

DESCRIPTION

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VINYL POLYMER PREPARATION PROCESS, VINYL MONOMER

5 POLYMERIZATION INITIATOR AND STYRENE RESIN COMPOSITIONS

Technical Field

The present invention relates to a vinyl polymer preparation process, vinyl monomer polymerization initiator and styrene resin compositions. According to the process of the present invention, living polymerization can be carried out in a controllable temperature range without causing self-accelerated reaction due to generation of heat in the polymerization reaction, transfer reaction and termination despite high monomer concentration and high temperature reaction conditions in comparison with the conventional anionic polymerization.

Background Art

20 Styrene polymers, a typical example of which is polystyrene, have been industrially produced for a long time by means of radical polymerization. However, radical polymerization, as is well known, causes reaction termination due to recombinations of growing radicals, etc. or radical transfer reactions to the solvent or monomer, so that it was difficult to achieve structural control of the polymer, such as control of molecular weight distribution or the structures of the polymer chain ends. Also, since

radical polymerization is not living polymerization, it was not possible to produce block polymers or radial polymers.

Living anionic polymerization of monomers such as styrene and butadiene has been proposed as a solution to the above problems. For instance, in anionic polymerization of styrene using butyl lithium which is a general-purpose initiator, there can be obtained a polymer with very narrow molecular weight distribution since, in this case, living polymerization free of transfer reactions and reaction termination can proceed. Also, by taking advantage of reactivity of the propagating species of the living polymer, it is possible to obtain various well-defined polymers which have been unobtainable with the conventional radical polymerization, such as styrene/butadiene block polymers. However, the living anionic polymerization of styrene, despite its potential in producing very attractive resin materials, has not been industrially utilized except for some specific cases. This is attributable, for one thing, to low production yield because living anionic polymerization is a type of solution polymerization and to high production cost as compared with conventional radical polymerization, resulting in little industrial utilization, because of the necessity of a large-scale solvent recovery process. Therefore, there has been no other way but to resort to the conventional solution polymerization techniques for the production of specific polymers such as styrene/

butadiene block polymers.

For reducing the production cost in living anionic polymerization, it is necessary to decrease the amount of the solvent used for the polymerization, to enhance productivity and to minimize the load for solvent recovery. However, reduction of the amount of the solvent invites a sharp rise of viscosity of the polymerization solution, necessitating elevation of the polymerization temperature to a remarkably higher level than required in conventional solution polymerization.

When styrene is polymerized by using, for example, butyl lithium under these conditions according to the conventional art, there arise the following problems, which make such polymerization impractical.

① Since the polymerization initiation reaction and propagation reaction take place very rapidly, polymerization reaction heat is generated quickly, often resulting in unsatisfactory release of heat from the polymerization system to cause a steep rise of temperature in the system, which tends to initiate a self-accelerated reaction, the so-called "runaway" reaction (a situation where control of the reaction rate is impossible).

② At a high temperature such as 100°C or more, carbonic anions at the propagating species of the polymer become unstable to cause frequent occurrence of transfer reactions to the solvent or polymer backbone or reaction termination due to the β -elimination, resulting in a remarkable reduction of activity of the living polymer.

In the conventional polymerization using an organic alkali metal such as butyl lithium as initiator, the above problem ① can be solved by controlling the polymerization rate by decreasing the amount of the initiator, but this gives rise to the problem that a polymer having a high molecular weight is only obtained. The number-average molecular weight M_n of a polymer obtained by anionic polymerization using an organic alkali metal depends upon the ratio of the monomer to the alkali metal according to the following equation:

$$M_n = [\text{monomer}] / [\text{organic alkali metal}] \times (\text{molecular weight of monomer})$$

([]: molar concentration)

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Therefore, when the amount of the initiator is small, the produced polymer is correspondingly high in molecular weight, which means that a large amount of initiator is necessary for obtaining a polymer of low molecular weight. It has thus been difficult with the prior art to freely obtain a polymer of a desired molecular weight because of the operational restrictions required for preventing the runaway reaction.

It is also notable that when a conventional organic alkali metal is used, the initiation reaction proceeds very rapidly as against the propagation reaction, so that in many cases the produced polymer has a very narrow molecular weight distribution. However, the narrow

molecular weight distribution is sometimes detrimental to the balance of moldability and physical properties of the resin material. Therefore, in order to have a broad molecular weight distribution, it has been essential to add an initiator gradually or to carry out polymerization in a continuous reactor having a specific retention time profile. Thus, discovery of a living anionic polymerization system capable of freely controlling the molecular weight distribution without a complicated polymerization reaction has been desired.

Disclosure of the Invention

An object of the present invention is to provide a novel process for producing vinyl polymers with a controlled molecular weight distribution, according to which anionic polymerization of vinyl monomers is carried out under the high monomer concentration and high temperature conditions to allow the polymerization reaction to proceed at a controllable rate without causing a runaway reaction due to self-induced reaction heat, making it possible to conduct living polymerization free of transfer reactions and reaction termination even when conducted at a high temperature, which has never been achievable with the prior art. Another object of the present invention is to provide a styrene resin composition having excellent moldability and minimized in production of styrene monomers due to thermal decomposition.

In the course of studies aimed at these objects, the present inventor found that when anionic polymerization of a vinyl monomer such as styrene or butadiene is carried out using an initiator comprising an organic magnesium compound and a specific alkyl metal compound, quite surprisingly living polymerization proceeds at a reaction rate which enables control of heat release without causing a runaway reaction or extremely slow polymerization rate even under the conditions of high monomer concentration and high temperature. As a result, control of the molecular weight distribution is made possible. It was further found that the thus obtained styrene resin composition is lower in decomposition rate under heat retention and less in monomer formation than the resin compositions obtained by using the conventional anionic polymerization initiators. The present invention has been attained on the basis of these findings.

The present invention relates to a vinyl polymer preparation process which comprises carrying out anionic polymerization under the condition in which the polymerization temperature is not lower than 45°C and not higher than 250°C and the concentration of the vinyl monomer based on the polymerization solvent is 45-100% by weight, in which anionic polymerization the metal of the cation forming a counterpart to the carbonic anion at the polymerization propagating species comprises Mg, or Mg and M^1 (wherein M^1 is at least one alkali metal selected from the group consisting of Li, Na and K, and the molar

concentrations of Mg and M^1 satisfy the relation of
 $[Mg]/[M^1] \geq 4$).

The present invention also relates to the vinyl
 polymer preparation process wherein $(R^2)_2Mg$ (R^2 :
 5 hydrocarbon group) is used singly as the polymerization
 initiator.

The present invention also relates to the vinyl
 polymer preparation process wherein organic compounds
 represented by $(R^2)_2Mg$ and R^1M^1 and/or R^1OM^1 (R^1 and R^2 : a
 10 hydrocarbon group; O: an oxygen atom; M^1 : at least one
 alkali metal selected from the group consisting of Li, Na
 and K) are used as polymerization initiator, and the molar
 concentrations of Mg and M^1 satisfy the relation of
 $[Mg]/[M^1] \geq 4$.

15 The present invention further relates to the
 vinyl polymer preparation process wherein the above molar
 concentrations satisfy the relation of $[Mg]/[M^1] = 10-100$.

The present invention also relates to the vinyl
 polymer preparation process wherein compounds represented
 20 by $(R^2)_2Mg$ and R^1M^1 and R^3OH and/or $(R^3)_2NH$ (R^1, R^2 and R^3 : a
 hydrocarbon group; O: an oxygen atom; N: a nitrogen atom;
 M^1 : at least one alkali metal selected from the group
 consisting of Li, Na and K) are used by mixing them so as
 to satisfy the relations of $[Mg] > [M^1]$ and $2 \times [Mg] +$
 25 $[M^1] > [R^3OH] + [(R^3)_2NH]$.

The present invention also relates to the vinyl
 polymer preparation process wherein the polymerization
 temperature is not lower than 45°C and not higher than

200°C in the region of conversion of the vinyl monomer of 0-70%.

The present invention further relates to the vinyl polymer preparation process wherein in organic metal compounds represented by $(R^2)_2Mg$ and R^1M^1 , at least one of the carbons attached to the metals of the hydrocarbon groups R^1 and R^2 is secondary carbon and/or tertiary carbon, and the total amount $[R^{1,2}]$ of R^1 and R^2 of the secondary carbon and/or tertiary carbon satisfies the relation of

10 $[R^{1,2}] \geq [Mg]$.

The present invention also relates to the vinyl polymer preparation process wherein in organic metal compounds represented by $(R^2)_2Mg$ and R^1M^1 , at least one of the hydrocarbon groups of R^1 and R^2 is a polymer carbonic

15 anion.

The present invention further relates to the vinyl polymer preparation process wherein compounds represented by $(R^2)_2Mg$ and R^3OH and/or $(R^3)_2NH$ (R^2 and R^3 : a hydrocarbon group; O: an oxygen atom; N: a nitrogen atom) are used by mixing them so as to satisfy the relation of 2

20 $x [Mg] > [R^3OH] + [(R^3)_2NH]$.

The present invention also relates to the vinyl polymer preparation process wherein the poly-merization solvent is a hydrocarbon compound; the vinyl polymer preparation process wherein the concentration of the vinyl

25 monomer based on the polymerization solvent is substantially 100% by weight; and the vinyl polymer preparation process wherein the polymerization reaction is

carried out in an extruder.

The present invention further relates to a vinyl monomer polymerization initiator containing $(R^2)_2Mg$ (R^2 : a hydrocarbon group).

5 The present invention also relates to a vinyl monomer polymerization initiator containing organic metal compounds represented by $(R^2)_2Mg$ and R^1M^1 and/or R^1OM^1 (R^1 and R^2 : a hydrocarbon group; O: an oxygen atom; M^1 : at least one alkali metal selected from the group consisting
10 of Li, Na and K), wherein the molar concentrations of the metals satisfies the relation of $[Mg]/[M^1] \geq 4$.

 The present invention also relates to a vinyl monomer polymerization initiator containing organic metal compounds represented by $(R^2)_2Mg$ and R^1M^1 and/or R^1OM^1 (R^1
15 and R^2 : a hydrocarbon group; O: an oxygen atom; M^1 : at least one alkali metal selected from the group consisting of Li, Na and K), wherein the molar concentrations of the metals satisfies the relation of $[Mg]/[M^1] = 10-100$.

 The present invention also relates to a vinyl
20 monomer polymerization initiator containing compounds represented by $(R^2)_2Mg$ and R^1M^1 and R^3OH and/or $(R^3)_2NH$ (R^1 , R^2 and R^3 : a hydrocarbon group; O: an oxygen atom; N: a nitrogen atom; M^1 : at least one alkali metal selected from the group consisting of Li, Na and K), wherein the
25 compounds satisfy the relations of $[Mg] > [M^1]$ and $2 \times [Mg] + [M^1] > [R^3OH] + [(R^3)_2NH]$.

 The present invention further relates to a vinyl monomer polymerization initiator containing compounds

represented by $(R^2)_2Mg$ and R^3OH and/or $(R^3)_2NH$ (R^2 and R^3 : a hydrocarbon group; O: an oxygen atom; N: a nitrogen atom), wherein the compounds satisfy the relation of $2 \times [Mg] > [R^3OH] + [(R^3)_2NH]$.

5 The present invention also relates to a vinyl polymer obtainable by the above-described preparation process.

 The present invention further relates to the styrene resin compositions obtainable by anionic
10 polymerization of styrene monomers, wherein their molecular weight distribution M_w/M_n is 2.0-10.0 and the content of trimers derived from the styrene monomers is 250 ppm or less.

 The present invention further relates to a
15 molded product obtainable by injection molding or extrusion molding of the above styrene resin compositions.

Brief Description of the Drawings

 Figs. 1, 4 and 10 are graphs showing the
20 relation between conversion (Conv.) and number-average molecular weight (M_n) of the polymers obtained in the Examples and Comparative Examples.

 Figs. 2, 3 and 9 are graphs showing the relation
between polymerization time (Time) and conversion of the
25 polymers obtained in the Examples and Comparative Examples.

 Fig. 5 shows GPC curves of the polymers obtained in the Examples.

 Fig. 6 is a graph showing the relation between

the number-average molecular weight (M_n) of the polymers obtained in the Examples and Comparative Examples and the concentration ratio of the monomer and Bu_2Mg ($[SM]/[Mg]$), which is the initial polymerization condition.

5 Fig. 7 is a graph showing the relation between the number-average molecular weight (M_n) of the polymers obtained in the Examples and Comparative Examples and the concentration ratio of Bu_2Mg and $BuLi$ ($[Mg]/[Li]$), which is the initial polymerization condition.

10 Fig. 8 is a graph showing the relation between the ratio (M_w/M_n) of weight-average molecular weight (M_w) and number-average molecular weight (M_n) of the polymers obtained in the Examples and Comparative Examples and the concentration ratio of Bu_2Mg and $BuLi$ ($[Mg]/[Li]$), which is
15 the initial polymerization condition.

Best Mode for Carrying Out the Invention

The "vinyl monomers" used in the present invention include styrene monomers and conjugated diene
20 monomers.

The styrene monomers include styrene, α -alkyl-substituted styrene, nuclear alkyl-substituted styrene and the like. More specifically, they include α -methylstyrene, α -methyl-p-methylstyrene, p-methylstyrene, m-methylstyrene, o-methylstyrene, p-ethylstyrene, 2,4-dimethylstyrene, 2,5-
25 dimethylstyrene, p-isopropylstyrene, 2,4,6-trimethylstyrene, etc.

The conjugated diene monomers include 1,3-

butadiene, isoprene, 2,3-dimethylbutadiene, 2-ethyl-1,3-butadiene, 1,3-pentadiene, etc.

These vinyl monomers may be used either singly or in combinations of two or more of them for the purpose
5 of obtaining a copolymer.

The polymerization temperature is not lower than 45°C and not higher than 250°C, preferably not lower than 50°C and not higher than 240°C, more preferably not lower than 60°C and not higher than 230°C. The lower limit of
10 the polymerization temperature should be a temperature which is at least capable of maintaining the polymerization rate at which the polymerization can be completed within the prescribed period of time. The polymerization can proceed at a low temperature below 45°C,
15 but in the polymerization solution according to the present invention, the polymerization rate is very slow at such a low temperature, so that use of a temperature below 45°C is disadvantageous from the viewpoint of industrial production of the polymers. When the polymerization
20 temperature is 250°C or higher, side reactions such as transfer reactions and reaction termination may take place frequently, making it difficult to obtain a polymer of a high molecular weight while causing coloration of the produced polymer.

25 In the present invention, the polymerization temperature need not be kept constant throughout the reaction; it may be raised at any desired rate in accordance with the progress of the polymerization

reaction. In view of the fact that the reaction rate is high and the volume of heat generated is large in the initial stage of the polymerization reaction when the monomer concentration is high, it is recommended to
5 initiate the polymer-ization reaction at a low temperature and gradually raise the temperature as the monomer concentration lowers with the progress of the reaction. Polymerization is preferably carried out in the temperature range of 45-200°C when the conversion of the
10 vinyl monomer is in the range of 0-70%, and a polymerization temperature in the range of not lower than 200°C and not higher than 250°C is preferred when the conversion is in the range of 70% or higher. In case the viscosity of the polymerization reaction solution is low
15 and there is no need of raising the polymerization temperature more than necessary, polymerization may be conducted at a temperature of 200°C or lower in the 70-100% conversion region.

The concentration of the vinyl monomer based on
20 the polymerization solvent is not lower than 45% by weight and not higher than 100% by weight, preferably not lower than 50% by weight and not higher than 100% by weight. The higher the monomer concentration, the more desirable for the recovery of solvent, but there are the cases,
25 depending on the type of the polymer produced, where a solvent is required to some extent from the relation between temperature and viscosity of the polymerization solution. However, since an extremely low monomer



concentration is responsible not only for slow polymerization rate but also for occurrence of a transfer reaction under a high temperature condition, it is essential that the monomer concentration be at least 45% by weight in view of living polymerization efficiency.

That the concentration of the vinyl monomer based on the polymerization solvent is substantially 100% by weight means that there exists no solvent to be used other than the one derived from the initiator solution.

10 Polymerization with 100% monomer concentration, where no polymerization solvent is used, is the most ideal form of polymerization for the industrial practice since no transfer reaction of monomer to solvent nor any reaction termination takes place. This assures high use efficiency of the initiator as well as high productivity. Also, a process for solvent recovery after termination of the polymerization is unnecessary.

The "polymerization solvent" referred to in the present invention means a solvent which takes no part in the polymerization reaction and has compatibility with the polymers. Any type of solvent generally employed for living anionic polymerization can be used, but the aromatic or alicyclic hydrocarbon compounds which are suppressive against transfer reaction and reaction termination are preferably used as polymerization solvent.

25 Typical examples of such solvents include ethylbenzene, toluene, isopropylbenzene, benzene, cyclohexane and the like. If necessary, small quantities of other substances,

for example, an ether compound such as tetrahydrofuran, dioxane, trioxane, etc., a tertiary amine such as tetramethylethylenediamine, a nitrogen compound such as pyridine, an aliphatic saturated hydrocarbon compound such as pentane, n-hexane, heptane, octane, nonane, decane, etc., and a weak Lewis acid such as triethylaluminum, diethyl zinc, etc., may be contained in the solvent within limits which do not jeopardize the effect of the present invention.

10 The "organic magnesium compounds represented by $(R^2)_2Mg$ " used in the present invention are the compounds in which a hydrocarbon group is attached to Mg. The hydrocarbon group is preferably a (linear or branched) alkyl group represented by $CH_3(CH_2)_n$ - such as methyl, ethyl, 15 propyl, isopropyl, n-butyl, t-butyl, sec-butyl, amyl and hexyl. Preferred examples of the magnesium compounds include di-n-butylmagnesium, di-t-butylmagnesium, di-sec-butylmagnesium, n-butyl-sec-butylmagnesium, n-butylethylmagnesium and n-amylmagnesium. These compounds 20 may be used either singly or in combination.

It has been known that no polymerization of a vinyl monomer is initiated when R^2Mg (R: alkyl) is used singly, and that no polymerization is initiated unless a polar compound such as hexamethylformamide (HMPA) is added. 25 The present inventor found, however, that even if an R^2Mg compound is used singly, with no polar compound added, and even in a non-polar hydrocarbon solvent, the polymerization of a vinyl monomer is initiated under a specific



temperature condition, and the manner of the polymerization is living polymerization.

The lower limit of polymerization temperature when using R^2Mg singly as the initiator is $100^{\circ}C$ or higher, preferably $110^{\circ}C$ or higher, more preferably $120^{\circ}C$ or higher. At $100^{\circ}C$ or lower, polymerization proceeds very slowly or is not initiated.

For conducting the polymerization initiating reaction or propagation reaction more efficiently than in polymerization using R^2Mg alone as initiator, it is recommended to add to R^2Mg an organic metal compound(s) represented by R^1M^1 and/or R^1OM^1 (R^1 , R^2 : a hydrocarbon group; O: an oxygen atom; M^1 : at least one alkali metal selected from the group consisting of Li, Na and K).

Some initiators comprising a combination of R^2Mg and R^1M^1 and/or R^1OM^1 have been known, but they were impractical because of the problems such as mentioned below.

Macromolecules, Vol. 19, p. 299 (1986) and US-A-3,716,495 show the examples of styrene polymerization, butadiene polymerization, and styrene and butadiene copolymerization at $50^{\circ}C$ or $70^{\circ}C$ using a polymerization initiator consisting of dibutyl magnesium and butyl lithium, or diamyl magnesium and butyl lithium as in the present invention. In these cases of polymerization, however, the concentration of the monomer based on the polymerization solvent cyclohexane is as low as about 11%, and further the metal concentration ratio is in the region

of $[Mg] < [Li]$. To the knowledge of the present inventor, in the region of $[Mg] < [Li]$, the metal at the polymerization propagating species does not have Mg, and it is impossible to control the polymerization rate, molecular weight of the polymer and molecular weight distribution independently of each other. Also, when the initiators cited in the above references are used, although it is possible to carry out living polymerization without causing a runaway reaction at 50°C or 70°C with a low monomer concentration such as 11%, a runaway reaction does take place with the monomer concentrations and temperature ranges specified in the present invention, thus making it unable to control the polymerization rate.

US-A-4,225,690 discloses a polymerization initiator comprising dibutyl magnesium and amyl potassium or amyl oxypotassium. However, in this polymer initiator, too, the metal concentrations are in the region of $[Mg] < [K]$, the monomer concentration is as low as about 10-25%, the polymerization propagating species does not have Mg, and it is impossible to independently control the polymerization rate, molecular weight of the polymer produced and its molecular weight distribution. Also, a runaway reaction occurs with the concentration and temperature ranges specified in the present invention, making it impossible to control the polymerization rate.

EP-A-234,512 discloses a process for producing styrene/butadiene block copolymers. Example 34 thereof describes a procedure where styrene is polymerized at 65°C

using a polymerization initiator composed of dibutyl magnesium and butyl lithium at a concentration ratio ($[Mg]/[Li]$) of 2.5, and then butadiene is blocked with styrene. In this case, however, the monomer concentration
5 based on the polymerization solvent (cyclohexane) is as low as 20%, and although no runaway reaction occurs, the activity of the living polymer lowers, so that unreacted polystyrene remains in the ensuing step of block
polymerization of butadiene. In addition, the molecular
10 weight M_n of the obtained copolymer is as low as 8,900.

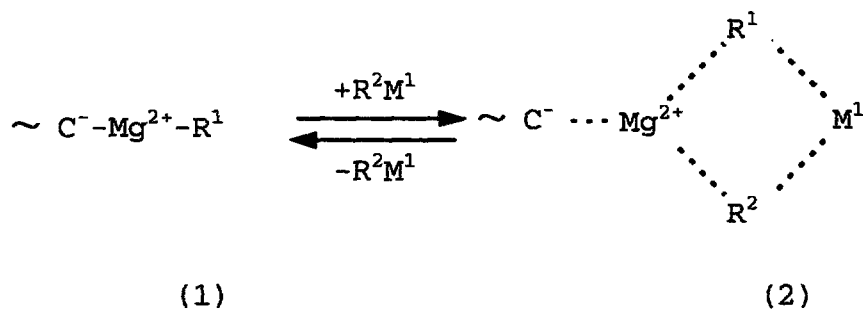
The present inventor found that if the polymerization initiator composed of R^2Mg and R^1M^1 and/or R^1OM^1 satisfies the particular relation of $[Mg]/[M^1] \geq 4$ ($[]$:
15 molar concentration) for the molar concentration ratio of metals, living polymerization proceeds without causing a runaway reaction even under the high temperature and high monomer concentration conditions. Thus, it is possible to
the control molecular weight, polymerization rate and molecular weight distribution independently of each other.

20 It has never been possible with the conventional anionic polymerization techniques to control molecular weight, polymerization rate and molecular weight distribution independently of each other in one pot of polymerization, so that this finding is quite surprising
25 and the present invention could have never been predicted from the prior art.

Such effect of the present invention is speculated to be attributable to the following mechanism.



It is considered that in the present invention, the carbonic anions which become unstable under high temperatures in polymerization with a conventional general-purpose initiator such as butyl lithium are capped with a metal forming a stable bond as shown in the following formula (1), and further a compound which can interact structurally with the compound of the formula (1) weakens the bonding force of the carbonic anions and their counter cations to thereby activate the carbonic anions (see the formula (2)). Further, under the polymerization temperature, the structure of the formula (1) is brought into a dormant state while the structure of the formula (2) becomes active, thus producing an equilibrium state between the structure of the formula (1) and that of the formula (2).



It is speculated that in a polymerization system having such a reaction mechanism, it will become easier to establish a living polymerization system if the equilibrium is biased to the left side (growing the dormant state) with rise of temperature to accordingly expand the stable state. It is also speculated that the molecular weight of the polymer is governed by the amount

of Mg since Mg always exists at the propagating species of polymerization, the polymerization rate is governed by the $[Mg]/[M^1]$ ratio since M^1 is activated to permit the polymerization to advance, and the molecular weight distribution is also governed by the $[Mg]/[M^1]$ ratio because of the bias of equilibrium and exchange rate to the other dormant terminals of RM^1 .

As the activator of the polymerization initiator in the present invention (when the term "polymerization initiator" is used in this specification, it may include its activator), the organic metal compounds represented by R^1M^1 and/or R^1OM^1 (R^1 and R^2 : a hydrocarbon group; O: an oxygen atom; M^1 is at least one alkali metal selected from the group consisting of Li, Na and K) are preferably used. Specifically, R^1 in the formula R^1M^1 represents a hydrocarbon group, preferably a linear or branched alkyl group represented by $CH_3(CH_2)_n$ - such as methyl, ethyl, propyl, isopropyl, n-butyl, t-butyl, sec-butyl, amyl or hexyl. Typical examples of R^1M^1 include methyl lithium, n-butyl lithium, sec-butyl lithium, t-butyl lithium, isopropyl lithium, n-propyl lithium, iso-propyl lithium, benzyl lithium, phenyl lithium, hexyl lithium, butyl sodium, butyl calcium, and cumyl potassium. These compounds may be used either singly or in combination.

R^1 in the formula R^1OM^1 represents a hydrocarbon group, preferably a linear or branched alkyl group represented by $CH_3(CH_2)_n$ - such as methyl, ethyl, propyl, isopropyl, n-butyl, t-butyl, sec-butyl, amyl or hexyl, a



phenyl group or an alkyl-substituted phenyl group.

Examples of R^1OM^1 include methoxylithium, methoxysodium, methoxypotassium, ethoxylithium, ethoxysodium, ethoxypotassium, propoxylithium, propoxysodium, 5 propoxypotassium, isopropoxylithium, isopropoxysodium, isopropoxypotassium, n-butoxylithium, n-butoxysodium, n-butoxypotassium, sec-butoxylithium, sec-butoxysodium, sec-butoxypotassium, tert-butoxy-lithium, tert-butoxysodium, tert-butoxypotassium, amyloxylithium, amyloxysodium, 10 amyloxypotassium, tert-amyloxylithium, tert-amyloxysodium, tert-amyloxy-potassium, hexyloxylithium, hexyloxysodium, hexyloxy-potassium, phenoxylithium, phenoxysodium, phenoxy-potassium, 2,4-di-tert-butylphenoxylithium, 2,4-di-tert-butylphenoxysodium, 2,4-di-tert-butylphenoxy- 15 potassium, 2,6-di-tert-butylphenoxylithium, 2,6-di-tert-butyl-phenoxy-sodium, 2,6-di-tert-butylphenoxypotassium, 3,5-di-tert-butylphenoxylithium, 3,5-di-tert-butyl-phenoxy-sodium, 3,5-di-tert-butylphenoxypotassium, 2,6-di-tert-butyl-4-methylphenoxylithium, 2,6-di-tert-butyl-4- 20 methylphenoxysodium, and 2,6-di-tert-butyl-4-methylphenoxypotassium. These compounds may be used either singly or in a combination of two or more of them.

R^1M^1 and R^1OM^1 may be used either singly or in combination.

25 R^1M^1 and/or R^1OM^1 are used so that the Mg to M^1 molar concentration ratio will satisfy the relation of $[Mg]/[M^1] \geq 4$ ([]: molar concentration), preferably $[Mg]/[M^1] \geq 4.5$, more preferably $[Mg]/[M^1] \geq 5$. When

[Mg]/[M¹] is less than 1, part of the cationic metal forming a counterpart to the carbonic anion at the polymerization propagating species of the living polymer produced during polymerization is constituted by the M¹ metal alone, and it is not possible to control the reactivity due to the presence of Mg. Consequently, a runaway reaction may take place with the polymerization temperature and monomer concentration ranges specified in the present invention, and no stable living polymerization system can be formed. In the region of $1 \leq [\text{Mg}]/[\text{M}^1] < 4$, living polymerization proceeds without causing a runaway reaction under a condition close to the lower limit of the polymerization concentration and temperature ranges in the present invention. In case polymerization is carried out under a condition of extremely high concentration, where almost no polymerization solvent is used, and at a high temperature of 100°C or more, a runaway reaction is induced and the living polymer activity is lowered. Further, in this case, there can be obtained only those polymers whose molecular weight distribution is substantially narrow. As for the molding resin material, it is desirable for certain uses of the product to use a polymer in which the low-molecular weight component and the high-molecular weight component are mixed with each other in a certain ratio, that is, a polymer whose molecular weight distribution is broad rather than narrow, from the standpoint of offering a good balance of fluidity and mechanical properties at the time of molding.

The present inventor found that when a vinyl monomer is polymerized by varying the $[Mg]/[M^1]$ ratio under conditions for completing polymerization in a certain prescribed period of time, quite surprisingly the

5 molecular weight distribution widens sharply in the region of $[Mg]/[M^1] \geq 4$. This is probably because the viscosity of the reaction system rises up with progress of polymerization in the high monomer concentration range, causing an apparent drop of exchange reaction rate of the

10 activator for the polymerization initiator.

For reducing the viscosity of the high concentration solution in the reaction system, it is recommended to carry out polymerization at a high temperature of 100 C or more, and to set the Mg and M^1

15 molar concentration rate at $[Mg]/[M^1] \geq 10$ for allowing progress of living polymerization without causing a runaway reaction in such a situation. The present inventor also found that the molecular weight distribution widens consistently as the $[Mg]/[M^1]$ ratio increases. However,

20 excessive increase of the $[Mg]/[M^1]$ ratio is undesirable as it causes too much widening of the molecular weight distribution and also increases the amount of the low molecular weight components, for example, oligomer moieties including dimers and trimers. The most preferred

25 range of molar concentration ratio is $10 \leq [Mg]/[M^1] \leq 100$.

The present inventor further found that when a compound or compounds represented by R^3OH and/or $(R^3)_2NH$ (R^3 : a hydrocarbon group; O: an oxygen atom; N: a nitrogen



atom), which normally can serve as an anionic polymerization terminator, is added to an initiator consisting of $(R^2)_2Mg$ and R^1M^1 ($[Mg] > [M^1]$) at a specific ratio, quite surprisingly polymerization of vinyl monomers is initiated and further living polymerization proceeds under the high-temperature and high-concentration conditions.

R^3OH and $(R^3)_2NH$ used in the present invention are the hydrocarbon groups, which are preferably linear or branched alkyl groups represented by $CH_3(CH_2)_n-$, such as methyl, ethyl, propyl, isopropyl, n-butyl, t-butyl, sec-butyl, amyl and hexyl, phenyl groups, alkyl-substituted phenyl groups, hydrocarbon-based ether compound groups represented by $CH_3(OCH_2CH_2)_n-$, and the groups represented by $(CH_3)_2N(CH_2CH_2)_n-$. Typical examples of R^3OH are methanol, ethanol, propanol, isopropanol, n-butyl alcohol, sec-butyl alcohol, tert-butyl alcohol, amyl alcohol, hexyl alcohol, phenol, 2,4-di-tert-butylphenol, 2,6-di-tert-butylphenol, 3,5-di-tert-butylphenol, 2,6-di-tert-butyl-4-methylphenol, 2-methoxyethanol, and 2-(2-di-tert-methoxyethoxy)ethanol. Examples of $(R^3)_2NH$ are N,N-dimethylethanolamine, dimethylamine, N-ethylmethylaniline, diethylamine, dipropylamine, dibutylamine, dihexylamine, dioctylamine, didecylamine, N,N,N'-trimethylethylenediamine, N,N,N',N'-tetramethyldiethylenetriamine and the like. These compounds may be used either singly or in combinations of two or more.

R^3OH and $(R^3)_2NH$ added must be in an amount that



satisfies the relation of $2 \times [\text{Mg}] + [\text{M}^1] > [\text{R}^3\text{OH}] + [(\text{R}^3)_2\text{NH}]$.
 Otherwise, if $2 \times [\text{Mg}] + [\text{M}^1] < [\text{R}^3\text{OH}] + [(\text{R}^3)_2\text{NH}]$,
 polymerization will not be initiated.

As a result of further research on the organic
 5 metal compounds composed of $(\text{R}^2)_2\text{Mg}$ and R^1M^1 , the present
 inventor found that at least one of the carbons attached
 to the metal of the hydrocarbon group of R^1 and R^2 is a
 secondary carbon and/or tertiary carbon, and when an
 organic metal compound satisfying the relation of $[\text{R}^{1,2}] \geq$
 10 $[\text{Mg}]$ ($[\text{R}^{1,2}]$: the total amount of R^1 and R^2 of secondary
 carbon and/or tertiary carbon) is used for polymerization
 of a vinyl monomer, the polymerization initiator
 efficiency of $(\text{R}^2)_2\text{Mg}$ is enhanced (the initiating reaction
 points are increased) and yet the polymerization rate is
 15 lowered. This is probably for the reason that since it is
 easier to initiate polymerization with R^1 and R^2 having a
 secondary carbon and/or tertiary carbon than with R^1 and R^2
 having a primary carbon, when $[\text{R}^{1,2}] \geq [\text{Mg}]$, Mg serves as a
 bifunctional initiator in an amount which corresponds to
 20 $[\text{R}^{1,2}] - [\text{Mg}]$, inviting a corresponding rise of initiator
 efficiency. Therefore, if R^1 and R^2 having a primary
 carbon and secondary and/or tertiary carbon are present in
 a mixed state, R^1 and R^2 having a secondary carbon and/or
 tertiary carbon alone are necessarily attached to the
 25 initiating terminal of the polymer, and the molecular
 weight is determined by the ratio amount of the monomer to
 R^1 and R^2 of secondary carbon and/or tertiary carbon. At
 the polymerization propagating species, there exist mixed

with each other two different structures: (A) ~ polymer ~
 -Mg-R² and (B) ~ polymer ~ Mg- ~ polymer ~, and it is
 supposed that (B) is lower in polymerization reactivity,
 that is, lower in polymerization rate. Therefore, it is
 5 possible to control the polymerization rate by adjusting
 the (A)/(B) ratio.

In the present invention, in the organic metal
 compounds composed of (R²)₂Mg and R¹M¹, at least one of the
 hydrocarbon compounds of R¹ and R² may be a polymer
 10 carbonic anion. "Polymer carbonic anion" is an anion of
 the living polymer obtained by living polymerization of a
 vinyl monomer, with its polymerization degree being not
 less than 1.

In the present invention, when a (R²)₂Mg compound
 15 is used, polymerization of a vinyl monomer is initiated
 even under a high-temperature and high-monomer-
 concentration condition, and living polymerization
 proceeds. It was further found that living polymerization
 is also allowed to proceed without causing a runaway
 20 reaction even under a high-temperature and high-
 concentration condition when a compound represented by R³OH
 and/or (R³)₂NH (R² and R³: a hydrocarbon group; O: an oxygen
 atom; N: a nitrogen atom) is mixed instead of adding R¹M¹
 and R¹OM¹. The effect of addition of R³OH and/or (R³)₂NH is
 25 to elevate the polymerization rate more than the addition
 of (R²)₂Mg alone. The polymerization rate is elevated as
 the amount of said compound(s) is increased. However, the
 amount of said compound(s) to be added is limited to such

a range that satisfies the relation of $2 \times [\text{Mg}] > [\text{R}^3\text{OH}] + [(\text{R}^3)_2\text{NH}]$. If $2 \times [\text{Mg}] + [\text{M}^1] \leq [\text{R}^3\text{OH}] + [(\text{R}^3)_2\text{NH}]$, polymerization will not proceed.

Since the polymerization of vinyl monomer using
5 an initiator of the present invention proceeds in the region of high monomer concentration, it is expected that the viscosity of the polymerization solution will become fairly high, so that it is desirable to use an extruder as the polymerization reactor in view of the uniformity of
10 the polymerization reaction. "Extruder" means here a single-screw or double-screw extruder which has a screw and/or a kneading disc.

Polymerization in the extruder by use of an initiator of the present invention can dispense with the
15 solvent recovery operation after completion of polymerization since living polymerization occurs even with a very small quantity of solvent, so that there can be realized a very economical process in which the solvent can be removed only by a deaeration treatment in the
20 extruder.

The method for termination of polymerization is not critical in the present invention; generally known termination methods of anionic polymerization can be used. For example, polymerization can be terminated by adding
25 water, an alcohol, a protonic acid compound such as carboxylic acids, carbon dioxide or the like to the polymerization solution.

It is known that a small quantity of monomer(s)

exists in the styrene polymers obtained by radical polymerization, and if a molded product of the styrene polymer is placed in an oleophilic compound atmosphere, the monomer(s) in the molded product may bleed out to give
5 rise to problems.

There are considered principally two patterns in which the monomers remain in the polymer: the monomers which have not been reacted during the polymerization operation being left in the polymer; or the monomers which
10 have been produced by decomposition of polymers or oligomers during the molding operation being present in the molded product. Monomers which remain unreacted during the polymerization can be significantly reduced by a deaeration treatment under high vacuum, but the polymer
15 and oligomer are further decomposed upon encountering thermal and shearing loads during molding so as to produce monomers. Monomers are produced in large quantities by thermal decomposition of the oligomers such as dimers and trimers, and it is difficult to remove these oligomers
20 from the polymer by a deaeration treatment.

It is known that, with oligomers produced by heat retention of a polymer, generally, the trimer exists in greater amount than the dimer (J. Polymer Sci.: Symposium No. 57, 81-88, (1976)). In fact, the amount of
25 trimer in a styrene polymer produced by radical polymerization is approximately ten times the amount of dimer. Therefore, it has been an important subject to control the formation of trimer in the polymer and to

provide a styrene resin which is minimized in the amount of monomer produced during the molding operation.

The present inventor has pursued research on this subject and found that the amount of trimer produced during polymerization can be significantly lessened by using a specific anionic polymerization technique, and that the polymer obtained by this process is minimized in the amount of monomer formed under heat retention. This finding constitutes a basis for the present invention. Thus, the styrene polymers produced according to the process of the present invention are minimized in the amount of monomers formed under heat retention.

Also, the styrene polymers produced by the process of the present invention can function to arrest formation of monomers under heat retention even if metal residues originating in the polymerization initiator exist in small quantities in the polymer. In the conventional anionic polymerization, metal residues originating in the polymerization initiator are inevitably left in the produced polymer, and it is considered that these metal residues accelerate thermal decomposition of the polymer in molding thereof. It is generally practiced to remove these metal residues by extraction with water, but this method is incapable of perfectly removing the metal residues, and thus small quantities of metal residues are substantially left in the produced polymer. In the case of the styrene polymers of this invention, even if small quantities of Mg and M¹ metals are left in the polymer,

there is insignificant formation of trimer. Thus, in accordance with this invention, a very economical industrial process requiring no step for extraction removal of metal residues can be employed for the
5 production of polymers obtainable with a small amount of initiator or for polymerization using a chain transfer agent.

The molecular weight of styrene resin obtained according to the process of the present invention is in
10 the range of 10^3 to 10^7 , and the amount of Mg used in this process is about 3 to 2,400 ppm, but the most favorable effect is obtained in the molecular weight range where the Mg content is not greater than 100 ppm.

"Mg" and " M^1 " which may be left in the styrene
15 polymers of the present invention mean the Mg and M^1 compounds which are produced after deactivation of the compounds used as polymerization initiator. The Mg to M^1 molar ratio ($[Mg]/[M^1]$) is preferably 4-10, more preferably 5-90, even more preferably 6-80.

20 Further research by the present inventor has led to the discovery of a styrene resin composition having excellent heat decomposability, moldability and, in particular, foaming characteristics. This styrene resin composition can be obtained from anionic polymerization
25 and its molecular weight distribution M_w/M_n is from 2.0 to 10.0 and the content of the styrene-derived trimer is not greater than 250 ppm.

A method for inhibiting formation of styrene

from polystyrene by thermal load in a molder or extruder is disclosed in JP-A-7-292188. This method, however, is still unsatisfactory in its effect of inhibiting formation of styrene by thermal load since polystyrene obtained from radical polymerization is used as polymer. Use of polystyrene obtained by anionic polymerization can afford a certain improvement of the styrene formation inhibitory effect, but this patent document sheds no light on the amount of trimer present in the produced polymer and the effect of the foaming characteristics.

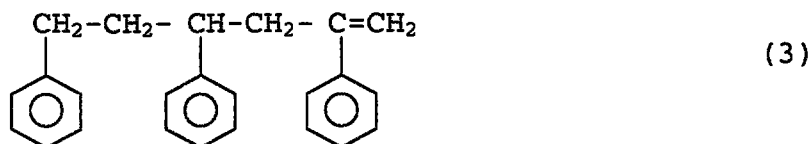
The present inventor discovered a styrene resin composition whose foaming characteristics are improved in a specific region of molecular weight distribution and which is very stable thermally and minimized in formation of monomers by decomposition, and this discovery is embodied in the present invention.

The term "styrene resin" used in the present invention refers to styrene polymers that can be obtained by anionic polymerization and whose molecular weight distribution M_w/M_n (weight-average molecular weight/number-average molecular weight) is from 2.0 to 10.0, preferably from 2.1 to 9.5, more preferably from 2.2 to 9.0. When M_w/M_n is less than 2.0, the foaming characteristics are deteriorated while when it exceeds 10.0, the low-molecular weight component increases, resulting in increased formation of styrene monomers by decomposition of the polymer in the course of secondary working such as injection foam molding or extrusion

foaming.

The term "trimer" used in the present invention refers to trimers having the molecular structure represented by the following formula (3):

5



The amount of trimer existing in the styrene polymers is not greater than 250 ppm, preferably not greater than 230 ppm, more preferably not greater than 200 ppm. When the trimer content exceeds 250 ppm, the amount of the styrene monomers formed under heat retention increases, which may cause problems with the migration of such monomers to the packed fat-containing foods when the molded product of the styrene polymer is used as a food packaging material.

The styrene resin composition of the present invention is minimized in formation of styrene monomers by heat decomposition and has excellent foaming characteristics, so that it is very suitable for use as an injection or extrusion molding material.

The styrene resin composition of the present invention may contain additives such as lubricants, releasing agents, plasticizers, colorants, flame retardants, foaming agents, etc., within the limits of the conception of the present invention.

The present invention will be further illustrated by the following Examples and Comparative

Examples, but it should not be construed to be restricted by these examples.

The monomers and solvents used in the present invention were purified in the following way before use.

5 The organic metal compounds, alcohols, secondary amines and other reagents used in the Examples and Comparative Examples are explained below.

(1) Styrene (SM)

A commercial product manufactured by Asahi
10 Chemical Industry Co., Ltd. It was distilled under reduced pressure once under CaH_2 , subjected to a deaeration treatment and then sealed under a dry nitrogen atmosphere.

(2) Ethylbenzene (EB) and cyclohexane

Commercial products manufactured by Wako Pure
15 Chemical Industries Co., Ltd. The special grade products were distilled under reduced pressure once under CaH_2 , subjected to a deaeration treatment, mixed with molecular sieves and then sealed under dry nitrogen.

(3) n-Butyl lithium (nBuLi)

20 Product manufactured by Kanto Chemical Co., Ltd. Used as a 1.6 Mn-hexane solution.

(4) sec-Butyl lithium (sBuLi)

Product manufactured by Kanto Chemical Co., Ltd. Used as a 1.0 Mcyclohexane solution.

25 (5) tert-Butyl lithium (tBuLi)

Product manufactured by Kanto Chemical Co., Ltd. Used as a 1.6 Mn-heptane solution.

(6) Dibutyl magnesium (Bu_2Mg)

Product manufactured by Aldrich Inc. A 1.0M heptane solution of 1:1 mixture of n-dibutyl magnesium and sec-dibutyl magnesium.

- (7) n-Butyl alcohol (nBuOH), sec-butyl alcohol (sBuOH),
 5 tert-butyl alcohol (tBuOH) and di-n-butylamine (Bu₂NH)

Special grade products manufactured by Kanto Chemical Co., Ltd. Distilled under CaH₂, subjected to deaeration treatment, mixed with molecular sieves and
 10 sealed under dry nitrogen.

- (8) tert-Butoxysodium (tBuONa) and tert-butoxypotassium (tBuOK)

Products manufactured by Aldrich Inc.

- (9) Polymerization terminator
 15 A 90/10 (by volume) mixture of tetrahydrofuran (THF) and methanol (MeOH) was used.

The polymerization rate, molecular weight and molecular weight distribution of the obtained polymers were determined in the following ways.

- 20 (10) Polymerization rate

Unreacted SM was measured by gas chromatography (GC) under the conditions 1, and the polymerization rate (conversion) was determined from the following equation:

25
$$\text{Polymerization rate (\%)} = \frac{([\text{supplied SM concentration}] - [\text{unreacted SM concentration}])}{[\text{supplied SM concentration}]} \times 100$$

(11) Number-average molecular weight (M_n), weight-average molecular weight (M_w) and M_w/M_n

Determined by gel permeation chromatography (GPC).

5 (12) Measurement of trimer

Conducted under the conditions 2.

[GC determination conditions]

Conditions 1

Measuring device: GC 14B mfd. by Shimadzu Corp.

10 Column: PEG 20M (ϕ 3 mm x 3 m)

Carrier gas: nitrogen, flow rate = 50 ml/min

Detector: FID

Column temp.: Maintained at 125°C for 10 minutes and then further heated at a rate of 35°C/min until reaching 230°C. Injection and detector temp. = 230°C.

Internal standard reagent: EB

Conditions 2

Measuring device: GC 14B mfd. by Shimadzu Corp.

20 Column: TC-1 (inner diameter: 0.25 mm; thickness: 0.25 μ m;

length: 30 m; mfd. by GL Science Inc.)

Carrier gas: nitrogen, flow rate = 50 ml/min

Detector: FID

25 Column temp.: Maintained at 50°C for 5 minutes and then further heated at a rate of 20°C/min until reaching 320°C.

Injection temp.: 260°C

Detector temp.: 330°C

Internal standard reagent: anthracene

[GPC measuring conditions]

5 Measuring device: TOSO HLC-8020 (with built-in
differential refractive index
detector)

Column: TOSO TSKgel-GMH_{XL} x 2

Temperature: 38°C

Solvent: tetrahydrofuran (THF)

10 Sample concentration: 0.1 wt/v%

Sampling pitch: once per 0.4 second

Determination of molecular weight:

15 Calibration curves were drawn by plotting the
relation between the molecular weight of TOSO
TSK standard polystyrenes and elution time as
third-order repression curve, and the molecular
weight was determined from the curve.

In the following Examples and Comparative
Examples, all the polymerization operations were carried
20 out according to the following procedure unless otherwise
noted.

[Polymerization operation]

A glass container and a syringe, which had been
heated to 140°C and dried, a monomer, a solvent and a
25 reagent were placed in a nitrogen globe (Model VDB-SA-Q
mfd. by Eiko Shokai KK). The inside atmosphere of the
nitrogen globe has been well substituted with nitrogen
which had been dehydrated and dried with molecular sieves.



Prescribed amounts of the monomer and solvent were put into a 50 ml pressure glass bottle, followed by further addition of a prescribed amount of a polymerization initiator. In case the concentration of the polymerization initiator was high, it was diluted with ethylbenzene and then added to the monomer solution. The polymerization solution was 10 ml in all cases. After feeding has been completed, the pressure bottle was stoppered with nitrile rubber, then taken out from the nitrogen globe and capped with a metal crown. The pressure bottle was put into an oil bath of a prescribed temperature. The time when the bottle was put into the oil bath was indicated as time 0. The pressure bottle was shaken properly to stir the reaction solution. On passage of a prescribed period of time, the pressure bottle was taken out from the oil bath and immediately put into water for cooling to room temperature. After cooling, 5 ml of the terminator was supplied into the pressure bottle so as to prevent entrance of air. Also, the pressure bottle was shaken quickly to effect uniform dispersion of the terminator. The resulting polymerization solution was diluted with THF and this diluted solution was used for GC and GPC analyses.

Examples 1-3

25 In the nitrogen globe, 9 ml of EB and 1 ml of Bu_2Mg were put into a 30 ml beaker to dilute Bu_2Mg . A mixed solution of SM and EB was supplied into the pressure bottle to a concentration shown in Table 1, then the

diluted initiator solution was added thereto to a prescribed concentration, and the resulting polymerization solution was mixed well by shaking. Three bottles of completely the same polymerization solution were prepared. On reaching the prescribed polymerization time shown in Table 1, the terminator was added to the solution to stop polymerization. The analytical results of the obtained polymers are shown in Table 1.

Generally, in the living polymerization systems, the molecular weight M_n of the polymer increases linearly in proportion to the conversion. A graph showing the relation between conversion and M_n in Examples 1-3 embodying the polymerization system of the present invention is shown in FIG. 1. In the polymerization solutions shown in these Examples, M_n increased linearly in proportion to conversion, indicating that these polymerization solutions are those of living polymerization. Also, in Examples 1-3, polymerization proceeded at a moderate rate without causing a runaway reaction as shown in Table 2.

Comparative Example 1

The procedure of Example 1 was followed except that an $n\text{BuLi}$ solution was used in place of Bu_2Mg to a concentration of 2.56 mM, and that the pressure bottle containing the polymerization initiator was placed in liquid nitrogen so as to prevent polymerization from starting. After being taken out of the nitrogen globe, it

was put into an oil bath of 120°C. In a few minutes, the polymerization solution was bumped to conclude polymerization (runaway reaction occurred).

5 Comparative Example 2

The procedure of Example 1 was followed except that polymerization was carried out at the concentration shown in Table 2. Polymerization proceeded without causing a runaway reaction, but as seen from FIG. 1, Mn increased
10 deviating from linearity with conversion and the living polymerization activity was decreased with increase of conversion.

Comparative Example 3

15 The procedure of Example 1 was followed except that polymerization was carried out at 150°C without adding the Bu_2Mg initiator solution.

As seen from plotting of Mn and conversion in FIG. 1, this polymerization solution (conventional heat
20 radical polymerization solution) was constant in molecular weight regardless of the progress of polymerization. Also, the polymers obtained only had a wide molecular weight distribution ($M_w/M_n = 2.2$).

The polymerization conditions of Examples 1-3
25 are 120-150°C and 6 hours, which are the conditions normally supposed to cause heat radical polymerization. However, no peak of the molecular weight such as shown in Comparative Example 3 was observed in GPC analysis. This



indicates that no heat radical polymerization but only anionic polymerization occurred in Examples 1-3.

Examples 4-8

5 In the nitrogen globe, dilute solutions of Bu_2Mg and $n\text{BuLi}$ were each prepared in advance at the mixing ratios shown in Table 3. A dilute initiator solution was added to a mixed solution of SM and EB to the concentrations shown in Table 3 and mixed well. The
10 resulting solution was dispensed into pressure bottles in an amount of 10 ml per bottle and polymerized at the temperatures and for the times shown in Table 3.

 As seen from FIG. 3, polymerization proceeded without a runaway reaction despite the high-temperature
15 and high-monomer-concentration conditions.

 From FIG. 4 showing the relation between M_n and conversion, it is seen that the molecular weight increased with progress of polymerization, and that living polymerization proceeded. It is noted that the molecular
20 weight distribution was widened with increase of conversion. It is considered that this is not due to a decrease of living characteristics of the polymerization solution but is attributable to such factors as rise of viscosity of the polymerization solution and increase of
25 the ratio of propagation rate to exchange reaction rate between the polymerization active point (Mg) and polymerization activator (Li). The molecular weight distribution patterns of Examples 8-1 and 8-2 are shown in FIG. 5, from

which it is seen that the molecular weight distribution is generally shifted with progress of polymerization, and there exists no deactivated polymer.

5 Comparative Example 4

Polymerization was carried out in a region with a low concentration of SM relative to EB at $\text{Bu}_2\text{Mg}/\text{nBuLi} = 4$. Although polymerization proceeded without causing a runaway reaction, the molecular weight distribution widened with progress of polymerization. GPC analysis showed pronounced tailing of the molecular weight distribution toward the low molecular weight side with the progress of polymerization, indicating that the active points were gradually deactivated in the course of polymerization (decrease of living polymerization activity).

Comparative Example 5

Polymerization was carried out under the conditions shown in Table 7. Progress of polymerization was very slow.

Examples 9-12

Polymerization was carried out under the conditions shown in Table 4 using cyclohexane as solvent and Bu_2Mg and nBuLi as initiators. Polymerization was conducted at 80°C for 4 hours in the conversion range of 70% or less, then the temperature was raised to 120°C and

30 minutes after polymerization was stopped.

Polymerization had already been completed. In Example 12, however, polymerization had been completed in a polymerization time of 4 hours. The relation between M_n of the
5 obtained polymer and $[SM]/[Mg]$ ratio is shown in FIG. 6.

Comparative Examples 6-8

Polymerization was carried out under the conditions shown in Table 7 using cyclohexane as solvent
10 and Bu_2Mg and $nBuLi$ as initiators. Polymerization was performed at $50^\circ C$ in the conversion range of 70% or less, and then the temperature was raised to $80^\circ C$ to conclude polymerization. In Comparative Example 8, the internal temperature became slightly higher than the oil bath
15 temperature in the early phase of polymerization. The relation between M_n of the obtained polymer and $[SM]/[Mg]$ ratio is shown in FIG. 6.

From the results of FIG. 6, it is apparent that M_n of the polymer is decided by the $[SM]/[Mg]$ ratio in the
20 region of $[Mg] \geq [Li]$.

The relation between M_n and $[Mg]/[Li]$ ratio is shown in FIG. 7. In the region of $[Mg] \geq [Li]$, the value of M_n of the polymer is constant regardless of the $[Mg]/[Li]$ ratio, but in the region of $[Mg] < [Li]$ the molecular weight
25 is lowered.

H^1 and C^{13} NMR analyses of the polymer obtained in the region of $[Mg] \geq [Li]$ confirmed that the butyl groups attached to the end of the molecular chain of the polymer

were sec-butyl groups, that the number thereof was equal to the number of the benzyl protons at the polymerization termination ends, and that the value of M_n calculated from the number of sec-butyl groups substantially agreed with the value of M_n determined by GPC. From these facts, it was confirmed that the metal cation forming a counterpart to the carbonic anion at the polymerization active point was Mg.

10 Examples 13-14 and Comparative Examples 9-10

Polymerization was carried out under the conditions shown in Tables 4 and 7 using EB as polymerization solvent and Bu_2Mg and $nBuLi$ as initiators. In each case, polymerization was conducted under a condition designed to complete the polymerization in 240 minutes.

The relation between the molecular weight distribution of the polymer obtained from the polymerization of 240 minutes (a polymer having a conversion of 95% or more) and the $[Mg]/[Li]$ ratio is shown in FIG. 8. The molecular weight distribution was narrow at $[Mg]/[Li] \leq 2$ but widened when the $[Mg]/[Li]$ ratio was made equal to or greater than 4.

25 Examples 15 and 17

Bu_2Mg and $nBuOH$ or $sBuOH$ were mixed at a molar ratio of 1 : 1 in EB, and $nBuLi$ was added to the resulting solution at a $[Mg]/[Li]$ ratio shown in Table 5.

Polymerization was carried out by using this preparation as polymerization initiator. EB was used as polymerization solvent.

5 Examples 16, 18 and 19

nBuLi and nBuOH or sBuOH or tBuOH were mixed in a molar ratio of 1 : 1 in EB, and nBuLi was added to the resulting solution at a [Mg]/[Li] ratio shown in Table 5. Polymerization was carried out using this preparation as
10 polymerization initiator and EB as solvent.

Example 20

nBuLi and nBuOH were mixed at a molar ratio of 1 : 1 in EB. In a separate container, Bu₂Mg and nBuOH were
15 mixed at a molar ratio of 1 : 1 in EB. Two solutions were mixed at a [Mg]/[Li] ratio shown in Table 6, and polymerization was carried out using the mixed solution as polymerization initiator and EB as solvent.

20 Example 21

Bu₂Mg and Bu₂NH were mixed in a molar ratio of 1 : 1 in EB, and then nBuLi was added thereto at a [Mg]/[Li] ratio shown in Table 6. Polymerization was carried out using this preparation as polymerization
25 initiator and EB as solvent.

Examples 22 and 23

tBuONa or tBuOK powder was added to EB, and then

Bu₂Mg was mixed therewith at a [Mg]/[M¹] ratio shown in Table 6. Polymerization was carried out using this preparation as polymerization initiator and EB as solvent.

The polymerization results of Examples 15-23 are shown in Table 6. In each case, living polymerization proceeded without causing a runaway reaction as in the case of the Bu₂Mg/BuLi initiator.

R³OH and (R³)₂NH were mixed in each initiator so that the {[R³OH] + [(R³)₂NH]}/{2 x [Mg] + [M¹]} ratio would be quintuplicated, and each mixture was used as initiator, but polymerization was not initiated with any of these initiators.

Examples 24 and 25

Dilute solutions of Bu₂Mg and sBuLi or tBuLi were prepared at the mixing ratios shown in Table 8 in a nitrogen globe. EB was used as polymerization solvent. Polymerization was carried out under the condition shown in Table 8.

Polymerization was conducted under the same conditions as in Example 4, but the polymerization rate was lower and the molecular weight of the obtained polymer was also somewhat smaller. sBuLi and tBuLi showed completely the same polymerization behavior. The results of polymerization are shown in FIGS. 9 and 10.

Example 26

nBuLi was added to EB, followed by further

addition of SM at $[SM]/[Li]$ of 2. The solution changed in color after a while. Then Bu_2Mg was added at $[Mg]/[Li]$ of 4 to prepare an initiator solution. Polymer-ization was carried out under the conditions shown in Table 8. The
5 result was completely the same as when the process was initiated with $Bu_2Mg/nBuLi$.

Example 27

Bu_2Mg and $sBuOH$ were mixed at a molar ratio of
10 1 : 1 in EB. Using this preparation as initiator, polymerization was carried out under the conditions shown in Table 8. Living polymerization proceeded without causing a runaway reaction.

15 Example 28

Bu_2Mg and $(Bu)_2NH$ were mixed at a molar ratio of
1 : 1 in EB, and using this preparation as initiator, polymerization was carried out under the conditions shown in Table 8. Living polymerization proceeded without
20 causing a runaway reaction.

In the initiator solutions of Examples 27 and 28, $sBuOH$ and Bu_2Mg , and Bu_2NH and Bu_2Mg , were mixed so as to satisfy $[sBuOH]/[Bu_2Mg] = 10$ and $[Bu_2NH]/[Bu_2Mg] = 10$. Polymerization was attempted by using these mixed
25 initiators, but polymerization could not be initiated in each case.

Although the polymerization reaction was conducted at a high temperature in Examples 1-28, there

was observed no peak of molecular weight attributable to radical polymerization.

Example 29

5 High-temperature bulk polymerization of SM was carried out using a polymerization initiator $\text{Bu}_2\text{Mg}/\text{nBuLi}$ (10/1) of the present invention in an extruder (ZSK-25 (L/D = 47) mfd. by Werner Corp.).

The 11 blocks of the extruder were set at the following temperatures: block 1 : room temperature; block 10 2 : 120°C; blocks 3 and 4 : 140°C; blocks 5 and 6 : 160°C; blocks 7 and 8 : 200°C; blocks 9-11 : 220°C. A liquid-adding device was provided between the blocks 8 and 9, from which the polymerization terminator (a mixed solution 15 of BuOH and EB) was supplied under pressure. The purified and dehydrated SM, EB and EB-diluted $\text{Bu}_2\text{Mg}/\text{nBuLi}$ (10/1) initiators were stored in the respective containers under a closed nitrogen atmosphere. The materials in the respective containers can be fed into a tank provided with 20 a 3-liter agitating element by a gear pump, and therefrom into the zone 1 of the extruder by another gear pump. The interior atmosphere of the extruder was well substituted with dry nitrogen and a mixed solution of EB and initiator was fed into the extruder to clean its interior. Then the 25 concentration of SM was gradually raised to finally reach 100. The SM feed rate was set at 100 ml/min. The initiator was supplied in such an amount that $[\text{SM}]/[\text{Mg}]$ would become 1,000. The polymer extruded from the die was



immediately cooled in water and pelletized. The molecular weight of the produced polymer and its molecular weight distribution were as follows: $M_n = 91,000$; $M_w/M_n = 3.5$.

5 Example 30 and Comparative Examples 11 and 12

Polymers were produced under the conditions shown in Table 9. Each polymer was dissolved in EB to a concentration of about 20% and part of the metal residues was extracted with distilled water. The metal contents of
10 the polymers are shown in Table 9. Methanol was added to each polymer solution after washing to precipitate the polymer, and then the solution was dried in vacuo at 80°C. 0.2 g of each of the obtained polymers was put into a glass tube. The glass tubes were sealed in vacuo. The
15 glass tubes were placed in a 280°C oil bath for 10 minutes, 20 minutes and 40 minutes and then taken out. The taken-out glass tubes were put into water for cooling. The glass tubes were crushed and the contents were put into and dissolved in THF. The monomer formation rate was
20 determined by gas chromatography using anthracene as an internal standard.

The results are shown in Table 10.

Example 31

25 The polymer obtained in Example 29 was subjected to an extrusion foaming test using Freon 12. The rate of the open cells in the obtained foam was determined according to ASTM-2856. The monomers contained in the

obtained foam were also determined. The results are shown in Tables 11 and 12.

Comparative Example 13

5 Using uBuLi as initiator and EB as solvent, polymerization was carried out at an SM concentration of 50 vol% in a 100-liter autoclave. The polymerization temperature rose to 145°C. The solvent was removed from the obtained polymer solution by a drum dryer. The polymer
10 was then put into an extruder having a cylinder temperature of 220°C and the residual EB was vented away. The polymer was recovered as pellets. The results are shown in Tables 11 and 12.

15 Comparative Example 14

A polymer obtained from radical polymerization was extrusion foamed in the same way as in Example 31, and the open cell rate and monomer content of the obtained foam were examined. The results are shown in Tables 11 and
20 12.

This application is based on Japanese Patent Application No. 8-084474 filed in Japan on March 14, 1996, Japanese Patent Application No. 8-303483 filed in Japan on October 30, 1996, and Japanese Patent Applica-tion No. 8-
25 303484 filed in Japan on October 30, 1996, the contents of which are incorporated hereinto in its entirety by reference.

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Table 1

	[SM] (vol%)	[Bu ₂ Mg] (mM)	Polymerization temperature* (°C)	Polymeriza- tion time (min)	Conv. (%)	Mn (x10 ⁻³)	Mw (x10 ⁻³)	Mw/Mn
Example 1-1	50	5.16	150	60	19	12	19	1.62
Example 1-2	50	5.16	150	120	27	18	30	1.65
Example 1-3	50	5.16	150	240	42	25	42	1.68
Example 2-1	80	2.58	150	60	22	42	63	1.51
Example 2-2	80	2.58	150	120	36	83	134	1.62
Example 2-3	80	2.58	150	240	58	125	210	1.68
Example 3-1	80	2.58	120	120	10	20	27	1.40
Example 3-2	80	2.58	120	240	20	38	56	1.48
Example 3-3	80	2.58	120	480	33	61	92	1.50

* EB was used as solvent.

Table 2

	[SM] (vol%)	[Bu ₂ Mg] (mM)	Polymerization temperature* (°C)	Polymeriza- tion time (min)	Conv. (%)	Mn (x10 ⁻³)	Mw (x10 ⁻³)	Mw/Mn
Comp. Example 1	50	*1	120	*2	100	183	198	1.08
Comp. Example 2-1	20	2.06	150	60	15	10	17	1.71
Comp. Example 2-2	20	2.06	150	120	23	14	25	1.82
Comp. Example 2-3	20	2.06	150	240	38	18	38	2.10
Comp. Example 3-1	50	0	150	120	29	92	212	2.30
Comp. Example 3-2	50	0	150	240	43	92	207	2.25

* : EB was used as solvent.

*1: 2.56 mM of BuLi was added in place of Bu₂Mg.

*2: Runaway reaction occurred in the polymerization solution, and polymerization was concluded within one minute.

Table 3

	[SM] (vol%)	[Bu ₂ Mg] (mM)	$\frac{[\text{Bu}_2\text{Mg}]}{[\text{BuLi}]}$	Polymeriza- tion tem- perature (°C)	Polymeriza- tion time (min)	Conv. (%)	Mn (x10 ⁻³)	Mw (x10 ⁻³)	Mw/Mn
Example 4-1	80	6.9	4	80	60	60	70	82	1.17
Example 4-2	80	6.9	4	80	120	82	82	101	1.23
Example 4-3	80	6.9	4	80	240	96	91	114	1.25
Example 5-1	90	7.8	6	90	60	59	62	73	1.18
Example 5-2	90	7.8	6	90	120	80	77	95	1.24
Example 5-3	90	7.8	6	90	240	95	90	126	1.40
Example 6-1	90	7.8	10	100	60	38	35	43	1.23
Example 6-2	90	7.8	10	100	120	60	55	74	1.35
Example 6-3	90	7.8	10	100	240	85	79	130	1.65

- Cont'd -

Table 3 (Cont'd)

Example 7-1	100	8.6	20	110	60	36	31	43	1.40
Example 7-2	100	8.6	20	110	120	60	51	77	1.51
Example 7-3	100	8.6	20	110	240	83	57	98	1.72
Example 8-1	100	8.6	30	120	60	33	25	44	1.76
Example 8-2	100	8.6	30	120	120	61	48	85	1.78
Example 8-3	100	8.6	30	120	240	80	55	104	1.90

Table 4

	[SM] (vol%)	[Bu ₂ Mg] (mM)	$\frac{[\text{Bu}_2\text{Mg}]}{[\text{BuLi}]}$	Polymeriza- tion temperature* (°C)	Polymeriza- tion time (min)	Conv. (%)	Mn ($\times 10^{-3}$)	Mw ($\times 10^{-3}$)	Mw/Mn
Example 9-1	80	69	6	80	240	72	7.5	8.8	1.18
Example 9-2	80	69	6	80→120	240+30	100	11	13	1.17
Example 10-1	80	35	6	80	240	65	14	16	1.17
Example 10-2	80	35	6	80→120	240+30	100	21	24	1.17
Example 11-1	80	23	6	80	240	60	17	20	1.17
Example 11-2	80	23	6	80→120	240+30	100	29	34	1.16
Example 12	80	35	4	80	240	100	20	23	1.17
Example 13	100	6.9	10	100	240	100	88	150	1.70
Example 14	100	6.9	20	120	240	100	70	127	1.81

* Cyclohexane was used as solvent.

Table 5

	Initiator	Component ratio	[SM] (vol%)	[Mg] (mM)	[Mg] [Li]	Polymerization temperature (°C)	
Example 15-1	nBuLi/Bu ₂ Mg/nBuOH	1/6/6	90	7.8	6	90	
Example 15-2	nBuLi/Bu ₂ Mg/nBuOH	1/6/6	90	7.8	6	90	
Example 15-3	nBuLi/Bu ₂ Mg/nBuOH	1/6/6	90	7.8	6	90	
Example 16-1	nBuLi/Bu ₂ Mg/nBuOH	1/6/1	90	7.8	6	90	
Example 16-2	nBuLi/Bu ₂ Mg/nBuOH	1/6/1	90	7.8	6	90	
Example 16-3	nBuLi/Bu ₂ Mg/nBuOH	1/6/1	90	7.8	6	90	
Example 17-1	nBuLi/Bu ₂ Mg/sBuOH	1/10/10	90	7.8	10	100	
Example 17-2	nBuLi/Bu ₂ Mg/sBuOH	1/10/10	90	7.8	10	100	
Example 17-3	nBuLi/Bu ₂ Mg/sBuOH	1/10/10	90	7.8	10	100	
Example 18-1	nBuLi/Bu ₂ Mg/sBuOH	1/6/1	90	7.8	6	100	
Example 18-2	nBuLi/Bu ₂ Mg/sBuOH	1/6/1	90	7.8	6	100	
Example 18-3	nBuLi/Bu ₂ Mg/sBuOH	1/6/1	90	7.8	6	100	
Example 19-1	nBuLi/Bu ₂ Mg/tBuOH	1/6/1	90	7.8	6	100	
Example 19-2	nBuLi/Bu ₂ Mg/tBuOH	1/6/1	90	7.8	6	100	

- Cont'd -

Table 5 (Cont'd)

Polymerization time (min)	Conv. (%)	Mn ($\times 10^{-3}$)	Mw ($\times 10^{-3}$)	Mw/Mn
60	53	49	58	1.19
120	78	74	90	1.22
240	93	89	117	1.32
60	44	42	48	1.15
120	71	68	82	1.20
240	90	85	107	1.26
60	68	63	88	1.40
120	90	80	131	1.64
240	10	90	154	1.71
60	63	56	76	1.36
120	85	79	130	1.64
240	99	90	153	1.70
60	90	81	133	1.64
120	10	90	153	1.70



Table 6

	Initiator	Component ratio	[SM] (vol%)	[Mg] (mM)	[Mg] [Li]	Polymerization temperature (°C)	
Example 20-1	nBuLi/Bu ₂ Mg/nBuOH	1/10/11	90	7.8	10	100	
Example 20-2	nBuLi/Bu ₂ Mg/nBuOH	1/10/11	90	7.8	10	100	
Example 20-3	nBuLi/Bu ₂ Mg/nBuOH	1/10/11	90	7.8	10	100	
Example 21-1	nBuLi/Bu ₂ Mg/Bu ₂ NH	1/10/10	90	7.8	10	100	
Example 21-2	nBuLi/Bu ₂ Mg/Bu ₂ NH	1/10/10	90	7.8	10	100	
Example 21-3	nBuLi/Bu ₂ Mg/Bu ₂ NH	1/10/10	90	7.8	10	100	
Example 22-1	tBuONa/Bu ₂ Mg	1/6	90	7.8	6	80	
Example 22-2	tBuONa/Bu ₂ Mg	1/6	90	7.8	6	80	
Example 22-3	tBuONa/Bu ₂ Mg	1/6	90	7.8	6	80	
Example 23-1	tBuOK/Bu ₂ Mg	1/10	90	7.8	10	80	
Example 23-2	tBuOK/Bu ₂ Mg	1/10	90	7.8	10	80	
Example 23-3	tBuOK/Bu ₂ Mg	1/10	90	7.8	10	80	

- Cont'd -

Table 6 (Cont'd)

Polymerization time (min)	Conv. (%)	Mn ($\times 10^{-3}$)	Mw ($\times 10^{-3}$)	Mw/Mn
60	37	34	42	1.23
120	59	54	73	1.36
240	84	79	131	1.66
60	70	65	92	1.42
120	91	81	134	1.66
240	100	90	156	1.73
60	60	59	67	1.14
120	82	79	95	1.20
240	98	95	121	1.27
60	62	60	82	1.36
120	83	80	132	1.65
240	99	91	156	1.71

Table 7

	[SM] (vol%)	[Bu ₂ Mg] (mM)	$\frac{[\text{Bu}_2\text{Mg}]}{[\text{BuLi}]}$	Polymeriza- tion temperature (C)	Polymeriza- tion time (min)	Conv. (%)	Mn (x10 ⁻³)	Mw (x10 ⁻³)	Mw/Mn
Comp. Example 4-1	10	0.9	4	80	60	19	18	22	1.21
Comp. Example 4-2	10	0.9	4	80	120	38	33	43	1.30
Comp. Example 4-3	10	0.9	4	80	240	62	45	70	1.55
Comp. Example 5-1	50	4.3	6	25	120	1	ND	ND	ND
Comp. Example 5-2	50	4.3	6	25	240	3	ND	ND	ND
Comp. Example 5-3	50	4.3	6	25	480	6	0.7	0.8	1.17
Comp. Example 6-1	50	22	2	50	240	71	16	17	1.09
Comp. Example 6-2	50	22	2	50→80	240→60	100	20	22	1.10

Table 7 (Cont'd)

Comp. Example 7-1	50	22	1	50	240	62	13	14	1.07
Comp. Example 7-2	50	22	1	50→80	240→60	100	20	22	1.08
Comp. Example 8	30	13	0.5	30	60	100	14	16	1.14
Comp. Example 9	80	6.9	2	80	240	95	105	114	1.09
Comp. Example 10	80	6.9	1	25	240	100	110	118	1.07

Table 8

	Initiator	[SM] (vol%)	[Mg] (mM)	[Mg] [Li]	Polymerization temperature (°C)	
Example 24-1	Bu ₂ Mg/sBuLi	80	6.9	4	80	
Example 24-2	Bu ₂ Mg/sBuLi	80	6.9	4	80	
Example 24-3	Bu ₂ Mg/sBuLi	80	6.9	4	80	
Example 25-1	Bu ₂ Mg/tBuLi	80	6.9	4	80	
Example 25-2	Bu ₂ Mg/tBuLi	80	6.9	4	80	
Example 25-3	Bu ₂ Mg/tBuLi	80	6.9	4	80	
Example 26-1	Bu ₂ Mg/StLi	80	6.9	4	80	
Example 26-2	Bu ₂ Mg/StLi	80	6.9	4	80	
Example 26-3	Bu ₂ Mg/StLi	80	6.9	4	80	
Example 27-1	Bu ₂ Mg/sBuOH (1/1)	100	8.6	--	150	
Example 27-2	Bu ₂ Mg/sBuOH (1/1)	100	8.6	--	150	
Example 27-3	Bu ₂ Mg/sBuOH (1/1)	100	8.6	--	150	
Example 28-1	Bu ₂ Mg/Bu ₂ NH (1/1)	100	8.6	--	150	
Example 28-2	Bu ₂ Mg/Bu ₂ NH (1/1)	100	8.6	--	150	
Example 28-3	Bu ₂ Mg/Bu ₂ NH (1/1)	100	8.6	--	150	

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Table 8 (Cont'd)

Polymerization time (min)	Conv. (%)	Mn ($\times 10^{-3}$)	Mw ($\times 10^{-3}$)	Mw/Mn
60	40	32	36	1.13
120	63	47	55	1.16
240	89	68	84	1.24
60	40	32	36	1.13
120	63	47	55	1.16
240	89	68	84	1.24
60	60	70	82	1.17
120	82	82	101	1.23
240	96	91	114	1.25
60	50	47	66	1.40
120	76	74	104	1.41
240	90	85	120	1.41
60	40	37	55	1.50
120	58	55	82	1.50
240	83	39	59	1.51

Table 9

	Initiator	[SM] (vol%)	[Mg] (mM)	$\frac{[Mg]}{[Li]}$	Polymer- ization temperature (°C)	Polymeriza- tion time (min)	Conv. (%)	Mn ($\times 10^{-3}$)	Mw ($\times 10^{-3}$)	Mw/Mn
Example 30	Bu ₂ Mg/nBuLi (6/1)	100	8.6	6	80→120	120→30	100	95	103	1.09
Comp. Example 11	nBuLi	50	4.3	0	80	~1	100	94	127	1.35
Comp. Example 12	None	100	---	---	120	240	21	250	437	1.75

Notes: In Example 30, polymerization was first carried out at 80°C for 120 minutes and then further conducted at 120°C for 30 minutes. EB was used as polymerization solvent in Example 30 and Comparative Example 11.

In Comparative Example 11, runaway reaction took place and the internal temperature ultimately rose to 150-160°C.

In Comparative Example 12, radical polymerization was carried out. Unreacted monomer was removed by reprecipitating the polymer in methanol.

	Amount of metals after washing of polymer		
	Mg	Li	Mg/Li
Example 30	25	4	6.3
Comp. Example 11	---	30	---

Table 10

	SM concentration in polymer after heat retention test*		
	Retention time		
	10	20	40
Example 30	38	95	200
Comp. Example 11	90	190	410
Comp. Example 12	140	265	530

* Unit: ppm

Table 11

	Polymer characteristics			Content in polymer (ppm)	
	$M_n \times 10^{-3}$	$M_w \times 10^{-3}$	M_w/M_n	SM	Trimer
Example 31	91	319	3.5	10	52
Comp. Example 13	254	305	1.2	16	75
Comp. Example 14	96	328	3.4	450	1810

Table 12

	Amount of SM existing in foam	Foam characteristics		
		Foaming rate	Form diameter (mm)	Ratio of open cells
Example 31	21	16	22	94
Comp. Example 13	28	12	21	38
Comp. Example 14	558	15	22	93



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1. A process for producing a vinyl polymer which comprises carrying out anionic polymerization under the conditions that the polymerization temperature is not
5 lower than 45°C and not higher than 250°C, and that the concentration of the vinyl monomer based on the polymerization solvent is 45-100% by weight, in which anionic polymerization the metal of the cation forming a counterpart to the carbonic anion at the polymerization
10 propagating species consists essentially of Mg, or Mg and M^1 wherein M^1 is at least one alkali metal selected from the group consisting of Li, Na and K, and the molar concentrations of Mg and M^1 satisfy the relation of $[Mg]/[M^1] \geq 4$.
- 15 2. The process according to Claim 1 wherein $(R^2)_2Mg$ wherein R^2 is a hydrocarbon group is used singly as polymerization initiator.
3. The process according to Claim 1 wherein organic compounds represented by $(R^2)_2Mg$ and R^1M^1 and/or R^1OM^1
20 wherein R^1 and R^2 are each a hydrocarbon group, O is an oxygen atom and M^1 is at least one alkali metal selected from the group consisting of Li, Na and K are used as polymerization initiator, and the molar concentrations of Mg and M^1 satisfy the relation of $[Mg]/[M^1] \geq 4$.
- 25 4. The process according to Claim 1 or 3 wherein said molar concentrations satisfy the relation of $[Mg]/[M^1] = 10-100$.
5. The process according to Claim 1 wherein

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compounds represented by $(R^2)_2Mg$ and R^1M^1 and R^3OH and/or $(R^3)_2NH$ wherein R^1 , R^2 and R^3 are each a hydrocarbon group, O is an oxygen atom, N is a nitrogen atom and M^1 is at least one alkali metal selected from the group consisting of Li, Na and K are used as polymerization initiator by mixing them so as to satisfy the relations of $[Mg] > [M^1]$ and $2 \times [Mg] + [M^1] > [R^3OH] + [(R^3)_2NH]$.

6. The process according to Claim 1 wherein the polymerization temperature in the region of conversion of the vinyl monomer of 0-70% is not lower than $45^\circ C$ and not higher than $200^\circ C$.

7. The process according to any one of Claims 3-5 wherein in the organic compounds represented by $(R^2)_2Mg$ and R^1M^1 , at least one of the carbons attached to the metals of the hydrocarbon groups R^1 and R^2 is a secondary carbon and/or tertiary carbon, and the total amount $[R^{1,2}]$ of R^1 and R^2 of the secondary carbon and/or tertiary carbon satisfies the relation of $[R^{1,2}] \geq [Mg]$.

8. The process according to Claim 7 wherein in the organic compounds represented by $(R^2)_2Mg$ and R^1M^1 , at least one of the hydrocarbon groups R^1 and R^2 is a polymer carbonic anion.

9. The process according to Claim 1 wherein the compounds represented by $(R^2)_2Mg$ and R^3OH and/or $(R^3)_2NH$ wherein R^2 and R^3 are each a hydrocarbon group, O is an oxygen atom and N is a nitrogen atom are used as polymerization initiator by mixing them so as to satisfy the relation of $2 \times [Mg] > [R^3OH] + [(R^3)_2NH]$.



10. The process according to Claim 1 wherein the polymerization solvent is a hydrocarbon compound.
11. The process according to Claim 1 wherein the concentration of the vinyl monomer based on the
5 polymerization solvent is substantially 100% by weight.
12. The process according to Claim 1 wherein the polymerization reaction is conducted in an extruder.
13. An initiator for polymerization of vinyl monomers, which comprises $(R^2)_2Mg$ wherein R^2 is a
10 hydrocarbon group.
14. A vinyl monomer polymerization initiator which comprises organic metal compounds represented by $(R^2)_2Mg$ and R^1M^1 and/or R^1OM^1 wherein R^1 and R^2 are each a hydrocarbon group, O is an oxygen atom and M^1 is at least
15 one alkali metal selected from the group consisting of Li, Na and K, and the molar concentrations of the metals satisfy the relation of $[Mg]/[M^1] \geq 4$.
15. A vinyl monomer polymerization initiator which comprises organic metal compounds represented by $(R^2)_2Mg$
20 and R^1M^1 and/or R^1OM^1 wherein R^1 and R^2 are each a hydrocarbon group, O is an oxygen atom and M^1 is at least one alkali metal selected from the group consisting of Li, Na and K, and the molar concentrations of the metals satisfy the relation of $[Mg]/[M^1] = 10-100$.
- 25 16. A vinyl monomer polymerization initiator comprising compounds represented by $(R^2)_2Mg$ and R^1M^1 and R^3OH and/or $(R^3)_2NH$ wherein R^1 , R^2 and R^3 are each a hydrocarbon group, O is an oxygen atom and N is a nitrogen



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atom and M^1 is at least one alkali metal selected from the group consisting of Li, Na and K, and satisfying the relations of $[Mg] > [M^1]$ and $2 \times [Mg] + [M^1] > [R^3OH] + [(R^3)_2NH]$.

- 5 17. A vinyl monomer polymerization initiator comprising compounds represented by $(R^2)_2Mg$ and R^3OH and/or $(R^3)_2NH$ wherein R^2 and R^3 are each a hydrocarbon group, O is an oxygen atom and N is a nitrogen atom, and satisfying the relation of $2 \times [Mg] > [R^3OH] + [(R^3)_2NH]$.
- 10 18. A vinyl polymer obtainable from the process set forth in any one of Claims 1-12.
19. A styrene resin composition which is a styrene polymer obtained by anionic polymerization, wherein its molecular weight distribution Mw/Mn is 2.0-10.0 and
- 15 wherein the content of the trimer originating in the styrene monomer is 250 ppm or less.
20. A molded article obtained by injection molding or extrusion molding the styrene resin composition set forth in Claim 18 or 19.

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