Japanese Patent Application Laid-Open No. 6-157424 (corresponding to European Patent No. 0582931, and U.S. Patent No. 5334742); Patent Document 12-2: Japanese Patent Application Laid-Open No. 6-184058 (corresponding to European Patent No. 0582930, and U.S. Patent No. 5344954)); Patent Document 22: Japanese Patent Application Laid-Open No. 7-304713; Patent Document 23: Japanese Patent Application Laid-Open No. 9-40616; Patent Document 24: Japanese Patent Application Laid-Open No. 9-59225; Patent Document 25: Japanese Patent Application Laid-Open No. 9-110805; Patent Document 26: Japanese Patent Application Laid-Open No. 9-165357; Patent Document 27: Japanese Patent Application Laid-Open No. 9-173819; Patent Documents 28-1: Japanese Patent Application Laid-Open No. 9-176094; Patent Document 28-2: Japanese Patent Application Laid-Open No. 2000-191596; Patent Document 28-3: Japanese Patent Application Laid-Open No. 2000-191597; Patent Document 29: Japanese Patent Application Laid-Open No. 9-194436 (corresponding to European Patent No. 0785184, and U.S. Patent No. 5705673); Patent Document 30: International Publication No. 00/18720 (corresponding to U.S. Patent No. 6093842), Patent Documents 31-1: Japanese Patent Application Laid-Open No. 2001-64234; Patent Document 31-2: Japanese Patent Application Laid-Open No. 2001-64235; Patent Documents 32: International Publication No. 02/40439 (corresponding to U.S. Patent No. 6596894, U.S. Patent No. 6596895, U.S. Patent No. 6600061)).

Among reactive distillation systems, the present applicants have further proposed, as a method that enables highly pure aromatic carbonates to be produced stably for a prolonged period of time without a large amount of a catalyst being

required, a method in which a high boiling point material containing a catalyst component is reacted with an active substance and then separated off, and the catalyst component is recycled (see Patent Document 33: International Publication No. 97/11049 (corresponding to European Patent No. 0855384, and U.S. Patent No. 5872275)), and a method carried out while keeping a weight ratio of a polyhydric aromatic hydroxy compound in the reaction system to a catalyst metal at not more than 2.0 (see Patent Document 34: Japanese Patent Application Laid-Open No. 11-92429 (corresponding to European Patent No. 1016648, and U.S. Patent No. 6262210)). Furthermore, the present inventors have proposed a method in which 70 to 99 % by weight of phenol produced as a by-product in a polymerization process is used as a starting material, and diphenyl carbonate can be produced by means of the reactive distillation method. This diphenyl carbonate can be used as the raw material for polymerization of aromatic polycarbonates. (see Patent Document 35: Japanese Patent Application Laid-Open No. 9-255772 (corresponding to European Patent No. 0892001, and U.S. Patent No. 5747609)).

However, in all of these prior art documents in which the production of the aromatic carbonates using the reactive distillation method is proposed, there is no disclosure whatsoever of a specific process or apparatus enabling mass production on an industrial scale (e.g. 1 ton per hour), nor is there any description suggesting such a process or apparatus. For example, the descriptions regarding a height (H: cm), a diameter (D: cm), and a number of stages (n) of the reactive distillation column and a feeding rate of the raw materials (Q: kg/hr) disclosed for producing mainly methyl phenyl carbonate (MPC) from dimethyl carbonate and phenol are summarized in the following Table 1.

Table 1.

H : cm	D : cm	NUMBER OF STAGE : n	Q : kg/hr	PATENT DOCUMENT
60	5	10	0.5	19
200	5	20	1	20
350	2.8	—	0.2	21
500	5	50	0.6	23
100	4	—	1.4	24
300	5	40	1.5	26
300	5	40	1.5	28
400	12	40	53	29
340	5	40	2.3	32
1200	20	40	86	33
1200	20	40	86	34
600	—	20	66	35

In other words, the biggest continuous multi-stage distillation columns used when carrying out this reaction using the reactive distillation system are those disclosed by the present applicants in Patent Documents 33 and 34. As can be shown from Table 1, the maximum values of the various conditions for the continuous multi-stage distillation columns disclosed for the above reaction are H = 1200 cm, D = 20 cm, n = 50 (Patent document 23), and Q = 86 kg/hr, and the total amount of aromatic carbonates produced (methyl phenyl carbonate and diphenyl carbonate combined) was only approximately 10 kg/hr, which was not an amount produced on an industrial scale.

Moreover, several proposals have also been made regarding processes for separating out an alcohol from a reaction mixture containing methanol and the like by-produced through a transesterification reaction between dimethyl carbonate and phenol. For example, there have been proposed a process in which the above reaction is carried out using a reactor in which a liquid phase portion is divided into a plurality of reaction sections, and the reaction liquid passes through the sections in

order and flows out from the reactor, and gas is withdrawn from a vapor phase portion, and subjected to heat exchange, before being subjected to separation in a distillation column (see Patent document 36: Japanese Patent Application Laid-Open No. 2003-113144), and a process in which the same reactor is used, and the gas is
5 withdrawn from the vapor phase portion, and subjected to heat exchange and thus liquefied, before being subjected to separation by distillation at a pressure higher than the pressure in the vapor phase portion of the reactor (see Patent Document 37: Japanese Patent Application Laid-Open No. 2003-155264). However, the object of these processes is to recover the heat energy in the gas components by
10 producing steam using a heat exchanger when carrying out reaction using a continuous stirred tank reactor as mentioned earlier as the reactor. There is no disclosure or suggestion whatsoever regarding using the heat energy in the gas components to heat the starting material. Moreover, the composition of the gas components obtained using this reaction system is 97 % by weight of dimethyl
15 carbonate, 1.5 % by weight of methanol, and 1.5 % by weight of phenol (see Patent Document 36), or 98.1 % by weight of dimethyl carbonate, 1.4 % by weight of methanol, and 0.5 % by weight of phenol, methyl phenyl carbonate and so on (see patent Document 37), which differs greatly to the composition of a low boiling point reaction mixture containing a by-produced alcohol produced using a reactive
20 distillation system. This is obviously different therefore to the case of separating out to a predetermined concentration the alcohol from the low boiling point reaction mixture produced using a reactive distillation system. A process has also been proposed in which a liquid containing approximately 10 to 74 % by weight of methanol is distilled off at approximately 30 g / hr from the top of a distillation column
25 provided on top of a tank reactor (see Patent Document 38: Japanese Patent Application Laid-Open No. 6-157410). However, the above patent documents either

relate to processes carried out on a small-amount laboratory scale, or else merely relate to carrying out a comparative calculation of the amount of energy required for the distillation. There is no specific description or suggestion whatsoever in any of the above patent documents relating to carrying out separation on an industrial
5 scale.

In the case of carrying out transesterification reaction between a dialkyl carbonate and an aromatic hydroxy compound using a reactive distillation system, the by-produced alcohol is generally continuously withdrawn from an upper portion of the reactive distillation column as a low boiling point reaction mixture also containing
10 compounds present in the reaction system having a lower boiling point than that of the aromatic carbonate produced, for example the dialkyl carbonate and aromatic hydroxy compound constituting the starting material, a by-produced alkyl aryl ether and so on. The transesterification reaction is an equilibrium reaction having an extremely low equilibrium constant, and hence by-produced alcohol impedes this
15 reaction. In the case of industrial implementation, it thus becomes important to continuously carry out separation and recovery from the low boiling point reaction mixture into a component having a low content of the alcohol and a component containing mainly the alcohol efficiently and stably for a prolonged period of time.

Several proposals have been made regarding processes for carrying out
20 separation by distillation on a low boiling point reaction mixture containing methanol and dimethyl carbonate withdrawn from an upper portion of a column when subjecting dimethyl carbonate and phenol to transesterification reaction using a reactive distillation system. These are an extractive distillation process in which the methanol is withdrawn from the top of the column while extracting the dimethyl
25 carbonate using dimethyl oxalate as an extractant (see Patent Document 39: Japanese Patent Application Laid-Open No. 7-101908), an extractive distillation

process in which the methanol is withdrawn from the top of the column while extracting the dimethyl carbonate using ethylene carbonate as an extractant (see Patent Document 23), a process in which distillation is carried out at normal pressure and a mixture containing approximately 70 % by weight of methanol and

5 approximately 30 % by weight of dimethyl carbonate is obtained from the top of the column (see Patent Document 28), a process in which a mixture containing 64.5 % by weight of methanol and 35.5 % by weight of dimethyl carbonate is obtained from the top of the column (see Patent Document 29), and a process in which a mixture containing 60 to 40 % by weight of methanol and 40 to 60 % by weight of dimethyl
10 carbonate is obtained from the top of the column (see Patent Document 24).

However, with the extractive distillation processes, a large amount of the extractant must be used, and after the extraction, the extractant and the dimethyl carbonate must be further separated from one another. With the other processes, the content of the methanol in the liquid withdrawn from the top of the column is low
15 at less than 80 % by weight, and hence this is undesirable in the case of use as a raw material for producing dimethyl carbonate. Moreover, in the separation / recovery processes described in the above Patent Documents, the amount of methanol separated out and recovered is not more than a few hundreds of grams per hour. Even in Patent Document 20, which describes the largest amount, the
20 amount of methanol processed is only approximately 0.9 kg / hr.

Moreover, regarding the time for which the separating out of the methanol by distillation is carried out continuously in the above patent documents, the longest is in the case of Patent Document 26, in which a reaction system other than a reactive distillation system is used, and this is at most 720 hours. The longest in the case
25 that a reactive distillation system is used is only 2 weeks (Patent Document 28), with the others being 10 days (Patent Document 24), or the time taken for a steady state

to be attained (Patent Documents 14 and 30). These periods of time are extremely short, and there is no disclosure or suggestion of an industrial separation process in which the distillation operation is carried out stably for a prolonged period of time of several thousand hours, for example 5000 hours. In this way, hitherto there has
5 been no specific disclosure or suggestion whatsoever of an industrial separation process or apparatus for separating out the alcohol efficiently and stably for a prolonged period of time from a low boiling point reaction mixture containing an alcohol by-produced in a large amount when industrially producing the aromatic carbonate using a reactive distillation method.

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Disclosure of Invention

It is an object of the present invention to provide, in the case of producing an aromatic carbonate through a reactive distillation system using a continuous multi-stage distillation column from a dialkyl carbonate and an aromatic
15 monohydroxy compound, a specific process that enables the aromatic carbonate to be produced stably for a prolonged period of time on an industrial scale of not less than 1 ton / hr while efficiently separating out a by-produced alcohol.

Since the present inventors disclosed a process for producing aromatic carbonates using a continuous multi-stage distillation column, various proposals
20 regarding processes for the production of the aromatic carbonates by means of a reactive distillation method have been made. However, these have all been on a small scale and short operating time laboratory level, and there have been no disclosures whatsoever on a specific process or apparatus enabling mass production on an industrial scale. In view of these circumstances, the present inventors carried
25 out studies aimed at discovering a specific process enabling the aromatic carbonate to be produced stably for a prolonged period of time on an industrial scale of not less

than 1 ton / hr, while efficiently separating out a by-produced alcohol. As a result, the present inventors have arrived at the present invention.

That is, the present invention provides:

1. In an industrial process for the production of an aromatic carbonate in which the aromatic carbonate is continuously mass-produced on an industrial scale through a reactive distillation system of continuously feeding a starting material containing a dialkyl carbonate and an aromatic monohydroxy compound into a continuous multi-stage distillation column A in which a catalyst is present, carrying out transesterification reaction and distillation simultaneously in said distillation column A, continuously withdrawing a low boiling point reaction mixture A_T containing a by-produced alcohol from an upper portion of said distillation column A in a gaseous form, and continuously withdrawing a high boiling point reaction mixture A_B containing the aromatic carbonate from a lower portion of said distillation column A in a liquid form, the improvement which comprises:

- (a) said continuous multi-stage distillation column A comprises a distillation column having a length L (cm), an inside diameter D (cm), an internal with a number of stages n thereinside, a gas outlet having an inside diameter d_1 (cm) at the top of the column or in an upper portion of the column near to the top, a liquid outlet having an inside diameter d_2 (cm) at the bottom of the column or in a lower portion of the column near to the bottom, at least one inlet provided in the upper portion and/or a middle portion of the column below said gas outlet, and at least one inlet provided in the lower portion of the column above said liquid outlet, wherein L , D , n , d_1 , and d_2 satisfy the following formulae (1) to (6);

$$1500 \leq L \leq 8000 \quad (1)$$

$$100 \leq D \leq 2000 \quad (2)$$

$$2 \leq L/D \leq 40 \quad (3)$$

$$20 \leq n \leq 120 \quad (4)$$

$$5 \leq D / d_1 \leq 30 \quad (5)$$

$$3 \leq D / d_2 \leq 20 \quad (6);$$

(b) the low boiling point reaction mixture A_T is continuously fed into a continuous multi-stage distillation column B , and a low boiling point mixture B_T in which the concentration of the alcohol is not less than 90 % by weight is continuously withdrawn from an upper portion of said distillation column B in a gaseous form;

(c) a high boiling point mixture B_B having a low content of the alcohol is continuously withdrawn from a lower portion of said continuous multi-stage distillation column B in a liquid form, and said high boiling point mixture B_B is continuously fed into said continuous multi-stage distillation column A and thus reused in the transesterification; and

(d) said continuous multi-stage distillation column B comprises a distillation column comprising a stripping section having a length L_1 (cm), an inside diameter D_1 (cm) and an internal with a number of stages n_1 therein, and an enrichment section having a length L_2 (cm), an inside diameter D_2 (cm) and an internal with a number of stages n_2 therein, wherein L_1 , D_1 , n_1 , L_2 , D_2 , and n_2 satisfy the following formulae (7) to (14):

$$500 \leq L_1 \leq 3000 \quad (7)$$

$$100 \leq D_1 \leq 500 \quad (8)$$

$$2 \leq L_1 / D_1 \leq 30 \quad (9)$$

$$10 \leq n_1 \leq 40 \quad (10)$$

$$700 \leq L_2 \leq 5000 \quad (11)$$

$$50 \leq D_2 \leq 400 \quad (12)$$

$$10 \leq L_2 / D_2 \leq 50 \quad (13)$$

$$35 \leq n_2 \leq 100 \quad (14).$$

2. The process according to item 1, wherein not less than 1 ton / hr of the aromatic carbonate is produced.

3. The process according to item 1 or 2, wherein said d_1 and said d_2 satisfy the following formula:

$$1 \leq d_2 / d_1 \leq 5.$$

4. The process according to any one of items 1 to 3, wherein said continuous multi-stage distillation column A comprises a distillation column having a tray and/or a packing as said internal.

5. The process according to item 4, wherein said continuous multi-stage distillation column A comprises a plate-type distillation column having the tray as said internal.

6. The process according to item 5, wherein said tray is a sieve tray having a sieve portion and a down comer portion.

7. The process according to item 6, wherein said sieve tray has 100 to 1000 holes / m^2 in said sieve portion.

8. The process according to item 6 or 7, wherein the cross-sectional area per hole of said sieve tray is in a range of from 0.5 to 5 cm^2 .

9. The process according to any one of items 1 to 8, wherein L_1 , D_1 , L_1 / D_1 , n_1 , L_2 , D_2 , L_2 / D_2 , and n_2 for said continuous multi-stage distillation column B satisfy the following formulae: $800 \leq L_1 \leq 2500$, $120 \leq D_1 \leq 400$, $5 \leq L_1 / D_1 \leq 20$, $13 \leq n_1 \leq 25$, $1500 \leq L_2 \leq 3500$, $70 \leq D_2 \leq 200$, $15 \leq L_2 / D_2 \leq 30$, $40 \leq n_2 \leq 70$, $L_1 \leq L_2$, and $D_2 \leq D_1$.

10. The process according to any one of items 1 to 9, wherein the internal in each of the stripping section and the enrichment section of said continuous multi-stage distillation column B is a tray and/or a packing.

11. The process according to item 10, wherein the internal in each of the stripping section and the enrichment section of said continuous multi-stage distillation column

B is a tray.

12. The process according to item 11, wherein said tray is a sieve tray having a sieve portion and a down comer portion.

13. The process according to item 12, wherein said sieve tray has 100 to 1000
5 holes / m^2 in said sieve portion.

14. The process according to item 12 or 13, wherein the cross-sectional area per hole of said sieve tray is in a range of from 0.5 to 5 cm^2 .

15. The process according to any one of items 1 to 14, wherein an amount of the alcohol separated out in said continuous multi-stage distillation column B is not less
10 than 200 kg / hr.

16. The process according to any one of items 1 to 15, wherein a concentration of the alcohol in said low boiling point mixture B_T is not less than 95 % by weight.

17. The process according to item 16, wherein the concentration of the alcohol in said low boiling point mixture B_T is not less than 97 % by weight.

15 18. The process according to any one of items 1 to 17, wherein said low boiling point mixture B_T is taken as a starting material for producing a dialkyl carbonate.

19. The process according to any one of items 1 to 18, wherein a content of the alcohol in said high boiling point mixture B_B continuously withdrawn from the lower portion of said continuous multi-stage distillation column B in a liquid form is not
20 more than 0.2 % by weight.

20. The process according to item 19, wherein the content of the alcohol in said high boiling point mixture B_B is not more than 0.1 % by weight.

21. The process according to any one of items 1 to 20, wherein heat in said low boiling point reaction mixture A_T withdrawn in a gaseous form is used to heat the
25 starting material for the transesterification fed into said continuous multi-stage distillation column A.

Advantageous Effects of the Invention

It has been discovered that by implementing the present invention, the aromatic carbonate can be produced on an industrial scale of not less than 1 ton / hr, preferably not less than 2 ton / hr, more preferably not less than 3 ton / hr, with a high selectivity of not less than 95%, preferably not less than 97%, more preferably not less than 99%, stably for a prolonged period of time of not less than 2000 hours, preferably not less than 3000 hours, more preferably not less than 5000 hours, from a dialkyl carbonate and an aromatic monohydroxy compound, while efficiently separating out a by-produced alcohol at not less than 200 kg / hr.

Brief Description of Drawings

FIG. 1 is a schematic view of an example showing a continuous multi-stage distillation column A for carrying out reactive distillation in the present invention.

The continuous multi-stage distillation column A comprises an internal (for example, a tray 6) installed therein, which has n stages.

FIG. 2 is a schematic view of an example showing a continuous multi-stage distillation column B for carrying out separation by distillation on a low boiling point reaction mixture (A_T) containing an alcohol in the present invention. The continuous multi-stage distillation column B comprises an internal installed therein, wherein the number of stages of the internals is n_1 in a stripping section (for example, a tray 7) and n_2 in an enrichment section (for example, a tray 8), respectively; and

FIG. 3 is a schematic view of an example showing an apparatus for carrying out reactive distillation and distillation to separate out by-produced alcohols in the present invention.

1: gas outlet; 2: liquid outlet; 3 and 4: inlet; 5: end plate; 6, 7, 8: tray; SS: stripping

section; ES: enrichment section; L: length (cm) of a continuous multi-stage distillation column A; D: inside diameter (cm) of the continuous multi-stage distillation column A; d₁: inside diameter (cm) of gas outlet of the continuous multi-stage distillation column A; d₂: inside diameter (cm) of liquid outlet of the continuous multi-stage distillation column A; L₁: length (cm) of the stripping section of the continuous multi-stage distillation column A; L₂: length (cm) of the enrichment section of the continuous multi-stage distillation column A; D₁: inside diameter (cm) of a stripping section of the continuous multi-stage distillation column B; D₂: inside diameter of an enrichment section of the continuous multi-stage distillation column B; 10, 11, 20, 21, 31, 41, 51: inlet; 22, 25, 32, 35, 39: liquid outlet; 26, 36: gas outlet; 24, 34, 38 inlet; 23, 33, 27, 37: heat exchanger.

Best Mode for Carrying Out the Invention

In the following, the present invention is described in detail.

A dialkyl carbonate used in the present invention is a compound represented by the general formula (15);



wherein R¹ represents an alkyl group having 1 to 10 carbon atoms, an alicyclic group having 3 to 10 carbon atoms, or an aralkyl group having 6 to 10 carbon atoms.

Examples of R¹ include an alkyl group such as methyl, ethyl, propyl (isomers), allyl, butyl (isomers), butenyl (isomers), pentyl (isomers), hexyl (isomers), heptyl (isomers), octyl (isomers), nonyl (isomers), decyl (isomers) and cyclohexylmethyl; an alicyclic group such as cyclopropyl, cyclobutyl, cyclopentyl, cyclohexyl and cycloheptyl; and an aralkyl group such as benzyl, phenethyl (isomers), phenylpropyl (isomers), phenylbutyl (isomers) and methylbenzyl (isomers). The above-mentioned alkyl groups, alicyclic group and aralkyl group may be substituted with other substituents such as a lower alkyl group, a lower alkoxy group, a cyano group or a halogen atom,

and may also contain an unsaturated bond therein.

Examples of dialkyl carbonates having such R^1 include dimethyl carbonate, diethyl carbonate, dipropyl carbonate (isomers), diallyl carbonate, dibutenyl carbonate (isomers), dibutyl carbonate (isomers), dipentyl carbonate (isomers),
 5 dihexyl carbonate (isomers), diheptyl carbonate (isomers), dioctyl carbonate (isomers), dinonyl carbonate (isomers), didecyl carbonate (isomers), dicyclopentyl carbonate, dicyclohexyl carbonate, dicycloheptyl carbonate, dibenzyl carbonate, diphenethyl carbonate (isomers), di(phenylpropyl) carbonate (isomers), di(phenylbutyl) carbonate (isomers), di(chlorobenzyl) carbonate (isomers),
 10 di(methoxybenzyl) carbonate (isomers), di(methoxymethyl) carbonate, di(methoxyethyl) carbonate (isomers), di(chloroethyl) carbonate (isomers) and di(cyanoethyl) carbonate (isomers).

Of these dialkyl carbonates, ones preferably used in the present invention are dialkyl carbonates in which R^1 is an alkyl group having not more than four carbon
 15 atoms and not containing a halogen atom. A particularly preferable one is dimethyl carbonate. Moreover, of preferable dialkyl carbonates, particularly preferable ones are dialkyl carbonates produced in a state substantially not containing a halogen, for example ones produced from an alkylene carbonate substantially not containing a halogen and an alcohol substantially not containing a halogen.

20 An aromatic monohydroxy compound used in the present invention is a compound represented by the following formula (16). The type of the aromatic monohydroxy compound is not limited, so long as the hydroxyl group is directly bonded to the aromatic group;



25 wherein Ar^1 represents an aromatic group having 5 to 30 carbon atoms. Examples of aromatic monohydroxy compounds having such Ar^1 include phenol; various

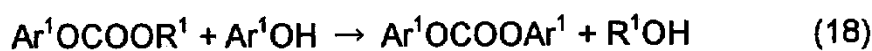
alkylphenols such as cresol (isomers), xlenol (isomers), trimethylphenol (isomers), tetramethylphenol (isomers), ethylphenol (isomers), propylphenol (isomers), butylphenol (isomers), diethylphenol (isomers), methylethylphenol (isomers), methylpropylphenol (isomers), dipropylphenol (isomers), methylbutylphenol (isomers), pentylphenol (isomers), hexylphenol (isomers) and cyclohexylphenol (isomers); various alkoxyphenols such as methoxyphenol (isomers) and ethoxyphenol (isomers); arylalkylphenols such as phenylpropylphenol (isomers); naphthol (isomers) and various substituted naphthols; and heteroaromatic monohydroxy compounds such as hydroxypyridine (isomers), hydroxycoumarin (isomers) and hydroxyquinoline (isomers). Of these aromatic monohydroxy compounds, ones preferably used in the present invention are unsubstituted and substituted phenols in which Ar^1 is an aromatic group having 6 to 10 carbon atoms. Phenol is particularly preferable. Moreover, of these aromatic monohydroxy compounds, ones substantially not containing a halogen are preferably used in the present invention.

The molar ratio of the dialkyl carbonate to the aromatic monohydroxy compound used as a starting material in the present invention must be in a range of from 0.5 to 3. Outside this range, the amount of unreacted starting material remaining relative to a predetermined amount produced of the aromatic carbonate aimed for becomes high, which is not efficient, and moreover much energy is required to recover the aromatic carbonate. For such reasons, the above molar ratio is more preferably in a range of from 0.8 to 2.5, yet more preferably from 1.0 to 2.0.

In the present invention, at least 1 ton / hr of the aromatic carbonate is produced continuously. The minimum amount of the aromatic monohydroxy compound fed in continuously for the above production is generally 13P ton / hr,

preferably 10P ton / hr, more preferably 7P ton / hr, based on the amount of the aromatic carbonate (P ton / hr) to be produced. More preferably, this amount can be made to be less than 7P ton / hr.

The aromatic carbonate produced in the present invention includes an alkyl aryl carbonate, or a diaryl carbonate or a mixture thereof, which are obtained through transesterification between the dialkyl carbonate and the aromatic monohydroxy compound. Included under this transesterification are a reaction in which one or both of the alkoxy groups of the dialkyl carbonate is/are exchanged with the aryloxy group of the aromatic monohydroxy compound and an alcohol is by-produced (formulae (17) and (18)). In the present invention, it is the reaction of formula (17) that mainly occurs.



Moreover, a reaction in which two molecules of the alkyl aryl carbonate produced are converted into the diaryl carbonate and the dialkyl carbonate through transesterification therebetween, i.e. disproportionation (formula (19)) is also partially involved.



In the present invention, although the alkyl aryl carbonate is mainly obtained, this alkyl aryl carbonate can be converted into the diaryl carbonate by being made to further undergo transesterification with the aromatic monohydroxy compound, or disproportionation (formula (19)). This diaryl carbonate does not contain a halogen at all, and hence will be important as a raw material when industrially producing a polycarbonate by means of a transesterification method.

Note that the dialkyl carbonate and the aromatic monohydroxy compound used in the starting material in the transesterification of the present invention may

each be of high purity, or may contain other compounds, for example may contain compounds or reaction by-products produced in this process and/or another process.

In the case of industrial implementation, for the starting material, besides fresh dialkyl carbonate and aromatic monohydroxy compound newly introduced into the reaction system, it is also preferable to use dialkyl carbonate and aromatic monohydroxy compound recovered from this process and/or another process.

In the present invention, a low boiling point reaction mixture (A_T) continuously withdrawn from an upper portion of a continuous multi-stage distillation column A is continuously subjected to separation by distillation in a continuous multi-stage distillation column B; a high boiling point mixture (B_B) having a low content of the by-produced alcohol continuously obtained as a column bottom component from the continuous multi-stage distillation column B must be reused as a starting material for the transesterification carried out in the continuous multi-stage distillation column A, this being essential for industrial implementation. In the process of the present invention, such recovered material containing other compounds can be used as the starting material. Accordingly, in the present invention, for example in the case of producing methyl phenyl carbonate and diphenyl carbonate using, in the starting material, dimethyl carbonate as the dialkyl carbonate and phenol as the aromatic monohydroxy compound, the starting material may contain small amounts of methanol, methyl phenyl carbonate and diphenyl carbonate, which are reaction products, and may also contain anisole, which is a reaction by-product, and high boiling point by-products.

As a catalyst used in the present invention, for example, a metal-containing compound selected from the following compounds can be used:

<lead compounds>:

lead oxides such as PbO , PbO_2 and Pb_3O_4 ; lead sulfides such as PbS and

Pb₂S; lead hydroxides such as Pb(OH)₂ and Pb₂O₂(OH)₂; plumbites such as Na₂PbO₂, K₂PbO₂, NaHPbO₂ and KHPbO₂; plumbates such as Na₂PbO₃, Na₂H₂PbO₄, K₂PbO₃, K₂[Pb(OH)₆], K₄PbO₄, Ca₂PbO₄ and CaPbO₃; lead carbonates and basic salts thereof such as PbCO₃ and 2PbCO₃·Pb(OH)₂; lead salts of organic acids, and carbonates and basic salts thereof, such as Pb(OCOCH₃)₂, Pb(OCOCH₃)₄ and Pb(OCOCH₃)₂·PbO·3H₂O, organolead compounds such as Bu₄Pb, Ph₄Pb, Bu₃PbCl, Ph₃PbBr, Ph₃Pb (or Ph₆Pb₂), Bu₃PbOH and Ph₃PbO (where Bu represents a butyl group, and Ph represents a phenyl group); alkoxylead compounds and aryloxylead compounds such as Pb(OCH₃)₂, (CH₃O)Pb(OPh) and Pb(OPh)₂; lead alloys such as Pb-Na, Pb-Ca, Pb-Ba, Pb-Sn and Pb-Sb; lead minerals such as galena and zinc blende; and hydrates of such lead compounds;

<copper family metal compounds>:

salts and complexes of copper family metals such as CuCl, CuCl₂, CuBr, CuBr₂, CuI, CuI₂, Cu(OAc)₂, Cu(acac)₂, copper oleate, Bu₂Cu, (CH₃O)₂Cu, AgNO₃, AgBr, silver picrate, AgC₆H₆ClO₄, [AuC≡C-C(CH₃)₃]_n and [Cu(C₇H₈)Cl]₄ (wherein acac represents an acetylacetone chelate ligand);

<alkali metal complexes>:

alkali metal complexes such as Li(acac) and LiN(C₄H₉)₂;

<zinc complexes>:

zinc complexes such as Zn(acac)₂;

<cadmium complexes>:

cadmium complexes such as Cd(acac)₂;

<iron family metal compounds>:

complexes of iron family metals such as Fe(C₁₀H₈)(CO)₅, Fe(CO)₅, Fe(C₄H₆)(CO)₃, Co(mesitylene)₂, (PEt₂Ph)₂, CoC₅F₅(CO)₇, Ni-π-C₅H₅NO and ferrocene;

<zirconium complexes>:

zirconium complexes such as $\text{Zr}(\text{acac})_4$ and zirconocene;

<Lewis acid type compounds>:

Lewis acids and Lewis acid-forming transition metal compounds such as AlX_3 ,

- 5 TiX_3 , TiX_4 , VOX_3 , VX_5 , ZnX_2 , FeX_3 and SnX_4 (wherein X represents a halogen atom, an acetoxy group, an alkoxy group or an aryloxy group); and

<organotin compounds>:

organotin compounds such as $(\text{CH}_3)_3\text{SnOCOCH}_3$, $(\text{C}_2\text{H}_5)_3\text{SnOCOC}_6\text{H}_5$,

$\text{Bu}_3\text{SnOCOCH}_3$, $\text{Ph}_3\text{SnOCOCH}_3$, $\text{Bu}_2\text{Sn}(\text{OCOCH}_3)_2$, $\text{Bu}_2\text{Sn}(\text{OCOC}_{11}\text{H}_{23})_2$,

- 10 $\text{Ph}_3\text{SnOCOCH}_3$, $(\text{C}_2\text{H}_5)_3\text{SnOPh}$, $\text{Bu}_2\text{Sn}(\text{OCH}_3)_2$, $\text{Bu}_2\text{Sn}(\text{OC}_2\text{H}_5)_2$, $\text{Bu}_2\text{Sn}(\text{OPh})_2$,

$\text{Ph}_2\text{Sn}(\text{OCH}_3)_2$, $(\text{C}_2\text{H}_5)_3\text{SnOH}$, Ph_3SnOH , Bu_2SnO , $(\text{C}_8\text{H}_{17})_2\text{SnO}$, Bu_2SnCl_2 and

$\text{BuSnO}(\text{OH})$.

Each of these catalysts may be a solid catalyst fixed inside the multi-stage distillation column, or may be a soluble catalyst that dissolves in the reaction system.

- 15 Each of these catalyst components may of course have been reacted with an organic compound present in the reaction system such as an aliphatic alcohol, the aromatic monohydroxy compound, the alkyl aryl carbonate, the diaryl carbonate or the dialkyl carbonate, or may have been subjected to heating treatment with the starting material or the products prior to the reaction.

- 20 In the case of carrying out the present invention with a soluble catalyst which dissolves in the reaction system, the catalyst is preferably one having a high solubility in the reaction liquid under the reaction conditions. Examples of preferable catalysts in this sense include PbO , $\text{Pb}(\text{OH})_2$ and $\text{Pb}(\text{OPh})_2$; TiCl_4 , $\text{Ti}(\text{OMe})_4$, $(\text{MeO})\text{Ti}(\text{OPh})_3$, $(\text{MeO})_2\text{Ti}(\text{OPh})_2$, $(\text{MeO})_3\text{Ti}(\text{OPh})$ and $\text{Ti}(\text{OPh})_4$; SnCl_4 ,
25 $\text{Sn}(\text{OPh})_4$, Bu_2SnO and $\text{Bu}_2\text{Sn}(\text{OPh})_2$; FeCl_3 , $\text{Fe}(\text{OH})_3$ and $\text{Fe}(\text{OPh})_3$; or such catalysts which have been treated with phenol, the reaction liquid or the like.

FIG. 1 is a schematic view of an example showing a continuous multi-stage distillation column A for carrying out reactive distillation in the present invention.

The continuous multi-stage distillation column A used for carrying out the reactive distillation in the present invention must be a distillation column having a length L

(cm), an inside diameter D (cm), an internal (for example, tray 6) with a number of stages n thereinside, a gas outlet having an inside diameter d_1 (cm) at the top of the column or in an upper portion of the column near to the top, a liquid outlet having an inside diameter d_2 (cm) at the bottom of the column or in a lower portion of the column near to the bottom, at least one inlet provided in the upper portion and/or a central portion of the column below the gas outlet, and at least one inlet provided in the lower portion of the column above the liquid outlet, wherein wherein L, D, n, d_1 , and d_2 satisfy the following formulae (1) to (6):

$$1500 \leq L \leq 8000 \quad (1)$$

$$100 \leq D \leq 2000 \quad (2)$$

$$2 \leq L / D \leq 40 \quad (3)$$

$$20 \leq n \leq 120 \quad (4)$$

$$5 \leq D / d_1 \leq 30 \quad (5)$$

$$3 \leq D / d_2 \leq 20 \quad (6).$$

It should be noted that the term "in an upper portion of the column near to the top" refers to the portion extending downwardly from the top of the column to the location measuring about 0.25 L, and the term "in a lower portion of the column near to the bottom" refers to the portion extending upwardly from the bottom of the column to the location measuring about 0.25L. Note that L is defined above.

FIG. 2 is a schematic view of an example showing a continuous multi-stage distillation column B for carrying out separation by distillation on a low boiling point

reaction mixture (A_T) containing an alcohol in the present invention. In the present invention, the continuous multi-stage distillation column B used for continuously subjecting the low boiling point reaction mixture (A_T) continuously withdrawn from the upper portion of the continuous multi-stage distillation column A to separation by

5 distillation into a low boiling point mixture (B_T) in which the concentration of the alcohol is not less than 90 % by weight and the high boiling point mixture (B_B) having a low content of the alcohol must be a distillation column comprising a stripping section SS having a length L_1 (cm), an inside diameter D_1 (cm) and an internal (for example, tray 7) with a number of stages n_1 thereinside, and an enrichment section

10 ES having a length L_2 (cm), an inside diameter D_2 (cm), and an internal (for example, tray 8) with a number of stages n_2 thereinside, wherein L_1 , D_1 , n_1 , L_2 , D_2 , and n_2 satisfy formulae (7) to (14):

$$500 \leq L_1 \leq 3000 \quad (7)$$

$$100 \leq D_1 \leq 500 \quad (8)$$

$$15 \quad 2 \leq L_1 / D_1 \leq 30 \quad (9)$$

$$10 \leq n_1 \leq 40 \quad (10)$$

$$700 \leq L_2 \leq 5000 \quad (11)$$

$$50 \leq D_2 \leq 400 \quad (12)$$

$$10 \leq L_2 / D_2 \leq 50 \quad (13)$$

$$20 \quad 35 \leq n_2 \leq 100 \quad (14).$$

Note that reference is made to the drawings in which the same reference numbers are used through the different figures to designate the same members.

It has been discovered that by using the continuous multi-stage distillation column A simultaneously satisfying formulae (1) to (6) and the multi-stage distillation

25 column B simultaneously satisfying formulae (7) to (14), the aromatic carbonate can be produced on an industrial scale of not less than 1 ton / hr with high selectivity and

high productivity stably for a prolonged period of time, for example not less than 2000 hours, preferably not less than 3000 hours, more preferably not less than 5000 hours, from the dialkyl carbonate and the aromatic monohydroxy compound, while efficiently separating out the by-produced alcohol stably for a prolonged period of time, and while efficiently recovering and reusing unreacted starting material. The reason why it has become possible to produce the at least one aromatic carbonate on an industrial scale with such excellent effects by implementing the process of the present invention is not clear, but this is supposed to be due to a combined effect brought about when the conditions of formulae (1) to (14) are combined.

10 Preferable ranges for the respective factors are described below.

 If L (cm) is less than 1500, then the conversion decreases and it is not possible to attain the desired production amount. Moreover, to keep down the equipment cost while securing the conversion enabling the desired production amount to be attained, L must be made to be not more than 8000. A more
15 preferable range for L (cm) is $2000 \leq L \leq 6000$, with $2500 \leq L \leq 5000$ being yet more preferable.

 If D (cm) is less than 100, then it is not possible to attain the desired production amount. Moreover, to keep down the equipment cost while attaining the desired production amount, D must be made to be not more than 2000. A more
20 preferable range for D (cm) is $150 \leq D \leq 1000$, with $200 \leq D \leq 800$ being yet more preferable.

 If L / D is less than 2 or greater than 40, then stable operation becomes difficult. In particular, if L / D is greater than 40, then the pressure difference between the top and bottom of the column becomes too great, and hence prolonged
25 stable operation becomes difficult. Moreover, it is necessary to increase the temperature in the lower portion of the column, and hence side reactions become

liable to occur, thereby bringing about a decrease in the selectivity. A more preferable range for L/D is $3 \leq L/D \leq 30$, with $5 \leq L/D \leq 15$ being yet more preferable.

If n is less than 20, then the conversion decreases and it is not possible to
 5 attain the desired production amount. Moreover, to keep down the equipment cost while securing the conversion enabling the desired production amount to be attained, n must be made to be not more than 120. Furthermore, if n is greater than 120, then the pressure difference between the top and bottom of the column becomes too great, and hence prolonged stable operation becomes difficult. Moreover, it is be
 10 necessary to increase the temperature in the lower portion of the column, and hence side reactions become liable to occur, thereby bringing about a decrease in the selectivity. A more preferable range for n is $30 \leq n \leq 100$, with $40 \leq n \leq 90$ being yet more preferable.

If D/d_1 is less than 5, then the equipment cost becomes high. Moreover,
 15 since large amounts of gaseous components are readily released to the outside of the system, the stable operation becomes difficult. If D/d_1 is greater than 30, then the gaseous component withdrawal amount becomes relatively low. Moreover, the stable operation becomes difficult, and a decrease in the conversion is brought about. A more preferable range for D/d_1 is $8 \leq D/d_1 \leq 25$, with $10 \leq D/d_1 \leq 20$
 20 being yet more preferable.

If D/d_2 is less than 3, then the equipment cost becomes high. Moreover,
 the liquid withdrawal amount becomes relatively high, and hence stable operation becomes difficult. If D/d_2 is greater than 20, then the flow rate through the liquid outlet and piping become excessively fast, and erosion becomes liable to occur,
 25 thereby bringing about corrosion of the apparatus. A more preferable range for D/d_2 is $5 \leq D/d_2 \leq 18$, with $7 \leq D/d_2 \leq 15$ being yet more preferable.

Furthermore, it has been found in the present invention that it is further preferable for d_1 and d_2 to satisfy the formula : $1 \leq d_2 / d_1 \leq 5$.

If L_1 (cm) is less than 500, then the separation efficiency for the stripping section decreases, and hence the desired separation efficiency cannot be attained.

5 Moreover, to keep down the equipment cost while securing the desired separation efficiency, L_1 must be made to be not more than 3000. A more preferable range for L_1 (cm) is $800 \leq L_1 \leq 2500$, with $1000 \leq L_1 \leq 2000$ being yet more preferable.

If D_1 (cm) is less than 100, then it is not possible to attain the desired distillation amount. Moreover, to keep down the equipment cost while attaining the
10 desired distillation amount, D_1 must be made to be not more than 500. A more preferable range for D_1 (cm) is $120 \leq D_1 \leq 400$, with $150 \leq D_1 \leq 300$ being yet more preferable.

If L_1 / D_1 is less than 2 or greater than 30, then prolonged stable operation becomes difficult. A more preferable range for L_1 / D_1 is $5 \leq L_1 / D_1 \leq 20$, with 7
15 $\leq L_1 / D_1 \leq 15$ being yet more preferable.

If n_1 is less than 10, then the separation efficiency for the stripping section decreases and hence the desired separation efficiency cannot be attained.
Moreover, to keep down the equipment cost while securing the desired separation efficiency, n_1 must be made to be not more than 40. A more preferable range for n_1
20 is $13 \leq n_1 \leq 25$, with $15 \leq n_1 \leq 20$ being yet more preferable.

If L_2 (cm) is less than 700, then the separation efficiency for the enrichment section decreases, and hence the desired separation efficiency cannot be attained.
Moreover, to keep down the equipment cost while securing the desired separation efficiency, L_2 must be made to be not more than 5000. Furthermore, if L_2 is greater
25 than 5000, then the pressure difference between the top and bottom of the column becomes too great, and hence prolonged stable operation becomes difficult.

Moreover, it becomes necessary to increase the temperature in the lower portion of the column, and hence side reactions become liable to occur. A more preferable range for L_2 (cm) is $1500 \leq L_2 \leq 3500$, with $2000 \leq L_2 \leq 3000$ being yet more preferable.

5 If D_2 (cm) is less than 50, then it is not possible to attain the desired distillation amount. Moreover, to keep down the equipment cost while attaining the desired distillation amount, D_2 must be made to be not more than 400. A more preferable range for D_2 (cm) is $70 \leq D_2 \leq 200$, with $80 \leq D_2 \leq 150$ being yet more preferable.

10 If L_2 / D_2 is less than 10 or greater than 50, then prolonged stable operation becomes difficult. A more preferable range for L_2 / D_2 is $15 \leq L_2 / D_2 \leq 30$, with $20 \leq L_2 / D_2 \leq 28$ being yet more preferable.

 If n_2 is less than 35, then the separation efficiency for the enrichment section decreases and hence the desired separation efficiency cannot be attained.

15 Moreover, to keep down the equipment cost while securing the desired separation efficiency, n_2 must be made to be not more than 100. Furthermore, if n_2 is greater than 100, then the pressure difference between the top and bottom of the column becomes too great, and hence prolonged stable operation becomes difficult.

 Moreover, it becomes necessary to increase the temperature in the lower portion of
20 the column, and hence side reactions become liable to occur. A more preferable range for n_2 is $40 \leq n_2 \leq 70$, with $45 \leq n_2 \leq 65$ being yet more preferable.

 Moreover, the relationship between L_1 and L_2 , and the relationship between D_1 and D_2 varies depending on the amount of the low boiling point reaction mixture (A_T) fed into the continuous multi-stage distillation column B, the concentration of the
25 alcohol and so on, but when carrying out the process of the present invention, preferably $L_1 \leq L_2$, and $D_2 \leq D_1$.

A characteristic feature of the present invention is that the aromatic carbonate can be produced stably for a prolonged period of time with high selectivity and with a high productivity of not less than 1 ton / hr, preferably not less than 2 ton / hr, more preferably not less than 3 ton / hr. Moreover, another characteristic feature of the present invention is that in the case that L , D , L / D , n , D / d_1 , and D / d_2 for the continuous multi-stage distillation column A satisfy the following formulae: $2000 \leq L \leq 6000$, $150 \leq D \leq 1000$, $3 \leq L / D \leq 30$, $30 \leq n \leq 100$, $8 \leq D / d_1 \leq 25$, and $5 \leq D / d_2 \leq 18$, respectively, not less than 2 ton / hr, preferably not less than 2.5 ton / hr, more preferably not less than 3 ton / hr of the aromatic carbonate can be produced. Furthermore, another characteristic feature of the present invention is that in the case that L , D , L / D , n , D / d_1 , and D / d_2 for the continuous multi-stage distillation column A satisfy the following formulae: $2500 \leq L \leq 5000$, $200 \leq D \leq 800$, $5 \leq L / D \leq 15$, $40 \leq n \leq 90$, $10 \leq D / d_1 \leq 25$, and $7 \leq D / d_2 \leq 15$, respectively, not less than 3 ton / hr, preferably not less than 3.5 ton / hr, more preferably not less than 4 ton / hr of the aromatic carbonate can be produced.

The "selectivity" for the aromatic carbonate in the present invention is based on the aromatic monohydroxy compound reacted. In the present invention, a high selectivity of not less than 95% can generally be attained, preferably not less than 97%, more preferably not less than 99%.

In the present invention, the continuous multi-stage distillation column A used as the reactive distillation column is preferably a distillation column having a tray and/or a packing as an internal. The term "internal" used in the present invention means the parts in each distillation column where gas and liquid are actually brought into contact with one another. As the tray, for example, a bubble-cap tray, a sieve tray, a valve tray, a counterflow tray, a Superfrac tray, a Maxfrac tray or the like are preferable. As the packing, an irregular packing such as a Raschig ring, a Lessing

ring, a Pall ring, a Berl saddle, an Intalox saddle, a Dixon packing, a McMahon packing or Heli-Pak, or a structured packing such as Mellapak, Gempak, TECHNO-PAK, Flexipac, a Sulzer packing, a Goodroll packing or a Glitchgrid are preferable. The multi-stage distillation column having both a tray portion and a portion packed with the packing can also be used. Note that the term "number of stages (n) of an internal" used in the present invention means that the total number of trays in the case of a tray, and the theoretical number of stages in the case of the packing. Accordingly, in the case of the multi-stage column having both the tray portion and the portion packed with the packing, n means the sum of the total number of trays and the theoretical number of stages of the packing.

It has been discovered that, because the transesterification reaction between the dialkyl carbonate and the aromatic monohydroxy compound in the present invention has an extremely low equilibrium constant and the reaction rate is slow, it is particularly preferable for the continuous multi-stage distillation column A used for the reactive distillation to be a plate-type distillation column having the tray as the internal. Furthermore, it has been discovered that the sieve tray having a sieve portion and a down comer portion is particularly good as the tray in terms of the relationship between performance and equipment cost. It has also been discovered that the sieve tray preferably has 100 to 1000 holes / m^2 in the sieve portion. A more preferable number of holes is 120 to 900 holes / m^2 , yet more preferably 150 to 800 holes / m^2 . Moreover, it has been discovered that the cross-sectional area per hole of the sieve tray is preferably in a range of from 0.5 to 5 cm^2 . A more preferable cross-sectional area per hole is 0.7 to 4 cm^2 , yet more preferably 0.9 to 3 cm^2 . Furthermore, it has been discovered that it is particularly preferable if the sieve tray has 100 to 1000 holes / m^2 in the sieve portion, and the cross-sectional area per hole is in a range of from 0.5 to 5 cm^2 . It has been shown that by adding

the above conditions to the continuous multi-stage distillation column A, the object of the present invention can be attained more easily.

The continuous multi-stage distillation column B used in the present invention is preferably a distillation column having a tray and/or a packing as the internal in each of the stripping section SS and the enrichment section ES. It is particularly preferable for the internal in each of the stripping section and enrichment section portion to be the tray. Furthermore, it has been discovered that the sieve tray having a sieve portion and a down comer portion is particularly good as the tray in terms of the relationship between performance and equipment cost. It has also been discovered that the sieve tray of each said stripping section and said enrichment section preferably has the same number of holes / m^2 and the same cross-sectional area per hole as described above in the case of said column A.

When carrying out the present invention, the dialkyl carbonate and aromatic monohydroxy compound constituting the starting material are continuously fed into the continuous multi-stage distillation column A in which the catalyst is present and reaction and distillation are carried out simultaneously in the column, and a high boiling point reaction mixture containing the aromatic carbonate is continuously withdrawn from the lower portion of the column in a liquid form, whereby the aromatic carbonate is continuously produced on an industrial scale. On the other hand, the low boiling point reaction mixture (A_T) containing the by-produced alcohol is continuously withdrawn from the upper portion of the column in a gaseous form. The low boiling point reaction mixture (A_T) is continuously fed into the continuous multi-stage distillation column B, the low boiling point mixture (B_T) having the alcohol as a main component thereof is continuously withdrawn from the upper portion of the column in a gaseous form, and the high boiling point mixture (B_B) is continuously withdrawn from the lower portion of the column in a liquid form. When being fed

into the continuous multi-stage distillation column B, the low boiling point reaction mixture (A_T) may be fed in as a gas, or as a liquid. Moreover, it is particularly preferable to use heat in the low boiling point reaction mixture (A_T), which is withdrawn from the continuous multi-stage distillation column A in a gaseous form, to heat another material, for example the starting material for the transesterification being fed into the continuous multi-stage distillation column A. In this case, depending on the extent to which the heat exchange is carried out, the low boiling point reaction mixture (A_T) fed into the continuous multi-stage distillation column B may be in a gaseous form, or a mixed gaseous/liquid form or a liquid form. It is also preferable to heat or cool the low boiling point reaction mixture (A_T) to a temperature close to the temperature of the liquid in the vicinity of the inlet of the continuous multi-stage distillation column B before feeding the low boiling point reaction mixture (A_T) into the continuous multi-stage distillation column B. Furthermore, as mentioned earlier, the starting material may contain the alcohol, the alkyl aryl carbonate and the diaryl carbonate that are reaction products, and reaction by-products such as an alkyl aryl ether and high boiling point compounds. Considering the equipment and cost required for separation and purification in other processes, when actually implementing the present invention industrially, it is preferable for the starting material to contain small amounts of such compounds.

Moreover, in the present invention, when continuously feeding the dialkyl carbonate and aromatic monohydroxy compound constituting the starting material into the continuous multi-stage distillation column A, this starting material may be fed into the distillation column A in a liquid form and/or a gaseous form from inlet(s) provided in one or a plurality of positions in the upper portion or the middle portion of the distillation column A below the gas outlet in the upper portion of the distillation column A. It is also preferable to feed a starting material containing a large

proportion of the aromatic monohydroxy compound into the distillation column in a liquid form from an inlet provided in the upper portion of the distillation column, and feed a starting material containing a large proportion of the dialkyl carbonate into the distillation column in a gaseous form and/or a liquid form from an inlet provided in the lower portion of the column above the liquid outlet in the lower portion of the distillation column. Moreover, the high boiling point mixture (B_B) from the continuous multi-stage distillation column B is continuously fed into the continuous multi-stage distillation column A from inlet(s) in the upper portion and/or the lower portion of the continuous multi-stage distillation column A; it is preferable to select the method of introduction depending on the composition of the high boiling point mixture (B_B).

In the present invention, the method of making the catalyst be present in the continuous multi-stage distillation column A may be any method, but in the case that the catalyst is a solid that is insoluble in the reaction liquid, there is, for example, a method in which the catalyst is fixed inside the column by, for example, being installed on a plate inside the continuous multi-stage distillation column or being installed in the form of a packing. In the case of a catalyst that dissolves in the starting material or the reaction liquid, it is preferable to feed the catalyst into the distillation column from a position above the middle portion of the distillation column. In this case, the catalyst liquid dissolved in the starting material or reaction liquid may be introduced into the column together with the starting material, or may be introduced into the column from a different inlet to the starting material. The amount of the catalyst used in the present invention varies depending on the type thereof, the types and proportions of the starting material compounds, and reaction conditions such as the reaction temperature and the reaction pressure. The amount of the catalyst is generally in a range of from 0.0001 to 30 % by weight, preferably

from 0.005 to 10 % by weight, more preferably from 0.001 to 1 % by weight, based on the total weight of the starting material.

The reaction time for the transesterification carried out in the present invention is considered to equate to the average residence time of the reaction liquid in the continuous multi-stage distillation column A. The reaction time varies depending on the form of the internal in the distillation column A and the number of stages, the amount of the starting material fed into the column, the type and amount of the catalyst, the reaction conditions and so on. The reaction time is generally in a range of from 0.01 to 10 hours, preferably 0.05 to 5 hours, more preferably 0.1 to 3 hours. The reaction temperature varies depending on the type of the starting material compounds used, and the type and amount of the catalyst. The reaction temperature is generally in a range of from 100 to 350°C. It is preferable to increase the reaction temperature so as to increase the reaction rate. However, if the reaction temperature is too high, then side reactions become liable to occur, for example production of by-products such as an alkyl aryl ether increases, which is undesirable. For this reason, the reaction temperature is preferably in a range of from 130 to 280°C, more preferably 150 to 260°C, yet more preferably 180 to 250°C. Moreover, the reaction pressure varies depending on the type of the starting material compounds used and the composition of the starting material, the reaction temperature and so on. The reaction pressure may be any of a reduced pressure, normal pressure, or an applied pressure. The reaction pressure is generally in a range of from 0.1 to 2×10^7 Pa, preferably 10^5 to 10^7 Pa, more preferably 2×10^5 to 5×10^6 Pa.

In the present invention, the position from which the low boiling point reaction mixture (A_T) continuously withdrawn from the upper portion of the continuous multi-stage distillation column A is fed into the continuous multi-stage distillation

column B is between the stripping section SS and the enrichment section ES. The continuous multi-stage distillation column B preferably has a reboiler for heating the distillate, and a refluxing apparatus.

In the present invention, the low boiling point reaction mixture (A_T) is
5 generally withdrawn from the continuous multi-stage distillation column A in an amount of 10 to 1000 ton / hr, before being fed into the continuous multi-stage distillation column B and thus subjected to the separation by distillation, whereupon the low boiling point mixture (B_T) is continuously withdrawn from the upper portion of the distillation column B, and the high boiling point mixture (B_B) is continuously
10 withdrawn from the lower portion of the distillation column B. In the present invention, the concentration of the alcohol in the low boiling point mixture (B_T) must be made to be not less than 90 % by weight, and can preferably be made to be not less than 95 % by weight, more preferably not less than 97 % by weight, based on 100 % by weight of the low boiling point mixture (B_T). Moreover, the content of the
15 alcohol in the high boiling point mixture (B_B) can be made to be not more than 0.2 % by weight, preferably not more than 0.1 % by weight, based on 100 % by weight of the high boiling point mixture (B_B). Furthermore, the amount of the alcohol separated out as the main component of the low boiling point mixture (B_T) must be not less than 200 kg / hr, and this alcohol can preferably be continuously separated
20 out stably for a prolonged period of time in an amount of not less than 500 kg / hr, more preferably 1 to 20 ton / hr.

In the present invention, the low boiling point mixture (B_T) separated off contains not less than 90 % by weight of the by-produced alcohol. All or most of the remainder of the low boiling point mixture (B_T) is dialkyl carbonate. It is thus
25 preferable to use the low boiling point mixture (B_T) as a raw material for dialkyl carbonate production. As processes for producing a dialkyl carbonate, a process

using a carbonylation reaction of an alcohol, and a process using an alcoholysis reaction of an alkylene carbonate are carried out industrially. The low boiling point mixture (B_T) can be used as a raw material for either of these reactions. The alcoholysis reaction of an alkylene carbonate is an equilibrium reaction, and hence it is preferable to use a raw material having a high alcohol concentration. It is thus preferable to use the low boiling point mixture (B_T) obtained in the present invention as the raw material for such a reaction. In this case, a low boiling point mixture (B_T) having an alcohol concentration of not less than 95 % by weight, more preferably not less than 97 % by weight, based on the 100 % by weight of the low boiling point mixture (B_T), is particularly preferably used as the raw material.

Moreover, the high boiling point mixture (B_B) separated off in the present invention comprises the components of the low boiling point reaction mixture (A_T) minus those withdrawn as the low boiling point mixture (B_T). The high boiling point mixture (B_B) contains not more than 0.2 % by weight, preferably not more than 0.1 % by weight, of the by-produced alcohol, and generally has the dialkyl carbonate and the aromatic monohydroxy compound as main components thereof, while also containing a small amount of the by-produced alkyl aryl ether and a small amount of the aromatic carbonate. In the present invention, it is thus particularly preferable to continuously feed the high boiling point mixture (B_B) into the continuous multi-stage distillation column A, and thus use the high boiling point mixture (B_B) as a starting material for the transesterification. In this case, the amount of the dialkyl carbonate in the starting material fed into the continuous multi-stage distillation column A will be insufficient with just that in the high boiling point mixture (B_B), and hence it is generally necessary to add fresh starting material containing the dialkyl carbonate in an amount commensurate with the amount consumed in the reaction. The starting material containing the dialkyl carbonate freshly added into the continuous

multi-stage distillation column A may be fed into the continuous multi-stage distillation column A directly, or may be fed into the continuous multi-stage distillation column B and thus then fed into the continuous multi-stage distillation column A as part of the high boiling point mixture (B_B). In the case that this freshly added starting material
5 containing the dialkyl carbonate contains the alcohol in a greater amount than, for example, 0.1 % by weight, it is preferable for this starting material to be fed into the continuous multi-stage distillation column B from a suitable position thereof so as to reduce the content of the alcohol, and to then be fed into the continuous multi-stage distillation column A as part of the high boiling point mixture (B_B).

10 It should be noted that the starting material fed into the continuous multi-stage distillation column A contains a starting material 1 and a starting material 2. Typically, the starting material 1 contains a dialkyl carbonate which has been mainly produced by the disproportionation reaction (formula (19)) of the alkyl aryl carbonate separately. Accordingly, in the continuous multi-stage distillation column A, about a
15 half amount of the dialkyl carbonate which has been consumed by the reaction in which the alkyl aryl carbonate is produced is made up for by adding the dialkyl carbonate into the starting material 1, which is produced by the above disproportionation reaction and is recycled. It is necessary to add a fresh dialkyl carbonate as the half amount of the dialkyl carbonate being deficient. This enables
20 the reactive distillation to continue at the steady state. In the present invention, the above deficiency can be generally made up for by adding the fresh dialkyl carbonate into the starting material 2, but the above deficiency can also be made up for by adding the fresh dialkyl carbonate into the starting material 1.

The distillation conditions for the continuous multi-stage distillation column B
25 used in the present invention are a column bottom temperature in a range of from 150 to 300°C, preferably 170 to 270°C, more preferably 190 to 250°C, and a column

top pressure in a range of from 2×10^5 Pa to 5×10^6 Pa, preferably 4×10^5 Pa to 3×10^6 Pa, more preferably 6×10^5 Pa to 2×10^6 Pa. A reflux ratio in the continuous multi-stage distillation column B is generally in a range of from 0.1 to 20, preferably from 0.5 to 15, more preferably from 1.0 to 10.

5 The term "prolonged stable operation" used in the present invention means that the continuous multi-stage distillation column A for carrying out the reactive distillation and the continuous multi-stage distillation column B for carrying out the separation by distillation on the low boiling point reaction mixture (A_T) can each be operated continuously in a steady state based on the operating conditions with no
10 flooding, clogging of piping, or erosion for not less than 1000 hours, preferably not less than 3000 hours, more preferably not less than 5000 hours, and a predetermined amount of the aromatic carbonate of not less than 1 ton / hr can be produced while maintaining a predetermined high productivity and high selectivity, and moreover a predetermined amount of the by-produced alcohol of not less than
15 200 kg / hr can be separated out by distillation while maintaining a prescribed separation efficiency.

 The material constituting the continuous multi-stage distillation columns used in the present invention is generally a metallic material such as carbon steel or stainless steel. In terms of the quality of the at least one aromatic carbonate
20 produced, stainless steel is preferable.

Examples

 Hereinbelow, the present invention will be described in more detail with reference to the following Examples, but the present invention is not limited to the
25 following Examples. A composition of each mixture was measured by means of a gas chromatography method, and a halogen content was measured by means of an

ion chromatography method.

Example 1:

<Continuous multi-stage distillation column A>

5 A continuous multi-stage distillation column as shown in FIG. 1 having $L = 3300$ cm, $D = 500$ cm, $L / D = 6.6$, $n = 80$, $D / d_1 = 17$, and $D / d_2 = 9$ was used. In this Example, a sieve tray was used as the internal, which has the cross-sectional area per hole being approximately 1.5 cm^2 and the number of holes being approximately $250 / \text{m}^2$.

10 <Continuous multi-stage distillation column B>

 A continuous multi-stage distillation column as shown in FIG. 2 having $L_1 = 1700$ cm, $D_1 = 180$ cm, $L_1 / D_1 = 9.4$, $n_1 = 16$, $L_2 = 2500$ cm, $D_2 = 100$ cm, $L_2 / D_2 = 25$, and $n_2 = 55$ was used. In this Example, a sieve tray (the cross-sectional area per hole being approximately 1.3 cm^2 and the number of holes being approximately
15 $550 / \text{m}^2$) was used as the internal in both the stripping section and the enrichment section.

<Reactive distillation, and separating out of by-produced methanol from low boiling point reaction mixture (A_T)>

 Reactive distillation and separating out of by-produced methanol were
20 carried out using the apparatus shown in FIG. 3.

 A starting material 1 containing 44 % by weight of dimethyl carbonate, 49 % by weight of phenol, 5.7 % by weight of anisole, 1 % by weight of methyl phenyl carbonate, and 0.3 % by weight of methanol was continuously introduced into the continuous multi-stage distillation column A in a liquid form at a flow rate of 80.8 ton /
25 hr from an upper portion inlet 21 of the continuous multi-stage distillation column A. Note that the starting material 1 was introduced from an inlet 20, and was fed in

through the inlet 21 after having been heated using a heat exchanger 27 with heat from a low boiling point reaction mixture (A_T) withdrawn in a gaseous form from the upper portion of the distillation column A. On the other hand, a starting material 2 containing 76 % by weight of dimethyl carbonate, 19.5 % by weight of phenol, 4.4 %
5 by weight of anisole, and 0.1 % by weight of methyl phenyl carbonate was continuously introduced into the distillation column A at a flow rate of 86 ton / hr from a lower portion inlet 11 of the distillation column A. The molar ratio for the starting materials introduced into the continuous multi-stage distillation column A was dimethyl carbonate / phenol = 1.87. The starting materials substantially did not
10 contain halogens (outside the detection limit for the ion chromatography, i.e. 1 ppb or less). $Pb(OPh)_2$ as a catalyst was introduced in from an inlet 10 in the upper portion of the distillation column A such that a concentration thereof in the reaction liquid would be approximately 70 ppm. Reactive distillation was carried out continuously under conditions of a temperature at the bottom of the distillation column A being
15 $233^{\circ}C$ and a pressure at the top of the distillation column A being 9.6×10^5 Pa. It was possible to attain stable steady state operation after 24 hours. A liquid continuously withdrawn at 82.3 ton / hr from an outlet 25 connected to the bottom of the distillation column A contained 10.1 % by weight of methyl phenyl carbonate and 0.27 % by weight of diphenyl carbonate. It was found that the amount of methyl
20 phenyl carbonate produced was 8.3 ton / hr (subtracting the amount introduced into the distillation column A, the actual amount produced was 7.5 ton / hr), and the amount of diphenyl carbonate produced was 0.22 ton / hr. The total selectivity for the methyl phenyl carbonate and diphenyl carbonate based on the phenol reacted was 99%.

25 Prolonged continuous operation was carried out under these conditions.

The amounts produced per hour at 500 hours, 2000 hours, 4000 hours, 5000 hours,

and 6000 hours after attaining stable steady state were 8.3 tons, 8.3 tons, 8.3 tons, 8.3 tons, and 8.3 tons respectively for the methyl phenyl carbonate, and 0.22 tons, 0.22 tons, 0.22 tons, and 0.22 tons respectively for the diphenyl carbonate. The total selectivities for the methyl phenyl carbonate and diphenyl carbonate were 5 99%, 99%, 99%, 99%, and 99% respectively, and hence the operation was very stable. Moreover, the aromatic carbonates produced substantially did not contain halogens (1 ppb or less).

The low boiling point reaction mixture (A_T) continuously withdrawn in a gaseous form from the top of the continuous multi-stage distillation column A was 10 cooled down to 170°C through heat therein being used to heat the starting material 1 using the heat exchanger 27 as described above. The composition of the low boiling point reaction mixture (A_T), which was withdrawn at 85.2 ton / hr, was 2 % by weight of methanol, 74 % by weight of dimethyl carbonate, 19.5 % by weight of phenol, 4.4 % by weight of anisole, and 0.1 % by weight of methyl phenyl carbonate. 15 After being made to have a temperature close to the temperature of the liquid in the vicinity of an inlet 31 provided between the stripping section and the enrichment section in the continuous multi-stage distillation column B, the low boiling point reaction mixture (A_T) was continuously fed into the distillation column B from the inlet 31. On the other hand, in order to make up for the deficient dimethyl carbonate, 20 fresh dimethyl carbonate was continuously introduced into the distillation column B at 2.53 ton / hr from an inlet 41 provided in the lower portion of the distillation column B. Separation by distillation was carried out continuously in the distillation column B at a column bottom temperature of 226°C, a column top temperature of 155°C, and a reflux ratio of 3, and a low boiling point mixture (B_T) was continuously withdrawn from 25 an outlet 39 at 1.73 ton / hr, while a high boiling point mixture (B_B) was continuously withdrawn from an outlet 35 at 86 ton / hr. The high boiling point mixture (B_B) had a

methanol content of not more than 0.1 % by weight, and had a composition the same as the starting material 2 for the continuous multi-stage distillation column A described above, and was circulated back and thus reused as the starting material 2.

The composition of the low boiling point mixture (B_T) was 97 % by weight of methanol, and 3 % by weight of dimethyl carbonate. The amount of methanol continuously separated out through the distillation was 1.68 ton / hr. The low boiling point mixture (B_T) was used as a raw material for producing dimethyl carbonate and ethylene glycol by reacting with ethylene carbonate.

The operation of the continuous multi-stage distillation column B was carried out in synchronization with the continuous operation of the continuous multi-stage distillation column A. The separation efficiency was the same after 500 hours, 2000 hours, 4000 hours, 5000 hours, and 6000 hours as initially, and hence operation remained stable.

15 Example 2:

Reactive distillation and separating out of by-produced methanol were carried out under the following conditions using the same continuous multi-stage distillation column A and continuous multi-stage distillation column B as in Example 1.

20 <Reactive distillation>

A starting material 1 containing 33.3 % by weight of dimethyl carbonate, 58.8 % by weight of phenol, 6.8 % by weight of anisole, 0.9 % by weight of methyl phenyl carbonate, and 0.2 % by weight of methanol was continuously introduced into the continuous multi-stage distillation column A in a liquid form at a flow rate of 86.2 ton / hr through the upper portion inlet 21 of the continuous multi-stage distillation column A via the heat exchanger 27 from the inlet 20. On the other hand, a starting

material 2 containing 64.4 % by weight of dimethyl carbonate, 33.8 % by weight of phenol, 1.3 % by weight of anisole, 0.4 % by weight of methyl phenyl carbonate, and 0.1 % by weight of methanol was continuously introduced into the distillation column A at a flow rate of 86.6 ton / hr from the lower portion inlet 11 of the distillation column A. The molar ratio for the starting materials introduced into the continuous multi-stage distillation column A was dimethyl carbonate / phenol = 1.1. The starting materials substantially did not contain halogens (outside the detection limit for the ion chromatography, i.e. 1 ppb or less). Pb(OPh)_2 as a catalyst was introduced in from the upper portion inlet 10 of the distillation column A such that a concentration thereof in the reaction liquid would be approximately 100 ppm. Reactive distillation was carried out continuously under conditions of a temperature at the bottom of the distillation column A being 230°C and a pressure at the top of the distillation column A being 6.5×10^5 Pa. It was possible to attain stable steady state operation after 24 hours. A liquid continuously withdrawn at 88 ton / hr from the outlet 25 connected to the bottom of the distillation column A contained 13.4 % by weight of methyl phenyl carbonate and 0.7 % by weight of diphenyl carbonate. It was found that the amount of methyl phenyl carbonate produced was 11.8 ton / hr (subtracting the amount introduced into the distillation column A, the actual amount produced was 10.7 ton / hr), and the amount of diphenyl carbonate produced was 0.6 ton / hr. The total selectivity for the methyl phenyl carbonate and diphenyl carbonate based on the phenol reacted was 98%.

Prolonged continuous operation was carried out under these conditions. The amounts produced per hour at 500 hours, 1000 hours, and 2000 hours after attaining the stable steady state were 11.8 tons, 11.8 tons, and 11.8 tons respectively for the methyl phenyl carbonate, and 0.6 tons, 0.6 tons, and 0.6 tons respectively for the diphenyl carbonate. The total selectivities for the methyl phenyl carbonate and

diphenyl carbonate were 98%, 98%, and 98% respectively, and hence the operation was very stable. Moreover, the aromatic carbonates produced substantially did not contain halogens (1 ppb or less).

<Separating out of by-produced methanol from low boiling point reaction mixture

5 (A_T)>

The low boiling point reaction mixture (A_T) continuously withdrawn in a gaseous form from the top of the continuous multi-stage distillation column A was cooled down to 161°C through heat therein being used to heat the starting material 1 using the heat exchanger 27 as described above. The composition of the low
10 boiling point reaction mixture (A_T), which was withdrawn at 85.4 ton / hr, was 3.1 % by weight of methanol, 61 % by weight of dimethyl carbonate, 34.3 % by weight of phenol, 1.2 % by weight of anisole, and 0.2 % by weight of methyl phenyl carbonate. After being made to have a temperature close to the temperature of the liquid in the vicinity of the inlet 31 provided between the stripping section and the enrichment
15 section in the continuous multi-stage distillation column B, the low boiling point reaction mixture (A_T) was continuously fed into the distillation column B from the inlet 31. On the other hand, in order to make up for the deficient dimethyl carbonate, fresh dimethyl carbonate was continuously introduced into the distillation column B at 3.98 ton / hr from an inlet 51 provided at the fourth stage from the bottom of the
20 enrichment section. Separation by distillation was carried out continuously in the distillation column B at a column bottom temperature of 213°C, a column top temperature of 138°C, and a reflux ratio of 2.89, and a low boiling point mixture (B_T) was continuously withdrawn from the outlet 39 at 2.78 ton / hr, while a high boiling point mixture (B_B) was continuously withdrawn from the outlet 35 at 86.6 ton / hr.
25 The high boiling point mixture (B_B) had a methanol content of not more than 0.1 % by weight, and had a composition substantially the same as the starting material 2 for

the continuous multi-stage distillation column A described above, and was circulated back and thus reused as the starting material 2.

The composition of the low boiling point mixture (B_T) was 93.3 % by weight of methanol, and 6.7 % by weight of dimethyl carbonate. The amount of methanol
5 continuously separated out through the distillation was 2.59 ton / hr. The low boiling point mixture (B_T) was used as a raw material for producing dimethyl carbonate and ethylene glycol by reacting with ethylene carbonate.

The operation of the continuous multi-stage distillation column B was carried out in synchronization with the continuous operation of the continuous multi-stage
10 distillation column A. The separation efficiency was the same after 500 hours, 1000 hours, and 2000 hours as initially, and hence operation remained stable.

Example 3:

Reactive distillation was carried out using a similar process and the same
15 continuous multi-stage distillation column A as in Example 1, and a low boiling point reaction mixture (A_T) containing 1.5 % by weight of methanol, 81.9 % by weight of dimethyl carbonate, 12.4 % by weight of phenol, 3.9 % by weight of anisole, and 0.3 % by weight of methyl phenyl carbonate was withdrawn at 80.26 ton / hr from the upper portion outlet 26 of the column. As in Example 1, the low boiling point
20 reaction mixture (A_T) was continuously fed into the continuous multi-stage distillation column B from the inlet 31 provided between the stripping section and the enrichment section of the continuous multi-stage distillation column B via the heat exchanger 27. On the other hand, in order to make up for the deficient dimethyl carbonate, fresh starting material containing 99 % by weight of dimethyl carbonate
25 and 1 % by weight of methanol was continuously introduced into the distillation column B at 1.76 ton / hr from the inlet 51 provided at the fourth stage from the

bottom of the enrichment section. Separation by distillation was carried out continuously in the distillation column B at a column bottom temperature of 219°C, a column top temperature of 151°C, and a reflux ratio of 6.74, and a low boiling point mixture (B_T) was continuously withdrawn from the outlet 39 at 1.19 ton / hr, while a
5 high boiling point mixture (B_B) was continuously withdrawn from the outlet 35 at 80.83 ton / hr. The high boiling point mixture (B_B) had a methanol content of not more than 0.1 % by weight, and was circulated back into the continuous multi-stage distillation column A and thus reused as starting material for the reactive distillation.

The composition of the low boiling point mixture (B_T) was 99 % by weight of
10 methanol, and 1 % by weight of dimethyl carbonate. The amount of methanol continuously separated out through the distillation was 1.18 ton / hr. The low boiling point mixture (B_T) was used as a raw material for producing dimethyl carbonate and ethylene glycol by reacting with ethylene carbonate.

The operation of the continuous multi-stage distillation column B was carried
15 out in synchronization with the continuous operation of the continuous multi-stage distillation column A. The separation efficiency was the same after 500 hours, 1000 hours, and 2000 hours as initially, and hence operation remained stable.

Example 4:

20 Reactive distillation was carried out using a similar process and the same continuous multi-stage distillation column A as in Example 1, and a low boiling point reaction mixture (A_T) containing 2.8 % by weight of methanol, 61.0 % by weight of dimethyl carbonate, 26.4 % by weight of phenol, 9.6 % by weight of anisole, and 0.2 % by weight of methyl phenyl carbonate was withdrawn at 57.45 ton / hr from the
25 upper portion outlet 26 of the column. As in Example 1, the low boiling point reaction mixture (A_T) was continuously fed into the continuous multi-stage distillation

column B from the inlet 31 provided between the stripping section and the enrichment section of the continuous multi-stage distillation column B via the heat exchanger 27. On the other hand, in order to make up for the deficient dimethyl carbonate, fresh starting material containing 99.7 by weight % of dimethyl carbonate and 0.3 % by weight of methanol was continuously introduced into the distillation column B at 2.44 ton / hr from the inlet 51 provided at the fourth stage from the bottom of the enrichment section. Separation by distillation was carried out continuously in the distillation column B at a column bottom temperature of 215°C, a column top temperature of 138°C, and a reflux ratio of 4.4, and a low boiling point mixture (B_T) was continuously withdrawn from the outlet 39 at 1.69 ton / hr, while a high boiling point mixture (B_B) was continuously withdrawn from the outlet 35 at 58.2 ton / hr. The high boiling point mixture (B_B) had a methanol content of 0.08 % by weight, and was circulated back into the continuous multi-stage distillation column A and thus reused as starting material for the reactive distillation.

The composition of the low boiling point mixture (B_T) was 94.9 % by weight of methanol, and 5.1 % by weight of dimethyl carbonate. The amount of methanol continuously separated out through the distillation was 1.6 ton / hr. The low boiling point mixture (B_T) was used as a raw material for producing dimethyl carbonate and ethylene glycol by reacting with ethylene carbonate.

The operation of the continuous multi-stage distillation column B was carried out in synchronization with the continuous operation of the continuous multi-stage distillation column A. The separation efficiency was the same after 500 hours and 1000 hours as initially, and hence operation remained stable.

Example 5:

Reactive distillation was carried out using a similar process and the same

continuous multi-stage distillation column A as in Example 1, and a low boiling point reaction mixture (A_T) containing 3.0 % by weight of methanol, 62.8 % by weight of dimethyl carbonate, 28.0 % by weight of phenol, 6.1 % by weight of anisole, and 0.1 % by weight of methyl phenyl carbonate was withdrawn at 57.11 ton / hr from the upper portion outlet 26 of the column. As in Example 1, the low boiling point reaction mixture (A_T) was continuously fed into the continuous multi-stage distillation column B from the inlet 31 provided between the stripping section and the enrichment section of the continuous multi-stage distillation column B via the heat exchanger 27. On the other hand, in order to make up for the deficient dimethyl carbonate, fresh dimethyl carbonate was continuously introduced into the distillation column B at 2.8 ton / hr from the inlet 51 provided at the fourth stage from the bottom of the enrichment section. Separation by distillation was carried out continuously in the distillation column B at a column bottom temperature of 213°C, a column top temperature of 138°C, and a reflux ratio of 2.89, and a low boiling point mixture (B_T) was continuously withdrawn from the outlet 39 at 1.84 ton / hr, while a high boiling point mixture (B_B) was continuously withdrawn from the outlet 35 at 58.07 ton / hr. The high boiling point mixture (B_B) had a methanol content of 0.09 % by weight, and was circulated back into the continuous multi-stage distillation column A and thus reused as starting material for the reactive distillation.

The composition of the low boiling point mixture (B_T) was 93.3 % by weight of methanol, and 6.7 % by weight of dimethyl carbonate. The amount of methanol continuously separated out through the distillation was 1.72 ton / hr. The low boiling point mixture (B_T) was used as a raw material for producing dimethyl carbonate and ethylene glycol by reacting with ethylene carbonate.

The operation of the continuous multi-stage distillation column B was carried out in synchronization with the continuous operation of the continuous multi-stage

distillation column A. The separation efficiency was the same after 500 hours, 1000 hours, and 2000 hours as initially, and hence operation remained stable.

Industrial Applicability

- 5 In the case of producing at least one aromatic carbonate through a reactive distillation system using a continuous multi-stage distillation column from a dialkyl carbonate and an aromatic monohydroxy compound, the present invention can be suitably used as a specific process that enables the at least one aromatic carbonate to be produced stably for a prolonged period of time on an industrial scale of not less
- 10 than 1 ton/hr while efficiently separating out a by-produced alcohol.

CLAIMS

We claim:

1. In an industrial process for the production of an aromatic carbonate in which the aromatic carbonate is continuously mass-produced on an industrial scale through a reactive distillation system of continuously feeding a starting material containing a dialkyl carbonate and an aromatic monohydroxy compound into a continuous multi-stage distillation column A in which a catalyst is present, carrying out transesterification reaction and distillation simultaneously in said distillation column A, continuously withdrawing a low boiling point reaction mixture A_T containing a by-produced alcohol from an upper portion of said distillation column A in a gaseous form, and continuously withdrawing a high boiling point reaction mixture A_B containing the aromatic carbonate from a lower portion of said distillation column A in a liquid form, the improvement which comprises:

- (a) said continuous multi-stage distillation column A comprises a distillation column having a length L (cm), an inside diameter D (cm), an internal with a number of stages n thereinside, a gas outlet having an inside diameter d_1 (cm) at the top of the column or in an upper portion of the column near to the top, a liquid outlet having an inside diameter d_2 (cm) at the bottom of the column or in a lower portion of the column near to the bottom, at least one inlet provided in the upper portion and/or a middle portion of the column below said gas outlet, and at least one inlet provided in the lower portion of the column above said liquid outlet, wherein L , D , n , d_1 , and d_2 satisfy the following formulae (1) to (6);

$$1500 \leq L \leq 8000 \quad (1)$$

$$100 \leq D \leq 2000 \quad (2)$$

$$2 \leq L/D \leq 40 \quad (3)$$

$$20 \leq n \leq 120 \quad (4)$$

$$5 \leq D / d_1 \leq 30 \quad (5)$$

$$3 \leq D / d_2 \leq 20 \quad (6);$$

(b) the low boiling point reaction mixture A_T is continuously fed into a continuous multi-stage distillation column B, and a low boiling point mixture B_T in which the concentration of the alcohol is not less than 90 % by weight is continuously withdrawn from an upper portion of said distillation column B in a gaseous form;

(c) a high boiling point mixture B_B having a low content of the alcohol is continuously withdrawn from a lower portion of said continuous multi-stage distillation column B in a liquid form, and said high boiling point mixture B_B is continuously fed into said continuous multi-stage distillation column A and thus reused in the transesterification; and

(d) said continuous multi-stage distillation column B comprises a distillation column comprising a stripping section having a length L_1 (cm), an inside diameter D_1 (cm) and an internal with a number of stages n_1 thereinside, and an enrichment section having a length L_2 (cm), an inside diameter D_2 (cm) and an internal with a number of stages n_2 thereinside, wherein L_1 , D_1 , n_1 , L_2 , D_2 , and n_2 satisfy the following formulae (7) to (14):

$$500 \leq L_1 \leq 3000 \quad (7)$$

$$100 \leq D_1 \leq 500 \quad (8)$$

$$2 \leq L_1 / D_1 \leq 30 \quad (9)$$

$$10 \leq n_1 \leq 40 \quad (10)$$

$$700 \leq L_2 \leq 5000 \quad (11)$$

$$50 \leq D_2 \leq 400 \quad (12)$$

$$10 \leq L_2 / D_2 \leq 50 \quad (13)$$

$$35 \leq n_2 \leq 100 \quad (14).$$

2. The process according to claim 1, wherein not less than 1 ton / hr of the aromatic carbonate is produced.

3. The process according to claim 1 or 2, wherein said d_1 and said d_2
5 satisfy the following formula:

$$1 \leq d_2 / d_1 \leq 5.$$

4. The process according to any one of claims 1 to 3, wherein said
continuous multi-stage distillation column A comprises a distillation column having a
10 tray and/or a packing as said internal.

5. The process according to claim 4, wherein said continuous multi-stage
distillation column A comprises a plate-type distillation column having the tray as said
internal.
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6. The process according to claim 5, wherein said tray is a sieve tray
having a sieve portion and a down comer portion.

7. The process according to claim 6, wherein said sieve tray has 100 to
20 1000 holes / m^2 in said sieve portion.

8. The process according to claim 6 or 7, wherein the cross-sectional area
per hole of said sieve tray is in a range of from 0.5 to 5 cm^2 .

9. The process according to any one of claims 1 to 8, wherein L_1 , D_1 , $L_1 /$
25 D_1 , n_1 , L_2 , D_2 , L_2 / D_2 , and n_2 for said continuous multi-stage distillation column B

satisfy the following formulae: $800 \leq L_1 \leq 2500$, $120 \leq D_1 \leq 400$, $5 \leq L_1 / D_1 \leq 20$, $13 \leq n_1 \leq 25$, $1500 \leq L_2 \leq 3500$, $70 \leq D_2 \leq 200$, $15 \leq L_2 / D_2 \leq 30$, $40 \leq n_2 \leq 70$, $L_1 \leq L_2$, and $D_2 \leq D_1$.

5 10. The process according to any one of claims 1 to 9, wherein the internal in each of the stripping section and the enrichment section of said continuous multi-stage distillation column B is a tray and/or a packing.

10 11. The process according to claim 10, wherein the internal in each of the stripping section and the enrichment section of said continuous multi-stage distillation column B is a tray.

15 12. The process according to claim 11, wherein said tray is a sieve tray having a sieve portion and a down comer portion.

13. The process according to claim 12, wherein said sieve tray has 100 to 1000 holes / m² in said sieve portion.

20 14. The process according to claim 12 or 13, wherein the cross-sectional area per hole of said sieve tray is in a range of from 0.5 to 5 cm².

15. The process according to any one of claims 1 to 14, wherein an amount of the alcohol separated out in said continuous multi-stage distillation column B is not less than 200 kg / hr.

25 16. The process according to any one of claims 1 to 15, wherein a

concentration of the alcohol in said low boiling point mixture B_T is not less than 95 % by weight.

17. The process according to claim 16, wherein the concentration of the
5 alcohol in said low boiling point mixture B_T is not less than 97 % by weight.

18. The process according to any one of claims 1 to 17, wherein said low boiling point mixture B_T is taken as a starting material for producing a dialkyl carbonate.

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19. The process according to any one of claims 1 to 18, wherein a content of the alcohol in said high boiling point mixture B_B continuously withdrawn from the lower portion of said continuous multi-stage distillation column B in a liquid form is not more than 0.2 % by weight.

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20. The process according to claim 19, wherein the content of the alcohol in said high boiling point mixture B_B is not more than 0.1 % by weight.

21. The process according to any one of claims 1 to 20, wherein heat in
20 said low boiling point reaction mixture A_T withdrawn in a gaseous form is used to heat the starting material for the transesterification fed into said continuous multi-stage distillation column A.