

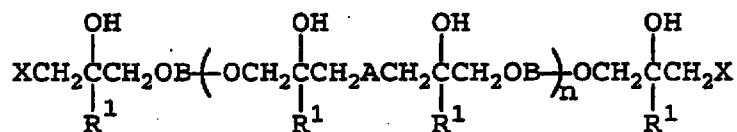
THERMALLY STABLE POLYETHERAMINES

This invention relates to polyethers having pendant hydroxyl moieties. More particularly, this invention relates to hydroxy-functionalized polyetheramines or polyhydroxyaminoethers (PHAE).

5 Hydroxy-functionalized polyetheramines are known and are described, for example, in U.S. Patents 5,275,853 and 5,464,924. These polyetheramines exhibit oxygen transmission rates of from 0.57 to 19 cm³-mil/100 in²-atm (O₂)-day, and are useful in the fabrication of barrier containers and films and as molding, extrusion and casting resins.

10 Hydroxy-functionalized polyetheramines can sometimes undergo cross-linking when fabricated at elevated temperatures. Modified, melt-stable polyetheramines, along with a process for their preparation, would clearly be desirable.

The present invention is, in a first aspect, a composition comprising a
15 blend of an inorganic base, an organic base, a monofunctional organic nucleophile or a multifunctional organic nucleophile and a thermoplastic hydroxy-functionalized polyetheramine having the formula:



wherein each A is independently an amine moiety and each B is independently a
20 divalent aromatic moiety; R¹ is hydrogen or a hydrocarbyl moiety; each X is independently a monovalent moiety; and n is a whole number from 5 to 1000.

In a second aspect, the present invention is a process for preparing a blend which comprises contacting an inorganic base, an organic base, a
monofunctional organic nucleophile or a multifunctional organic nucleophile with a
25 polyetheramine.

In a third aspect, the present invention is a laminate structure comprising one or more layers of an organic polymer and one or more layers of the composition of the first aspect.

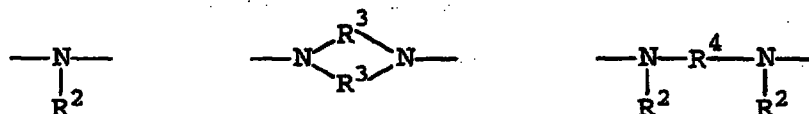
In a fourth aspect, the present invention is an article fabricated from the composition of the first aspect or laminate structure thereof, and can be in the form of a molded or coextruded container, or an impermeable monolayer or multilayer film. The article is suitable for packaging oxygen-sensitive materials such as foodstuffs and medicines.

In a fifth aspect, the present invention is a solvent or waterborne coating prepared from the composition of the first aspect.

These hydroxy-functionalized polyetheramine blends are melt-stable thermoplastics and exhibit oxygen transmission rates below 5.0 cc-mil/100 in²-atm-day.

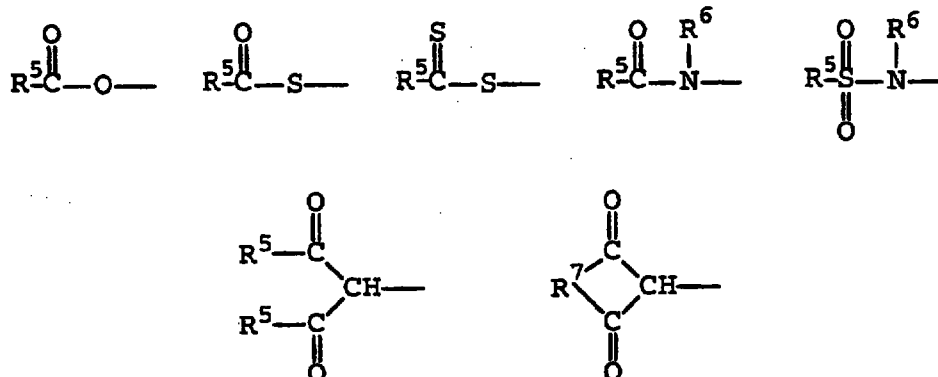
In addition to their use as barrier containers, films, laminate structures and coatings, the compositions of this invention are also useful as molding, extrusion and casting resins.

In preferred embodiments of the present invention, each A in the above formula is independently an amine moiety represented by any one of the formulas:



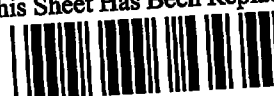
wherein R² is independently a hydrocarbyl, heterohydrocarbyl, inertly-substituted hydrocarbyl or inertly-substituted heterohydrocarbyl moiety, wherein the substituent(s) is hydroxyl, cyano, halo, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl; R³ and R⁴ are independently a hydrocarbylene, heterohydrocarbylene, inertly-substituted hydrocarbylene or inertly-substituted heterohydrocarbylene moiety, wherein the substituent(s) is hydroxyl, cyano, halo, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl with ethylene and p-xylylene being most preferred; each X is independently hydrogen, a primary, secondary or tertiary amino moiety, a hydroxyl moiety, an alkyl, heteroalkyl, inertly-substituted alkyl or inertly-substituted heteroalkyl group, an aryl or inertly-substituted aryl group, an alkoxy or inertly-substituted alkoxy group; an aryloxy or inertly-substituted aryloxy group, an alkanethio or inertly-substituted alkanethio group; an arenethio or inertly-substituted arenethio group, wherein the substituent(s) is hydroxyl, cyano, halo, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl; or is represented by any one of the formulas:





- 5 wherein R^5 is independently an alkyl or heteroalkyl, inertly-substituted alkyl or heteroalkyl, aryl or inertly-substituted aryl group, wherein the substituent(s) is cyano, halo, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl; R^6 is independently hydrogen, an alkyl or heteroalkyl, inertly-substituted alkyl or heteroalkyl, aryl or inertly-substituted aryl group, wherein the substituent(s) is the same as that for R^5 ; and R^7 is an alkylene or heteroalkylene, inertly-substituted alkylene or heteroalkylene, arylene or inertly-substituted arylene moiety, wherein the substituent(s) is the same as that for R^3 and R^4 .

- In the more preferred embodiments of the present invention, X is 2-hydroxyethylamino, dimethylamino, diethylamino, piperadino, N-(2-hydroxyethyl)piperazino, methoxy, ethoxy, propoxy, 2-(methoxy)ethoxy, 2-(ethoxy)ethoxy, benzyloxy, phenyloxy, *p*-methylphenyloxy, *p*-methoxyphenoxy, 4-*tert*-butylphenyloxy, methylmercapto, ethylmercapto, propylmercapto, 2-(methoxy)ethylmercapto, 2-(ethoxy)ethylmercapto, benzylmercapto, 2,3-dihydroxypropylmercapto, phenylmercapto, *p*-methylphenylmercapto, acetate, benzoate, acetamido or benzenesulfonamido; R^1 is hydrogen or methyl; R^2 is methyl, ethyl, propyl, isopropyl, 2-hydroxyethyl, 3-hydroxypropyl, 2-hydroxypropyl, 2,3-dihydroxypropyl, 2-(acetamido)ethyl, benzyl, phenyl, *p*-methoxyphenyl, *p*-methylphenyl; R^3 is ethylene, 1,2-propylene or 1,2-butylene and R^4 is ethylene, 1,2-propylene or 1,2-butylene, propylene, butylene, hexamethylene, 1,4-xylylene, 1,3-xylylene, 1,4-phenylene, 1,3-phenylene or 1,2-phenylene; and B is 1,4-phenylene, 1,3-phenylene, 1,2-phenylene, methylenediphenylene, isopropylidenediphenylene,



oxydiphenylene, thiodiphenylene, carbonyldiphenylene, diphenylfluorene or α -methylstilbene or a combination thereof.

The hydroxy-functionalized polyetheramines employed in the present invention can be prepared by reacting a difunctional amine with a diglycidyl ether
5 under conditions sufficient to cause the amine moieties to form a polymer backbone having amine linkages, ether linkages and pendant hydroxyl moieties. Residual epoxy end groups, should any remain, can optionally be reacted with a monofunctional nucleophile so that the isolated polyetheramine had no moieties capable of reacting with nucleophilic species.

10 As used herein, the term "diglycidyl ether" means the reaction product of an aromatic, aliphatic or poly(alkylene oxide) diol with epichlorohydrin.

The difunctional amines which can be employed in the practice of the present invention include the bis-secondary amines and primary amines. Suitable bis-secondary amines include piperazine and substituted piperazines, for example,
15 dimethylpiperazine and 2-methylamidopiperazine; bis(N-methylamino)benzene, 1,2-bis(N-methylamino)ethane, and N,N'-bis(2-hydroxyethyl)ethylenediamine. Preferred bis-secondary amines are piperazine, dimethylpiperazine, and 1,2-bis(N-methylamino)ethane. The most preferred bis-secondary amine is piperazine. Suitable primary amines include aniline and substituted anilines, for
20 example, 4-(methylamido)aniline, 4-methylaniline, 4-methoxyaniline, 4-tert-butylaniline, 3,4-dimethoxyaniline, 3,4-dimethylaniline; alkylamines, and substituted alkyl amines, for example, butylamine and benzylamine; and alkanol amines; for example, 2-aminoethanol and 1-aminopropan-2-ol. Preferred primary amines are
25 preferred primary amines are 4-methoxyaniline and 2-aminoethanol.

The diglycidyl ethers which can be employed in the practice of the present invention for preparing the polyetheramines include the diglycidyl ethers of the amide-containing bisphenols such as N,N'-bis(hydroxyphenyl)-alkylenedicarboxamides, N,N'-bis(hydroxyphenyl)arylene-dicarboxamides,
30 bis(hydroxybenzamido)alkanes or bis(hydroxybenzamido)arenes, N-(hydroxyphenyl)hydroxybenzamides, 2,2-bis(hydroxyphenyl)acetamides, N,N'-bis(3-hydroxyphenyl)glutaramide, N,N'-bis(3-hydroxyphenyl)adipamide, 1,2-bis(4-

hydroxybenzamido)-ethane, 1,3-bis(4-hydroxybenzamide)benzene, N-(4-hydroxyphenyl)-4-hydroxybenzamide, and 2,2-bis(4-hydroxyphenyl)acetamide, 9,9-bis(4-hydroxyphenyl)-fluorene, hydroquinone, resorcinol, 4,4'-sulfonyl-diphenol, 4,4'-thiodiphenol, 4,4'-oxydiphenol, 4,4'-dihydroxybenzophenone, 5 tetrabromoisopropylidene-bisphenol, dihydroxy dinitrofluorenylidenediphenylene, 4,4-bis(4-hydroxyphenyl)methane, α,α -bis(4-hydroxyphenyl)-ethylbenzene, 2,6-dihydroxynaphthalene and 4,4'-isopropylidene bisphenol (bisphenol A). More preferred diglycidyl ethers are the diglycidyl ethers of 9,9-bis(4-hydroxy-phenyl)fluorene, hydroquinone, resorcinol, 4,4'-sulfonyldiphenol, 4,4'-thiodiphenol, 10 4,4'-oxydiphenol, 4,4'-dihydroxybenzophenone, tetrabromoisopropylidenebisphenol, dihydroxy dinitrofluorenylidenediphenylene, 4,4'-biphenol, 4,4'-dihydroxybiphenylene oxide, bis(4-hydroxyphenyl)-methane, α,α -bis(4-hydroxyphenyl)ethylbenzene, 2,6-dihydroxynaphthalene and 4,4'-isopropylidene bisphenol (bisphenol A). Most preferred diglycidyl ethers are the diglycidyl ethers of 4,4'-isopropylidene bisphenol (bisphenol A), 4,4'-sulfonyldiphenol, 4,4'-oxydiphenol, 4,4'-dihydroxybenzophenone, 15 and 9,9-bis(4-hydroxy-phenyl)fluorene.

The inorganic bases which can be employed in the practice of the present invention include potassium hydroxide, sodium hydroxide, ammonium hydroxide, calcium oxide, magnesium oxide and mixtures thereof.

20 The organic bases which can be employed in the practice of the present invention include triethylenediamine and 1,5-diazabicyclo(5.4.0) undec-7-ene.

The monofunctional organic nucleophiles which can be employed in the practice of the present invention include a monofunctional amine, a hydroxyarene, an aryloxide salt, a carboxylic acid, a carboxylic acid salt, a thiol or a thiolate salt.

25 Preferably, the monofunctional amine is dimethylamine, diethylamine, bis(2-hydroxyethyl)amine, diphenylamine, piperadine, N-(2-hydroxyethyl)piperadine; the hydroxyarene is phenol, cresol, methoxyphenol, or 4-*tert*-butylphenol; the aryloxide salt is sodium or potassium phenate; the carboxylic acid salt is sodium acetate, potassium acetate, calcium acetate, copper (II) acetate, sodium propionate, potassium propionate, calcium propionate, sodium benzoate, potassium benzoate, sodium 30 ethylhexanoate, potassium ethylhexanoate, or calcium ethylhexanoate; the thiol is



3-mercapto-1,2-propanediol or benzenethiol; and the thiolate salt is sodium or potassium benzenethiolate.

The multifunctional organic nucleophiles which can be employed in the practice of the present invention include a multifunctional amine, a multifunctional
5 carboxylic acid, a multifunctional carboxylic acid salt, a multifunctional phenol, a multifunctional phenate salt, a multifunctional thiol, a multifunctional thiolate salt, an amino acid or an amino acid salt. The preferred multifunctional organic nucleophiles are ethylenediamine, propylenediamine, butylenediamine, diethylenetriamine, triethylenetetraamine, tetraethylenepentaamine, polyethylenamine, citric acid,
10 sodium or potassium citrate, glycine or sodium or potassium glycinate.

In general, the inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile is blended with the thermoplastic hydroxy-functionalized polyetheramines by conventional dry-blending methods using conventional means such as a barrel mixer, or a tumble mixer or by melt-blending in
15 an appropriate apparatus, such as a Banbury type internal mixer, rubber mill, single or twin-screw extruder or compounder.

The inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile can also be co-dissolved with the thermoplastic hydroxy-functionalized polyetheramines in a suitable solvent and the solvent removed
20 by evaporation. Examples of suitable solvents include 1-methyl-2-pyrrolidinone (NMP), and ethers or hydroxy ethers such as diglyme, triglyme, diethylene glycol ethyl ether, diethylene glycol methyl ether, dipropylene glycol methyl ether, propylene glycol phenyl ether, propylene glycol methyl ether and tripropylene glycol methyl ether.

Another suitable method of preparing the blends of the present
25 invention comprises reacting a difunctional amine, a diglycidyl ether and optionally a monofunctional nucleophile and then blending the reaction product *in situ* with an inorganic base, an organic base or a mono- or multifunctional organic nucleophile in a solvent, in a molten state or in an extruder.

The amount of the inorganic base, organic base, monofunctional
30 organic nucleophile or multifunctional organic nucleophile most advantageously blended with the hydroxy-functionalized polyether is dependent on a variety of factors including the specific polymers used in making the blends, as well as the desired



properties of the products resulting from the blends. Typical amounts can range from 0.1 to 15 weight percent of the blend. Preferably, the inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile is used in an amount of from 0.5 to 10 weight percent, more preferably from 0.5 to 3.0 weight percent and, most preferably, from 0.1 to 2.0 weight percent of the blend.

Films prepared from the composition of the present invention generally have oxygen transmission rates (OTR) of from 0.05 to 1.0 cc/mil/100 in²/atm/day, at 25°C and 60 percent relative humidity (ASTM D-3985) and carbon dioxide transmission rates (CO₂TR) of from 0.5 to 4.0 cc-mil/100 in²-atm-day, at 23°C and 0 percent relative humidity.

Films and laminate structures can be formed from the composition of the present invention by using conventional extrusion techniques such as feedblock extrusion, multimanifold die coextrusion or combinations of the two, or by solvent spraying or solution casting. Solution casting is a well known process and is described, for example, in the *Plastics Engineering Handbook* of the Society of the Plastics Industry, Inc., 4th Edition, page 448.

Containers and other molded parts can be fabricated from the films or laminate structures comprising the composition of the present invention by using conventional fabricating techniques for thermoplastic polymers such as compression molding, injection molding, extrusion, thermoforming, blow molding and solvent casting.

In general, laminate structures can be formed from the composition of the present invention by coextruding one or more layers of an organic polymer and one or more layers of the composition of the present invention, wherein the layer of the composition of the present invention is adhered to a contiguous organic polymer layer with or without an adhesive layer therebetween. Laminate structures also can be formed by co-injection of the composition of the present invention with an organic polymer; in some cases, preforms produced by such co-injection can be blow-molded into multilayer containers.

The laminate structure can be a three-layer laminate comprising a first outer layer of an organic polymer, a core layer of the composition of the present



invention and a second outer layer of an organic polymer which is the same as or different from the organic polymer of the first outer layer.

The laminate structure can also be a three-layer laminate comprising a first outer layer of the composition of the present invention, a core layer of an organic polymer and a second outer layer of an organic polymer which is the same as or different from the organic polymer of the core layer.

The laminate structure can also be a three-layer laminate comprising a first outer layer of the composition of the present invention, a core layer of an organic polymer and a second outer layer of the composition of the present invention.

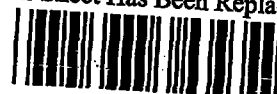
The laminate structure can of course comprise more than three layers, including, for example, five-layer structures comprising outer layers and an inner layer of an organic polymer separated by two layers of the composition of the present invention.

Organic polymers which can be employed in the practice of the present invention for preparing the laminate structure include crystalline thermoplastic polyesters, such as polyethylene terephthalate (PET); polyamides, polyolefins, and polyolefins based on monovinyl aromatic monomers.

Polyesters and methods for their preparation are well known in the art and reference is made thereto for the purposes of this invention. For purposes of illustration and not limitation, reference is particularly made to pages 1-62 of Volume 12 of the *Encyclopedia of Polymer Science and Engineering*, 1988 revision, John Wiley & Sons.

Polyamides which can be employed in the practice of the present invention include the various grades of nylon, such as nylon-6, nylon-6,6 and nylon-12.

Polyolefins which can be employed in the practice of the present invention include, for example, low density polyethylene, linear low density polyethylene, very low density polyethylene, polypropylene, polybutene, ethylene/vinyl acetate copolymers, ethylene/propylene copolymers and ethylene/butene-1 copolymers.



Polyolefins based on monovinyl aromatic monomers which can be employed in the practice of the present invention include polystyrene, polymethylstyrene, styrene/methylstyrene or styrene/chlorostyrene copolymers.

Other organic polymers of the polyester or polyamide type can also be employed in the practice of the present invention for preparing the laminate structure. Such polymers include polyhexamethylene adipamide, polycaprolactone, polyhexamethylene sebacamide, polyethylene 2,6-naphthalate and polyethylene 1,5-naphthalate, polytetramethylene 1,2-dioxybenzoate and copolymers of ethylene terephthalate and ethylene isophthalate.

The thickness of each layer in the laminate structure is dependent on a number of factors, including the intended use, materials stored in the container, the length of storage prior to use and the specific composition employed in each layer of the laminate.

In general, the laminate structure will have a total thickness of from 0.5 to 500 mils, preferably from 1.0 to 250 mils; with the thickness of the hydroxy-functionalized polyetheramine layer(s) being from 0.05 to 100 mils, preferably from 0.1 to 50 mils; and the thickness of the polyester layer(s) being from 0.45 to 400 mils, preferably from 0.9 to 200 mils.

The composition of the present invention can also be prepared and fabricated into a shaped article by a reactive extrusion process wherein the reactants are fed into and reacted in an extruder using the conditions described in U.S. Patent No. 4,612,156.

The following working examples are given to illustrate the invention and should not be construed as limiting its scope. Unless otherwise indicated, all parts and percentages are by weight.

Example 1

A. Preparation of Polymer

A polyhydroxyaminoether (PHAE) polymer was prepared from the reaction of D.E.R.TM 332 (a liquid diglycidyl ether of bisphenol A) liquid epoxy resin (LER) and ethanolamine (MEA) in a Werner & Pfleiderer ZSK-30 extruder which had 30-mm twin screws with a length to diameter ratio of 47:1. The extruder consisted of

15 barrel sections with 9 heating zones. The temperature profile was zone 1 (barrel sections 1 and 2), 65°C; zone 2 (barrel sections 3 and 4), 110°C; zone 3 (barrel sections 5 and 6), 160°C; zone 4 (barrel sections 7 and 8), 180°C; zone 5 (barrel section 9), 190°C; zone 6 (barrel sections 10 and 11), 190°C; zones 7 and 8 (barrel sections 12 to 15), 200°C; and zone 9 (extruder head), 200°C. The screw rotation speed was 130 to 150 rpm.

The LER and MEA were fed to barrel section 1 using Zenith HPB-5704 variable speed gear pumps with Max Model 213-300 positive displacement flow meters. The temperatures of the feed streams were measured with platinum RTD thermometers and density corrections applied to the gear pump set points to provide accurately controlled mass flow rates. The total reactant flow rate was controlled at 20 pounds./hour. with a molar ratio of LER to MEA of 0.971:1.

The diethanolamine (DEA), a cross-link suppressant additive, was fed to barrel section 14 at 2 weight percent of the blend using two 0.5 liter Isco Model LC-5000 syringe pumps synchronized such that one was injecting while the other was filling.

The resulting extrudate was processed through a gear pump, screen pack, strand die, water filled stand cooling trough, and strand chopper (pelletizer).

B. Thermal Stability Testing

The thermal stability of the PHAE polymer containing a cross-link suppressant was measured using a Haake Reocord 9000 torque measurement drive unit with a Haake Reomix 600 mixer chamber. The Reocord 9000 drive unit provides a torque measurement of the mixing of the polymer at controlled temperature and rotation speed.

The mixer chamber was preheated to 140°C metal temperature, and the torque reading was zeroed with the rotation speed at 50 rpm. Sixty grams of the polymer were poured into the feed port of the chamber over a 3 to 4 minute period as the material was drawn into the chamber by the rotors. When all the polymer was charged, a ram was lowered into the feed port, closing the chamber. A slow nitrogen purge was blown across the top of the closed feed port to minimize exposure to oxygen. At 10 minutes from the start of the polymer addition, the torque reading had reached a steady state, and the metal temperature control set point was increased to

220°C. The start of isothermal torque readings (time equal to zero minutes) was set at the moment when the metal temperature reached the 220°C set point. The melt temperature and torque readings were recorded for 83 minutes. At 10 minutes from time zero the torque had decreased 10 percent, and at 30 minutes the torque had
5 decreased 17 percent. The relative changes in the torque readings at 10 minutes and 30 minutes from time zero are recorded in Table I.

Examples 2 and 3

Two PHAE polymers were prepared and evaluated as in Example 1, except that the additives charged to the extruder are those described in Table I. The
10 relative changes in the torque readings at 10 minutes and 30 minutes from time zero are recorded in Table I.

Comparative Example A

A. Preparation of Polymer

A PHAE polymer was produced from the reaction of LER and MEA as described in Example 1 except that the molar ratio of LER to MEA was 0.99:1 and no
15 DEA was blended into the polymer.

The Haake mixer chamber described in Example 1 was preheated to 140°C metal temperature, and the torque reading was zeroed with the rotation speed at 50 rpm. Sixty grams of polymer were poured into the feed port of the chamber over
20 a 3 to 4 minute period as the material was drawn into the chamber by the rotors. When all the polymer was charged, the ram was lowered into the feed port, closing the chamber. A slow nitrogen purge was blown across the top of the closed feed port to minimize exposure to oxygen. At 10 minutes from the start of the polymer addition, the torque reading had reached a steady state, and the metal temperature control set
25 point was increased to 220°C. The start of the isothermal torque readings (time equal to zero minutes) was set at the moment when the metal temperature reached the 220°C set point. The melt temperature and torque readings were recorded for 10 minutes. At 10 minutes from time zero, the torque had increased 522 percent and the material had gelled. The relative change in the torque reading at 10 minutes from time
30 zero is recorded in Table I.

B. Barrier Testing

A film suitable for oxygen transmission rate (O_2TR) determination was prepared by pressing approximately 1.2 grams of polymer at 10,000 pounds pressure in a Tetrahedron Associates, Inc., MTP press at 195°C for 5 minutes. The resulting
5 film was 3.96 mils average thickness and 4 to 6 inches in diameter. The O_2TR of the film was tested following ASTM D3985-81 method on an Ox Tran 10/50 at 24°C, a relative humidity of 63 percent on the oxygen side of the film and 63 percent on the nitrogen side. The O_2TR result was 0.87 (cc x mil)/(100 in² x day x atm O_2), and is listed in Table IV.

10 Example 4

The Haake mixer chamber described in Example 1 was preheated to 140°C metal temperature, and the torque reading was zeroed with the rotation speed at 50 rpm. The polymer produced in Comparative Example A, 58.93 grams, was poured into the feed port of the chamber over a 3 to 4 minute period as the material
15 was drawn into the chamber by the rotors. As the last of the polymer was charged to the chamber, 1.066 grams of 2-(2-aminoethylamino)ethanol (AEEA) were also charged. When all the polymer and amine were charged, the ram was lowered into the feed port, closing the chamber. A slow nitrogen purge was blown across the top of the closed feed port to minimize exposure to oxygen. At 20 minutes from the start of
20 the polymer addition, the materials were homogeneously mixed, and the metal temperature control set point was increased to 220°C. The start of the isothermal torque readings (time equal to zero minutes) was set at the moment when the metal temperature reached the 220°C set point. The melt temperature and torque readings were recorded for 100 minutes. At 10 minutes from time zero, the torque had
25 decreased 11 percent, and at 30 minutes the torque had decreased 34 percent. The relative changes in the torque readings at 10 minutes and 30 minutes from time zero are recorded in Table II.

Examples 5-25

Several PHAE polymers were prepared following the procedure described in Example 4, except that the additives charged to the Haake mixer chamber are those described in Table II. The relative changes in the torque readings at 10 minutes and 30 minutes from time zero are recorded in Table II.

Example 26

The Haake mixer chamber described in Example 1 was preheated to 150°C metal temperature, and the torque reading was zeroed with the rotation speed at 50 rpm. Fifty grams of polymer which was prepared in a manner similar to Example 1 and which was the polymerization product of LER and MEA, and in which 0.5 weight percent diethanolamine was blended, were poured into the feed port of the chamber over a 3 to 4 minute period as the material was drawn into the chamber by the rotors. Time equal to zero minutes was set at the end of the addition of the polymer. At 5 minutes from time zero, 0.7615 grams of calcium ethylhexanoate were charged. At 10 minutes from time zero, the torque reading had reached a steady state, and the metal temperature control set point was manually increased 5°C at 2-minute intervals to 230°C. The melt temperature and torque readings were recorded for 50 minutes. As the polymer was warmed, the torque reading dropped with decreasing viscosity until cross-linking resulted in a minimum torque at 47 minutes, after which the torque values increased with increasing gelation. The time at minimum torque is recorded in Table III.

Examples 27-30

Several PHAE polymers were prepared and evaluated following the procedure described in Example 26, except that at 5 minutes from time zero, the additives described in Table III were charged to the Haake mixer chamber. The time at minimum torque is recorded in Table III.

Example 31

A. Preparation of PHAE Polymer

The mixer chamber described in Example 1 was preheated to 140°C metal temperature, and the torque reading was zeroed with the rotation speed at 50 rpm. The polymer produced in Comparative Example A, 58.8 grams, was poured into

the feed port of the chamber over a 3 to 4 minute period as the material was drawn into the chamber by the rotors. As the last of the polymer was charged to the chamber, 1.221 grams of AEEA were also charged. When all the polymer and amine were charged, the ram was lowered into the feed port, closing the chamber. At 20 minutes from the start of the polymer addition, the materials were homogeneously mixed, and the blend was recovered from the mixer chamber.

B. Barrier Testing

A film suitable for O_2 TR determination was prepared by pressing approximately 1.2 grams of polymer at 10,000 pounds pressure using the press described in Comparative Example A. The resulting film was 3.10 mils in thickness and 4 to 6 inches in diameter. The O_2 TR of the film was tested using the same equipment and procedure as described in Comparative Example A at 24°C, a relative humidity of 63 percent on the oxygen side of the film and 63 percent on the nitrogen side. The O_2 TR result was 0.73 (cc x mil)/(100 in² x day x atm O_2), and is listed in Table IV.

Examples 32-36

Several PHAE polymers were prepared and evaluated following the procedure described in Example 31, except that the additives charged to the Haake mixer chamber are those described in Table IV. The O_2 TR results are listed in Table IV.

Table I

Example	Additive	Additive Wt. %	Change in torque at 10 min.	Change in torque at 30 min.
Comparative Example A	-	-	522%	Gel
Example 1	Diethanolamine (DEA)	2.00%	-10%	-17%
Example 2	Triethylenetetraamine-propylene oxide adduct (TETA-PO)	2.00%	5%	-19%
Example 3	polyethyleneamine	2.00%	3%	-31%

Table II

Example	Additive	Additive wt., g	Polymer wt., g	Additive Wt. %	Change in torque at 10 min.	Change in torque at 30 min.
Example 4	2-(2-aminoethylamino)ethanol (AEEA)	1.066	58.93	1.78%	-11%	-34%
Example 5	Glycine	1.159	58.84	1.93%	99%	824%
Example 6	Glycine sodium salt	1.694	58.31	2.82%	-31%	-50%
Example 7	Sodium benzoate	1.110	58.89	1.85%	10%	21%
Example 8	Potassium benzoate	1.237	58.76	2.06%	-4%	317%
Example 9	Ammonium benzoate	1.074	58.93	1.79%	392%	Gel
Example 10	Potassium citrate, monohydrate	3.229	56.77	5.38%	62%	183%
Example 11	Potassium citrate, aqueous	3.226	56.77	5.38%	-46%	-70%
Example 12	Magnesium oxide	1.380	58.62	2.30%	234%	Gel
Example 13	Potassium hydroxide	0.502	59.50	0.84%	-58%	-44%
Example 14	Mercaptopropanediol	0.844	59.16	1.41%	45%	490%

Table II (continued)

Example 15	1,5-Diazabicyclo(5.4.0) undec-7-ene (DBU)	1.174	58.83	1.96%	-24%	-41%
Example 16	2-Methylimidazol	2.482	57.52	4.14%	-3%	28%
Example 17	Aminopropanediol	1.399	58.60	2.33%	-15%	-31%
Example 18	Hydroxyethylpiperazine	1.019	58.98	1.70%	-14%	-20%
Example 19	Triethylenediamine	1.730	58.27	2.88%	252%	Gel
Example 20	Jeffamine T-403 polyetheramine	1.140	58.86	1.90%	82%	713%
Example 21	Aminoethylpiperazine	1.322	58.68	2.20%	-20%	-32%
Example 22	Diethylenetriamine (DETA)	0.642	59.36	1.07%	-5%	-14%
Example 23	Triethylenetetramine (TETA)	0.753	59.25	1.26%	-4%	-19%
Example 24	Tetraethylenepentamine (TEPA)	0.847	59.15	1.41%	1%	-20%
Example 25	Adduct of TEPA and 3 moles of propylene oxide (TEPA-3PO)	3.141	56.86	5.23%	-13%	-39%

Table III

Example	Extruder-blended Additive	Additive Wt. %	Haake-blended Additive	Additive Wt. %	Time at minimum torque, min.
Example 26	DEA	0.5	Calcium ethylhexanoate	1.50	47
Example 27	DEA	0.5	—	—	31
Example 28	DEA	0.5	Copper ethylhexanoate	7.90	37
Example 29	DEA	0.5	Calcium propionate	4.33	39
Example 30	DEA	0.5	Copper acetate	4.22	33

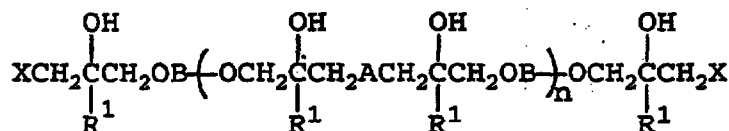
Table IV

Example	Additive	Additive Wt. %	O ₂ TR*	Average Temperature, °C	Relative Humidity % (N ₂)	Relative Humidity % (O ₂)	Average Thickness, mils
Comparative Example A			0.87	24	63	63	3.96
Example 31	polyethylene-polyamine	2.03%	0.60	22	49	54	3.58
Example 32	TETA-PO	1.99%	0.65	24	63	64	3.15
Example 33	AEEA	2.04%	0.73	24	63	63	3.10
Example 34	TETA	1.20%	0.65	24	63	63	3.17
Example 35	TEPA	2.02%	0.57	22	49	55	3.27
Example 36	DEA	2.01%	0.64	22	49	55	3.12

*O₂TR = (cc x mils) / (100 in² x day x atm O₂)

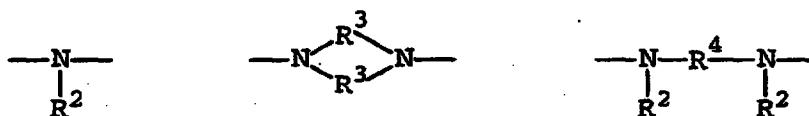
**CLAIMS:**

1. A composition comprising a blend of an inorganic base, an organic base, a monofunctional organic nucleophile or a multifunctional organic nucleophile and a thermoplastic hydroxy-functionalized polyetheramine having the formula:



wherein each A is independently an amine moiety and each B is independently a divalent hydrocarbylene or heterohydrocarbylene moiety; R¹ is hydrogen or a hydrocarbyl moiety; each X is independently a monovalent moiety; and n is a whole number from 5 to 1000.

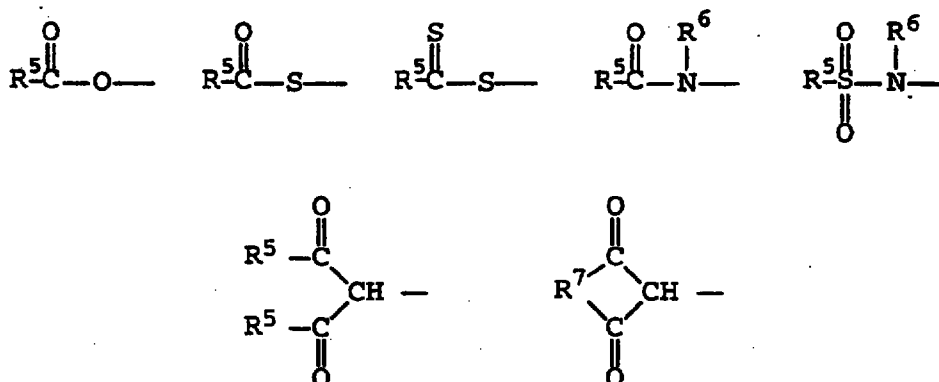
2. The composition of Claim 1 wherein A in the formula of the polyetheramine is represented by any one of the formulas:



wherein each R² is independently a hydrocarbyl, heterohydrocarbyl, inertly-substituted hydrocarbyl or inertly-substituted heterohydrocarbyl moiety, wherein the substituent(s) is hydroxyl, cyano, halo, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl; R³ and R⁴ are independently a hydrocarbylene, heterohydrocarbylene, inertly-substituted hydrocarbylene or inertly-substituted heterohydrocarbylene moiety, wherein the substituent(s) is alkylamido, hydroxy, alkoxy, halo, cyano, aryloxy, alkylcarbonyl or arylcarbonyl.

3. The composition of Claim 2 wherein X in the formula of the polyetheramine is independently hydrogen, a primary, secondary or tertiary amino moiety, a glycidyloxy moiety, a hydroxyl moiety, an alkyl, heteroalkyl, inertly-substituted alkyl or inertly-substituted heteroalkyl group, an aryl or inertly-substituted aryl group; an alkoxy or inertly-substituted alkoxy group; an aryloxy or inertly-substituted aryloxy group; an alkanethio or inertly-substituted alkanethio group; an arenethio or inertly-substituted arenethio group; wherein the substituent(s) is hydroxyl, cyano, halo, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl.

4. The composition of Claim 2 wherein X in the formula of the polyetheramine is independently represented by any one of the formulas:



wherein R^5 is independently an alkyl or heteroalkyl, inertly-substituted alkyl or heteroalkyl, aryl or inertly-substituted aryl group, wherein the substituent(s) is cyano, halo, alkyl, aryl, alkoxy, aryloxy, alkylamido, arylamido, alkylcarbonyl, or arylcarbonyl; R^6 is independently hydrogen, an alkyl or heteroalkyl, inertly-substituted alkyl or heteroalkyl, aryl or inertly-substituted aryl group, wherein the substituent(s) is the same as that for R^5 ; and R^7 is an alkylene or heteroalkylene, inertly-substituted alkylene or heteroalkylene, arylene or inertly-substituted arylene moiety, wherein the substituent(s) is the same as that for R^3 and R^4 .

- 10 5. The composition of Claim 3 wherein X in the formula of the polyetheramine is 2-hydroxyethylamino, dimethylamino, diethylamino, piperadino, N-(2-hydroxyethyl)piperazino, methoxy, ethoxy, propoxy, 2-(methoxy)ethoxy, 2-(ethoxy)ethoxy, benzyloxy, phenyloxy, p-methylphenyloxy, p-methoxyphenoxy, 4-tert-butylphenyloxy, methylmercapto, ethylmercapto, propylmercapto, 2-(methoxy)ethylmercapto, 15 2-(ethoxy)ethylmercapto, benzylmercapto, 2,3-dihydroxypropylmercapto, phenylmercapto, p-methylphenylmercapto, acetate, benzoate, acetamido or benzenesulfonamido.

- 20 6. The composition of Claim 2 wherein in the formula of the polyetheramine, R^1 is hydrogen or methyl; R^2 is methyl, ethyl, propyl, isopropyl, 2-hydroxyethyl, 3-hydroxypropyl, 2-hydroxypropyl, 2,3-dihydroxypropyl, 2-(acetamido)ethyl, benzyl, phenyl, p-methoxyphenyl, p-methylphenyl; R^3 is ethylene, 1,2-propylene or 1,2-butylene; and R^4 is ethylene, 1,2-propylene or 1,2-butylene, propylene, butylene, hexamethylene, 1,4-xylylene, 1,3-xylylene, 1,4-phenylene, 1,3-phenylene or 1,2-phenylene.

- 25 7. The composition of Claim 2 wherein B in the formula of the polyetheramine is 1,4-phenylene, 1,3-phenylene, 1,2-phenylene, methylenediphenylene, isopropylidenediphenylene, oxydiphenylene, thiodiphenylene, carbonyldiphenylene, diphenylflourene or α -methylstilbene or a combination thereof.



8. The composition of Claim 1 wherein the polyetheramine is the reaction product of a diglycidyl ether, a difunctional amine and optionally a monofunctional nucleophile.

9. The composition of Claim 1 wherein the organic nucleophile is a monofunctional nucleophile.

10. The composition of Claim 9 wherein the monofunctional nucleophile is an amine, a hydroxyarene, an aryloxy salt, a carboxylic acid, a carboxylic acid salt, a thiol or a thiolate salt.

11. The composition of Claim 10 wherein the amine is dimethylamine, diethylamine, bis(2-hydroxyethyl)amine, diphenylamine, piperadine, N-(2-hydroxyethylpiperazine) or 2-methylimidazole; the hydroxyarene is phenol, cresol, methoxyphenol, or 4-tert-butylphenol; the aryloxy salt is sodium or potassium phenate; the carboxylic acid is acetic acid or benzoic acid; the carboxylic acid salt is sodium acetate, potassium acetate, calcium acetate, copper (II) acetate, sodium propionate, potassium propionate, calcium propionate, sodium benzoate, potassium benzoate, sodium ethylhexanoate, potassium ethylhexanoate, or calcium ethylhexanoate; the thiol is 3-mercapto-1,2-propanediol or benzenethiol; and the thiolate salt is sodium or potassium benzenethiolate.

12. The composition of Claim 1 wherein the organic nucleophile is a multifunctional nucleophile.

13. The composition of Claim 12 wherein the multifunctional nucleophile is a multifunctional amine, a multifunctional carboxylic acid, a multifunctional carboxylic acid salt, a multifunctional phenol, a multifunctional phenate salt, a multifunctional thiol, a multifunctional thiolate salt, an amino acid or an amino acid salt.

14. The composition of Claim 13 wherein the multifunctional amine is ethylenediamine, propylenediamine, butylenediamine, diethylenetriamine, triethylenetetraamine, tetraethylenepentaamine, or polyethylenepolyamine; the multifunctional carboxylic acid is citric acid; the multifunctional carboxylic acid salt is sodium or potassium citrate; the amino acid is glycine; and the amino acid salt is sodium or potassium glycinate.

15. The composition of Claim 1 wherein the organic nucleophile is the product of the reaction of a polyethylenepolyamine with ethylene oxide or propylene oxide or a mixture of such products.



16. The composition of Claim 1 wherein the inorganic base is potassium hydroxide, sodium hydroxide, ammonium hydroxide, calcium oxide, or magnesium oxide.

17. The composition of Claim 1 wherein the organic base is triethylenediamine or 1,5-diazabicyclo(5.4.0)undec-7-ene.

5 18. The composition of Claim 1 wherein the inorganic base, organic base or organic nucleophile is present in an amount of 0.1 to 15.0 weight percent based on the weight of the composition.

10 19. A process for preparing the composition of Claim 1 which comprises contacting an inorganic base, an organic base or a mono- or multifunctional organic nucleophile with a polyetheramine.

20. The process of Claim 19 wherein the inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile is added to the polyetheramine in a molten state.

15 21. The process of Claim 19 wherein the inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile is mixed with the polyetheramine in an extruder.

22. The process of Claim 19 wherein the inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile is co-dissolved with the polyetheramine in a solvent and the solvent is removed by evaporation.

20 23. A process for preparing the composition of Claim 1 which comprises first reacting a difunctional amine, a diglycidyl ether and optionally a monofunctional nucleophile, and blending the reaction product *in situ* with an inorganic base, an organic base, a monofunctional organic nucleophile or a multifunctional organic nucleophile in a solvent or in a molten state.

25 24. The process of Claim 23 wherein the difunctional amine, diglycidyl ether and the optional monofunctional nucleophile are first reacted, and then blended *in situ* with the inorganic base, organic base, monofunctional organic nucleophile or multifunctional organic nucleophile in an extruder.

30 25. The composition of Claim 1 in the form of a solvent-borne coating, a water-borne coating, a laminate, a foam, a film, a container or a molded article.

26. A multilayer structure comprising alternating layers of a polyester, polyamide, polyolefins or polymers based on monovinyl aromatic monomers and the composition of Claim 1.

27. The structure of Claim 26 wherein the polyester is poly(ethylene
5 terephthalate) or poly(ethylene naphthalenedicarboxylate).

28. The structure of Claim 26 in the form of an extruded film, an extrusion blown film, an extruded sheet, a thermoformed container or an injection or extrusion blow-molded bottle or container.

