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(54) **Title:** IMPROVED CONTINUOUS PROCESS FOR THE PRODUCTION OF LOW MOLECULAR WEIGHT POLYETHERS WITH A DMC CATALYST

(57) **Abstract:** Low molecular weight polyoxyalkylene polyether polyols having a hydroxy! content of from about 3.4 to about 12.1 % by weight, and OH numbers of from about 112 to about 400 are produced by a continuous process using a DMC catalyst. In the process of the present invention, oxyalkylation conditions are established in a continuous reactor in the presence of a DMC catalyst; alkylene oxide and a low molecular weight starter are continuously introduced into the continuous reactor; a partially oxyalkylated polyether polyol is recovered from the reactor; and the recovered partially oxyalkylated polyether polyol is allowed to further reactor until the un reacted alkylene oxide content of the mixture is reduced to 0.001 % or less by weight. The alkoxylation of the present invention must be carried out a pressure sufficiently high to prevent deactivation of the DMC catalyst. Pressures of from 45 to 55 psia are preferred.

molecular weight (i.e. at least 100,000 MW and higher) polymer. This high molecular weight polymer is commonly referred to as high molecular weight tail. High molecular weight tail causes difficulties with the foaming process when reacting a polyol with a polyisocyanate to produce a polyurethane foam.

There have been numerous efforts over the years to improve and extend double metal cyanide catalysis to enable effective oxyalkylation of low molecular weight starters such as glycerin, and to produce low molecular weight polyoxyalkylene polyols. In particular, U.S. Patent 6,077,978 describes direct polyoxyalkylation of glycerin with a DMC catalyst in which catalyst deactivation is decreased by i) acidifying the acid sensitive low molecular weight starter prior to introducing the acid sensitive starter into the reactor; ii) treating the acid sensitive low molecular weight starter with an effective amount of a base-reactive or base-absorptive substance other than an acid prior to introducing the low molecular weight starter into the reactor; and iii) adding an effective amount of an acid to prevent catalyst deactivation to the reactor in which the acid is not contained in a feed stream containing acid sensitive low molecular weight starter.

U. S. Patent 7,919,575 describes a polyoxyalkylation process using a double metal cyanide (DMC) catalyst in which the low molecular weight starter is acidified with at least one of an inorganic protic mineral acid and an organic acid, wherein the acid is present in an amount of greater than that required to neutralize the basicity of the low molecular weight starter. Typically, the acid is present in an amount of greater than 100 ppm, based on the weight of the starter. This process permits the use of a smaller quantity of catalyst, and enables low molecular weight starters to be used in the process without catalyst deactivation.

Another process for producing polyethers using DMC catalysts is described in U.S. Published Patent Application 2008/0021191. This process uses 5 to 1000 ppm of a double metal cyanide catalyst in the oxyalkylation reaction, and requires that the low molecular weight starter

has a number average molecular weight of less than about 300 Daltons, contains from about 200 to about 5000 ppm of water, and is acidified with from about 10 to about 2000 ppm of at least one of an inorganic protic mineral acid and an organic acid. The addition of the acid to the low
5 molecular weight starter which contains a relatively high water content minimizes and/or prevents catalyst deactivation due to the water.

U.S. Patent 6,359,101 also describes a process for preparing polyether polyols from double metal cyanide catalysts. In this process, an epoxide is polymerized in the presence of DMC catalyst and a
10 continuously added first starter. The epoxide and first starter are continuously added to the reactor in a first step to produce an intermediate. The polyol intermediate is then reacted with additional epoxide, and optionally, additional DMC catalyst and a second starter to produce a polyether polyol. Suitable starters include: 1,6-hexanediol,
15 cyclohexane dimethanol, bis-hydroxyethyl hydroquinone, and bis-hydroxyethyl resorcinol. In addition, the mole ratio of epoxide to total first starter is at least about 3:1, and the first starter added in the first step has an impurity level (of total amount of water, propylene glycol and neutralized base residues) of less than about 100 ppm by weight.

20 Co-pending application U.S. Serial Number 13/528,909 filed on June 21, 2012 is directed to a process for the preparation of low molecular weight polyoxyalkylene polyether polyols in a continuous process in which a low molecular weight starter is alkoxyated in the presence of a double metal cyanide catalyst in which the oxyalkylation reaction is maintained at
25 a sufficiently high temperature to prevent catalyst deactivation, even in the presence of high levels of low molecular weight starters.

The present invention allows the preparation of low molecular weight polyoxyalkylene polyether polyols by a continuous process in which a low molecular weight starter is alkoxyated in the presence of a double
30 metal cyanide catalyst by carefully maintaining the pressure during the oxyalkylation reaction at 45 to 55 psia to prevent catalyst deactivation, even in the presence of high levels of low molecular weight starters.

Advantages of the present invention include efficient, sustainable production of low molecular weight products useful in polyurethane applications. The present invention also provides an efficient and sustainable means to produce low molecular weight polyether products that are useful as starters for higher molecular weight polyether products. The present invention makes it possible to produce low molecular weight polyethers at optimized DMC catalyst concentrations. One skilled in the art will recognize that a continuous process is more efficient than a batch or semi-batch process typically used to make low molecular weight polyether products and/or polyether starters.

SUMMARY OF THE INVENTION

This invention relates to a continuous process for the production of polyoxyalkylene polyether polyols. These polyoxyalkylene polyether polyols have a hydroxyl content of from about 3.4 to about 12.1%, by weight. In this continuous process:

- (1) oxyalkylation conditions are established in a continuous oxyalkylation reactor in the presence of a double metal cyanide (DMC) catalyst;
- (2) alkylene oxide and a low molecular weight starter (number average molecular weight of from 50 to 250, preferably from 50 to 230, more preferably from 50 to 200 and most preferably from 50 to 100) are continuously introduced into the continuous oxyalkylation reactor; and
- (3) a partially oxyalkylated polyether polyol is recovered from the continuous oxyalkylation reactor.

In this process, the pressure in the continuous oxyalkylation reactor during the oxyalkylation reaction is maintained at a sufficiently high pressure (preferably at least at 45 psia, and more preferably at least 48 psia) to prevent deactivation of the DMC catalyst. The concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% (preferably 1 to 2%) by weight and the hydroxyl

content of the reactor contents is maintained at 3.4 to 12.1% by weight. The partially oxyalkylated polyether polyol recovered from the continuous oxyalkylation reactor may then be further reacted until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less

5 (preferably, 0.0005% or less) by weight.

In another embodiment of the present invention is also directed to a continuous process for the production of a polyoxyalkylene polyether polyol having a hydroxyl content of from about 3.4 to about 12.1% by weight in which:

- 10 (1) oxyalkylation conditions are established in a continuous oxyalkylation reactor in the presence of a double metal cyanide catalyst;
- (2) alkylene oxide and a low molecular weight starter (having at least two hydroxyl groups per molecule and an equivalent
- 15 weight of up to 115) are continuously introduced into the continuous oxyalkylation reactor;
- (3) a partially oxyalkylated polyether polyol is recovered from the continuous oxyalkylation reactor.

In this process, the oxyalkylation is conducted in the continuous oxyalkylation reactor at a pressure of from 45 to 55 psia, preferably from

20 about 48 to about 52 psia, most preferably, about 50 psia thereby preventing deactivation of the DMC catalyst. The concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% by weight and the hydroxyl content of

25 the reactor contents is maintained at 3.4 to 12.1% by weight. The partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor may be further reacted until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less by weight.

In the above-described second embodiment, it is preferred that the

30 build ratio in the continuous oxyalkylation reactor be from 4.6 to 16.2 and the overall build ratio is from 4.6 to 16.2, and that the temperature of the reaction mixture in the further reaction step increases by up to 35°C as a

result of the exothermic polymerization reaction.

In another embodiment of the present invention, polyoxyalkylene polyether polyols having a hydroxyl content of from about 3.4 to about 12.1% by weight are continuously produced by:

- 5 (1) continuously polymerizing at least one alkylene oxide in the presence of a double metal cyanide (DMC) catalyst in a continuous reactor maintained at a pressure of from 45 to 55 psia;
- 10 (2) feeding a low molecular weight starter that has at least two hydroxyl groups per molecule and an equivalent weight of up to 115 and at least one alkylene oxide to the continuous reactor containing alkylene oxide and a double metal cyanide catalyst; and
- 15 (3) recovering a partially oxyalkylated polyol mixture from the continuous reactor.

The concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% (preferably 1 to 2%) by weight and the hydroxyl content of the reactor contents is maintained at 3.4 to 12.1% by weight. Subsequently, the partially
20 oxyalkylated polyol mixture withdrawn from the continuous reactor is permitted to further react until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less (preferably 0.0005% or less) by weight. In this embodiment, it is preferred that the build ratio in the continuous oxyalkylation reactor be from 4.6 to 16.2 and the overall build
25 ratio be from 4.6 to 16.2, and that the temperature of the reaction mixture in the further reaction step increases by up to 35°C as a result of the exothermic polymerization reaction.

In another aspect of the present invention, an alkylene oxide is continuously polymerized in the presence of a double metal cyanide
30 (DMC) polymerization catalyst to form a polyether polyol having a hydroxyl content of from about 3.4 to about 12.1% by weight in a process in which in a first step, an initiator compound that has at least two hydroxyl groups

per molecule and an equivalent weight of up to 115 and at least one
alkylene oxide are fed to a continuous reactor containing a double metal
cyanide catalyst, and a partially polymerized mixture is withdrawn from the
continuous reactor. In this first step, the continuous reactor is maintained
5 at a pressure of from 45 to 55 psia and a polymerization temperature that
is greater than or equal to 125°C (preferably that is greater than or equal to
130°C). The concentration of unreacted alkylene oxide in the contents of
the continuous reactor is maintained at a level of from 1 to 3% (preferably
1 to 2%) by weight, and the hydroxyl content of the reactor contents is
10 maintained at 3.4 to 12.1% by weight.

In a subsequent second step, the partially polymerized mixture
withdrawn from the reactor in the first step is permitted to further react until
the unreacted alkylene oxide content of the mixture is reduced to 0.001%
or less (preferably 0.0005% or less) by weight.

15 In this embodiment of the present invention, it is preferred that the
build ratio in the first step is from 4.6 to 16.2 and the overall build ratio of
from 4.6 to 16.2, and that the temperature of the reaction mixture in the
second step increases by up to 35°C as a result of the exothermic
polymerization reaction.

20 The present invention also relates to a continuous process for the
production of a polyoxyalkylene polyether polyol having an OH number of
from 112 to 400 (preferably 200 to 375) in which:

- (1) oxyalkylation conditions are established in a continuous
oxyalkylation reactor maintained at a pressure of from 45 to 55 psia
25 in the presence of a double metal cyanide (DMC) catalyst;
- (2) alkylene oxide and a low molecular weight starter having at least
two hydroxyl groups per molecule and a number average molecular
weight of from 50 to 250 (preferably from 50 to 230, more preferably
from 50 to 200 and most preferably from 50 to 100) are
30 continuously introduced into the reactor;
- (3) a partially oxyalkylated polyether polyol is recovered from the
continuous oxyalkylation reactor; and

(4) the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor is further reacted, thereby forming the polyoxyalkylene polyether polyol having an OH number of from 112 to 400 (preferably 200 to 375).

5 In a preferred embodiment of this continuous process, the build ratio in the continuous oxyalkylation reactor is from 4.6 to 16.2 and the overall build ratio is from 4.6 to 16.2, and the temperature of the reaction mixture in step (4) the further reaction step, increases by up to 35°C as a result of the exothermic polymerization reaction.

10 A particularly preferred embodiment of the present invention is directed to a process for the production of a polyoxyalkylene polyether polyol by continuously polymerizing an alkylene oxide in the presence of a double metal cyanide (DMC) polymerization catalyst to form a polyether polyol having a hydroxyl content of from about 3.4 to about 9.1% by weight
15 in which:

(1) an initiator compound that has at least two hydroxyl groups per molecule and an equivalent weight of up to 115 and at least one alkylene oxide are fed to a continuous reactor maintained at a pressure of from 45 to 55 psia containing a double metal cyanide
20 catalyst, and a partially polymerized mixture is withdrawn from the continuous reactor

wherein the concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% (preferably 1 to 2%) by weight and the hydroxyl content of the reactor
25 contents is maintained at 3.4 to 9.1% by weight, and

(2) in a subsequent step, the partially polymerized mixture which is withdrawn from the reactor in (1) is permitted to further react until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less (preferably 0.0005% or less) by weight

30 wherein the build ratio in step a) is from 6.1 to 16.2 and the overall

build ratio of from 6.1 to 16.2, and wherein the temperature of the reaction mixture in step b) increases by up to about 24°C as a result of the exothermic polymerization reaction.

5 DETAILED DESCRIPTION OF THE INVENTION

The present invention will now be described for purposes of illustration. Except in the operating examples, or where otherwise indicated, all numbers expressing quantities, percentages, OH numbers, functionalities, and so forth in the specification are to be understood as
10 being modified by the term "about".

As used herein, all molecular weights are number average molecular weights unless otherwise specified.

The continuous process described herein is suitable for the production of polyoxyalkylene polyether polyols. These polyoxyalkylene
15 polyether polyols are characterized as having a hydroxyl content of from about 3.4 to about 12.1% by weight, based on 100% by weight of the polyoxyalkylene polyether polyols. The polyoxyalkylene polyether polyols produced by this process may also be described as typically having an OH number of from at least about 112, and preferably from at least about 200.
20 These polyoxyalkylene polyether polyols also typically have an OH number of less than or equal to about 400, and preferably of less than or equal to about 375. The polyoxyalkylene polyether polyols may also have an OH number ranging between any combination of these upper and lower values, inclusive, such as, for example from at least about 112 to less than
25 or equal to about 400, and preferably from at least about 200 to less than or equal to about 375.

As is known by one skilled in the art, OH numbers of from about 112 to about 400 correspond to equivalent weights of about 500 to about 140, respectively; and OH numbers of from about 200 to about 375
30 correspond to equivalent weights of from about 280 to about 150, respectively.

In addition, the conversion of OH number to hydroxyl content and from hydroxyl content to OH number is easily calculated and readily determined by one of ordinary skill in the art. A polyoxyalkylated polyether polyol having an OH number of about 112 will have a hydroxyl content of about 3.4% by weight, and a polyoxyalkylated polyether polyol having an OH number of about 400 will have a hydroxyl content of about 12.1% by weight.

The polyoxyalkylene polyether polyols prepared by the presently claimed process typically have a hydroxyl content of at least about 3.4%, preferably at least about 6%, and more preferably at least about 7% by weight. These polyoxyalkylene polyether polyols also typically have a hydroxyl content of less than or equal to 12.1%, preferably less than or equal to 11.4%, more preferably less than or equal to 10.6% and most preferably less than or equal to 9.1% by weight. The polyoxyalkylene polyether polyols may have a hydroxyl content ranging between any combination of these upper and lower values, inclusive, e.g., from 3.4% to 12.1%, preferably from 6% to 11.4%, more preferably from 7% to 10.6% and most preferably from 7% to 9.1% by weight, based on 100% by weight of the polyoxyalkylene polyols.

Suitable double metal cyanide (DMC) catalysts to be used in the process of the present invention include, for example, any known DMC catalyst. These include both the crystalline and the substantially non-crystalline (i.e. substantially amorphous) DMC catalysts. Crystalline DMC catalysts are known and described in, for example, U.S. Patents 5,158,922, 4,477,589, 3,427,334, 3,941,849 and 5,470,813. Double metal cyanide (DMC) catalysts which exhibit a substantially non-crystalline character (i.e. are substantially amorphous) are known and described in, for example, U.S. Patents 5,482,908 and 5,783,513.

The catalysts disclosed in U.S. Patents 5,482,908 and 5,783,513 differ from other DMC catalysts because these catalysts exhibit a substantially non-crystalline morphology. In addition, these catalysts are based on a combination of ligands, such as t-butyl alcohol and a

polydentate ligand (polypropylene oxide polyol). Zinc hexacyanocobaltates are preferred DMC catalysts. Preferred DMC catalysts are the substantially amorphous catalysts.

5 The DMC catalyst concentration in the inventive process is chosen to ensure a good control of the polyoxyalkylation reaction under the given reaction conditions. The catalyst concentration is preferably in the range from 15 ppm to 200 ppm, more preferably in the range from 20 ppm to 150 ppm, most preferably in the range from 30 to 120 ppm, based on the weight of the polyether polyol produced. The crystalline and the
10 substantially non-crystalline DMC catalysts may be present in an amount ranging between any combination of these values, inclusive of the recited values.

Suitable low molecular weight starter compounds include compounds which have a functionality of at least about 2 up to about 8,
15 and preferably from about 2 to about 6, and which have an equivalent weight of up to about 115, and preferably up to about 100. Suitable starter compounds include, but are not limited to, C₃-C₅ monols, ethylene glycol, propylene glycol, 1,3-propanediol, 1,4-butanediol, 1,2-butanediol, 1,3-butanediol, 2,3-butanediol, water, glycerin, sorbitol, etc. Mixtures of
20 monomeric initiators or their oxyalkylated oligomers may also be utilized.

Preferred starter compounds are propylene glycol and glycerin. Glycerin is the most preferred starter compound.

Starter compounds may also be referred to as initiators.

The suitable low molecular weight starter compounds may also be
25 described as compounds having the above described functionality and a number average molecular weight of less than or equal to about 250, preferably less than or equal to about 230, more preferably less than or equal to about 200, and most preferably less than or equal to about 100. Typically, the starter compound has a number average molecular weight of
30 at least about 50.

Alkylene oxides useful in the present invention include, but are not limited to, ethylene oxide, propylene oxide, 1,2- and 2,3-butylene oxide,

isobutylene oxide, epichlorohydrin, cyclohexene oxide, and styrene oxide. Propylene oxide alone or mixtures of propylene oxide with ethylene oxide, preferably at a ratio of 85:15 and more preferably at a ratio of 90:10, are preferred for use in the present invention. Other alkylene oxides mixed
5 with propylene oxide may also prove useful in the inventive processes. Propylene oxide alone is the most preferred alkylene oxide.

In the process of the invention, oxyalkylation conditions are established in the continuous reactor by charging a polyether polyol containing a double metal cyanide (DMC) catalyst to the continuous
10 reactor, preferably a continuous stirred tank reactor. The polyether polyol should contain from about 30 to about 120 ppm of DMC catalyst. Once the polyether polyol containing DMC catalyst has been charged to the reactor, the reactor contents are slowly heated to a temperature of 135°C, and preferably at least 140°C. Once the reactor and contents are heated, an
15 initial charge of an alkylene oxide, preferably propylene oxide, is charged to the reactor over a time period of 5 to 10 minutes. Within a short time period, i.e. from about 5 to about 10 minutes, the pressure in the reactor will drop, which indicates that the DMC catalyst has been activated.

Once the DMC catalyst is activated, a feed stream of at least one
20 alkylene oxide (preferably propylene oxide) is started and continuously feed to the reactor. In addition, a separate feed stream of a low molecular weight starter having a molecular weight of from 50 to 250 (or one of the possible ranges described herein) is started and continuously fed to the reactor. The feed stream of the low molecular weight starter also typically
25 contains DMC catalyst in an amount of from 130 to 2000 ppm, depending on the final product hydroxyl number and the final desired catalyst concentration. An alternative method for the catalyst addition is to have a 3rd stream that contains a catalyst loading of 1 to 2 weight % in either the low molecular starter or a low molecular weight polyether. In this
30 alternative method, the 2nd stream contains low molecular weight starter and is free of DMC catalyst; and the 1st stream comprises the alkylene oxide.

Oxyalkylation is conducted in the reactor which is maintained at a pressure sufficient to prevent deactivation of the DMC catalyst. Preferably, this pressure is at least 45 psia, and more preferably at least 48 psia. The maximum pressure in the reactor is preferably about 55 psia, but more preferably about 52 psia and most preferably about 50 psia. Oxyalkylation in the reactor may be conducted at a pressure between any combination of these upper and lower values, inclusive. The oxyalkylation reaction continues for at 4 residence times or more, and preferably 6 residence times or more while maintaining a positive temperature differential between the reaction temperature and the temperature of the cooling/heating loop thus indicating an exothermic reaction that requires cooling. During the oxyalkylation, the concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3%, preferably 1 to 2%, by weight, based on the total weight of the contents in the reactor, and the hydroxyl content of the reactor contents is maintained in the range of from 3.4 to 12.1% by weight (or any of the other suitable ranges for hydroxyl content), based on 100% by weight of the reactor contents.

The temperature at which the oxyalkylation reaction is conducted is generally from 120 to 160°C, preferably, from 125 to 150°C, most preferably, from 130 to 140°C.

Recovery of the partially oxyalkylated polyether polyol from the continuous oxyalkylation reactor is preferably continuous but may be intermittent in some embodiments. The temperature and pressure at which the partially oxyalkylated polyether polyol further reacts can increase during this step due to the exothermic reaction of the residual alkylene oxide onto the end of the polymer chains. Minimal or no external cooling is typically applied at this point in the process. In addition, it is not typically necessary to heat this portion of the process due to the exothermic nature of the polymerization reaction that occurs here. In general, the temperature of the reaction mixture entering this step of the process is at least about 140°C or greater, and preferably at least about 160°C or

greater. The temperature of the reaction mixture entering this step is also typically less than or equal to about 220°C.

In addition, the reaction mixture in this step or portion of the process may increase in temperature by up to 35°C as a result of the exothermic polymerization. Generally, however, the temperature increase of this reaction mixture is more typically from about 10°C to about 25°C. In a preferred embodiment, the temperature increase of the reaction mixture increases up to about 24°C due to the exothermic polymerization.

The partially completed (i.e. oxyalkylated) polyether polyol is continuously removed from the full liquid reactor through a back pressure regulator. The partially oxyalkylated polyether polyol is allowed to further react until the unreacted alkylene oxide content of the reaction mixture is reduced to 0.001% or less, preferably 0.0005% or less, by weight. The final product typically contains small amounts of catalyst residues, i.e. less than or equal to about 100 ppm, more preferably less than or equal to 50 ppm; small quantities of the initiator compound or low molecular weight alkoxyates thereof; and small amounts of other organic impurities and water. As is known in the production of polyoxyalkylated polyether polyols, volatile compounds can be flashed or stripped from the polyols, and catalyst residues may remain in the product or may be removed. Moisture can be removed by stripping the polyols.

It is preferred that the partially oxyalkylated polyether polyols further reacts in a pipe reactor. This typically occurs by passing the partially oxyalkylated polyether polyol through a pipe reactor that is steam heated to maintain a high temperature of about 145°C for reaction of the remaining alkylene oxide. It is preferred that the further reaction of the partially oxyalkylated polyether polyol occurs isothermally.

The minimum build ratios for the continuous oxyalkylation reactor are typically at least about 4.6, preferably at least about 4.9, more preferably at least about 5.2 and most preferably at least about 6.1. The maximum build ratios for the continuous oxyalkylation reactor are typically less than or equal to about 16.2, preferably less than or equal to about 9.1,

and more preferably less than or equal to about 7.9. The build ratios for the continuous oxyalkylation reactor may range from any combination of these upper and lower values, inclusive, such as, for example, from at least about 4.6 to less than or equal to about 16.2, preferably from at least
5 about 4.9 to less than or equal to about 9.1, and more preferably from at least about 5.2 to less than or equal to about 7.9. These same build ratios are also suitable for the overall process. It is particularly preferred to use a build ratio of from 5.2 to 7.9 when glycerin is the low molecular weight starter. Another preferred build ratio for the invention ranges from at least
10 about 6.1 to about less than or equal to about 16.2.

In accordance with the present invention, it is preferred that the low molecular weight starter is acidified with a small amount of a suitable acid as described in, for example, U.S. Patent 6,077,978 and U.S. Patent 7,919,575. The acid may be any inorganic protic mineral acid or organic
15 acid which is known to suitable as described in the art. Typically, the amount of acid to be added to the low molecular weight starter ranges from 30 to 200 ppm, based on the weight of the low molecular weight starter. Preferably, the starter contains from 30 to 100 ppm of acid. Phosphoric acid is the preferred acid.

20 It is also possible, although not preferred, that when propylene glycol is used as the carrier for the DMC catalyst, an acid such as phosphoric acid, may be added to the propylene glycol in an amount sufficient to decrease the pH of the propylene glycol, e.g., in an amount of from 60 to 75 ppm without detrimentally affecting the DMC catalyst activity.

25 When using a 3rd stream containing an acidified low molecular weight starter or polyol as the catalyst carrier (see the alternate embodiment described above) the acid level in the mixture of carrier and catalyst is less than 1500 ppm. Preferably the mixture of low molecular weight starter or polyol catalyst carrier and the catalyst contains less than
30 1250 ppm of acid.

The term "partially" with regard to the oxyalkylated polyether polyols formed in the processes of the present invention may be understood to

mean that the oxyalkylation of the starter to form the polyether polyol is substantially completed. In other words, after the oxyalkylated polyether polyol is recovered or removed from the continuous oxyalkylation reactor, a minor amount of reaction occurs outside of the reactor. More specifically, at the point the oxyalkylated polyether polyol is recovered from the continuous oxyalkylation reactor, the reaction is preferably at least 98% complete, more preferably at least 98.5% complete, and most preferably at least 99% complete.

The following examples further illustrate details for the process of this invention. The invention, which is set forth in the foregoing disclosure, is not to be limited either in spirit or scope by these examples. Those skilled in the art will readily understand that known variations of the conditions of the following procedures can be used. Unless otherwise noted, all temperatures are degrees Celsius and all parts and percentages are parts by weight and percentages by weight, respectively.

EXAMPLES

Example 1 (Comparative)

A 270 hydroxyl number glycerine-based all-PO polyether (about 1779 grams) containing 60 ppm of DMC catalyst which was prepared according to the procedure in U.S. Patent 5,482,908 was charged to a 1 gallon stainless steel reactor equipped with a mechanical agitator and slowly heated. During the heat-up, continuous vacuum was pulled on the headspace and nitrogen was introduced to the liquid phase via a dip tube. Once the reactor temperature reached 140°C, the vacuum and nitrogen continued for an additional ten minutes, the nitrogen was then stopped and the reactor was blocked in at a pressure of 1.5 psia. An initial charge of PO was charged to the reactor over several minutes. After 10 minutes, the pressure in the reactor decreased indicating that the DMC catalyst was active. The PO feed was restarted and set at a rate of 20.2 g/min (equivalent to a 2.5 hour residence time). After establishing the oxide

feed, a feed containing glycerin with 406 ppm of DMC catalyst and 75 ppm phosphoric acid was started at a rate of 3.50 g/min. The DMC catalyst was added to the glycerine by constant agitation of the glycerin / DMC catalyst feed vessel. The glycerin / catalyst feed line may have constant
5 recirculation between the reactor feed point and the glycerin / DMC catalyst feed vessel to eliminate settling of the catalyst in the feed line, although constant recirculation was not used in the present examples unless otherwise noted. The DMC concentration in the glycerin is sufficient to provide 60 ppm of DMC catalyst in the final product. When
10 the pressure in the reactor reached 41 psia, a valve at the top of the reactor was opened to a back pressure regulator and the liquid contents of the full continuously stirred tank reactor were allowed to flow out of the reactor. The polyether passed through a steam heated section of pipe before being collected in a heated and stirred jacketed vessel. After
15 approximately 1 hour of oxide feed to the stirred jacketed vessel, the reactor cooling system switched to heating indicating a loss of reaction. After an additional 30 minutes of heating with no sign of reaction, the oxide feeds and glycerin / DMC feeds were stopped.

20 Example 2 (Comparative)

Using the same reactor contents as described at the end of Example 1 and a similar start-up procedure as set forth in Example 1, the reaction pressure was set at 15 psia and the temperature was set at
25 140°C prior to starting the PO and glycerin / DMC feeds. The PO was fed at a constant rate of 20.2 g/min (equivalent to a 2.5 hour residence time). The glycerin / DMC feed contained 406 ppm of DMC catalyst and 75 ppm phosphoric acid, and was fed at a constant rate of 3.50 g/min. When the pressure in the reactor reached 43 psia, a valve at the top of the reactor was opened to a back pressure regulator and the liquid contents of the full
30 continuously stirred tank reactor were allowed to flow out of the reactor. The polyether passed through a steam heated section of pipe before being collected in a heated and stirred jacketed vessel. After approximately 1

hour of oxide feed to the stirred jacketed vessel, the reactor cooling system switched to heating indicating a loss of reaction. After an additional 30 minutes of heating with no sign of reaction, the oxide feeds and glycerin / DMC feeds were stopped. The reaction mixture cooked down to 20 psia.

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Example 3

Using the final reactor contents as described in Example 2 as the starter, the temperature was maintained at 140°C, the PO feed was re-started at 20.2 g/min and the glycerin / DMC feed containing 406 ppm of DMC catalyst and 75 ppm phosphoric acid was re-started at a rate of 3.50 g/min. When the reaction pressure reached 48 psia, a valve at the top of the reactor was opened to a back pressure regulator and the liquid contents of the full continuously stirred tank reactor were allowed to flow out of the reactor. The polyether passed through a steam heated section of pipe before being collected in a heated and stirred jacketed vessel. The reaction continued for 21 hours (8 residence times) with a good heat of reaction (constant reactor cooling). The collected product had a measured hydroxyl number of 271 mg KOH/g and a viscosity of 292 cSt at 25°C and a polydispersity of 1.088 (Mw/Mn).

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Example 4 (Comparative)

Using the final reactor contents as described in Example 3 and continuing the same feed rates as were used in Example 3 and the same DMC concentration as was used in Example 3, the pressure on the back pressure regulator was decreased to 40 psia. After approximately 30 minutes of oxide feed to the stirred jacketed vessel, the reactor cooling system switched to heating indicating a loss of reaction. After an additional 30 minutes of heating with no sign of reaction, the oxide feeds and glycerin / DMC feeds were stopped and reaction mixture allowed to cookout.

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Example 5

A 240 hydroxyl number glycerine-based all-PO polyether (about 1779 grams) containing 60 ppm of DMC catalyst which was prepared according to the procedure in U.S. Patent 5,482,908 was charged to a 1 gallon stainless steel reactor equipped with a mechanical agitator and slowly heated. During the heat-up, continuous vacuum was pulled on the headspace and nitrogen was introduced to the liquid phase via a dip tube. Once the reactor temperature reached 140°C, the vacuum and nitrogen continued for an additional ten minutes, the nitrogen was then stopped and the reactor was blocked in at a pressure of 1.5 psia. An initial charge of PO was charged to the reactor over several minutes. After 10 minutes, the pressure in the reactor decreased indicating that the DMC catalyst was active. The PO feed was restarted and set at a rate of 20.61 g/min (equivalent to a 2.5 hour residence time). After establishing the oxide feed, a feed containing glycerin with 457 ppm of DMC catalyst and 75 ppm phosphoric acid was started at a rate of 3.12 g/min. The DMC catalyst was added to the glycerine by constant agitation of the glycerin / DMC catalyst feed vessel. The glycerin / catalyst feed line may have constant recirculation between the reactor feed point and the glycerin / DMC catalyst feed vessel to eliminate settling of the catalyst in the feed line, although constant recirculation was not used in the present examples unless otherwise noted. The DMC concentration in the glycerin is sufficient to provide 60 ppm of DMC catalyst in the final product. When the pressure in the reactor reached 50 psia, a valve at the top of the reactor was opened to a back pressure regulator and the liquid contents of the full continuously stirred tank reactor were allowed to flow out of the reactor. The polyether passed through a steam heated section of pipe before being collected in a heated and stirred jacketed vessel. The reaction continued for 21 hours (8 residence times) with a good heat of

reaction (constant reactor cooling). The collected product had a measured hydroxyl number of 230 mg KOH/g and a viscosity of 287 cSt at 25°C and a polydispersity of 1.089 (Mw/Mn).

5 Example 6 (Comparative)

Using the final reactor contents as described in Example 5 and continuing the same feed rates as were used in Example 5 and DMC concentration as was used in Example 5, the pressure on the back pressure regulator was slowly decreased to 38 psia over 2 hours. After approximately 30 minutes of oxide feed to the stirred jacketed vessel, the reactor cooling system switched to heating indicating a loss of reaction. After an additional 30 minutes of heating with no sign of reaction, the oxide feeds and glycerin / DMC feeds were stopped and reaction mixture allowed to cookout.

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Examples 3 and 5 demonstrated that using a slightly higher reaction pressure than that which was used in Examples 1, 2, 4 and 6 maintained the reaction and provided a steady state process.

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Although the invention has been described in detail in the foregoing for the purpose of illustration, it is to be understood that such detail is solely for that purpose and that variations can be made therein by those skilled in the art without departing from the spirit and scope of the invention except as it may be limited by the claims.

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WHAT IS CLAIMED IS:

1. A continuous process for the production of a polyoxyalkylene polyether polyol having a hydroxyl content of from about 3.4 to about 12.1% by weight comprising:
- 5 (a) establishing oxyalkylation conditions in a continuous oxyalkylation reactor in the presence of a double metal cyanide catalyst;
- (b) continuously introducing alkylene oxide and a low molecular weight starter into the continuous oxyalkylation reactor, wherein the starter has a number average molecular weight of from 50 to 250;
- 10 (c) recovering a partially oxyalkylated polyether polyol from the continuous oxyalkylation reactor;
- wherein (i) the oxyalkylation in the continuous oxyalkylation reactor occurs at a sufficiently high pressure to prevent deactivation of the DMC catalyst;
- (ii) the concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% by weight; and
- 15 (iii) the hydroxyl content of the reactor contents is maintained at 3.4 to 12.1% by weight;
- and
- (d) allowing further reaction of the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor
- 20 to occur until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less by weight.
2. The process of Claim 1, wherein the resultant
- 25 polyoxyalkylene polyether polyol has a hydroxyl number of from about 112 to about 400.
3. The process of Claim 1 wherein the build ratio in the continuous oxyalkylation reactor is from 4.6 to 16.2.

4. The process of Claim 1, wherein the overall build ratio is from 4.6 to 16.2.
5. The process of Claim 1, wherein the alkylene oxide is propylene oxide or a mixture of propylene oxide and ethylene oxide that contains at least 85% by weight of propylene oxide.
6. The process of Claim 1, wherein the hydroxyl content of the reactor contents is maintained at 6 to 11.4% by weight.
7. The process of Claim 1, wherein the unreacted alkylene oxide in the contents of the continuous oxyalkylation reactor is maintained at a level of from 1 to 2% by weight.
8. The process of Claim 1, wherein the low molecular weight starter comprises glycerine.
9. The process of Claim 1, wherein the continuous oxyalkylation reactor is a continuously stirred tank reactor and the further reaction of the partially oxyalkylated polyether polyol is performed in a pipe reactor.
10. The process of Claim 1, wherein the concentration of the double metal cyanide catalyst in the continuous oxyalkylation reactor is from 30 to 120 ppm, based on the weight of the product.
11. The process of Claim 1, wherein the pressure in the continuous oxyalkylation reactor is at least 45 psia.
12. The process of Claim 1, wherein the pressure in the continuous oxyalkylation reactor is from 45 to 55 psia.

13. The process of Claim 1, wherein the double metal cyanide catalyst is a zinc hexacyanocobaltate catalyst complex.

14. The process of Claim 1, wherein the resultant
5 polyoxyalkylene polyether polyol has a hydroxyl content of from 7 to 10.6% by weight.

15. The process of Claim 1, wherein the low molecular weight starter comprises glycerine and the overall build ratio is from 5.2 to 7.9.
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16. The process of Claim 1, wherein the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor passes through a pipe reactor that is steam heated to maintain a high temperature of about 145°C for reaction of the remaining oxide until
15 the unreacted alkylene oxide content of the mixture is reduced to 0.0005% or less by weight.

17. The process of Claim 1, wherein the further reaction of the partially oxyalkylated polyether polyol occurs isothermally.
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18. A continuous process for the production of a polyoxyalkylene polyether polyol having a hydroxyl content of from about 3.4 to about 12.1% by weight comprising:

- 25 (a) establishing oxyalkylation conditions in a continuous oxyalkylation reactor in the presence of a double metal cyanide catalyst;
- (b) continuously introducing alkylene oxide and a low molecular weight starter into the continuous oxyalkylation reactor, wherein the starter has at least two hydroxyl groups per molecule and an equivalent weight of up to 115;
- 30 (c) recovering a partially oxyalkylated polyether polyol from the continuous oxyalkylation reactor;

wherein (i) the oxyalkylation in the continuous oxyalkylation reactor occurs

at a sufficiently high pressure to prevent deactivation of the DMC catalyst;

(ii) the concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% by weight; and

(iii) the hydroxyl content of the reactor contents is maintained at 3.4 to

5 12.1% by weight;

and

(d) allowing further reaction of the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor

to occur until the unreacted alkylene oxide content of the mixture is

10 reduced to 0.001% or less by weight

wherein the build ratio in the continuous oxyalkylation reactor is from 4.6 to

16.2 and the overall build ratio is from 4.6 to 16.2, and wherein the

temperature of the reaction mixture in further reaction step (d) increases

by up to 35°C as a result of the exothermic polymerization reaction.

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19. A continuous process for the production of a polyether polyol having a hydroxyl content of from about 3.4 to about 12.1% by weight, comprising:

(a) continuously polymerizing at least one alkylene oxide in the presence of a double metal cyanide catalyst in a continuous reactor;

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(b) feeding a low molecular weight starter that has at least two hydroxyl groups per molecule and an equivalent weight of up to 115, and at least one alkylene oxide to the continuous reactor containing

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alkylene oxide and a double metal cyanide catalyst;

recovering a partially oxyalkylated polyol mixture from the continuous reactor

wherein (i) the continuous reactor is maintained at a pressure of from 45 to

55 psia, (ii) the concentration of unreacted alkylene oxide in the contents

30 of the continuous reactor is maintained at a level of from 1 to 3% by

weight, and (iii) the hydroxyl content of the reactor contents is maintained at 3.4 to 12.1% by weight;

and

(d) subsequently, the partially oxyalkylated polyol mixture which is withdrawn from the continuous reactor is permitted to further react until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less by weight

wherein the build ratio in the continuous oxyalkylation reactor is from 4.6 to 16.2 and the overall build ratio is from 4.6 to 16.2, and wherein the temperature of the reaction mixture in the further reaction step increases by up to 35°C as a result of the exothermic polymerization reaction .

10

20. The process of Claim 19, wherein the resultant polyether polyol has an OH number of from about 112 to about 400.

21. A process for continuously polymerizing an alkylene oxide in the presence of a double metal cyanide polymerization catalyst to form a polyether polyol having a hydroxyl content of from about 3.4 to about 12.1% by weight, wherein:

(a) in a first step, an initiator compound that has at least two hydroxyl groups per molecule and an equivalent weight of up to 115, and at least one alkylene oxide are fed to a continuous reactor containing a double metal cyanide catalyst, and a partially polymerized mixture is withdrawn from the continuous reactor;

wherein (i) the continuous reactor is maintained at a pressure of from 45 to 55 psia, (ii) the concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% by weight, and (iii) the hydroxyl content of the reactor contents is maintained at 3.4 to 12.1% by weight, and

(b) in a second step, the partially polymerized mixture which is withdrawn from the reactor in step (a) is permitted to further react until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less by weight

wherein the build ratio in step (a) is from 4.6 to 16.2 and the overall build

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ratio is from 4.6 to 16.2, and wherein the temperature of the reaction mixture in step (b) increases by up to 35°C as a result of the exothermic polymerization reaction.

5 22. The process of Claim 21, wherein the resultant polyether polyol has an OH number of from about 112 to about 400.

10 23. A continuous process for the production of a polyoxyalkylene polyether polyol having an OH number of from 112 to 400 comprising:

- (1) establishing oxyalkylation conditions in a continuous oxyalkylation reactor in the presence of a double metal cyanide catalyst;
- (2) continuously introducing alkylene oxide and a low molecular weight starter into the reactor, the starter having a number average
- 15 molecular weight of from 50 to 250;

and

- (3) recovering a partially oxyalkylated polyether polyol from the continuous oxyalkylation reactor;

20 wherein (i) the oxyalkylation is conducted in the continuous reactor at a sufficiently high pressure to prevent deactivation of the DMC catalyst; and

- (4) further reacting the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor thereby forming the polyoxyalkylene polyether polyol having an OH number of from 112 to 400.

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24. The process of Claim 23, wherein the build ratio in the continuous oxyalkylation reactor is from 4.6 to 16.2 and the overall build ratio is from 4.6 to 16.2, and wherein the reaction temperature of the partially oxyalkylated polyether polyol in step (4) increases by up to 35°C

30 as a result of the exothermic polymerization reaction.

25. The process of Claim 23, wherein the oxyalkylation in the continuous reactor occurs at a temperature of at least 135°C.

26. The process of Claim 23, wherein the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor is reacted isothermally.

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27. The process of Claim 23, wherein the partially oxyalkylated polyether polyol which is recovered from the continuous oxyalkylation reactor is reacted until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less by weight.

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28. A process for continuously polymerizing an alkylene oxide in the presence of a double metal cyanide (DMC) polymerization catalyst to form a polyether polyol having a hydroxyl content of from about 3.4 to about 9.1% by weight, wherein

15 (a) in a first step, an initiator compound that has at least two hydroxyl groups per molecule and an equivalent weight of up to 115 and at least one alkylene oxide are fed to a continuous reactor containing a double metal cyanide catalyst, and a partially polymerized mixture is withdrawn from the continuous reactor

20 wherein (i) the continuous reactor is maintained at a pressure of from 45 to 55 psia, (ii) the concentration of unreacted alkylene oxide in the contents of the continuous reactor is maintained at a level of from 1 to 3% by weight, and (iii) the hydroxyl content of the reactor contents is maintained at 3.4 to 9.1% by weight, and

25 (b) in a subsequent step, the partially polymerized mixture which is withdrawn from the reactor in step (a) is permitted to further react until the unreacted alkylene oxide content of the mixture is reduced to 0.001% or less by weight

wherein the build ratio in step (a) is from 6.1 to 16.2 and the overall build
30 ratio of from 6.1 to 16.2, and wherein the temperature of the reaction mixture in step (b) increases by up to about 24°C as a result of the exothermic polymerization reaction.

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US2014/024141**A. CLASSIFICATION OF SUBJECT MATTER****C08G 65/10(2006.01)i, C08G 65/26(2006.01)i, C08G 18/48(2006.01)i**

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

C08G 65/10; C08G 65/00; C07C 41/03; C07C 43/11; C08G 65/26; C08G 18/48

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Korean utility models and applications for utility models

Japanese utility models and applications for utility models

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

eKOMPASS(KIPO internal) & Keywords: polyoxyalkylene polyether polyol, continuous process, double metal cyanide catalyst, alkylene oxide, low molecular weight starter, high pressure

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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A	US 5689012 A (PAZOS, JOSE F. et al.) 18 November 1997 See abstract; and claims 1-31.	1-28
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 Further documents are listed in the continuation of Box C. See patent family annex.

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

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