

POLYBUTENE DERIVATIVE FOR RUBBER COMPOUNDING AND RUBBER
COMPOSITION INCLUDING SAME

CROSS REFERENCE TO RELATED APPLICATION

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The present application claims priority to Korean Patent Application No. 10-2020-0090281, filed July 21, 2020, the entire contents of which is incorporated herein for all purposes by this reference.

10

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a polybutene derivative
15 for rubber compounding and a rubber composition including the same.

2. Description of the Related Art

Polybutene is a polymer having a number average molecular
20 weight (Mn) of about 300 to 10,000 and obtained by polymerizing an olefin component having 4 carbon atoms (C4) obtained in a naphtha-cracking process using a Friedel-Craft-type catalyst.

What remains after extracting 1,3-butadiene from C4 feedstock is called C4 raffinate-1, and includes paraffins such
25 as isobutane, normal butane, etc., and olefins such as 1-

butene, 2-butene, isobutene, etc. Here, the content of isobutene in the C4 raffinate-1 is about 30% to 50% by weight. The C4 raffinate-1 is mainly used for the preparation of polybutene or methyl t-butylether (MTBE) serving as an octane
5 number improver. Since the reactivity of isobutene is the highest among the olefin components of the C4 raffinate-1, the resulting polybutene is mainly composed of isobutene units. Polybutene increases in viscosity with increasing molecular weight thereof and has a viscosity of about 4 to 40,000 cSt
10 (centi-stokes) at 100°C.

Korean Patent Application Publication No. 10-2011-0072253 discloses a method of improving the grip performance of a tire tread using highly reactive polybutene. Korean Patent Application Publication No. 10-2007-0096748 discloses a method
15 of improving wear resistance, fuel efficiency, and braking performance using carboxylated liquid isoprene rubber. As such, efforts are being made to increase fuel efficiency and braking performance of rubber, specifically when applied to tire treads.

20 With regard to improving grip force, Korean Patent Application Publication No. 10-2016-0002044 discloses a composition exhibiting good grip performance and wear resistance under high-speed conditions due to the use of a masterbatch in which pellet-type plant resins such as sesame
25 resin, sunflower resin, coconut resin and the like are added to

styrene butadiene rubber. The grip force is a technique in which the surface of a tire is brought into close contact with the road surface, and it is advantageous for the tire to have superior elasticity to increase the grip force. However, when
5 considering both grip force and rolling resistance, rolling resistance advantageously decreases with a decrease in closeness of contact with the road surface, so there is a tradeoff between the rolling resistance and the grip force of the tire. Specifically, a tire having low rolling resistance
10 is advantageous in terms of fuel efficiency but may have poor contact with a surface road when the road is wet. Accordingly, recent tire development is progressing in a way to control both at the same time, rather than a one-dimensional approach of increasing either the rolling resistance or the grip force.

15 For example, Korean Patent Application Publication No. 10-2015-0024701 and U.S. Patent No. 8,637,606 disclose the use of silica and a modified terpene phenol resin having a high softening point, in which the phenol increases compatibility with synthetic rubber to thus reduce the fluidity of the resin,
20 thereby improving grip performance on wet surfaces without deteriorating rolling resistance. Korean Patent No. 10-1591276 discloses a rubber composition including 20 to 50 parts by weight of epoxidized natural rubber having a glass transition temperature (T_g) of -50°C to -40°C, a Mooney viscosity of 60 to
25 80, and an epoxidation degree of 5% to 50%, thereby improving

the braking power of tires on wet road surfaces, and uniformly improving low rolling resistance or fuel efficiency and durability without deteriorating wear resistance. Despite a variety of such attempts, there is still a need for a technique
5 that can give satisfactory numerical values for both rolling resistance and grip force of tires.

[Citation List]

[Patent Literature]

(Patent Literature 1) Korean Patent Application
10 Publication No. 10-2011-0072253

(Patent Literature 2) Korean Patent Application
Publication No. 10-2007-0096748

(Patent Literature 3) Korean Patent Application
Publication No. 10-2016-0002044

15 (Patent Literature 4) Korean Patent Application
Publication No. 10-2015-0024701

(Patent Literature 5) U.S. Patent No. 8,637,606

(Patent Literature 6) Korean Patent No. 10-1591276

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SUMMARY OF THE INVENTION

An objective of the present invention is to provide a polybutene derivative for rubber compounding, which enables the preparation of a rubber composition capable of exhibiting
25 improved processability, grip performance, and rolling

resistance as well as high dispersibility when mixed with a filler.

The present invention provides a polybutene derivative for rubber compounding, prepared by mixing 30% to 98% by weight of polyisobutylene, 1% to 35% by weight of unsaturated dicarboxylic anhydride, and 1% to 50% by weight of one or two components selected from among alkanolamines, amine-based compounds, and polyhydric alcohols.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the polyisobutylene may have a number average molecular weight of 300 g/mol to 10,000 g/mol.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the polyisobutylene may have a polydispersity of 1 to 6.

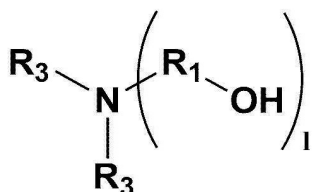
In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the unsaturated dicarboxylic anhydride may be at least one selected from among maleic anhydride, itaconic anhydride, citraconic anhydride, propenyl succinic anhydride, and 2-pentendioic anhydride.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the alkanolamine may include an amino group and a hydroxyl group, the amine compound may include two or more amino groups, and

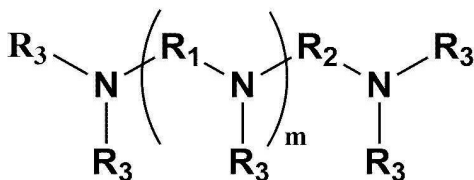
the polyhydric alcohol may include two or more hydroxyl groups.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the alkanolamine may be represented by Chemical Formula 1 below, the amino compound may be represented by Chemical Formula 2 below, and the polyhydric alcohol may be represented by Chemical Formula 3 below.

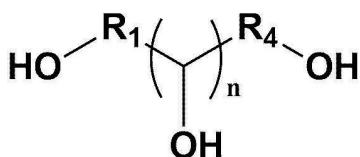
[Formula 1]



10 [Formula 2]



[Formula 3]



In Chemical Formulas 1 to 3, R₁ and R₂ are each independently a C1-C9 alkylene group or a C1-C9 alkyl carbonylene group, R₃ is hydrogen, a C1-C9 alkyl group, or a C1-C9 alkyl carbonyl group, R₄ is a directly bound, a C1-C9 alkylene group, or a C1-C9 alkyl carbonyl group, 1 is a real

number in a range of from 1 to 3, and m and n are each independently a real number in a range of from 0 to 6.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the
5 alkanolamine may be at least one selected from among ethanolamine, diethanolamine, triethanolamine, aminomethanol, normal-propanolamine, isopropanolamine, diisopropanolamine, triisopropanolamine, butanolamine, dibutanolamine, tributanolamine, and 4-amino-1,2,3-butanetriol.

10 The amine-based compound may be at least one selected from among ethylene diamine, diethylenetriamine, triethylenetetraamine, tetraethylenepentaamine, pentaethylenehexaamine, hexaethyleneheptaamine, putrescine, spermidine, N¹-acetylspermidine, N⁸-acetylspermidine, N¹,N¹²-
15 diacetylspermidine, cadaverine, spermine, thermospermine, caldopentamine, caldohexamine, tris(3-aminopropyl)amine, tris(2-aminoethyl)amine, tetrakis(3-aminopropyl)ammonium, cyclen, 1,4,7-triazacyclononane, 1,1,1-tris(aminomethyl)ethane, and subunits of polyethylenimine.

20 The polyhydric alcohol compound may be at least one selected from among ethylenediol, 1,2-propylenediol, glycerol, 1,3-propanediol, 1,2-butanediol, 1,2,3-butanetriol, 1,2,4-butanetriol, 1,2-pentanediol, 1,3,5-pentanetriol, 2,3,4-pentanetriol, 1,2,4-pentanetriol, 1,2,5-pentanetriol, 1,2 -
25 Hexanediol, 1,6-hexanediol, 1,2,6-hexanetriol, 1,2,3-

hexanetriol, 1,2,5-hexanetriol, 1,2,4-hexanetriol, 1,3,6-hexanetriol, 1,2-heptanediol, 1,2,3-heptanetriol, 1,2,7-heptanetriol, 1,4,5-heptanetriol, 1,4,7-heptanetriol, 1,2-octanediol, 1,1,3-octanetriol, 1,3,8-octanetriol, 2,3,7-octanetriol, 1,3,5-octanetriol, 1,2-nonanediol, 1,2-decanediol, 5 sugar alcohol having 4 to 6 carbon atoms, and span.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the polybutene derivative for rubber compounding prepared using the 10 alkanolamine may include at least one selected from among an imide group, an amide group, and an ester group.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the polybutene derivative for rubber compounding prepared using the 15 amine-based compound may include at least one selected from among an imide group and an amide group.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the polybutene derivative for rubber compounding prepared using the 20 polyhydric alcohol may include an ester group.

The polybutene derivative for rubber compounding, according to one embodiment of the present invention, may have a glass transition temperature of -40°C or lower.

The polybutene derivative for rubber compounding, 25 according to one embodiment of the present invention, may have

a Brookfield viscosity of 1 to 10,000 cP at 150°C.

The polybutene derivative for rubber compounding, according to one embodiment of the present invention, may have a number average molecular weight of 500 to 15,000 g/mol and a
5 polydispersity of 1 to 6.

The present invention also provides a rubber composition. The rubber composition according to one embodiment of the present invention includes a polybutene derivative for rubber compounding, a rubber base, and filler.

10 In the rubber composition according to one embodiment of the present invention, the filler may include at least one selected from silica and carbon black.

In the rubber composition according to one embodiment of the present invention, the rubber base may include at least one
15 selected from among butadiene rubber, butyl rubber, emulsion polymerization styrene butadiene rubber (E-SBR), solution polymerization styrene butadiene rubber (S-SBR), epichlorohydrin rubber, nitrile rubber, hydrogenated nitrile rubber, brominated polyisobutylisoprene-co-paramethyl styrene
20 (BIMS) rubber, urethane rubber, fluororubber, silicone rubber, styrene-ethylenebutadiene styrene copolymer rubber, ethylenepropylene rubber, ethylenepropylenediene monomer rubber, hypalon rubber, chloroprene rubber, ethylene vinyl acetate rubber, and acrylic rubber.

25 The rubber composition according to one embodiment of the

present invention may include 50 to 150 parts by weight of silica, 5 to 20 parts by weight of carbon black, 2 to 40 parts by weight of a polybutene derivative for rubber compounding, and 2 to 15 parts by weight of a silane coupling agent, with
5 respect to 100 parts by weight of the rubber base.

The polybutene derivative for rubber compounding, according to the present invention, is prepared by mixing 30% to 98% by weight of polyisobutylene, 1% to 35% by weight of an unsaturated dicarboxylic acid anhydride; and 1% to 50% by
10 weight of one or more components selected from among alkanolamines, amine-based compounds, and polyhydric alcohols. When the polybutene derivative is applied to a rubber composition, the polybutene derivative improves the processability of rubber, remarkably improves the
15 dispersibility of the filler, and enables the rubber composition to exhibit high grip performance and low rolling resistance.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

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The advantages and features of embodiments of the present invention and methods of achieving the same will be clarified with reference to examples described below in detail. However, the present invention is not limited to these embodiments, but
25 may be modified in other forms. These embodiments are provided

to fully convey the spirit of the present invention to those skilled in the art so that the contents introduced herein are thorough and complete, and the present invention is only defined by the scope of the claims. Like numbers refer to like
5 elements throughout the following description herein.

Further, in describing embodiments of the present invention, well-known functions or constructions will not be described in detail since they may unnecessarily obscure the gist of the present invention. The following terms are defined
10 in consideration of the functions in the examples of the present invention and thus may vary depending on the intentions of users, operators, or the like. Therefore, the definition of each term should be interpreted based on the contents throughout this specification.

15 According to the present invention, a polybutene derivative for rubber compounding is prepared by mixing 30% to 98% by weight of polyisobutylene, 1% to 35% by weight of unsaturated dicarboxylic anhydride, and 1% to 50% by weight of at least one selected from among alkanolamines, amine-based
20 compounds, and polyhydric alcohols. When one or more components selected from among alkanolamines, amine-based compounds, and polyvalent alcohols is added and mixed with the rubber base and the filler to meet the range described above, the processability of rubber and the dispersibility of the
25 filler may be improved.

The polybutene derivative according to one embodiment of the embodiment of the present invention may have a glass transition temperature of -40°C or below. Preferably, the polybutene derivative may have a glass transition temperature
5 in a range of -60 to -100°C , and more preferably in a range of -65 to -90°C . In addition, the polybutene derivative may have a viscosity in a range of 1 to 10,000 cP measured by a Brookfield viscometer at 150°C , and preferably in a range of 100 to 5,000 cP. When the glass transition temperature and
10 viscosity of the polybutene derivative fall within the ranges, a storage modulus difference ($\Delta G'$) due to the Payne effect may be as low as 3.0 or less, preferably 2.7 or less, and most preferably 2.3 or less, upon subsequent mixing with the rubber base and the filler, indicating that the filler is uniformly
15 dispersed. Here, $\Delta G'$ means $G'_{20\%} - G'_{0.02\%}$, which is a difference between storage modulus values measured at elongations of 0.02% and 20%, respectively.

In an embodiment of the present invention, the polybutene derivative has a number average molecular weight of 500 to
20 15,000 g/mol and a polydispersity of 1 to 6. When the polydispersity is greater than 6, there is a problem in that the physical properties of rubber compositions containing the polybutene derivative largely vary. On the other hand, when the number average molecular weight is less than 500 g/mol,
25 the production productivity of rubber is lowered because light

polymers are generated in a large amount. Conversely, when the number average molecular weight exceeds 15,000 g/mol, there is a disadvantage that the production of rubber is not easy because a rubber production plant is overloaded due to the increased viscosity. With the polybutene derivative having properties falling within those ranges, rubber having a dynamic loss coefficient of 0.600 or greater at 0°C and a dynamic loss coefficient of 0.1148 or less at 60°C will be produced when being subsequently mixed with the rubber base and the filler.

The dynamic loss coefficient at 0°C is an indicator of the grip performance (wet grip). The higher the dynamic loss coefficient at 0°C, the better the grip performance. On the other hand, the dynamic loss coefficient at 60°C is an indicator of the rolling resistance. the lower the dynamic loss coefficient at 60°C, the better the rolling resistance. That is, when the polybutene derivative according to one embodiment of the present invention is used to prepare rubber, there is an advantage in that the prepared rubber exhibits both the improved grip performance and the improved rolling resistance which were difficult to achieve in the related art.

More preferably, as will be described later, the appropriate number average molecular weight range, polydispersity range, viscosity range, glass transition temperature range, etc. of the polybutene derivative may vary depending on the type of the active hydrogen group-containing

compound used in the reaction.

As a specific example, when the active hydrogen group-containing compound is alkanolamine, the polybutene derivative may have a number average molecular weight of 500 to 10,000 g/mol and a polydispersity of 1 to 6, and most preferably, a number average molecular weight of 1,000 to 5,000 g/mol and a polydispersity of 1 to 3. In addition, the polybutene derivative may have a glass transition temperature of -50°C to -100°C and preferably -60°C to -90°C, and a viscosity of 50 to 10,000 cP measured by a Brookfield viscometer at 150°C and preferably 100 to 5,000 cP. When all of the physical properties are satisfied, the storage modulus difference $\Delta G'$ ($= G'_{20\%} - G'_{0.02\%}$) value of the rubber prepared by mixing the polybutene derivative with the rubber base and filler may be lowered to 2.2 or less, and the standard in which the dynamic loss coefficient at 0°C must be 0.6010 or greater and the dynamic loss coefficient at 60°C must be 0.1120 or less can be satisfied.

As a specific example, when the active hydrogen group-containing compound is an amine-based compound, the polybutene derivative may have a number average molecular weight of 500 to 10,000 g/mol and a polydispersity of 1 to 5, and most preferably, a number average molecular weight of 1,000 to 5,000 g/mol and a polydispersity of 1 to 3. In addition, the polybutene derivative may have a glass transition temperature

of -50°C to -100°C and preferably -60°C to -90°C , and a viscosity of 50 to 10,000 cP measured by a Brookfield viscometer at 150°C and preferably 150 to 5,000 cP. When all of the physical properties are satisfied, the storage modulus difference $\Delta G'$ ($= G'_{20\%} - G'_{0.02\%}$) value of the rubber prepared by
5 mixing the polybutene derivative with the rubber base and filler may be lowered to 2.4 or less, and the standard in which the dynamic loss coefficient at 0°C must be 0.6500 or greater and the dynamic loss coefficient at 60°C must be 0.1130 or less
10 can be satisfied.

As a specific example, when the active hydrogen group-containing compound is a polyhydric alcohol, the polybutene derivative may have a number average molecular weight of 1,000 to 15,000 g/mol and a polydispersity of 1 to 5, and most
15 preferably, a number average molecular weight of 10,000 to 15,000 g/mol and a polydispersity of 1 to 3. In addition, the polybutene derivative may have a glass transition temperature of -40°C to -100°C and preferably -50°C to -90°C , and a viscosity of 100 to 10,000 cP measured by a Brookfield
20 viscometer at 150°C and preferably 3,000 to 5,000 cP. When all of the physical properties are satisfied, the storage modulus difference $\Delta G'$ ($= G'_{20\%} - G'_{0.02\%}$) value of the rubber prepared by mixing the polybutene derivative with the rubber base and filler may be lowered to 2.7 or less, and the standard in which

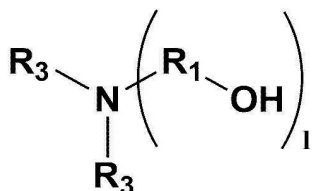
the dynamic loss coefficient at 0°C must be 0.6020 or greater and the dynamic loss coefficient at 60°C must be 0.1120 or less can be satisfied.

In the polybutene derivative according to one embodiment
5 of the present invention, the polyisobutylene may have a number average molecular weight of 300 to 10,000 g/mol, preferably 400 to 6,000 g/mol, and most preferably 500 to 3,000 g/mol, and a polydispersity of 1 to 6, preferably 1 to 4, more preferably 1 to 3, and most preferably 1 to 2. In addition, the viscosity
10 of the polyisobutylene measured by a Brookfield viscometer at 150°C may be in a range of 1 to 10,000 cP, preferably in a range of 50 to 5,000 cP, and most preferably in a range of 100 to 1,000 cP. In addition, the polyisobutylene may have a terminal vinylidene (α -vinylidene) content of 80 mol% or more,
15 and preferably 85 mol% or more, based on ^{13}C -NMR. Here, the upper limit of the α -vinylidene content is not particularly limited, but may be, for example, 100 mol% or less, and particularly 95 mol% or less. Increasing the vinylidene content of the polyisobutylene is advantageous in that the
20 reaction conversion rate and the active ingredient content in reactants increase. In addition, when the number average molecular weight of the polyisobutylene is less than 300 g/mol, a large amount of light polymer with low molecular weights may be generated in the polybutene derivative prepared. On the
25 other hand, when the number average molecular weight of the

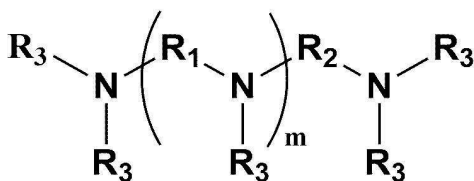
polyisobutylene is more than 10,000 g/mol, there is a problem in that the viscosity of the produced polybutene derivative is overly high. When the polydispersity falls within a range of 1 to 6, it is possible to prepare a polybutene derivative having
 5 a uniform molecular weight, thereby reducing variations in physical properties of the prepared polybutene derivative.

In the polybutene derivative for rubber compounding, according to one embodiment of the present invention, the alkanolamine may be a compound represented by Chemical Formula
 10 1 below, the amine-based compound may be a compound represented by Chemical Formula 2 below, and the polyhydric alcohol may be a compound represented by Chemical Formula 3 below.

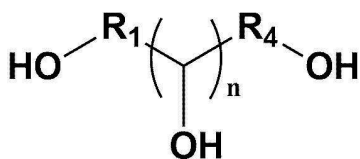
[Formula 1]



15 [Formula 2]



[Formula 3]



In Chemical Formulas 1 to 3, R_1 and R_2 are each independently a C1-C9 alkylene group or a C1-C9 alkyl carbonylene group, R_3 is hydrogen, a C1-C9 alkyl group, or a C1-C9 alkyl carbonyl group, R_4 is a directly bound, C1-C9 alkylene group or a C1-C9 alkyl carbonyl group, l is a real number in a range of from 1 to 3, and m and n are each independently a real number in a range of from 0 to 6.

More preferably, R_1 and R_2 are each independently a C1-C5 alkylene, R_3 is hydrogen, a C1-C5 alkyl group, or a C1-C5 alkyl carbonyl group, R_4 is a directly bound, C1-C5 alkylene group or a C1-C5 alkyl carbonyl group, l is a real number in a range of from 1 to 3, and m and n are each independently a real number in a range of from 0 to 4.

In Formula 3, a case where n is 0 means that R_1 and R_4 are directly bound.

When the polybutene derivative is prepared by selecting an amino alkylamine, an amine-based compound, and a polyhydric alcohol that satisfy the above-mentioned ranges, there is an advantage in that the dispersibility of the filler is further improved.

Specifically, the alkanolamine compound may be at least one selected from among ethanolamine, diethanolamine, triethanolamine, aminomethanol, normal-propanolamine, isopropanolamine, diisopropanolamine, triisopropanolamine, butanolamine, dibutanolamine, tributanolamine, and 4-amino-

1,2,3-butanetriol.

The amine-based compound may be at least one selected from among ethylene diamine, diethylenetriamine, triethylenetetraamine, tetraethylenepentaamine, 5 pentaethylenehexaamine, hexaethyleneheptaamine, putrescine, spermidine, N¹-acetylspermidine, N⁸-acetylspermidine, N¹,N¹²-diacetylspermidine, cadaverine, spermine, thermospermine, caldopentamine, caldohexamine, tris(3-aminopropyl)amine, tris(2-aminoethyl)amine, tetrakis(3-aminopropyl)ammonium, 10 cyclen, 1,4,7-triazacyclononane, 1,1,1-tris(aminomethyl)ethane, and subunits of polyethylenimine.

The polyhydric alcohol compound may be at least one selected from among ethylenediol, 1,2-propylenediol, glycerol, 1,3-propanediol, 1,2-butanediol, 1,2,3-butanetriol, 1,2,4- 15 butanetriol, 1,2-pentanediol, 1,3,5-pentanetriol, 2,3,4-pentanetriol, 1,2,4-pentanetriol, 1,2,5-pentanetriol, 1,2-Hexanediol, 1,6-hexanediol, 1,2,6-hexanetriol, 1,2,3-hexanetriol, 1,2,5-hexanetriol, 1,2,4-hexanetriol, 1,3,6-hexanetriol, 1,2-heptanediol, 1,2,3-heptanetriol, 1,2,7- 20 heptanetriol, 1,4,5-heptanetriol, 1,4,7-heptanetriol, 1,2-octanediol, 1,1,3-octanetriol, 1,3,8-octanetriol, 2,3,7-octanetriol, 1,3,5-octanetriol, 1,2-nonanediol, 1,2-decanediol, sugar alcohol having 4 to 6 carbon atoms, and span.

In the polybutene derivative according to one embodiment 25 of the present invention, the unsaturated dicarboxylic

anhydride may be at least one selected from among maleic anhydride, itaconic anhydride, citraconic anhydride, propenyl succinic anhydride, and 2-pentendioic anhydride.

Furthermore, the polybutene derivative prepared by
5 selecting one or more components selected from among polyisobutylene, unsaturated dicarboxylic acid anhydride and alkanolamine, amine-based compound, and polyhydric alcohol may contain nitrogen and/or oxygen, and preferably may contain a nitrogen atom and an oxygen atom that are joined through
10 covalent bonding. In addition, the polybutene derivative may include an amide group, an imide group, or an ester group. Specifically, the polybutene derivative for rubber compounding, which is prepared using the alkanolamine, may include at least one selected from among an amide group, an imide group, and an
15 ester group. The polybutene derivative for rubber compounding, prepared using an amine-based compound, may include one or more functional groups selected from among an amide group and an imide group. The polybutene derivative for rubber compounding, prepared using a polyhydric alcohol may include an ester group.

20 The present invention also provides a rubber composition.

The rubber composition according to one embodiment of the present invention includes the polybutene derivative for rubber compounding, according to one embodiment of the present invention, a rubber base, and a filler.

25 As described above, the rubber composition according to

one embodiment of the present invention has the advantage of exhibiting improved processability due to the presence of the polybutene derivative, and the advantage of exhibiting both good grip performance and rolling resistance because the filler
5 is uniformly dispersed.

In the rubber composition according to one embodiment of the present invention, the rubber base may include at least one selected from among butadiene rubber, butyl rubber, emulsion polymerization styrene butadiene rubber (E-SBR), solution
10 polymerization styrene butadiene rubber (S-SBR), epichlorohydrin rubber, nitrile rubber, hydrogenated nitrile rubber, brominated polyisobutylisoprene-co-paramethyl styrene (BIMS) rubber, urethane rubber, fluororubber, silicone rubber, styrene-ethylenebutadiene styrene copolymer rubber,
15 ethylenepropylene rubber, ethylenepropylenediene monomer rubber, hypalon rubber, chloroprene rubber, ethylene vinyl acetate rubber, and acrylic rubber. More preferably, the rubber base may include at least one selected from among butadiene rubber, styrene butadiene rubber (S-SBR), and butyl
20 rubber.

More preferably, the rubber base may include styrene butadiene rubber, in which the styrene butadiene rubber has a styrene content of 9% to 19% and a vinyl group content of 10% to 54% in butadiene. Alternatively, the styrene butadiene
25 rubber has a styrene content of 20% to 28% and a vinyl group

content of 40% to 72% in butadiene. Further alternatively, the styrene butadiene rubber has a styrene content of 30% to 42% and a vinyl group content of 20% to 70% in butadiene.

In the rubber composition according to one embodiment of the present invention, the filler may be used without limitation, so long as it is a filler typically used in a rubber composition, preferably a rubber composition for tire treads, and the present invention is not limited thereto. As a specific and non-limiting example, the filler may include at least one selected from among silica and carbon black.

Here, the silica may be used without limitation, so long as it is silica particles used in rubber, preferably rubber for tire treads. Specifically, the silica may have a specific surface area (CTAB) of 80 to 300 m²/g, preferably 110 to 220 m²/g, more preferably 150 to 180 m²/g, and most preferably 165 m²/g. When the specific surface area thereof is less than the above lower limit, reinforcing properties may decrease and thus the strength thereof may be lowered. On the other hand, when the specific surface area thereof exceeds the above upper limit, the viscosity may increase upon rubber compounding, and dispersion may also be impeded.

The carbon black also may be used without limitation, so long as it is carbon black typically used in rubber for tire treads, and carbon black having a grade of 500 to 600 is preferably used. Specific and non-limiting examples thereof

may include commercially available carbon black such as N110, N121, N134, N220, N231, N234, N242, N293, N299, S315, N326, N330, N332, N339, N343, N347, N351, N358, N375, N539, N550, N582, N630, N642, N650, N660, N683, N754, N762, N765, N774,
5 N787, N907, N908, N990, N991, etc., but the present invention is not limited thereto.

Moreover, the rubber composition according to one embodiment of the present invention may further include a silane-coupling agent. Here, examples of the silane-coupling
10 agent may include commercially available products such as Si-69 and the like and known materials such as bis-(3-triethoxysilylpropyl)tetrasulfane (TESPT), bis-(3-ethoxysilylpropyl)disulfane (ESPD), N-[2-(vinylbenzylamino)-3-aminopropyltrimethoxysilane] and the like, but the present
15 invention is not limited thereto.

The rubber composition according to one embodiment of the present invention may include, with respect to 100 parts by weight of the rubber base, 50 to 150 parts by weight of silica, 5 to 20 parts by weight of carbon black, 2 to 40 parts by
20 weight of the polybutene derivative, and 2 to 15 parts by weight of the silane-coupling agent. Preferably, the rubber composition may include, with respect to 100 parts by weight of the rubber base, 60 to 120 parts by weight of silica, 7 to 15 parts by weight of carbon black, 5 to 15 parts by weight of the
25 polybutene derivative, and 3 to 10 parts by weight of the

silane-coupling agent.

The rubber composition according to one embodiment of the present invention may further include an additive typically used in rubber compositions. As a specific and non-limiting
5 example, the rubber composition may further include additional additives such as an antioxidant, an activator, a vulcanizing agent, a vulcanization accelerator, etc., and the amount of each of the added additives may vary depending on the type of additive and the use of rubber being manufactured. As a
10 specific and non-limiting example, with respect to 100 parts by weight of the rubber base, 0.5 to 5 parts by weight of each additive may be added, but the present invention is not limited thereto.

As a specific and non-limiting example, the vulcanizing
15 agent that is used may be sulfur, morpholine disulfide, etc., and the vulcanization accelerator may include at least one selected from among sulfenamide-based, thiazole-based, thiuram-based, thiourea-based, guanidine-based, dithiocarbamic-acid-based, aldehyde-amine-based, aldehyde-ammonia-based,
20 imidazoline-based, and xanthate-based vulcanization accelerators.

Specifically, the sulfenamide-based vulcanization accelerator may include at least one sulfenamide-based compound selected from among CBS (N-cyclohexyl-2-
25 benzothiazylsulfenamide), TBBS (N-tert-butyl-2-

benzothiazylsulfenamide), N,N-dicyclohexyl-2-benzothiazylsulfenamide, N-oxydiethylene-2-benzothiazylsulfenamide and N,N-diisopropyl-2-benzothiazylsulfenamide, the thiazole-based vulcanization accelerator may include at least one thiazole-based compound selected from among MBT (2-mercaptobenzothiazole), MBTS (dibenzothiazyl disulfide), 2-mercaptobenzothiazole sodium salt, zinc salt, copper salt, cyclohexylamine salt, 2-(2,4-dinitrophenyl)mercaptobenzothiazole and 2-(2,6-diethyl-4-morpholinio)benzothiazole, the thiuram-based vulcanization accelerator may include at least one thiuram-based compound selected from among TMTD (tetramethylthiuram disulfide), tetraethylthiuram disulfide, tetramethylthiuram monosulfide, dipentamethylenethiuram disulfide, dipentamethylenethiuram monosulfide, dipentamethylenethiuram tetrasulfide, dipentamethylenethiuram hexasulfide, tetrabutylthiuram disulfide and pentamethylenethiuram tetrasulfide, the thiourea-based vulcanization accelerator may include at least one thiourea-based compound selected from among thiocarbamide, diethylthiourea, dibutylthiourea, trimethylthiourea and di(ortho-tolyl)thiourea, and the guanidine-based vulcanization accelerator may include at least one guanidine-based compound selected from among diphenylguanidine, di(ortho-tolyl)guanidine, triphenylguanidine, ortho-tolyl biguanide and diphenylguanidine phthalate, but the present invention is not

limited thereto.

In addition, the present invention pertains to a tire tread including the rubber composition according to one embodiment of the present invention. The tire tread according to the present invention has superior grip performance and rolling resistance, as described above, and thus has an advantage of exhibiting excellent fuel efficiency compared to other tire treads under the same conditions. Specifically, the tire tread may be a tire tread used for a passenger car, an SUV, a bus, a truck, or an electric vehicle, but the present invention is not limited thereto.

A better understanding of the present invention will be given through the following examples and comparative examples. The following examples are merely set forth to illustrate the present invention and are not to be construed as limiting the scope of the present invention.

[Synthesis Example 1-1]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-1)>

Polyisobutylene (product name: DAELIM HRPB1000, Mn: 992 g/mol, PD=1.4, α -vinylidene: 88.3 mol% based on ^{13}C -NMR, viscosity: 193 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (49 g, 0.2 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen

bubbling was performed for 2 hours. Thus, 431 g of polyisobutylene succinic anhydride [PIBSA-1] was obtained. The conversion rate thereof was determined to be 78.4% through column chromatography.

5 <Preparation of Polybutene Derivative>

The PIBSA-1 thus prepared (200 g, 0.18 mol) and glycerol (16.7 g, 0.18 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 650 g of a polybutene
10 derivative (yield: 96.9% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 475 cP at 150°C, a number average molecular weight of 2,939 g/mol (PD=3.4), and a glass transition temperature (T_g) of -67°C.

15 **[Synthesis Example 1-2]**

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-2)>

Polyisobutylene (M_n: 300 g/mol, PD=1.2, α-vinylidene: 81.6 mol% based on ¹³C-NMR, viscosity: 6 cSt at 40°C, 500 g, 1.67
20 mol) and maleic anhydride (172 g, 1.75 mol) were placed in a 1 L autoclave and allowed to react at 200°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 550 g of polyisobutylene succinic anhydride (PIBSA-2) was obtained. The
25 conversion rate thereof was determined to be 79.1% through

column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-2 thus prepared (200 g, 0.49 mol) and glycerol (47 g, 0.51 mol) were added to 200 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 220 g of a polybutene derivative (yield: 95.5% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 44 cP at 150°C, a number average molecular weight of 1,127 g/mol (PD = 2.8), and a glass transition temperature of -70°C.

[Synthesis Example 1-3]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-3)>

15 Polyisobutylene (Mn: 5,199 g/mol, PD = 1.8, α -vinylidene: 87 mol% based on ^{13}C -NMR, viscosity: 11,322 cSt at 100°C, 500 g, 0.1 mol) and maleic anhydride (10.0 g, 0.1 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 20 410 g of polyisobutylene succinic anhydride (PIBSA-3) was obtained. The conversion rate thereof was determined to be 70.4% through column chromatography.

<Preparation of Polybutene Derivative>

25 The PIBSA-3 thus prepared (200 g, 0.04 mol) and glycerol

(3.7 g, 0.04 mol) were added to 500 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 195 g of a polybutene derivative (yield: 94.3% by weight) was obtained.

5 The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 4,891 cP at 150°C, a number average molecular weight of 11,500 g/mol (PD=4.5), and a glass transition temperature of -54°C.

[Synthesis Example 1-4]

10 Polyisobutylene (Mn: 997 g/mol, PD=1.4, α -vinylidene: 68.3 mol% based on ¹³C-NMR, viscosity: 197 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (52 g, 0.5 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride,
15 nitrogen bubbling was performed for 2 hours. Thus, 420 g of polyisobutylene succinic anhydride (PIBSA-4) was obtained. The conversion rate thereof was determined to be 73.4% through column chromatography.

<Preparation of Polybutene Derivative>

20 The PIBSA-4 thus prepared (200 g, 0.20 mol) and glycerol (18.4 g, 0.20 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 200.0 g of a polybutene derivative (yield: 83.3% by weight) was obtained.

25 The polybutene derivative thus obtained was determined to

have a Brookfield viscosity of 430 cP at 150°C, a number average molecular weight of 2,423 g/mol (PD = 3.3), and a glass transition temperature (T_g) of -68°C.

[Synthesis Example 2-1]

5 <Preparation of Polyisobutylene Succinic Anhydride (PIBSA-1)>

Polyisobutylene (product name: DAELIM HRPB1000, M_n: 992 g/mol, PD = 1.4, α-vinylidene: 88.3 mol% based on ¹³C-NMR, viscosity: 193 cSt at 100°C, 500 g, 0.5 mol) and maleic
10 anhydride (49 g, 0.2 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 431 g of polyisobutylene succinic anhydride (PIBSA-1) was obtained. The
15 conversion rate thereof was determined to be 78.4% through column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-1 thus prepared (200 g, 0.18 mol) and diethanolamine (19.1 g, 0.18 mol) were added to 400 mL of
20 xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 212.0 g of a polybutene derivative (yield: 96.7% by weight) was obtained.

The polybutene derivative thus obtained was determined to
25 have a Brookfield viscosity of 1,165 cP at 150°C, a number

average molecular weight of 2,885 g/mol (PD = 4.7), and a glass transition temperature of -69°C.

[Synthesis Example 2-2]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-
5 2)>

Polyisobutylene (Mn: 300 g/mol, PD=1.2, α -vinylidene: 81.6 mol% based on ^{13}C -NMR, viscosity: 6 cSt at 40°C, 500 g, 1.67 mol) and maleic anhydride (172 g, 1.75 mol) were placed in a 1 L autoclave and allowed to react at 200°C for 12 hours using a
10 mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 550 g of polyisobutylene succinic anhydride (PIBSA-2) was obtained. The conversion rate thereof was determined to be 79.1% through column chromatography.

15 <Preparation of Polybutene Derivative>

The PIBSA-2 thus prepared (200 g, 0.49 mol) and diethanolamine (52.5 g, 0.51 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 225 g of
20 a polybutene derivative (yield: 95.1% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 132 cP at 150°C, a number average molecular weight of 1,185 g/mol (PD = 3.0), and a glass transition temperature of -70°C.

25 **[Synthesis Example 2-3]**

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-3)>

Polyisobutylene (Mn: 5,199 g/mol, PD = 1.8, α -vinylidene: 87 mol% based on ^{13}C -NMR, viscosity: 11,322 cSt at 100°C, 500 g, 0.1 mol) and maleic anhydride (10.0 g, 0.1 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 410 g of polyisobutylene succinic anhydride (PIBSA-3) was obtained. The conversion rate thereof was determined to be 70.4% through column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-3 thus prepared (200 g, 0.04 mol) and diethanolamine (4.1 g, 0.04 mol) were added to 500 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 187 g of a polybutene derivative (yield: 90.2% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 5,675 cP at 150°C, a number average molecular weight of 12,700 g/mol (PD = 5.1), and a glass transition temperature of -52°C.

[Synthesis Example 2-4]

Polyisobutylene (Mn: 997 g/mol, PD=1.4, α -vinylidene: 68.3 mol% based on ^{13}C -NMR, viscosity: 197 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (52 g, 0.5 mol) were placed in a 1 L

autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 420 g of polyisobutylene succinic anhydride (PIBSA-4) was obtained. The
5 conversion rate thereof was determined to be 73.4% through column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-4 thus prepared (200 g, 0.20 mol) and diethanolamine (22.0 g, 0.21 mol) were added to 400 mL of
10 xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 200.0 g of a polybutene derivative (yield: 83.3% by weight) was obtained

The polybutene derivative thus obtained was determined to
15 have a Brookfield viscosity of 1,050 cP at 150°C, a number average molecular weight of 2,650 g/mol (PD = 4.6), and a glass transition temperature of -70°C.

[Synthesis Example 3-1]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-
20 1)>

Polyisobutylene (product name: DAELIM HRPB1000, Mn: 992 g/mol, PD = 1.4, α -vinylidene: 88.3 mol% based on ^{13}C -NMR, viscosity: 193 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (49 g, 0.2 mol) were placed in a 1 L autoclave and
25 allowed to react at 230°C for 12 hours using a mechanical

stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 431 g of polyisobutylene succinic anhydride (PIBSA-1) was obtained. The conversion rate thereof was determined to be 78.4% through
5 column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-1 thus prepared (200 g, 0.18 mol) and triethylenetetramine (26.6 g, 0.18 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4
10 hours using a Dean-Stark apparatus. Unreacted compounds were removed, after which 216.6 g of a polybutene derivative (yield: 97.0% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 200 cP at 150°C, a number
15 average molecular weight of 1,002 g/mol (PD = 1.9), and a glass transition temperature (T_g) of -70°C.

[Synthesis Example 3-2]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-2)>

20 Polyisobutylene (M_n: 300 g/mol, PD=1.2, α-vinylidene: 81.6 mol% based on ¹³C-NMR, viscosity: 6 cSt at 40°C, 500 g, 1.67 mol) and maleic anhydride (172 g, 1.75 mol) were placed in a 1 L autoclave and allowed to react at 200°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride,
25 nitrogen bubbling was performed for 2 hours. Thus, 550 g of

polyisobutylene succinic anhydride (PIBSA-2) was obtained. The conversion rate thereof was determined to be 79.1% through column chromatography.

<Preparation of Polybutene Derivative>

5 The PIBSA-2 thus prepared (200 g, 0.49 mol) and triethylenetetramine (96.5 g, 0.51 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 260 g of a polybutene derivative (yield: 93.5% by weight) was obtained.

10 The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 69 cP at 150°C, a number average molecular weight of 537 g/mol (PD = 1.5), and a glass transition temperature (T_g) of -65°C.

[Synthesis Example 3-3]

15 <Preparation of Polyisobutylene Succinic Anhydride (PIBSA-3)>

 Polyisobutylene (M_n: 5,199 g/mol, PD = 1.8, α-vinylidene: 87 mol% based on ¹³C-NMR, viscosity: 11,322 cSt at 100°C, 500 g, 0.1 mol) and maleic anhydride (10.0 g, 0.1 mol) were placed in
20 a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 410 g of polyisobutylene succinic anhydride (PIBSA-3) was obtained. The conversion rate thereof was determined to be
25 70.4% through column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-3 thus prepared (200 g, 0.04 mol) and triethylenetetramine (7.6 g, 0.04 mol) were added to 500 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4
5 hours. Unreacted compounds were removed, after which 200 g of a polybutene derivative (yield: 91.5% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 2,000 cP at 150°C, a number average molecular weight of 5,441 g/mol (PD = 3.5), and a glass
10 transition temperature (T_g) of -61°C.

[Synthesis Example 3-4]

Polyisobutylene (M_n: 997 g/mol, PD = 1.4, α-vinylidene: 68.3 mol% based on ¹³C-NMR, viscosity: 197 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (52 g, 0.5 mol) were placed in a
15 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 420 g of polyisobutylene succinic anhydride (PIBSA-4) was obtained. The conversion rate thereof was determined to be 73.4% through
20 column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-4 thus prepared (200 g, 0.20 mol) and triethylenetetramine (38.0 g, 0.2 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4
25 hours using a Dean-Stark apparatus. Unreacted compounds were

removed, after which 220 g of a polybutene derivative (yield: 85.3% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 175 cP at 150°C, a number
5 average molecular weight of 1,100 g/mol (PD = 1.8), and a glass transition temperature of -69°C.

[Synthesis Example 4-1]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-1)>

10 Polyisobutylene (product name: DAELIM HRPB1000, Mn: 992 g/mol, PD = 1.4, α -vinylidene: 88.3 mol% based on ^{13}C -NMR, viscosity: 193 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (49 g, 0.2 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical
15 stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 431 g of polyisobutylene succinic anhydride (PIBSA-1) was obtained. The conversion rate thereof was determined to be 78.4% through column chromatography.

20 <Preparation of Polybutene Derivative>

The PIBSA-1 thus prepared (200 g, 0.18 mol) and sorbitol (33.1 g, 0.18 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 224.5 g of a polybutene
25 derivative (yield: 96.3% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 800 cP at 150°C, a number average molecular weight of 2,338 g/mol (PD = 2.7), and a glass transition temperature (T_g) of -67°C.

5 **[Synthesis Example 4-2]**

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-2)>

Polyisobutylene (M_n: 300 g/mol, PD = 1.2, α-vinylidene: 81.6 mol% based on ¹³C-NMR, viscosity: 6 cSt at 40°C, 500 g, 10 1.67 mol) and maleic anhydride (172 g, 1.75 mol) were placed in a 1 L autoclave and allowed to react at 200°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, nitrogen bubbling was performed for 2 hours. Thus, 550 g of polyisobutylene succinic anhydride (PIBSA-2) was 15 obtained. The conversion rate thereof was determined to be 79.1% through column chromatography.

<Preparation of Polybutene Derivative>

The PIBSA-2 thus prepared (200 g, 0.49 mol) and sorbitol (92.8 g, 0.51 mol) were added to 400 mL of xylene in a 1 L 20 autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 255 g of a polybutene derivative (yield: 92.9% by weight) was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 48 cP at 150°C, a number average 25 molecular weight of 537 g/mol (PD = 1.5), and a glass

transition temperature (T_g) of -55°C.

[Synthesis Example 4-3]

<Preparation of Polyisobutylene Succinic Anhydride (PIBSA-3)>

5 Polyisobutylene (M_n: 5,199 g/mol, PD = 1.8, α-vinylidene: 87.0 mol% based on ¹³C-NMR, viscosity: 11,322 cSt at 100°C, 500 g, 0.1 mol) and maleic anhydride (10.0 g, 0.1 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic
10 anhydride, nitrogen bubbling was performed for 2 hours. Thus, 410 g of polyisobutylene succinic anhydride (PIBSA-3) was obtained. The conversion rate thereof was determined to be 70.4% through column chromatography.

<Preparation of Polybutene Derivative>

15 The PIBSA-3 thus prepared (200 g, 0.04 mol) and sorbitol (7.3 g, 0.04 mol) were added to 500 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours. Unreacted compounds were removed, after which 205 g of a polybutene derivative (yield: 93.9% by weight) was obtained.

20 The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 7,100 cP at 150°C, a number average molecular weight of 14,780 g/mol (PD = 4.5), and a glass transition temperature (T_g) of -55°C.

[Synthesis Example 4-4]

25 Polyisobutylene (M_n: 997 g/mol, PD = 1.4, α-vinylidene:

68.3 mol% based on ^{13}C -NMR, viscosity: 197 cSt at 100°C, 500 g, 0.5 mol) and maleic anhydride (52 g, 0.5 mol) were placed in a 1 L autoclave and allowed to react at 230°C for 12 hours using a mechanical stirrer. To remove unreacted maleic anhydride, 5 nitrogen bubbling was performed for 2 hours. Thus, 420 g of polyisobutylene succinic anhydride (PIBSA-4) was obtained. The conversion rate thereof was determined to be 73.4% through column chromatography.

<Preparation of Polybutene Derivative>

10 The PIBSA-4 thus prepared (200 g, 0.20 mol) and sorbitol (37.0 g, 0.18 mol) were added to 400 mL of xylene in a 1 L autoclave and allowed to react at 160°C for 4 hours using a Dean-Stark apparatus. Unreacted compounds were removed, after which 200 g of a polybutene derivative (yield: 78.0% by weight) 15 was obtained.

The polybutene derivative thus obtained was determined to have a Brookfield viscosity of 760 cP at 150°C, a number average molecular weight of 2,210 g/mol (PD = 2.6), and a glass transition temperature of -69°C.

20 The types and physical properties of the compounds used in each of the above synthesis examples and the physical properties of the polybutene derivative produced through the polymerization are described in Tables 1 and 2 below, respectively.

25 [Table 1]

	Polyisobutylene			Unsaturated dicarboxylic anhydride	Active hydrogen group-containing compound
	Mn (g/mol)	PD	α -vinylidene (mol%)		
Synthesis Example 1-1	992	80.6	88.3	Maleic anhydride	glycerol
Synthesis Example 1-2	300	81	81.6		
Synthesis Example 1-3	5199	87	87		
Synthesis Example 1-4	997	88.3	86.3		
Synthesis Example 2-1	992	89.6	88.3	Maleic anhydride	diethanol amine
Synthesis Example 2-2	300	87.5	81.6		
Synthesis Example 2-3	5,199	81.4	87		
Synthesis Example 2-4	997	85.7	68.3		
Synthesis Example 3-1	992	85.2	88.3	Maleic anhydride	triethylene tetraamine
Synthesis Example 3-2	300	87	81.6		
Synthesis Example 3-3	5199	78.4	87		
Synthesis Example 3-4	997	80.4	68.3		
Synthesis Example 4-1	992	68.3	88.3	Maleic anhydride	sorbitol
Synthesis Example 4-2	300	68.3	81.6		
Synthesis Example 4-3	5199	68.3	87		
Synthesis Example 4-4	997	68.3	68.3		

[Table 2]

	Polyisobutylene			
	Mn (g/mol)	PD	Viscosity at 150°C (cP)	Tg(°C)
Synthesis Example 1-1	2,939	3.4	475	-67
Synthesis Example 1-2	1,127	2.8	44	-70
Synthesis Example 1-3	11,500	4.5	4,891	-54
Synthesis Example 1-4	2,423	3.3	430	-68
Synthesis Example 2-1	2,855	4.7	1,165	-69
Synthesis Example 2-2	1,185	3.0	132	-70
Synthesis Example 2-3	12,700	5.1	5,675	-52
Synthesis Example 2-4	2,650	4.6	1,050	-70
Synthesis Example 3-1	1,002	1.9	200	-68
Synthesis Example 3-2	537	1.5	69	-65
Synthesis Example 3-3	5,441	3.5	2,000	-61
Synthesis Example 3-4	1,100	1.8	175	-69
Synthesis Example 4-1	2,338	2.7	800	-67
Synthesis Example 4-2	537	1.5	48	-55
Synthesis Example 4-3	14,780	4.5	7,100	-55
Synthesis Example 4-4	2,210	2.6	760	-69

[Preparation Examples 1-1 to 4-3 for Rubber]

A rubber base was prepared by mixing 40 parts by weight of styrene butadiene rubber 1 (styrene: 10%, vinyl: 40%, SBR1) and 82.5 parts by weight of styrene butadiene rubber 2 (styrene: 33%, vinyl: 48%, SBR2). After that, with respect to 100 parts by weight of the rubber base, 10 parts by weight of carbon black, 80 parts by weight of silica (US7000GR, Evonik, CTAB 165 m²/g), 6.4 parts by weight of Si-69 as a silane-coupling agent, 8.1 parts by weight of oil (treated distillate aromatic extracted, TDAE), 3.0 parts by weight of zinc oxide, 2.0 parts

by weight of stearic acid, 1.6 parts by weight of sulfur (manufactured by Miwon Chemicals Co., Ltd.) as a vulcanizing agent, 1.6 parts by weight of N-cyclohexyl-2-benzothiazylsulfenamide (CBS) as a vulcanization accelerator, 2
5 parts by weight of diphenyl guanidine (DPG), and 10 parts by weight of the polybutene derivative prepared in one of Synthesis Examples 1-1 to 1-3, 2-1 to 2-3, 3-1 to 3-3, and 4-1 to 4-3 were mixed using an internal Banbury mixer to prepare a masterbatch. After that, the mixture was further mixed using
10 an open twin-screw roll mill, followed by vulcanization at 165°C for 10 min, thereby manufacturing rubber. The components and amounts of the rubber composition are shown in Table 3 below.

Comparative Example 1

15 Rubber was manufactured in the same manner as in Preparation Example 1-1, with the exception that a rubber composition was prepared by mixing 10 parts by weight of commercially available terpene phenolic resin Chemical T160 (manufactured by Yasuhara Chemical Co., Ltd.), rather than the
20 polybutene derivative.

Comparative Example 2

Rubber was manufactured in the same manner as in Preparation Example 1-1, with the exception that a rubber composition was prepared by mixing 10 parts by weight of
25 rubber-compounding oil (TDAE), instead of the polybutene

derivative. That is, in this comparative example, the rubber-compounding oil (TDAE) was used in a total amount of 18.1 parts by weight.

Comparative Example 3

5 Rubber was manufactured in the same manner as in Preparation Example 1-1, with the exception that a rubber composition was prepared by mixing 10 parts by weight of the polyisobutylene succinic anhydride [PIBSA-1] prepared in Synthesis Example 1-1, rather than the polybutene derivative.

Comparative Example 4

10 Rubber was manufactured in the same manner as in Preparation Example 1-1, with the exception that a rubber composition was prepared by mixing 10 parts by weight of the polybutene derivative prepared in Synthesis Example 1-4, rather
15 than any of the polybutene derivatives prepared in the synthesis examples mentioned in Preparation Example 1-1.

Comparative Example 5

Rubber was manufactured in the same manner as in Preparation Example 1-1, with the exception that a rubber
20 composition was prepared by mixing 10 parts by weight of the polybutene derivative prepared in Synthesis Example 2-4, rather than any of the polybutene derivatives prepared in the synthesis examples mentioned in Preparation Example 1-1.

Comparative Example 6

25 Rubber was manufactured in the same manner as in

Preparation Example 1-1, with the exception that a rubber composition was prepared by mixing 10 parts by weight of the polybutene derivative prepared in Synthesis Example 3-4, rather than any of the polybutene derivatives prepared in the
5 synthesis examples mentioned in Preparation Example 1-1.

Comparative Example 7

Rubber was manufactured in the same manner as in Preparation Example 1-1, with the exception that a rubber composition was prepared by mixing 10 parts by weight of the
10 polybutene derivative prepared in Synthesis Example 4-4, rather than any of the polybutene derivatives prepared in the synthesis examples mentioned in Preparation Example 1-1.

[Table 3]

Classification (phr)		Comp. Ex. 1	Comp. Ex. 2	Comp. Ex. 3	Comp. Ex. 4	Comp. Ex. 5	Comp. Ex. 6	Comp. Ex. 7	Ex. 1-1	Ex. 2-1	Ex. 3-1	Ex. 4-1
Polymer	SBR1	40	40	40	40	40	40	40	40	40	40	40
	SBR2	82.5	82.5	82.5	82.5	82.5	82.5	82.5	82.5	82.5	82.5	82.5
Filler	Silica	80	80	80	80	80	80	80	80	80	80	80
	Carbon black	10	10	10	10	10	10	10	10	10	10	10
	Silane (Si-69)	6.4	6.4	6.4	6.4	6.4	6.4	6.4	6.4	6.4	6.4	6.4
Oil & Chemical	Oil (TDAE)	8.1	18.1	8.1	8.1	8.1	8.1	8.1	8.1	8.1	8.1	8.1
	Terepene resin	10	-	-	-	-	-	-	-	-	-	-
	PIBSA-1	-	-	10	-	-	-	-	-	-	-	-
	Synthesis Ex. 1-4	-	-	-	10	-	-	-	-	-	-	-
	Synthesis Ex. 2-4	-	-	-	-	10	-	-	-	-	-	-
	Synthesis Ex. 3-4	-	-	-	-	-	10	-	-	-	-	-
	Synthesis Ex. 4-4	-	-	-	-	-	-	10	-	-	-	-
	Synthesis Ex. 1-1	-	-	-	-	-	-	-	10	-	-	-
	Synthesis Ex. 2-1	-	-	-	-	-	-	-	-	10	-	-
	Synthesis Ex. 3-1	-	-	-	-	-	-	-	-	-	10	-
	Synthesis Ex. 4-1	-	-	-	-	-	-	-	-	-	-	10
	ZnO	3	3	3	3	3	3	3	3	3	3	3
	Stearic-acid	2	2	2	2	2	2	2	2	2	2	2
Final MB	Sulfur	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6
	CBS	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6
	DPG	2	2	2	2	2	2	2	2	2	2	2

[Table 4]

Classification (phr)		Ex. 1-2	Ex. 1-3	Ex. 2-2	Ex. 2-3	Ex. 3-2	Ex. 3-3	Ex. 4-2	Ex. 4-3
Polymer	SBR1	40	40	40	40	40	40	40	40
	SBR2	82.5	82.5	82.5	82.5	82.5	82.5	82.5	82.5
Filler	Silica	80	80	80	80	80	80	80	80
	Carbon black	10	10	10	10	10	10	10	10
	Silane (Si-69)	6.4	6.4	6.4	6.4	6.4	6.4	6.4	6.4
Oil & Chemical	Oil (TDAE)	8.1	8.1	8.1	8.1	8.1	8.1	8.1	8.1
	Synthesis Ex. 1-2	10	-	-	-	-	-	-	-
	Synthesis Ex. 1-3	-	10	-	-	-	-	-	-
	Synthesis Ex. 2-2	-	-	10	-	-	-	-	-
	Synthesis Ex. 2-3	-	-	-	10	-	-	-	-
	Synthesis Ex. 3-2	-	-	-	-	10	-	-	-
	Synthesis Ex. 3-3	-	-	-	-	-	10	-	-
	Synthesis Ex. 4-2	-	-	-	-	-	-	10	-
	Synthesis Ex. 4-3	-	-	-	-	-	-	-	10
	ZnO	3	3	3	3	3	3	3	3
	Stearic-acid	2	2	2	2	2	2	2	2
Final MB	Sulfur	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6
	CBS	1.6	1.6	1.6	1.6	1.6	1.6	1.6	1.6
	DPG	2	2	2	2	2	2	2	2

[Evaluation of Rubber Properties]

The properties of the prepared rubber compositions were measured through the methods described below. Considering that some properties of the rubber composition vary depending on the surrounding environmental conditions, results obtained under the same conditions on the same day are shown in Tables 4 and 5 below.

1) Evaluation of Payne Effect

The Payne effect is associated with storage modulus values measured at elongations of 0.02% and 20%, and the smaller the change, the better the dispersion of silica, whereby superior rolling resistance can be obtained and thus the general properties of the rubber can be improved. For the rubber manufactured in Examples and Comparative Examples, the Payne effect value was measured in a 0.02-20% strain sweep at a rate of 1 Hz at 60°C using a sample having a weight of 7 g or more and an RPA 2000 from ALPHA Technologies Ltd., and the difference ($\Delta G' = G'_{20\%} - G'_{0.02\%}$) between the storage modulus values measured at elongations of 0.02% and 20% was determined, and the results thereof are shown in Table 5 below.

2) Measurement of Grip Performance and Rolling Resistance through Dynamic Loss Coefficient

The $\tan\delta$ value at 0°C corresponds to braking force on wet road surfaces, and the higher this value, the better the grip force, whereas the $\tan\delta$ value at 60°C corresponds to rolling resistance, and the lower this value, the better the rolling resistance [M. J. Wang, Rubber. Chem. Technol., 71, 520 (1998)]. For each of the rubbers manufactured in Examples and Comparative Examples, the dynamic loss coefficients at 0°C and 60°C were measured using dynamic mechanical thermal spectrometry (DMTS) (GABO, EPLEXOR 500N) and the glass transition temperature (T_g) was measured, and the results

thereof are shown in Table 5 below. Here, the measurement conditions were as follows: frequency: 10 Hz, strain (static strain: 3%, dynamic strain: 0.25%), and temperature: -60°C to 70°C.

5 [Table 5]

	Payne Effect	IMA		
	$\Delta G'_{\text{non-vulcanization}}$	Tg(°C)	Tan δ at 0°C	Tan δ at 60°C
Comp. Ex. 1	3.4	-5.6	0.6832	0.1258
Comp. Ex. 2	3.3	-9.4	0.5757	0.1149
Comp. Ex. 3	2.8	-10.4	0.6010	0.1150
Comp. Ex. 4	2.2	-8.0	0.6212	0.1212
Comp. Ex. 5	2.3	-9.7	0.6044	0.1158
Comp. Ex. 6	2.5	-8.0	0.6664	0.1183
Comp. Ex. 7	2.6	-8.8	0.6020	0.1180
Example 1-1	2.0	-7.7	0.6153	0.1115
Example 1-2	2.2	-8.1	0.6103	0.1075
Example 1-3	2.3	-7.6	0.6309	0.1115
Example 2-1	2.1	-9.3	0.6011	0.1114
Example 2-2	2.1	-9.6	0.6041	0.1096
Example 2-3	2.2	-9.4	0.6171	0.1116
Example 3-1	2.3	-7.3	0.6649	0.1114
Example 3-2	2.4	-7.5	0.6518	0.1095
Example 3-3	2.3	-7.2	0.6782	0.1123
Example 4-1	2.6	-8.6	0.6023	0.1148
Example 4-2	2.7	-9.0	0.6023	0.1108
Example 4-3	2.7	-8.7	0.6089	0.1146

With reference to Table 5, in the case of the $\Delta G'$ value representing the extent of dispersion of filler, such as carbon black and silica, all of the examples exhibited 2.7 or less

while all of the comparative examples exhibited 2.8 or more. The results show that the polybutene derivative according to the embodiment of the present invention improves the dispersibility of silica and carbon black. Specifically, in
5 the case of Examples 1-1 to 3-3, all of the $\Delta G'$ values were 2.4 or less, indicating more excellent filler dispersibility, and in the case of Example 1-1, the $\Delta G'$ value was 2.0, indicating the best filler dispersibility. On the other hand, in the case of the rubbers to which the polybutene derivative prepared
10 through Synthesis Examples 4-1 to 4-3 is applied, the $\Delta G'$ value was 2.6 to 2.7, which was superior in dispersibility to the comparative examples, but was somewhat less effective than in the other examples.

In addition, in the case of 0°C $\text{Tan}\delta$ which indicates
15 better grip performance as the number thereof increases, the rubbers of the examples exhibited 0.6 or more, specifically 0.6011 or more, and in the case of 60°C $\text{Tan}\delta$ which indicates a better rolling resistance as the value thereof decreases, the rubbers of the examples exhibited a value of 0.1148 or less.
20 This means that the rubbers prepared according to the examples of the present invention exhibit excellent grip performance and excellent rolling resistance, unlike rubbers of the related arts.

On the other hand, Comparison Examples 1 to 7 exhibited
25 lower values for the grip performance and the rolling

resistance and did not show that both of the properties were simultaneously improved. That is, compared to Comparative Example 2, which is a basic form in which only oil was added, Comparative Example 1 in which terpene resin was additionally
5 added, Comparative Example 3 in which polyisobutylene succinic anhydride (PIBSA-1) was additionally added, and Comparative Examples 4 to 7 in which polyisobutylene having a low terminal vinylidene content is used, the grip performance was superior, but the rolling resistance was inferior. However, the
10 polybutene derivatives prepared using highly reactive polyisobutylene as in Examples 1-1 to 4-3 improved both the grip performance and the rolling resistance.

WHAT IS CLAIMED IS:

1. A polybutene derivative for rubber compounding, the polybutene derivative comprising:

5 30% to 98% by weight of polyisobutylene;

1% to 35% by weight of unsaturated dicarboxylic anhydride;
and

1% to 50% by weight of at least one selected from among alkanolamines, amine-based compounds, and polyhydric alcohols.

10

2. The polybutene derivative of claim 1, wherein the polyisobutylene has a number average molecular weight of 300 to 10,000 g/mol.

15 3. The polybutene derivative of claim 1, wherein the polyisobutylene has a polydispersity of 1 to 6.

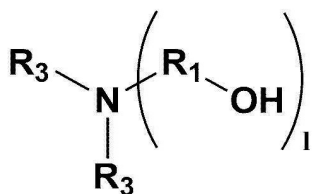
4. The polybutene derivative of claim 1, wherein the unsaturated dicarboxylic anhydride comprises at least one
20 selected from among maleic anhydride, itaconic anhydride, citraconic anhydride, propenyl succinic anhydride, and 2-pentendioic anhydride.

5. The polybutene derivative of claim 1, wherein the
25 alkanolamine includes an amino group and a hydroxy group, the

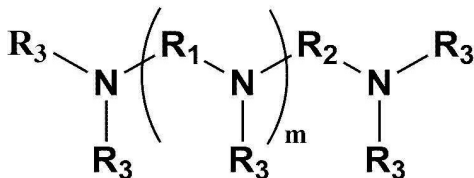
amine-based compound includes two or more amino groups, and the polyhydric alcohol includes two or more hydroxy groups.

6. The polybutene derivative of claim 5, wherein the alkanolamine is a compound represented by Formula 1, the amino compound is a compound represented by Formula 2, and the polyhydric alcohol is a compound represented by Formula 3,

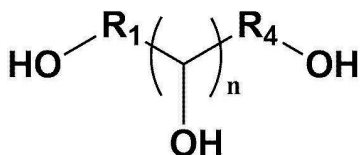
[Formula 1]



10 [Formula 2]



[Formula 3]



In Chemical Formula 1 to 3,

15 R_1 and R_2 are each independently a C1-C9 alkylene group or a C1-C9 alkyl carbonylene group,

R_3 is hydrogen, a C1-C9 alkyl group, or a C1-C9 alkyl carbonyl group,

R₄ is a directly bound, C1-C9 alkylene group or C1-C9 alkyl carbonyl group,

l is a real number in a range of from 1 to 3, and

m and n are each independently a real number in a range of
5 from 0 to 6.

7. The polybutene derivative of claim 5, wherein the alkanolamine compound is at least one selected from among ethanolamine, diethanolamine, triethanolamine, amino methanol,
10 normal-propanolamine, isopropanol amine, diisopropanolamine, triisopropanolamine, butanolamine, dibutanolamine, tributanolamine, and 4-amino-1,2,3-butanetriol, or

the amine-based compound is at least one selected from among ethylene diamine, diethylenetriamine,
15 triethylenetetraamine, tetraethylenepentaamine, pentaethylenehexamine, hexaethyleneheptaamine, putrescine, spermidine, N¹-acetylspermidine, N⁸-acetylspermidine, N¹,N¹²-diacetylspermidine, cadaverine, spermine, thermospermine, caldopentamine, caldohexamine, tris(3-aminopropyl)amine,
20 tris(2-aminoethyl)amine, tetrakis(3-aminopropyl) ammonium, cyclen, 1,4,7-triazacyclononane, 1,1,1-tris(aminomethyl)ethane, and subunits of polyethylenimine, or

the polyhydric alcohol compound is at least one selected from among ethylenediol, 1,2-propylenediol, glycerol, 1,3-
25 propanediol, 1,2-butanediol, 1,2,3-butanetriol, 1,2,4-

butanetriol, 1,2-pentanediol, 1,3,5-pentanetriol, 2,3,4-pentanetriol, 1,2,4-pentanetriol, 1,2,5-pentanetriol, 1,2 - Hexanediol, 1,6-hexanediol, 1,2,6-hexanetriol, 1,2,3-hexanetriol, 1,2,5-hexanetriol, 1,2,4-hexanetriol , 1,3,6-hexanetriol, 1,2-heptanediol, 1,2,3-heptanetriol, 1,2,7-heptanetriol, 1,4,5-heptanetriol, 1,4,7-heptanetriol, 1,2-octanediol, 1,1,3-octanetriol, 1,3,8-octanetriol, 2,3,7-octanetriol, 1,3,5-octanetriol, 1,2-nonanediol, 1,2-decanediol, sugar alcohol having 4 to 6 carbon atoms, and span.

10

8. The polybutene derivative of claim 1, wherein the polybutene derivative manufactured using the alkanolamine includes at least one selected from among an imide group, an amide group, and an ester group.

15

9. The polybutene derivative of claim 1, wherein the polybutene derivative manufactured using the amine-based compound includes at least one selected from among an imide group and an amide group.

20

10. The polybutene derivative of claim 1, wherein the polybutene derivative manufactured using the polyhydric alcohol includes an ester group.

25

11. The polybutene derivative of claim 1, wherein the

polybutene derivative has a glass transition temperature of -
40°C or lower.

12. The polybutene derivative of claim 1, wherein the
5 polybutene derivative has a Brooke field viscosity of 1 to
10,000 cP at 150°C.

13. The polybutene derivative of claim 1, wherein the
polybutene derivative has a number average molecular weight of
10 500 to 15,000 g/mol.

14. The polybutene derivative of claim 1, wherein the
polybutene derivative has a polydispersity of 1 to 6.

15 15. A rubber composition comprising:
the polybutene derivative of claim 1;
a rubber base; and
a filler.

20 16. The rubber composition of claim 15, wherein the filler
comprises at least one selected from among silica, carbon
black, and both.

17. The rubber composition of claim 15, wherein the rubber
25 base comprises at least one selected from among butadiene

rubber, butyl rubber, emulsion polymerization styrene butadiene rubber (E-SBR), solution polymerization styrene butadiene rubber (S-SBR), epichlorohydrin rubber, nitrile rubber, hydrogenated nitrile rubber, brominated polyisobutylisoprene-
5 co-paramethyl styrene (BIMS) rubber, urethane rubber, fluoro rubber, silicone rubber, styrene-ethylenebutadiene styrene copolymer rubber, ethylenepropylene rubber, ethylenepropylenediene monomer rubber, hypalon rubber, chloroprene rubber, ethylene vinyl acetate rubber, and acrylic
10 rubber.

18. The rubber composition of claim 15, wherein the rubber composition comprises 50 to 150 parts by weight of silica, 5 to 20 parts by weight of carbon black, 2 to 40 parts by weight of
15 the polybutene derivative, and 2 to 15 parts by weight of a silane coupling agent, with respect to 100 parts by weight of the rubber base.