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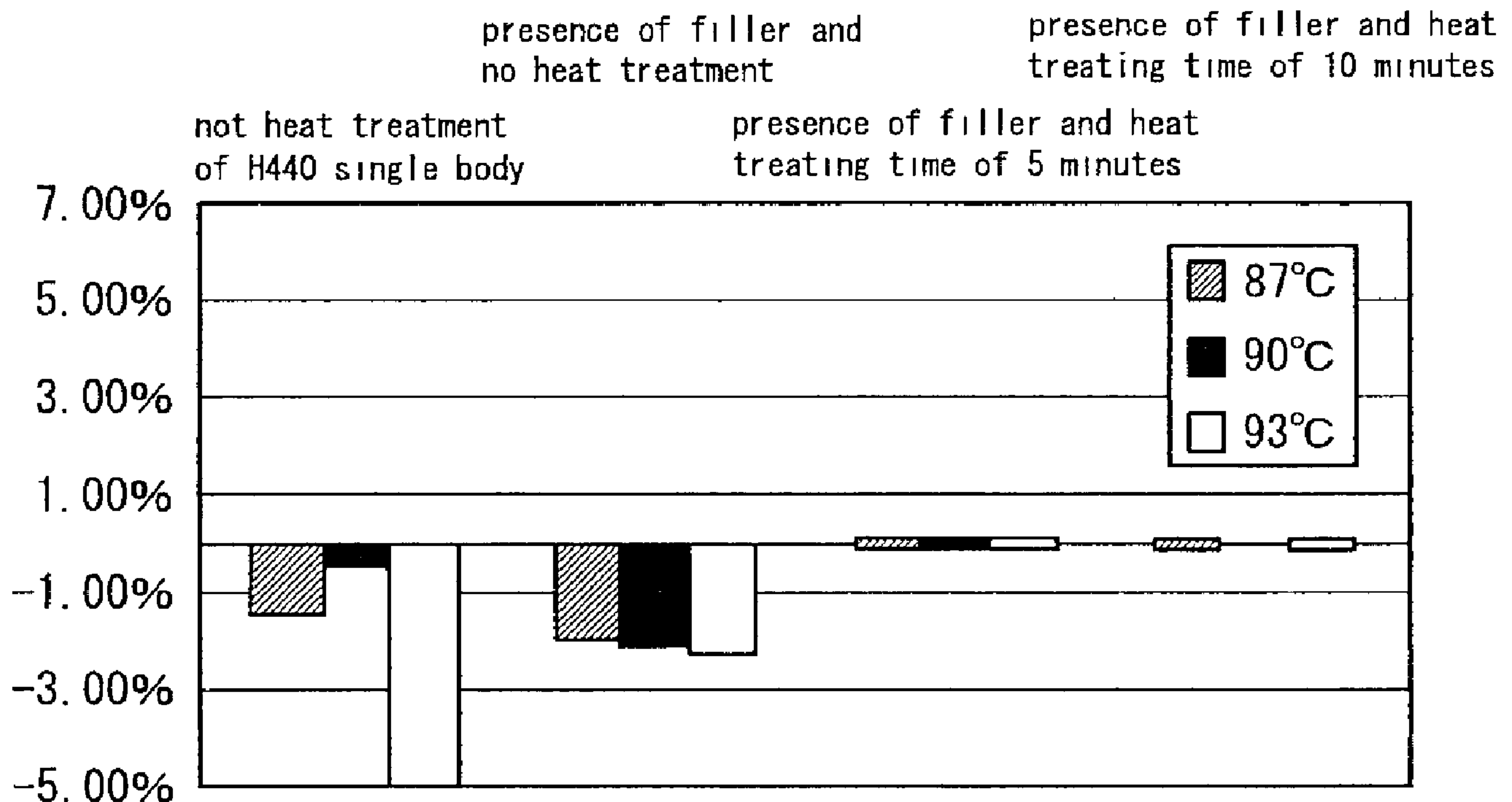
(71) Demandeur/Applicant:  
YOSHINO KOGYOSHO CO., LTD., JP

(72) Inventeurs/Inventors:  
SUGAI, MASAHIRO, JP;  
SUZUKI, MASATO, JP;  
SHIMURA, HIROMI, JP;  
CHIBA, JUNICHI, JP

(74) Agent: BLAKE, CASSELS & GRAYDON LLP

(54) Titre : PREFORME D'ACIDE POLY(L-LACTIQUE) RESISTANT A LA CHALEUR

(54) Title: HEAT-RESISTANT POLY-L-LACTIC ACID PREFORM



(57) Abrégé/Abstract:

Disclosed is a preform which comprises a functional filler blended into a resin comprising a poly(L-lactic acid) and which has an opening treated by heating. Also disclosed is a hollow molded article formed by the blow-molding of the preform. The preform is improved in the degree of crystallinity at the opening and has good heat resistance. Therefore, the preform is suitable for practical use.

# ABSTRACT OF THE DISCLOSURE

A preform is formed by compounding a resin made from poly-L-lactic acid with a functional filler and subjecting a mouth portion to a heat treatment. Also, a hollow shaped product is produced by blow-molding the  
5 preform.

SPECIFICATION  
HEAT-RESISTANT POLY-L-LACTIC ACID PREFORM

## TECHNICAL FIELD

- 5    **[0001]**     This invention relates to a preform obtained by compounding a functional filler into a resin made from a poly-L-lactic acid and then subjecting to a heat treatment.

## RELATED ART

- 10   **[0002]**     PET bottles become world-widely popular as a revolutionary container and are applied for soybean sauce, water for food, drinking water, light drinks and beers, which largely contribute to civil life and circulation.

Moreover, the progression of plastics including PET bottles highly contributes to human life and industrial activity, whereas it becomes noticed as a factor causing environmental issues such as depletion of recent petroleum sources, global  
15   warming and so on.

- [0003]**     As a countermeasure for these issues, it is attempted to develop plastics from botanical resources being a renewable resource. A polylactic acid resin is one of biodegradable resins obtained from renewable materials such as corn, potato and the like, and has excellent transparency and hardness and  
20   possesses properties similar to polystyrene currently and widely used in food containers and the like.

- [0004]**     In the container field are most frequently used PET bottles. Even in this field, the development of biodegradable resins is anticipated as a key word for solving the resource-waste issues. However, the development for use in the  
25   bottle is not promoting contrary to the anticipation at the present time.

- [0005]**     Since the polylactic acid is a crystalline polymer, it is low in the melt viscosity required for the shaping of the bottle and has no temperature stability and further slow in the crystallization rate and long in the shaping cycle. On the other hand, a method of lowering the crystallinity is adopted for increasing the  
30   melt viscosity to attain the stabilization, but such a method has drawbacks that the crystallinity is too low and the heat resistance of the resulting shaped product is deteriorated. Since the polylactic acid resin presently used has  $T_m = 155^{\circ}\text{C}$  and a crystallinity of about 16%, there can not be expected the improvement of

the heat resistance by the crystallization. In order to develop a bottle using the polylactic acid as a starting material, therefore, it is required that the behavior of the melt viscosity for maintaining the shapability is improved but also problems such as increase of crystallinity and fine reduction of crystal particle size are  
5 solved.

[0006] As an example of preparing a container or preform using the polylactic acid resin, there is a report that a resin film of a polyvinyl alcohol-based coating agent is formed on a surface of a container made from polylactic acid (Patent Document 1). Patent Document 1 uses the polylactic acid as a  
10 material for the container, but is to improve the barrier property instead of the heat resistance. There is also an example of preparing a hollow shaped product formed by compounding polylactic acid resin and polyacetal resin (Patent Document 2). In Patent Document 2, the hollow shaped product having excellent mechanical properties, heat resistance, impact resistance, gas barrier  
15 property and transparency is obtained by rendering the two different resins into the compatibility, but the thermal crystallization or the like is not conducted.

[0007] Patent Document 1: JP-A-H08-244781

Patent Document 2: JP-A-2004-91684

#### SUMMARY OF THE INVENTION

20 [0008] It is, therefore, an object of the invention to develop bottles made from polylactic acid resin not having the aforementioned problems and improving the crystallinity in a mouth portion and having as good heat resistance.

[0009] In order to achieve the above object, the invention provides a preform characterized by compounding a resin made from poly-L-lactic acid with a  
25 functional filler and subjecting a mouth portion to a heat treatment as well as a hollow shaped product through blow molding of such a preform.

[0010] Further, the invention provides a method of producing a preform which comprises steps of compounding a resin made from poly-L-lactic acid with a functional filler, preparing a resin shaped body through an extrusion molding,  
30 compression molding or injection molding of the resin compounded with the functional filler and subjecting a mouth portion of the shaped body to a heat treatment.

[0011] In the preform characterized by compounding a resin made from



poly-L-lactic acid with a functional filler and subjecting a mouth portion to a heat treatment according to the invention, the crystallinity is improved and the heat resistance is good. In the invention, the thermal crystallization of the poly-L-lactic acid resin itself is made possible by compounding the functional filler, and hence the improvement of the heat resistance in the mouth portion is attained.

#### BRIEF DESCRIPTION OF THE DRAWINGS

[0012] FIG. 1 is a graph showing influences of functional filler and whitening in H-440 upon a ratio of change in an outer mouth diameter during the heating.

10 FIG. 2 is a graph showing influences of functional filler and whitening in H-440 upon a ratio of change in a diameter of a threaded portion during the heating.

FIG. 3 is a graph showing influences of functional filler and whitening in H-440 upon a ratio of change in a neck height during the heating.

15 FIG. 4 is a graph showing influences of functional filler and whitening in H-440 upon a ratio of change in an inner mouth diameter during the heating.

FIG. 5 is a graph showing influences of functional filler and whitening in H-400 upon a ratio of change in an outer mouth diameter during the heating.

20 FIG. 6 is a graph showing influences of functional filler and whitening in H-400 upon a ratio of change in an outer mouth diameter during the heating.

FIG. 7 is a graph showing influences of functional filler and whitening in H-400 upon a ratio of change in a neck height during the heating.

FIG. 8 is a graph showing influences of functional filler and whitening in H-400 upon a ratio of change in an inner mouth diameter during the heating.

#### BEST MODE FOR CARRYING OUT THE INVENTION

30 [0013] The inventors have made various studies and discovered that the property of melt viscosity is rendered into a range suitable for blow molding by adding a resin having a high L-form content and made from poly-L-lactic acid having a high crystallinity with a functional filler comprising D-lactic acid

strongly interacting therewith. Also, the improvement of the heat resistance is attained by crystallizing a shaped bottle after the shaping. Furthermore, the properties, addition ratio and the like of the functional filler are optimized for preventing the bottle from opacifying by crystallization. Moreover, the heat  
5 resistance, properties and transparency are improved by reducing the size of crystal particles as small as possible and raising the crystallinity as limit as possible.

[0014] As previously mentioned, the invention provides a preform characterized by compounding a resin made from poly-L-lactic acid with a  
10 functional filler and subjecting a mouth portion to a heat treatment. In the following examples, LACEA (registered trademark) H440 and LACEA H400 made by Mitsui Chemicals, Inc. are used as a resin made from poly-L-lactic acid, and the use of these resins is a preferable embodiment of the invention. However, the resin made from poly-L-lactic acid for use in the object of the  
15 invention is not limited thereto, and Nature Works 7000D, 7032D and the like made by Nature Works LLC may be used.

[0015] In a preferable embodiment of the invention, the polylactic acid has a number average molecular weight of 60,000-80,000. When the number average molecular weight is within the above range, it is possible to preferably shape  
20 hollow shaped products such as bottles and so on.

[0016] The functional filler is preferably obtained by graft polymerization of a compound having 2-4 hydroxyl groups with 1-100 molecules of D-lactic acid. In the functional fillers, it is preferable that 30-50 molecules of D-lactic acid is graft-polymerized, and it is most preferable that 50 molecules of D-lactic acid is  
25 graft-polymerized. In the invention, the thermal crystallization can be made by the formation of a stereo-complex between D-lactic acid included in the functional filler and L-lactic acid in the resin, whereby the target effects such as heat resistance and the like are obtained. The feature that it is preferable to graft-polymerize about 50 molecules of D-lactic acid is confirmed by a  
30 differential scanning calorimetry (DSC).

[0017] Moreover, when the polymerizing quantity of D-lactic acid is not more than 10 molecules, the formation of stereo-complex in H400 + pentaerythritol could not be confirmed by DSC. Further, when the polymerizing

quantity of D-lactic acid is not less than 50 molecules, the crystal of the stereo-complex itself becomes large, from which is further crystallized a homopoly-lactic acid, so that there may be unfavorably a tendency of being opacified.

[0018] In the invention, the compound in the functional filler is preferable to  
5 be sugars selected from polysaccharides and oligosaccharides. Particularly, the oligosaccharide is preferable to be a pentasaccharide. As a concrete example of the preferable sugars may be mentioned monosaccharides such as glucose, fructose and the like; disaccharides such as sucrose and the like; and polysaccharides such as starch, cyclodextrin and the like. In a further preferable  
10 embodiment of the invention, the compound in the functional filler is an inorganic compound such as silica nonoparticles or the like, or an organic compound selected from polyethylene glycol, trimethylol propane and pentaerythritol.

[0019] In the invention, the amount of the functional filler compounded is  
15 preferably 5-20% by weight, more preferably 10% by weight per the poly-L-lactic acid. If the functional filler is added in an amount of not less than 30% by weight, the viscosity in the injection molding becomes low and hence there is caused a problem in the workability of the secondary shaping. Moreover, the formation of the stereo-complex between the filler and the lactic acid resin is  
20 confirmed by DSC when the amount of the filler compounded is 5% by weight, 10% by weight or 20% by weight.

[0020] The heat treatment in the invention is preferable to be carried out at a temperature of from a glass transition temperature ( $T_g$ ) to a melting point ( $T_m$ ), concretely at a temperature of about 60°C to about 160°C. Particularly, it is  
25 preferable that the heat treatment is carried out above a peak temperature of an isothermal crystallization, concretely at a temperature of 110°C to 120°C.

[0021] In a further preferable embodiment of the invention, one or more melting peaks are existent in addition to the melting point of the resin single body made from poly-L-lactic acid as measured by the differential scanning  
30 calorimetry (DSC). The melting point of the resin single body made from poly-L-lactic acid is about 145°C to 170°C. As shown in the following examples, however, one or two melting peaks are observed even at a higher temperature of from about 180°C to 200°C by compounding the functional filler.



[0022] The melting peak observed at a temperature higher than that of the resin single body made from poly-L-lactic acid shows that L-lactic acid of the resin and D-lactic acid of the filler form a stereo-complex. The thus formed stereo-complex affects the crystallization behavior of the poly-lactic acid resin and contributes to the promotion of the crystallization, and hence the improvement of the heat resistance can be attained.

[0023] Further, hollow shaped products may be prepared by blow molding of the preform according to the invention, which is within a scope of the invention. Moreover, the method of blow-molding the preform is well-known in this field. The blow molding method in biaxial orientation is preferably used without limiting thereto.

[0024] According to the invention, the preform is produced by the production method comprising steps of compounding a resin made from poly-L-lactic acid with a functional filler, preparing a resin shaped body through extrusion molding, compression molding or injection molding of the resin compounded with the functional filler and subjecting a mouth portion of the shaped body to a heat treatment. The method for extrusion molding, compression molding or injection molding and the heat treating method of the mouth portion are also well-known in this field.

## 20 EXAMPLES

[0025] The following examples are given in illustration of the invention and are not intended as limitations thereof.

### [0026] Example 1

As a polylactic acid resin is used a polylactic acid of a grade having a slow crystallization rate (PLA) (LACEA H440 made by Mitsui Chemicals, Inc.). On the other hand, a functional filler is used by graft-polymerizing pentaerythritol having 4 functional groups with 50 molecules of D-lactic acid. A preform is prepared by adding 10% of the functional filler to PLA. Then, a mouth portion of the preform is crystallized to confirm its heat resistance.

30 [0027] Moreover, the crystallization conditions are as follows:

- (1) Preform: 500 ml
- (2) Temperature set in a heater: 300→490°C
- (3) Heat treating time: 5 minutes or 10 minutes



(4) Temperature of a mouth portion at an outlet of a furnace: 81-126°C

[0028] A sample used in this test is as follows:

- (1) H440 single body (no heat treatment)
- (2) H440 + 10% filler (no heat treatment)
- 5 (3) H440 + 10% filler (heat treating time: 5 minutes)
- (4) H440 + 10% filler (heat treating time: 10 minutes)

Moreover, the heat treated H440 single body indicates a poor appearance due to the fusion and can not be used as a sample for evaluation.

[0029] As an evaluation method, the mouth portion is immersed in a hot  
10 water of 87°C, 90°C or 93°C for 5 minutes to measure a dimensional change of the mouth portion before and after the immersion. That is, there are measured a ratio of change in an outer diameter of the mouth portion, a ratio of change in an inner diameter of the mouth portion, a ratio of change in a diameter of the threaded portion, a ratio of change in a diameter of a bead portion, a ratio of  
15 change in a diameter under a bead portion, a ratio of change in a neck ring diameter and a ratio of change in a neck height during the heat treatment.

[0030] The results are shown in FIGS. 1-4. In the system crystallized by adding the filler, the change of the size in all portions is hardly observed even in the heating at 87°C, 90°C or 93°C. Therefore, the preform having a good heat  
20 resistance is obtained by subjecting the mouth portion of the preform comprised of PLA and the functional filler to the heat treatment. Moreover, the change of the size in PLA added with the filler prior to the heat treatment is smaller than that in PLA single body not added with the filler prior to the heat treatment. The heat resistance is clearly increased by the heat treatment, and is good in the  
25 system subjected to the heat treatment for 10 minutes.

[0031] Example 2

The polylactic acid or H440 used in Example 1 is a product consisting essentially of L-lactic acid and containing about 5% of D-form. Moreover, it is known that a slight amount of D-lactic acid contained in the poly-L-lactic acid  
30 influences on the crystallinity. Now, in order to examine the relationship between the crystallinity and the heat resistance of the polylactic acid resin, LACEA H400 made by Mitsui Chemicals, Inc. having a D-form content of about 2% and a high crystallinity is used to conduct the examination of the heat

resistance in the same manner as described above.

[0032] A sample used in this test is as follows:

- (1) H400 single body (no heat treatment)
- (2) H400 single body (heat treating time: 10 minutes)
- 5 (3) H400 + 10% filler (no heat treatment)
- (4) H400 + 10% filler (heat treating time: 10 minutes)

[0033] The results are shown in FIGS. 5-8. Even in H400, the high heat resistance is confirmed even in the heating at 87°C, 90°C or 93°C by conducting the heat treatment after the addition of the functional filler. Moreover, since  
10 H400 is high in the crystallinity, the heat resistance equal to that of H440 added with the functional filler is obtained by the heat treatment irrespectively of the addition of the functional filler. Also, the improvement of the isothermal crystallizing speed is confirmed.

[0034] Example 3

15 A material obtained by adding an organic filler to H400 and a material obtained by adding an organic filler to H440 are extruded into pellets by a biaxial extruder, respectively, which are examined by a differential scanning calorimetry (DSC). As a measuring device is used Plyris-DSC7 made by Perkin-Elmer. The measuring temperature is adopted as room temperature  
20 (30°C)→250°C in the system added with the filler and as 30°C→190°C in the system not added with the filler. The temperature rising rate is 10°C/min. Further, the functional filler is used by graft-polymerizing Aerosil silica 300, PEG 600, trimethylol propane or pentaerythritol with 10, 30 or 50 molecules of D-lactic acid, respectively. The results on H400 are shown in Table 1, and the  
25 results on H440 are shown in Table 2.

[0035] Table 1

Material		Amount of D-lactic acid graft- polymerized	Amount of filler compounded	Melting point (°C)		
				Tm1	Tm2	Tm3
Starting material	H400			166.3		
Blend	Aerosil silica 300	30 molecules	5	162.8	168.7	206.3
			10	165.7	199.4	209.6
			20	165.2		209.6
	PEG 600	30 molecules	5	168.2	188	
			10	165.6	193.7	
			20	163.7	196.8	
		50 molecules	10	167.4	204.4	
	trimethylol propane	30 molecules	5	166.4	186.5	
			10	166.6	187.6	
			20	163.7	190.8	
		50 molecules	5	164	167.7	190.6
			10	165	201.8	207.5
			20	166.4	200.4	206.4
	pentaerythritol	10 molecules	5	165.8		
			10	166		
			20	163.9		
		30 molecules	5	163.6	168.2	184.6
			10	164.6	185.7	
			20	164.5	195.8	
		50 molecules	5	169.6	192.2	
			10	167.3	182.3	200.6
			20	165.9	192.3	204.2

[0036] Table 2

Material		Amount of D-lactic acid graft- polymerized	Amount of filler compounded	Melting point (°C)		
				Tm1	Tm2	Tm3
Starting material	H440			147.3		
Blend	Aerosil silica 300	30 molecules	5	147.3	187	203.9
			10	146.5	189.8	203.2
			20	145.8	194.5	202.5
	PEG 600	30 molecules	5	148.3	183.6	
			10	146.1	188.2	195.4
			20	145.9	183.7	193.6
		50 molecules	10	145.8	191.4	
	trimethylol propane	30 molecules	5	149.6	179.7	
			10	162.6	180.4	
			20	143.4	184	
		50 molecules	5	148	184.1	194.3
			10	148.5	168	190.1
			20	146.8	183.4	192.7
	pentaerythritol	10 molecules	5	145.5	189.9	
			10	147.3	162.9	
			20	146.1	160.6	
		30 molecules	5	149.2	172.7	
			10	148.3	174.2	
			20	147.9	179.5	
		50 molecules	5	148.4	168.8	187.3
			10	147	168.8	
			20	155.2	192.8	226.7



[0037] As shown in Table 1, only a melting point of 166.3°C (Tm1) is observed in the single H400 system. On the other hand, one or two melting points (Tm2, Tm3) are further observed in the system containing Aerosil silica 300, PEG 600, trimethylol propane or pentaerythritol graft-polymerized with 30 or 50 molecules of D-lactic acid.

[0038] As shown in Table 2, only a melting point of 147.3°C is observed in the single H440 system. On the other hand, one or two melting points are further observed in the system containing Aerosil silica 300, PEG 600, trimethylol propane or pentaerythritol graft-polymerized with 30 or 50 molecules of D-lactic acid. Even in the system graft-polymerized with 10 molecules of D-lactic acid, one melting point is further observed in addition to the melting point of the single H440 system.

[0039] These results show that L-lactic acid and D-lactic acid in the filler form a stereo-complex. The thus formed stereo-complex affects the crystallinity of the polylactic acid resin and is considered to contribute to the improvement of the heat resistance in the mouth portion of the preform shown in Examples 1 and 2.

#### INDUSTRIAL APPLICABILITY

[0040] In the preform obtained by compounding the resin made from poly-L-lactic acid with a functional filler and subjecting a mouth portion to a heat treatment according to the invention, the crystallinity of the mouth portion is improved and the heat resistance is good. Therefore, the invention can overcome the drawbacks of the conventional bottle made from the polylactic acid resin, and hence the invention technique contributes to practical application of bottles made from polylactic acid as an environment-friendly container.

What is claimed is:

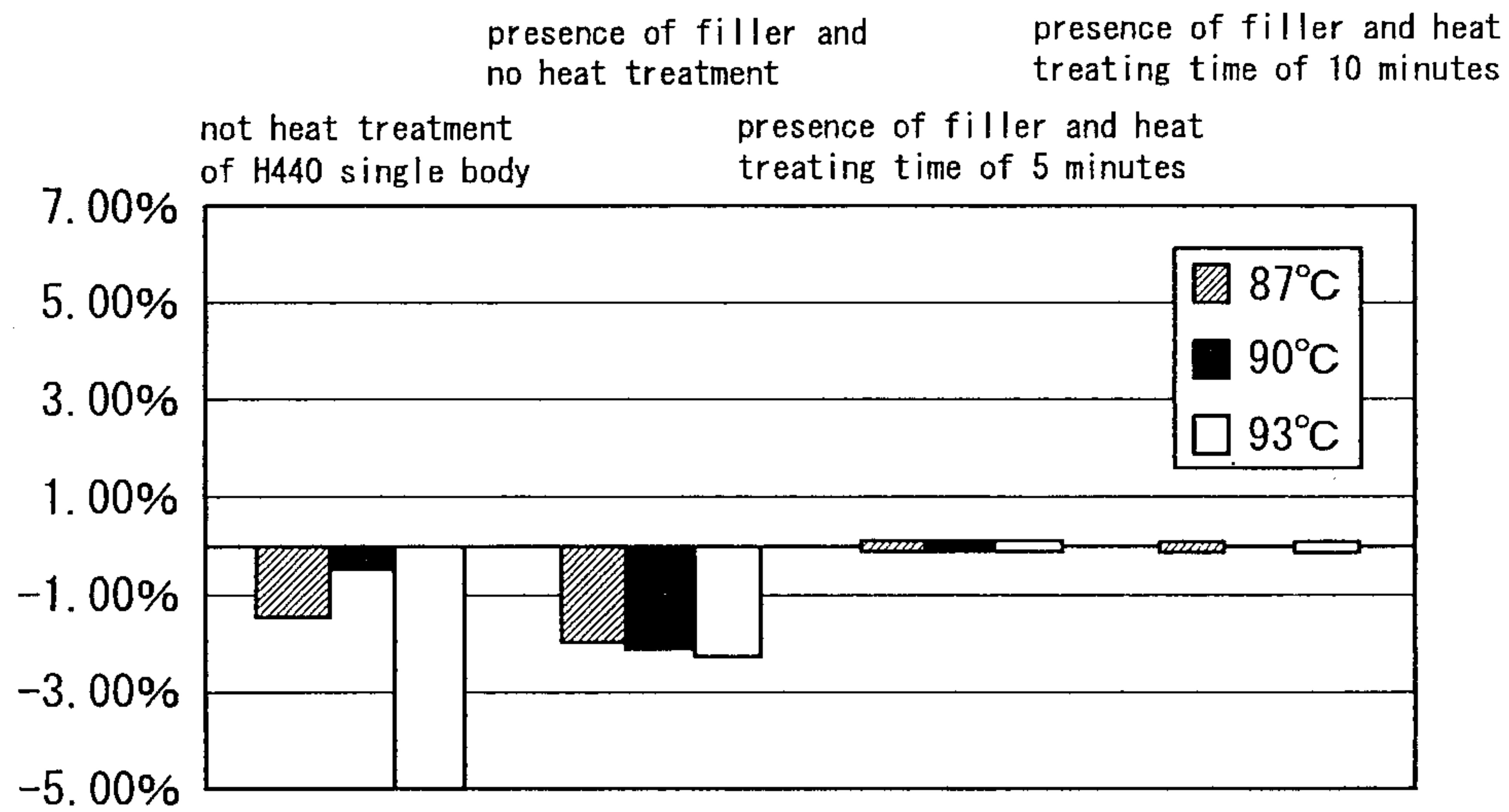
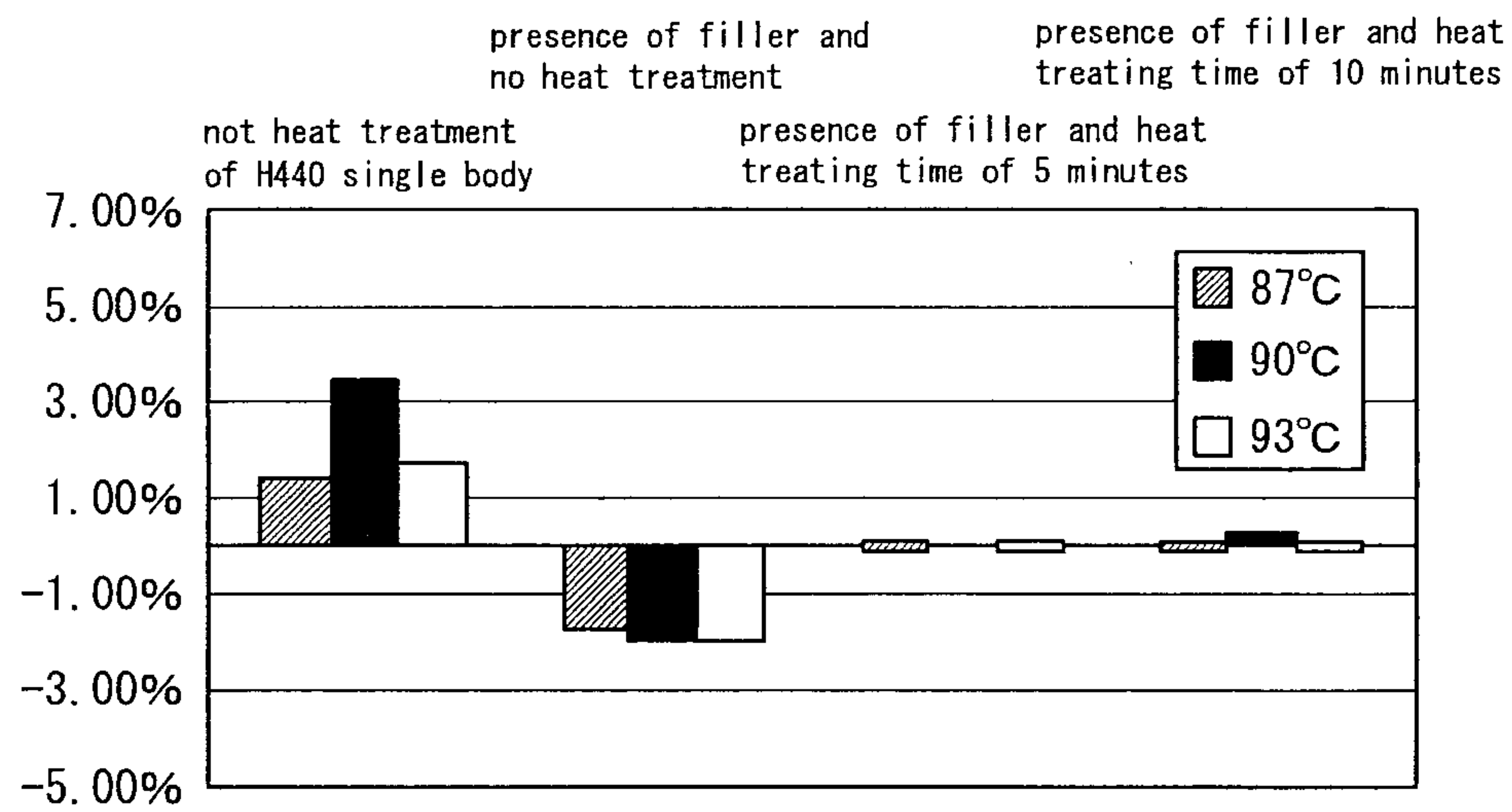
1. A preform characterized by compounding a resin made from poly-L-lactic acid with a functional filler and subjecting a mouth portion to a heat treatment.
- 5           2. A preform according to claim 1, wherein the poly-L-lactic acid has a number average molecular weight of 60,000-80,000.
3. A preform according to claim 1, wherein the functional filler is formed by graft-polymerizing a compound having 2-4 hydroxyl groups with 1-100 molecules of D-lactic acid.
- 10           4. A preform according to claim 3, wherein the compound is sugars selected from polysaccharides and oligosaccharides.
5. A preform according to claim 4, wherein the oligosaccharide is a pentasaccharide.
6. A preform according to claim 3, wherein the compound is an  
15 inorganic compound of silica nanoparticles.
7. A preform according to claim 3, wherein the compound is an organic compound selected from polyethylene glycol, trimethylol propane and pentaerythritol.
8. A preform according to claim 3, wherein the D-lactic acid is  
20 graft-polymerized in an amount of 30-50 molecules.
9. A preform according to claim 3, wherein the functional filler is formed by graft-polymerizing pentaerythritol having four hydroxyl groups with 50 molecules of D-lactic acid.
10. A preform according to claim 1, wherein an amount of the  
25 functional filler compounded is 5-20% by weight based on the poly-L-lactic acid.
11. A preform according to claim 10, wherein the amount of the functional filler compounded is 10% by weight based on the poly-L-lactic acid.
12. A preform according to claim 1, wherein one or more melting points are existent in addition to a melting point of a single body of the resin  
30 made from poly-L-lactic acid.
13. A hollow shaped product characterized by blow-molding a preform as claimed in any one of claims 1 to 12.
14. A method of producing a preform which comprises steps of

- 13 -

compounding a resin made from poly-L-lactic acid with a functional filler, preparing a resin shaped body through an extrusion molding, compression molding or injection molding of the resin compounded with the functional filler and subjecting a mouth portion of the shaped body to a heat treatment.

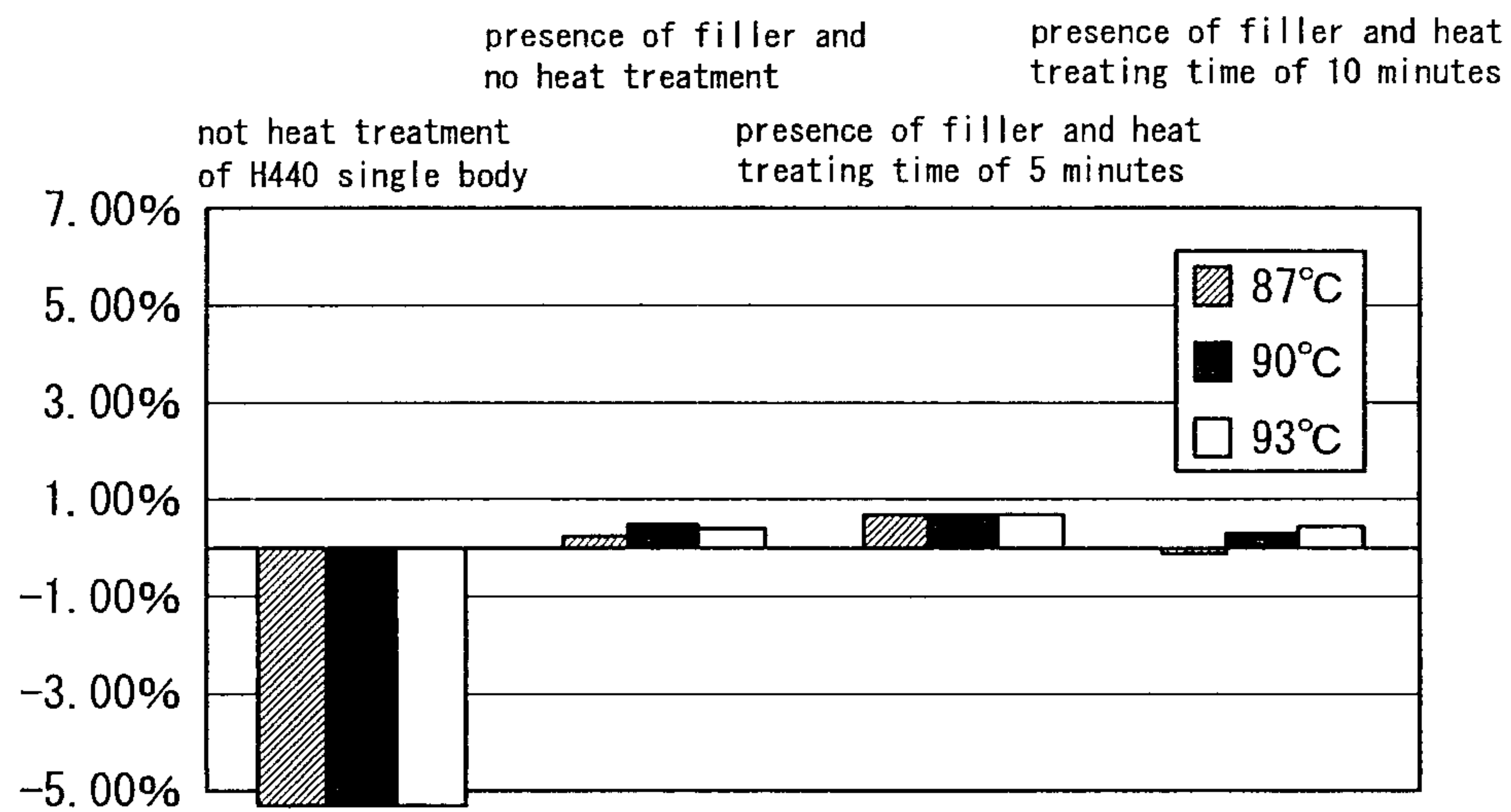
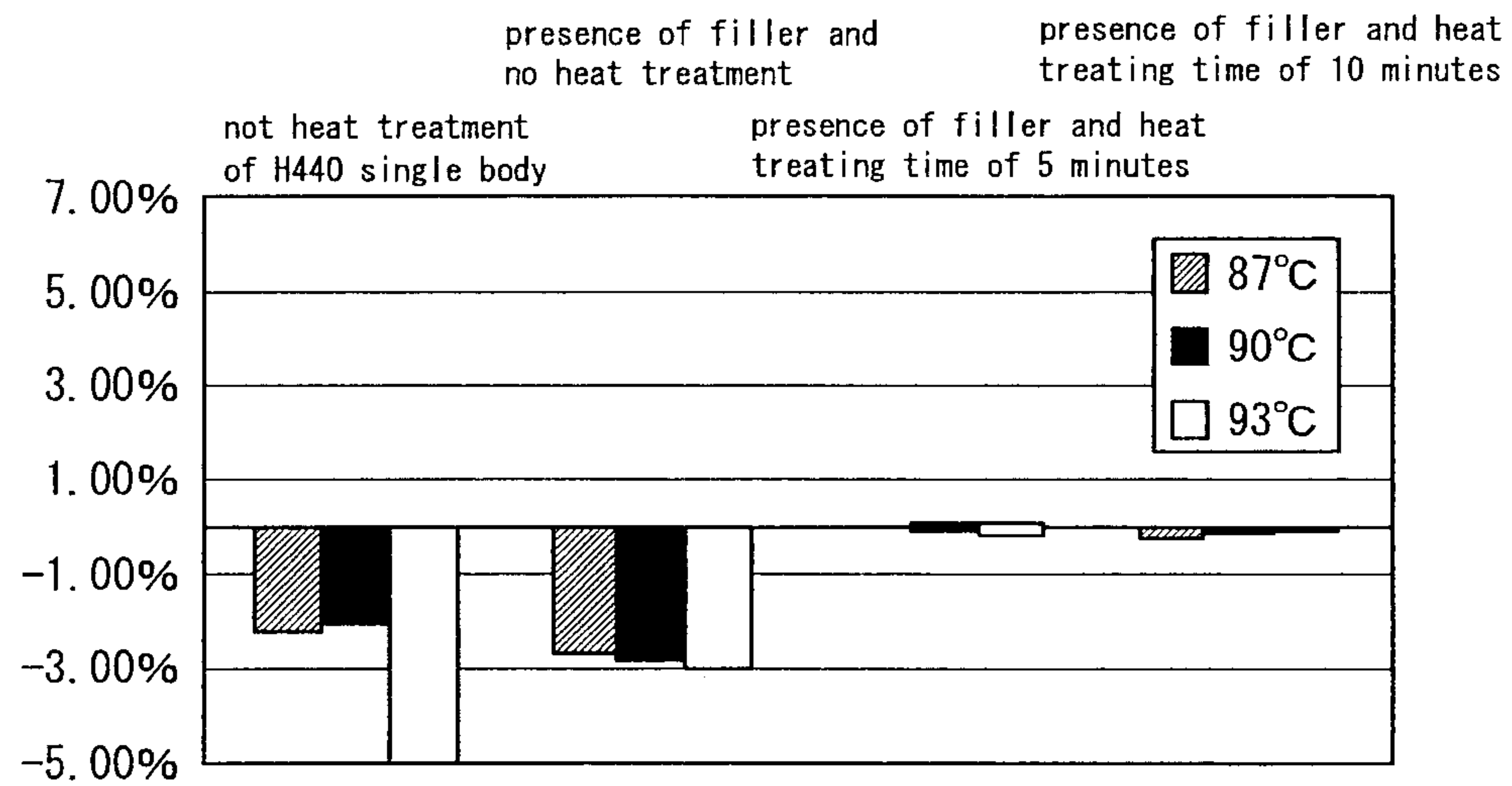
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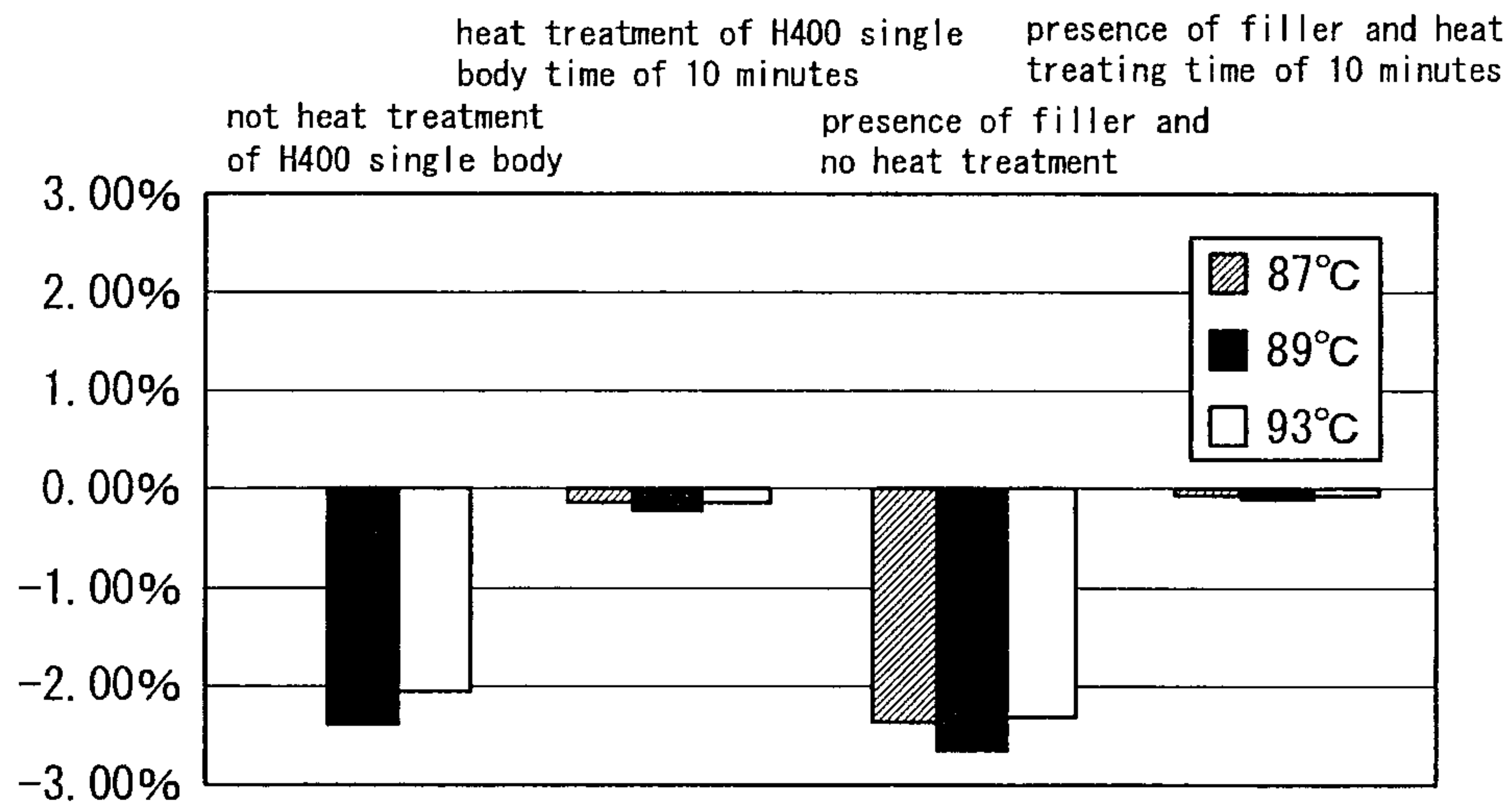
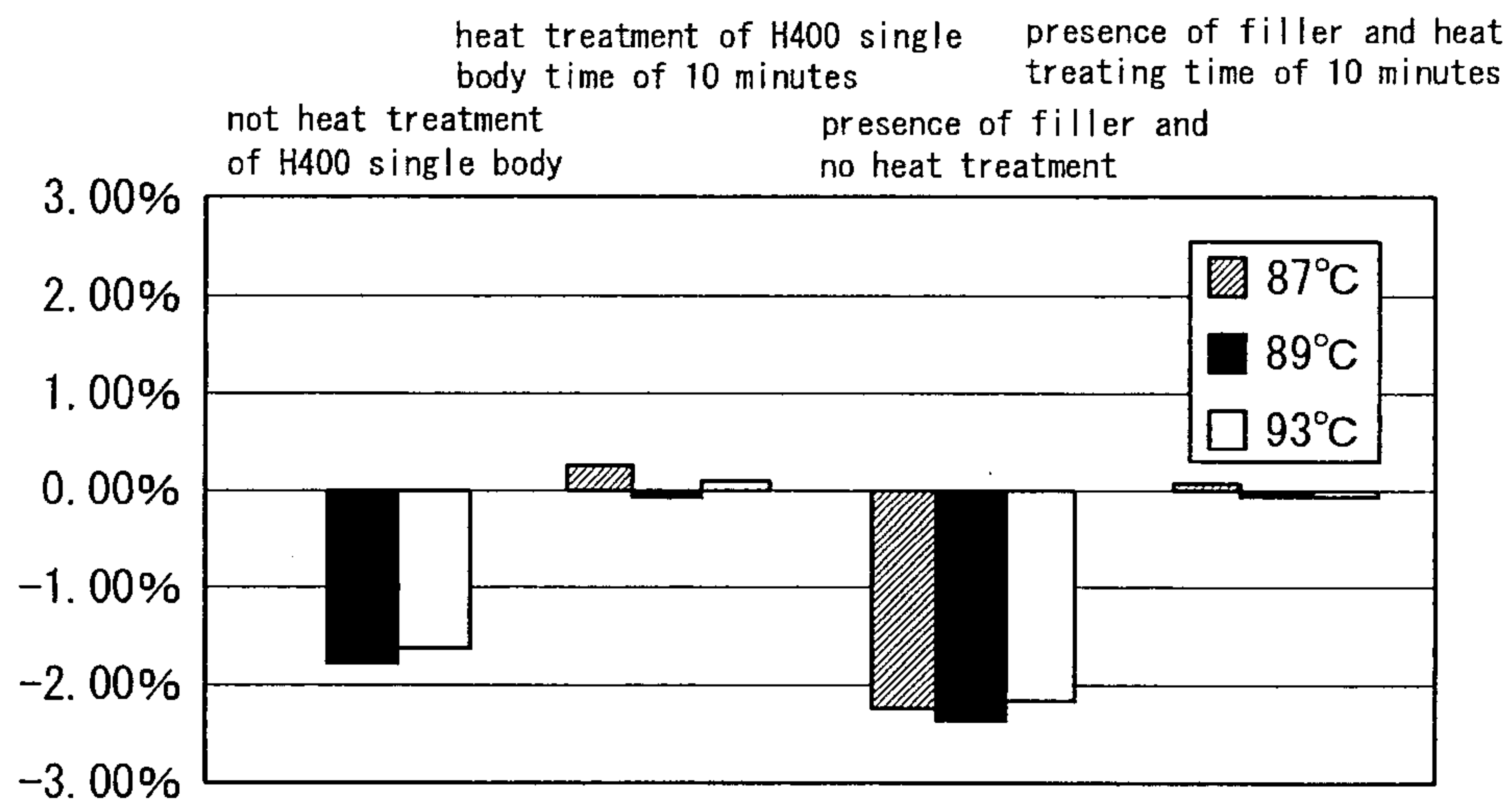
*FIG. 1**FIG. 2*



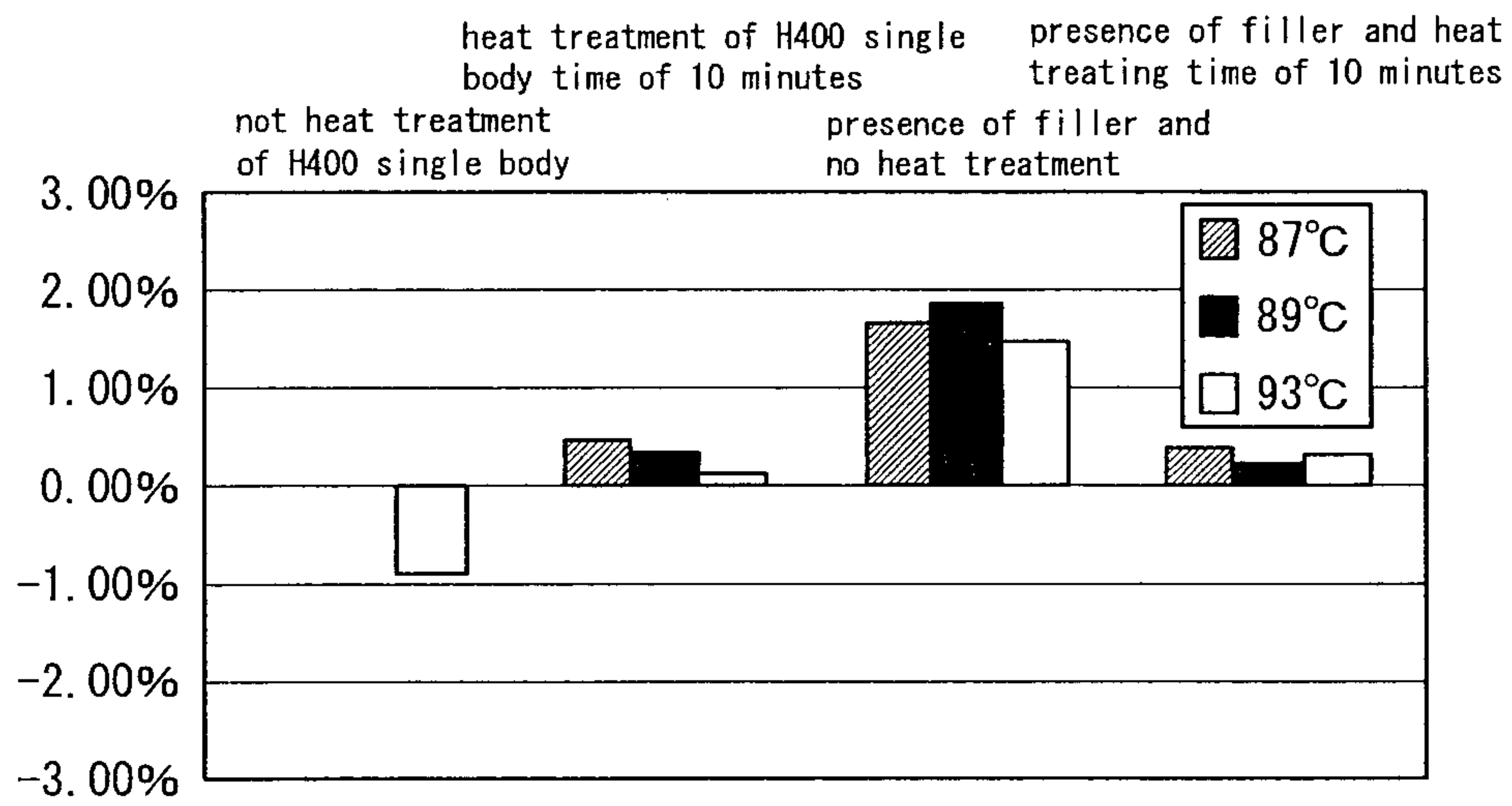
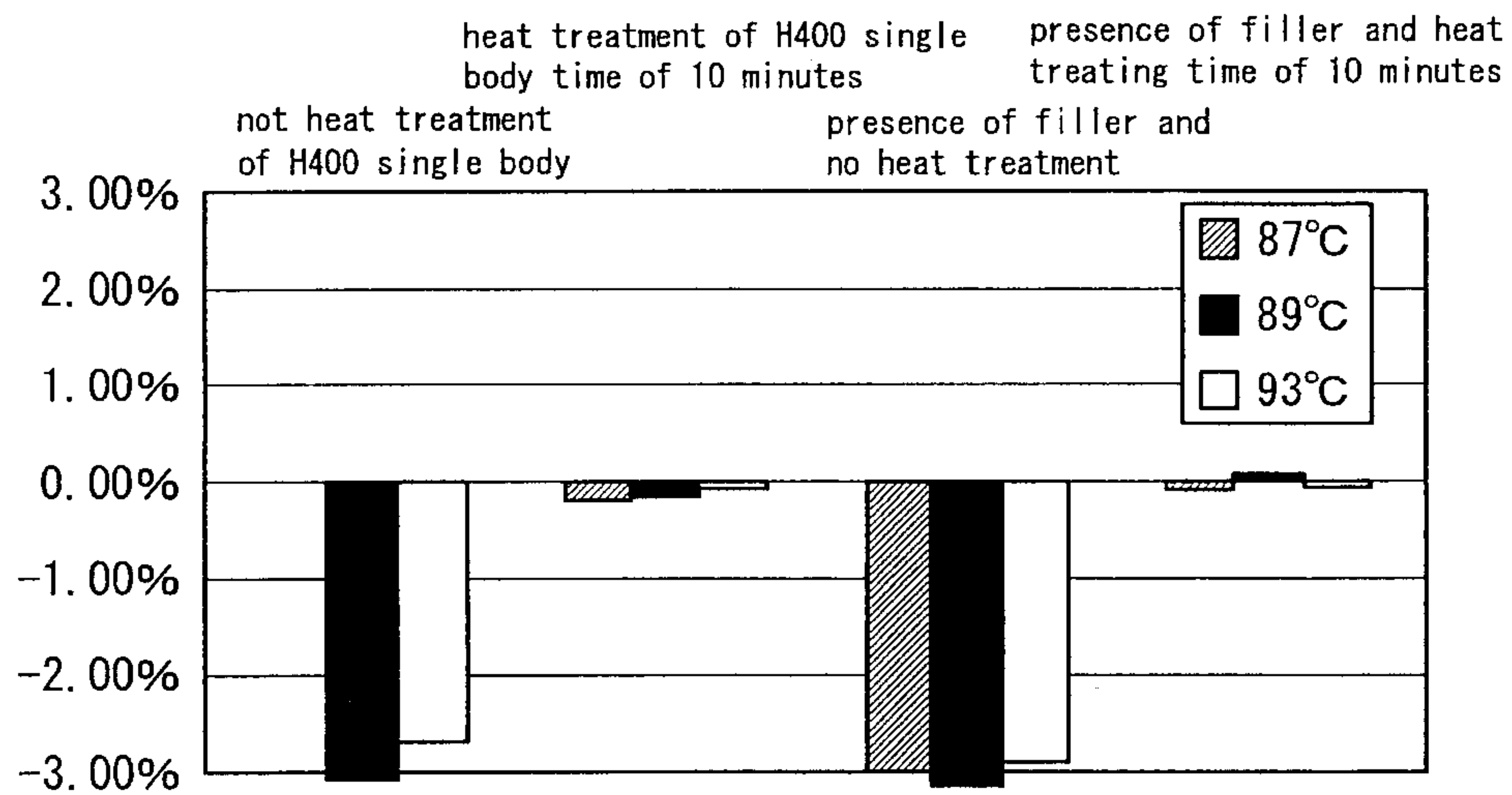
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*FIG. 3**FIG. 4*

3 / 4

*FIG. 5**FIG. 6*

4 / 4

*FIG. 7**FIG. 8*

presence of filler and  
no heat treatment

presence of filler and heat  
treating time of 10 minutes

not heat treatment  
of H440 single body

presence of filler and heat  
treating time of 5 minutes

7.00%

5.00%

3.00%

1.00%

-1.00%

-3.00%

-5.00%

