

## DESCRIPTION

### MODIFIED CONJUGATED DIENE-BASED POLYMER, METHOD FOR PREPARING THE SAME AND RUBBER COMPOSITION INCLUDING THE SAME

5

#### TECHNICAL FIELD

##### [Cross-reference to Related Applications]

[0001] The present application claims the benefit of priority based on Korean Patent Application No. 10-2019-  
10 0113004, filed on September 11, 2019, and Korean Patent Application No. 10-2020-0116220 and Korean Patent Application No. 10-2020-0116221, filed on September 10, 2020, the entire contents of which are incorporated herein by reference.

##### [Technical Field]

15 [0002] The present invention relates to a modified conjugated diene-based polymer which has excellent processability and good tensile strength and viscoelasticity properties, a method for preparing the same and a rubber composition including the same.

20

#### BACKGROUND ART

[0003] According to the recent demand for cars having a low fuel consumption ratio, a conjugated diene-based polymer having modulational stability represented by wet skid  
25 resistance as well as low rotation resistance, and excellent

abrasion resistance and tensile properties is required as a rubber material for tires.

**[0004]** In order to reduce the rotation resistance of tires, there is a method of reducing hysteresis loss of vulcanized rubber, and rebound resilience at 50°C to 80°C,  $\tan \delta$ , Goodrich heating, or the like is used as an evaluation index of the vulcanized rubber. That is, it is desirable to use a rubber material having high rebound resilience at the above temperature or a low  $\tan \delta$  value or Goodrich heating.

**[0005]** Natural rubbers, polyisoprene rubbers, or polybutadiene rubbers are known as rubber materials having low hysteresis loss, but these rubbers have a limitation of low wet skid resistance. Thus, recently, conjugated diene-based polymers or copolymers such as styrene-butadiene rubbers (hereinafter, referred to as "SBR") and butadiene rubbers (hereinafter, referred to as "BR"), are prepared by emulsion polymerization or solution polymerization to be used as rubbers for tires. Among these polymerization methods, the greatest advantage of the solution polymerization in comparison to the emulsion polymerization is that the vinyl structure content and the styrene content, which specify physical properties of the rubber, may be arbitrarily adjusted and its molecular weight and physical properties may be controlled by coupling or modification. Thus, the SBR prepared by the solution polymerization is widely used as a

rubber material for tires because it is easy to change a structure of the finally prepared SBR or BR, and movement of chain terminals may be reduced and a coupling force with a filler such as silica and carbon black may be increased by coupling or modification of the chain terminals.

**[0006]** If the solution-polymerized SBR is used as the rubber material for tires, since a glass transition temperature of the rubber is increased by increasing the vinyl content in the SBR, physical properties such as rotation resistance and braking force, required for tires may be controlled, and fuel consumption may be reduced by appropriately adjusting the glass transition temperature. The solution-polymerized SBR is prepared by using an anionic polymerization initiator and is being used by coupling or modifying the chain terminals of the polymer thus formed to introduce a functional group at the terminal using various modifiers. For example, U.S. Patent No. 4,397,994 discloses a method of coupling active anions of the chain terminals of a polymer obtained by polymerizing styrene-butadiene using alkyllithium which is a monofunctional initiator in a non-polar solvent, using a coupling agent such as a tin compound.

**[0007]** Meanwhile, as the modifier for introducing the functional group to the chain terminal of a polymer, technique of applying an aminoalkoxysilane-based modifier including an alkoxysilane group and an amine group in a

molecule at the same time for maximizing the dispersibility and reactivity of a filler is widely known. However, if the number of the amine groups in the modifier increases, there are problems in that the solubility in a hydrocarbon solvent used for preparing a polymer may decrease, and easy modification reaction may become difficult.

[0008] [Prior Art Document]

[0009] (Patent Document 1) US4397994 A

## 10 **DISCLOSURE OF THE INVENTION**

### **TECHNICAL PROBLEM**

[0010] The present invention has been devised to solve the above-mentioned problems of the conventional technique, and an object is to provide a modified conjugated diene-based polymer including a second chain including a repeating unit derived from a compound represented by Formula 1 and a derived unit from an alkoxysilane-based modifier, and having excellent affinity with a filler.

[0011] In addition, an object of the present invention is to provide a method for preparing the modified conjugated diene-based polymer including a modified active polymer first chain and a second chain derived from a macromonomer by including a step of reacting with a macromonomer including a repeating unit derived from a compound represented by Formula 1 after modification reaction, wherein the first chain and the second

chain are coupled by the derived unit of from a modifier.

**[0012]** Also, an object of the present invention is to provide a rubber composition including the modified conjugated diene-based polymer.

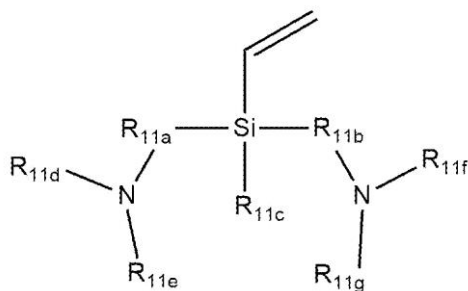
5

#### **TECHNICAL SOLUTION**

**[0013]** To solve the above-described tasks, according to an embodiment of the present invention, the present invention provides a modified conjugated diene-based polymer including:

10 a first chain including a repeating unit derived from a conjugated diene-based monomer; a second chain including a repeating unit derived from a compound represented by the following Formula 1; and a derived unit from an alkoxy silane-based modifier, wherein the first chain and the second chain  
15 are coupled by the derived unit of the modifier:

**[0014]** [Formula 1]



**[0015]** in Formula 1,

**[0016]** R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or a  
20 substituted with a substituent or unsubstituted alkylene group of 1 to 20 carbon atoms; a substituted with a

substituent or unsubstituted cycloalkylene group of 5 to 20 carbon atoms; or a substituted with a substituent or unsubstituted arylene group of 6 to 20 carbon atoms, wherein the substituent is an alkyl group of 1 to 10 carbon atoms, a  
5 cycloalkyl group of 5 to 10 carbon atoms, or an aryl group of 6 to 20 carbon atoms,

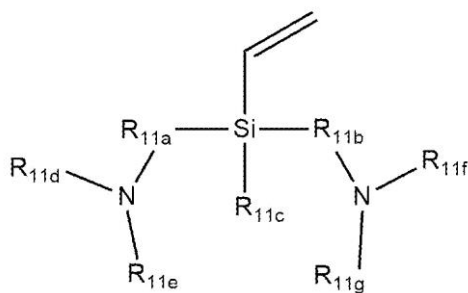
**[0017]** R<sub>11c</sub> is an alkyl group of 1 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon  
10 atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; or a heterocyclic group of 3 to 20 carbon atoms, and

**[0018]** R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1  
15 to 20 carbon atoms; an alkenyl group of 2 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of  
20 6 to 20 carbon atoms; a heterocyclic group of 3 to 20 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

**[0019]** In addition, the present invention provides a method  
25 for preparing the conjugated diene-based polymer including:

polymerizing a conjugated diene-based monomer, or a conjugated diene-based monomer and an aromatic vinyl-based monomer in the presence of a polymerization initiator in a hydrocarbon solvent to prepare an active first chain (S1);  
 5 reacting the active first chain with an alkoxysilane-based modifier to prepare a modified active first chain (S2); and reacting the modified active first chain and a macromonomer including a repeating unit derived from a compound represented by the following Formula 1 (S3):

10 **[0020]** [Formula 1]



**[0021]** in Formula 1,

**[0022]**  $R_{11a}$  and  $R_{11b}$  are each independently a single bond or a substituted with a substituent or unsubstituted alkylene group of 1 to 20 carbon atoms; a substituted with a substituent or unsubstituted cycloalkylene group of 5 to 20 carbon atoms; or a substituted with a substituent or unsubstituted arylene group of 6 to 20 carbon atoms, wherein the substituent is an alkyl group of 1 to 10 carbon atoms, a cycloalkyl group of 5 to 10 carbon atoms, or an aryl group of 6 to 20 carbon atoms,

**[0023]** R<sub>11c</sub> is an alkyl group of 1 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; or a heterocyclic group of 3 to 20 carbon atoms, and

**[0024]** R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 20 carbon atoms; an alkenyl group of 2 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; a heterocyclic group of 3 to 20 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

**[0025]** Also, the present invention provides a rubber composition including the modified conjugated diene-based polymer and a filler.

#### **ADVANTAGEOUS EFFECTS**

**[0026]** The modified conjugated diene-based polymer according to the present invention is prepared by a preparation method including a step of reacting a modified active first chain

and a macromonomer including a repeating unit derived from a compound represented by Formula 1 after modification reaction, and may include a functional group derived from the compound represented by Formula 1 in a polymer molecular chain separately from a functional group derived from a modifier, thereby may have excellent affinity with a filler.

[0027] In addition, the method for preparing a modified conjugated diene-based polymer according to the present invention includes a step of reacting a macromonomer including a repeating unit derived from the compound represented by Formula 1 after modification reaction, and a modified conjugated diene-based polymer with a high modification ratio may be prepared by introducing a functional group derived from the compound represented by Formula 1, for example, an amine group to a polymer separately from the modifier.

[0028] Also, the rubber composition according to the present invention includes the modified conjugated diene-based polymer and may show excellent effects of tensile properties and viscoelasticity properties.

#### **BEST MODE FOR CARRYING OUT THE INVENTION**

[0029] Hereinafter, the present invention will be described in more detail in order to assist the understanding of the present invention.

[0030] It will be understood that words or terms used in the description and claims of the present invention shall not be interpreted as the meaning defined in commonly used dictionaries, and the words or terms should be interpreted as having a meaning that is consistent with their meaning of the technical idea of the invention, based on the principle that an inventor may properly define the meaning of the words or terms to best explain the invention.

10 [0031] **Definition of Terms**

[0032] The term "macromonomer" used in the present disclosure is a monomer unit of two or more repeating units derived from a polymerization reactive monomer, and may be combined with a polymer chain or a reactive compound through a terminal group.

[0033] The term "polymer" used in the present disclosure refers to a polymer compound prepared by polymerizing monomers of the same or different type. Thus, the common term, polymer refers to a polymer prepared from one type of a monomer, but includes a commonly used homopolymer and a copolymer.

[0034] The term "first chain(main chain)" used in the present disclosure may mean the molecular chain of a main skeleton forming a polymer, and may mean a chain mainly including repeating units of a conjugated diene-based monomer,

or a conjugated diene-based monomer and an aromatic vinyl-based monomer, and the term "second chain(sub chain)" may mean a chain having a smaller number of repeating units than the first chain and mainly including the repeating unit  
5 derived from the compound represented by Formula 1.

**[0035]** The term "vinyl content" used in the present disclosure refers to the mass (or weight) percent of butadiene included in 1 and 2 positions in a polymer chain on the basis of a conjugated diene monomer (butadiene, etc.)  
10 moiety in the polymer (on the basis of the total weight of polymerized butadiene).

**[0036]** The term "monovalent hydrocarbon group" used in the present disclosure may mean a monovalent atomic group obtained by bonding carbon and hydrogen, in a monovalent  
15 alkyl group, alkenyl group, alkynyl group, cycloalkyl group, cycloalkyl group including one or more unsaturated bonds, and aryl group. The minimum carbon number of a substituent represented by the monovalent hydrocarbon may be determined according to the type of each substituent.

**[0037]** The term "divalent hydrocarbon group" used in the present disclosure may mean a divalent atomic group obtained by bonding carbon and hydrogen, in a divalent alkylene group, alkenylene group, alkynylene group, cycloalkylene group, cycloalkylene group including one or more unsaturated bonds  
25 and arylene group. The minimum carbon number of a

substituent represented by the divalent hydrocarbon may be determined according to the type of each substituent.

**[0038]** The term "alkyl group" used in the present disclosure may mean monovalent aliphatic saturated hydrocarbon, and may include a linear alkyl group such as methyl, ethyl, propyl and butyl; and a branched alkyl group such as isopropyl, sec-butyl, tert-butyl and neo-pentyl.

**[0039]** The term "alkenyl group" used in the present disclosure may mean a monovalent aliphatic unsaturated hydrocarbon including one or two or more double bonds.

**[0040]** The term "alkynyl group" used in the present disclosure may mean a monovalent aliphatic unsaturated hydrocarbon including one or two or more triple bonds.

**[0041]** The term "alkylene group" used in the present disclosure may mean divalent aliphatic saturated hydrocarbon such as methylene, ethylene, propylene and butylene.

**[0042]** The term "aryl group" used in the present disclosure may mean aromatic hydrocarbon, and may include both monocyclic aromatic hydrocarbon in which one ring is formed, and polycyclic aromatic hydrocarbon in which two or more rings are bonded.

**[0043]** The term "heterocyclic group" used in the present disclosure is a cycloalkyl group or an aryl group of which carbon atoms are substituted with one or more heteroatoms, for example, may mean a heterocycloalkyl group or a

heteroaryl group.

**[0044]** The term "substituted" used in the present disclosure may mean that the hydrogen of a functional group, an atomic group or a compound is substituted with a specific substituent. If the hydrogen of a functional group, an atomic group or a compound is substituted with a specific substituent, one or a plurality including two or more of substituents may be present according to the number of hydrogen present in the functional group, the atomic group or the compound, and if a plurality of substituents are present, each substituent may be the same or different.

**[0045]** The term "single bond" used in the present disclosure may mean a single covalent bond itself excluding a separate atomic or molecular group.

**[0046]** The term "derived unit", "derived repeating unit" and "derived functional group" used in the present disclosure may represent a component or a structure comes from a certain material, or the material itself.

**[0047]** It will be further understood that the terms "comprising", "including", and "having" and the derivatives thereof in the present disclosure, though these terms are particularly disclosed or not, do not preclude the presence or addition of optional components, steps, or processes. In order to avoid any uncertainty, all components claimed by using the term "comprising" may include additional additives,

auxiliaries, or compounds, including a polymer or other materials, unless described to the contrary. In contrast, the term "consisting essentially of ~" excludes unnecessary ones for operation and precludes optional other components, steps or processes from the scope of optional explanation. The term "consisting of ~" precludes optional components, steps or processes, which are not particularly described or illustrated.

10 **[0048] Measurement methods and conditions**

**[0049]** In the present disclosure, the "vinyl content" is measured and analyzed using Varian VNMRS 500 MHz NMR, and the 1,2-vinyl bond content in a total polymer is calculated and measured by using 1,1,2,2-tetrachloroethane as a solvent during measuring NMR, and calculating 6.0 ppm as a solvent peak, 7.2-6.9 ppm as random styrene peaks, 6.9-6.2 ppm as block styrene peaks, 5.8-5.1 ppm as 1,4-vinyl and 1,2-vinyl peaks, and 5.1-4.5 ppm as 1,2-vinyl peaks.

**[0050]** In the present disclosure, "weight average molecular weight (Mw)", "number average molecular weight (Mn)", and "molecular weight distribution (MWD)" are measured through gel permeation chromatography (GPC) analysis and are measured by checking a molecular weight distribution curve. The molecular weight distribution (PDI, MWD, Mw/Mn) is calculated from each molecular weight measured. Particularly, the GPC

uses two columns of PLgel Olexis (Polymer laboratories Co.) and one column of PLgel mixed-C (Polymer Laboratories Co.) in combination, and polystyrene (PS) is used as a GPC standard material for calculating the molecular weights, and  
5 tetrahydrofuran mixed with 2 wt% of an amine compound is used as a GPC measurement solvent.

**[0051]** In the present disclosure, the "N content" may be measured, for example, through an NSX analysis method, and measurement by the NSX analysis method may use a quantitative  
10 analyzer of a trace amount of nitrogen (NSX-2100H). For example, in case of using the quantitative analyzer of a trace amount of nitrogen, the quantitative analyzer of a trace amount of nitrogen (Auto sampler, Horizontal furnace, PMT & Nitrogen detector) is turned on, carrier gas flow  
15 amounts are set to 250 ml/min for Ar, 350 ml/min for O<sub>2</sub>, and 300 ml/min for ozonizer, a heater is set to 800°C, and the analyzer is stood for about 3 hours for stabilization. After stabilizing the analyzer, a calibration curve of calibration curve ranges of 5 ppm, 10 ppm, 50 ppm, 100 ppm and 500 ppm is  
20 made using Nitrogen standard (AccuStandard S-22750-01-5 ml), and an area corresponding to each concentration is obtained. Then, by using the ratios of concentrations to areas, a straight line is made. After that, a ceramic boat holding 20 mg of a specimen is put in the auto sampler of the analyzer  
25 and measurement is conducted to obtain an area. By using the

area of the specimen thus obtained and the calibration curve, the N content is calculated. In this case, the specimen is a modified conjugated diene-based polymer from which solvents are removed by putting the specimen in hot water heated by steam and stirring, and may be a specimen from which remaining monomers, remaining modifiers and oil are removed.

**[0052]** In the present disclosure, the "Si content" is measured using an inductively coupled plasma optical emission spectroscopy (ICP-OES; Optima 7300DV) as an ICP analysis method. Particularly, measurement is performed by adding about 0.7 g of a specimen to a platinum (Pt) crucible, adding about 1 mL of concentrated sulfuric acid (98 wt%, electronic grade) thereto, heating at 300°C for 3 hours, incinerating the specimen in an electrical furnace (Thermo Scientific, Lindberg Blue M) by the following program of steps 1 to 3:

**[0053]** 1) step 1: initial temp 0°C, rate (temp/hr) 180°C/hr, temp (holdtime) 180°C (1hr),

**[0054]** 2) step 2: initial temp 180°C, rate (temp/hr) 85°C/hr, temp (holdtime) 370°C (2hr), and

**[0055]** 3) step 3: initial temp 370°C, rate (temp/hr) 47°C/hr, temp (holdtime) 510°C (3hr),

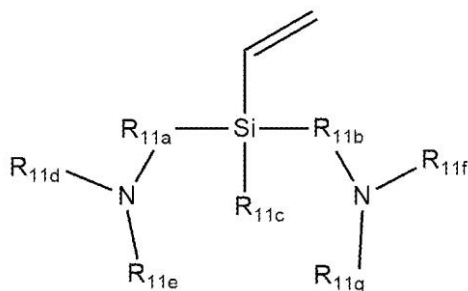
**[0056]** adding 1 mL of concentrated nitric acid (48 wt%) and 20 µl of concentrated hydrofluoric acid (50 wt%) to a residue, sealing the platinum crucible and shaking for 30 minutes or more, adding 1 mL of boric acid to the specimen, storing at

0°C for 2 hours or more, diluting in 30 ml of ultrapure water, and performing incineration.

**[0057] Modified conjugated diene-based polymer**

- 5 **[0058]** The present invention provides a modified conjugated diene-based polymer having excellent affinity with a filler, and as a result, capable of providing a rubber composition having excellent processability, tensile properties and viscoelasticity properties.
- 10 **[0059]** The modified conjugated diene-based polymer according to an embodiment of the present invention includes a first chain including a repeating unit derived from a conjugated diene-based monomer; a second chain including a repeating unit derived from a compound represented by the following
- 15 Formula 1; and a derived unit from an amine-containing alkoxy silane-based modifier, wherein the first chain and the second chain are coupled by the derived unit of the modifier:

**[0060]** [Formula 1]



- 20 **[0061]** in Formula 1,

**[0062]** R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or a

substituted with a substituent or unsubstituted alkylene group of 1 to 20 carbon atoms; a substituted with a substituent or unsubstituted cycloalkylene group of 5 to 20 carbon atoms; or a substituted with a substituent or unsubstituted arylene group of 6 to 20 carbon atoms, wherein the substituent is an alkyl group of 1 to 10 carbon atoms, a cycloalkyl group of 5 to 10 carbon atoms, or an aryl group of 6 to 20 carbon atoms,

**[0063]** R<sub>11c</sub> is an alkyl group of 1 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; or a heterocyclic group of 3 to 20 carbon atoms, and

**[0064]** R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 20 carbon atoms; an alkenyl group of 2 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; a heterocyclic group of 3 to 20 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

**[0065]** The modified conjugated diene-based polymer according to an embodiment of the present invention may be prepared by a preparation method, which will be explained later, including a step of reacting a macromonomer including a repeating unit derived from the compound represented by Formula 1 with a modified active first chain after modification reaction, and through this, may have a structure like a graft copolymer including the first chain including a repeating unit derived from a conjugated diene-based monomer, and a second chain derived from the macromonomer which is bonded to a derived unit from a modifier containing an amine-containing alkoxy silane-based modifier, which is bonded to at least one terminal of the first chain. That is, in the modified conjugated diene-based polymer, the first chain and the second chain may be coupled by the derived unit from a modifier.

**[0066]** The modified conjugated diene-based polymer according to an embodiment of the present invention may be prepared by a preparation method, which will be explained later, including a step of reacting a macromonomer including a repeating unit derived from the compound represented by Formula 1 with a modified first chain having activity after modification reaction, and through this, may have a structure

like a graft copolymer including the first chain including a repeating unit derived from a conjugated diene-based monomer, and a second chain derived from the macromonomer which is bonded to a derived unit from a modifier containing an amine-  
5 containing alkoxysilane-based, which is bonded to at least one terminal of the first chain. That is, in the modified conjugated diene-based polymer, the first chain and the second chain may be coupled by the derived unit from a modifier.

10 **[0067]** As described above, if all functional groups are intensively distributed at one terminal of the modified conjugated diene-based polymer and make interaction with silica, only one terminal of the polymer may be coupled with silica, and the other terminal may be a free state, and  
15 accordingly, similar to the conventional modified polymer at a single terminal, effects on the dispersibility of a filler and the prevention of flocculation may be excellent, and processability may be markedly improved. In addition, at one terminal coupled with a functional group, the second chain  
20 derived from a macromonomer and the derived unit from a modifier are included, and effects by the interaction with a filler may be achieved to the equal or better level as the conventional modified polymer at both terminals, and thus, tensile properties and viscoelasticity properties may become  
25 excellent.

**[0068]** In addition, generally, a residual group derived from a modifier, for example, an alkoxy group (-OR, where R is a hydrocarbon group) or a hydroxyl group (-OH) is present in a modified conjugated diene-based polymer, and as time goes by, condensation reaction, hydrolysis reaction, etc. may arise from the residual group, and storage stability may be deteriorated, mooney viscosity may increase, molecular weight distribution may increase, and the excellence of the compounding properties of the modified conjugated diene-based polymer may not be maintained, and thus, if used in a rubber composition, there are problems in not achieving desired properties. However, since the modified conjugated diene-based polymer according to an embodiment of the present invention is prepared by a preparation method, which will be explained later, a structure in which the second chain derived from a macromonomer is bonded to an alkoxy group which is a residual group derived from a modifier present in a polymer may be obtained, and as a result, the residual group derived from a modifier may not be present in the polymer or may be reduced in contrast to the conventional preparation method.

**[0069]** In addition, the modified conjugated diene-based polymer according to an embodiment of the present invention is prepared by the preparation method, which will be

explained later, and may have advantages of introducing more functional groups than a case of using only a modifier having lots of functional groups. Particularly, in view of the active polymer and the alkoxy group of the modifier, the coupling of one molecule of the modifier with two or more polymer chains is difficult due to the steric hindrance of the polymer, and though three or more chains may be coupled, a modified polymer in which three or more chains are coupled must be a little. However, according to the preparation method of the present invention, irrespective of the steric hindrance, to the alkoxy residual group of the modifier which is coupled with the polymer chain, the second chain derived from a macromonomer may be coupled, and more functional groups may be introduced into the polymer chain.

**[0070]** That is, there are limitations in introducing functional groups in one molecule of the modifier, and though no matter how many functional groups are introduced, there is difference in the absolute amount of the functional group when compared with a case of coupling a chain including a functional group with an alkoxy residual group without any influence by steric hindrance as in the present invention.

**[0071]** Accordingly, the modified conjugated diene-based polymer according to the present invention has excellent storage stability as time goes by and may maintain excellent compounding properties constantly at the initiation of

preparation or after the passage of time, and may have excellent tensile properties and viscoelasticity properties in contrast to the conventional modified polymer at a single terminal.

5

**[0072]** First chain including repeating unit derived from conjugated diene-based monomer

**[0073]** According to an embodiment of the present invention, the first chain which is the main skeleton of the modified  
10 conjugated diene-based polymer includes a repeating unit derived from a conjugated diene-based monomer, and the conjugated diene-based monomer may be one or more selected from the group consisting of 1,3-butadiene, 2,3-dimethyl-1,3-butadiene, piperylene, 3-butyl-1,3-octadiene, isoprene, 2-  
15 phenyl-1,3-butadiene and 2-halo-1,3-butadiene (halo means a halogen atom).

**[0074]** In addition, the first chain may further include a repeating unit derived from an aromatic vinyl-based monomer, and the aromatic vinyl-based monomer may be one or more  
20 selected from the group consisting of styrene,  $\alpha$ -methylstyrene, 3-methylstyrene, 4-methylstyrene, 4-propylstyrene, 1-vinylnaphthalene, 4-cyclohexylstyrene, 4-(p-methylphenyl)styrene, 1-vinyl-5-hexylnaphthalene, 3-(2-pyrrolidino ethyl)styrene, 4-(2-pyrrolidino ethyl)styrene and  
25 3-(2-pyrrolidino-1-methyl ethyl)- $\alpha$ -methylstyrene.

**[0075]** In another embodiment, the first chain of the modified conjugated diene-based polymer may be a copolymer further including a repeating unit derived from a diene-based monomer of 1 to 10 carbon atoms together with the repeating  
5 unit derived from the conjugated diene-based monomer. The repeating unit derived from the diene-based monomer may be a repeating unit derived from a diene-based monomer which is different from the conjugated diene-based monomer, and the diene-based monomer which is different from the conjugated  
10 diene-based monomer may be, for example, 1,2-butadiene. If the modified conjugated diene-based polymer is a copolymer further including a diene-based monomer, the modified conjugated diene-based polymer may include the repeating unit derived from the diene-based monomer in an amount of greater  
15 than 0 wt% to 1 wt%, greater than 0 wt% to 0.1 wt%, greater than 0 wt% to 0.01 wt%, or greater than 0 wt% to 0.001 wt%, and within this range, effects of preventing gel formation may be achieved.

**[0076]** According to an embodiment of the present invention,  
20 if repeating units derived from two or more monomers are included in the first chain which forms the skeleton of the modified conjugated diene-based polymer, the first chain may be a random copolymer chain, and in this case, effects of excellent balance between physical properties may be achieved.  
25 The random copolymer may mean the arrangement of repeating

units forming a copolymer in disorder.

**[0077]** Second chain including repeating unit derived from compound represented by Formula 1

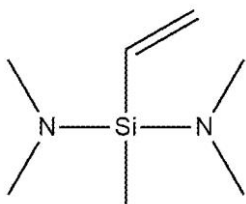
5 **[0078]** In addition, the modified conjugated diene-based polymer according to an embodiment of the present invention further includes a second chain in addition to the first chain, and the second chain is derived from a macromonomer including a repeating unit derived from the compound  
10 represented by Formula 1, and the main unit may be the repeating unit derived from the compound represented by Formula 1.

**[0079]** Particularly, in Formula 1, R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or an unsubstituted alkylene  
15 group of 1 to 10 carbon atoms, R<sub>11c</sub> is an alkyl group of 1 to 10 carbon atoms, and R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 10 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

20 **[0080]** In another embodiment, in Formula 1, R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or an unsubstituted alkylene group of 1 to 6 carbon atoms, R<sub>11c</sub> is an alkyl group of 1 to 6 carbon atoms, and R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 6 carbon atoms; or a tri-substituted  
25 trialkylsilyl group with alkyl groups of 1 to 6 carbon atoms.

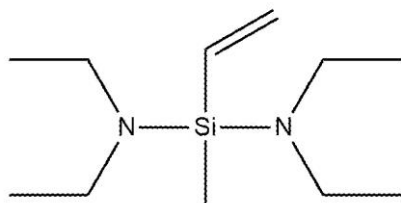
[0081] More particularly, the compound represented by Formula 1 may be one or more selected from the compounds represented by Formula 1-1 to 1-3 below.

[0082] [Formula 1-1]

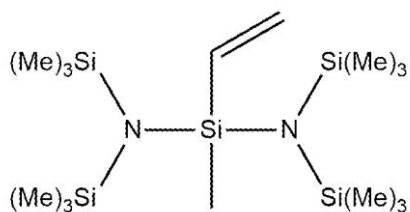


5

[0083] [Formula 1-2]



[0084] [Formula 1-3]



10 [0085] In Formula 1-3, Me is a methyl group.

[0086] Modifier

[0087] In addition, the modified conjugated diene-based polymer may have a coupled type of the first chain and the second chain by the derived unit from an alkoxy silane-based monomer, and the second chain may be coupled with the

15

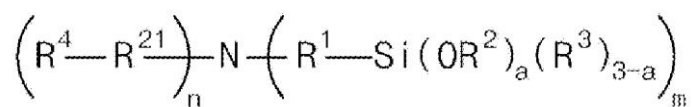
modifier as a hub.

**[0088]** According to an embodiment of the present invention, the modifier may be a modifier having affinity with silica. The modifier having affinity with silica may mean a modifier  
5 containing a functional group having affinity with silica in a compound used as a modifier, and the functional group having affinity with silica may mean a functional group having excellent affinity with a filler, particularly, a silica-based filler, and is capable of making interaction  
10 between the silica-based filler and the functional group derived from the modifier.

**[0089]** In addition, the alkoxysilane-based modifier according to the present invention may be an amine-containing alkoxysilane-based modifier or a non-amine-containing  
15 alkoxysilane-based modifier.

**[0090]** Particularly, according to an embodiment of the present invention, the amine-containing alkoxysilane-based modifier may be a compound represented by Formula 2 below.

**[0091]** [Formula 2]



**[0092]** In Formula 2,  $R^1$  may be a single bond, or an alkylene group of 1 to 10 carbon atoms,  $R^2$  and  $R^3$  may be each independently an alkyl group of 1 to 10 carbon atoms,  $R^4$  may

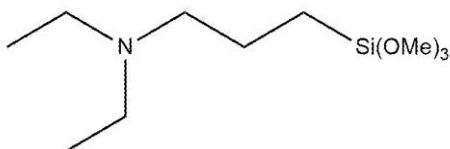
be hydrogen, an epoxy group, an alkyl group of 1 to 10 carbon atoms, an allyl group of 2 to 10 carbon atoms, a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms, or a  
 5 heterocyclic group of 2 to 10 carbon atoms,  $R^{21}$  may be a single bond, an alkylene group of 1 to 10 carbon atoms, or  $-[R^{42}O]_j-$ , where  $R^{42}$  may be an alkylene group of 1 to 10 carbon atoms, a and m may be each independently an integer selected from 1 to 3, n may be an integer of 0 to 2, and j may be an  
 10 integer selected from 1 to 30.

**[0093]** In a particular embodiment, the compound represented by Formula 2 may be one selected from the group consisting of N,N-bis(3-(dimethoxy(methyl)silyl)propyl)-methyl-1-amine, N,N-bis(3-(diethoxy(methyl)silyl)propyl)-methyl-1-amine, N,N-  
 15 bis(3-(trimethoxysilyl)propyl)-methyl-1-amine, N,N-bis(3-(triethoxysilyl)propyl)-methyl-1-amine, tri(trimethoxysilyl)amine, tri(3-(trimethoxysilyl)propyl)amine, N,N-bis(3-(diethoxy(methyl)silyl)propyl)-1,1,1-trimethylsilanamine, N-  
 20 (3-(1H-1,2,4-triazole-1-yl)propyl)-3-(trimethoxysilyl)-N-(3-(trimethoxysilyl)propyl)propan-1-amine, 3-(trimethoxysilyl)-N-(3-(trimethoxysilyl)propyl)-N-(3-(1-(3-(trimehtoxysilyl)propyl)-1H-1,2,4-triazol-3-yl)propyl)propan-1-amine, N-allyl-N-(3-(trimethoxysilyl)propyl)prop-2-en-1-  
 25 amine), N,N-bis(oxiran-2-ylmethyl)-3-(trimethoxysilyl)propan-

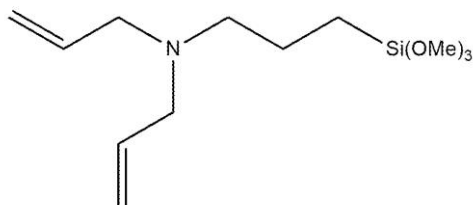
1-amine, 1,1,1-trimethyl-N-(3-(triethoxysilyl)propyl)-N-(trimethylsilyl)silamine) and N,N-bis(3-(triethoxysilyl)propyl)-2,5,8,11,14-pentaoxa-hexadecan-16-amine.

- 5 **[0094]** In another embodiment, the compound represented by Formula 2 may be one or more selected from the compounds represented by Formula 2-1 to Formula 2-6 below.

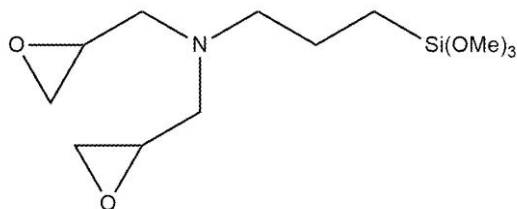
**[0095]** [Formula 2-1]



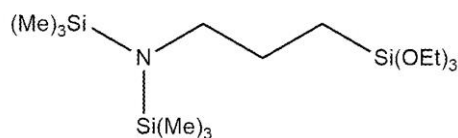
- 10 **[0096]** [Formula 2-2]



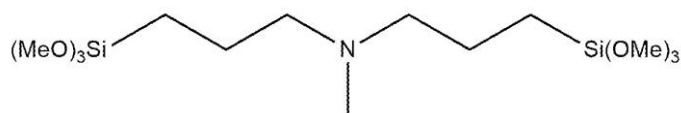
**[0097]** [Formula 2-3]



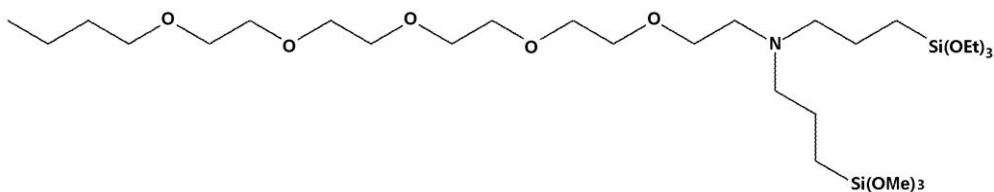
**[0098]** [Formula 2-4]



**[0099]** [Formula 2-5]



**[00100]** [Formula 2-6]



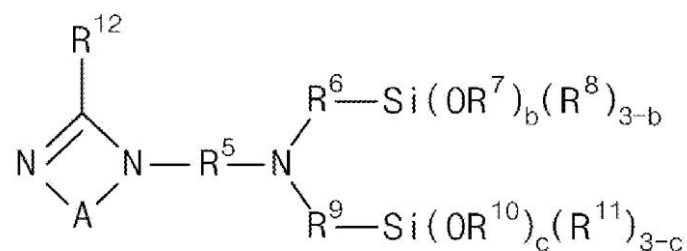
5

**[00101]** In Formula 2-1 to Formula 2-6, Me is a methyl group, and Et is an ethyl group.

**[00102]** In another embodiment, the amine-containing alkoxy-silane-based modifier may be a compound represented by

10 Formula 3 below.

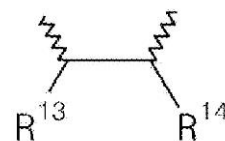
**[00103]** [Formula 3]



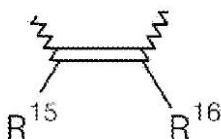
**[00104]** In Formula 3,  $\text{R}^5$ ,  $\text{R}^6$  and  $\text{R}^9$  may be each independently an alkylene group of 1 to 10 carbon atoms,  $\text{R}^7$ ,  $\text{R}^8$ ,  $\text{R}^{10}$  and  $\text{R}^{11}$  may be each independently an alkyl group of 1 to 10 carbon atoms,  $\text{R}^{12}$  may be hydrogen or an alkyl group of 1 to 10

15

carbon atoms, b and c may be each independently 1, 2 or 3,



where  $b+c \geq 4$  may be satisfied, and A may be

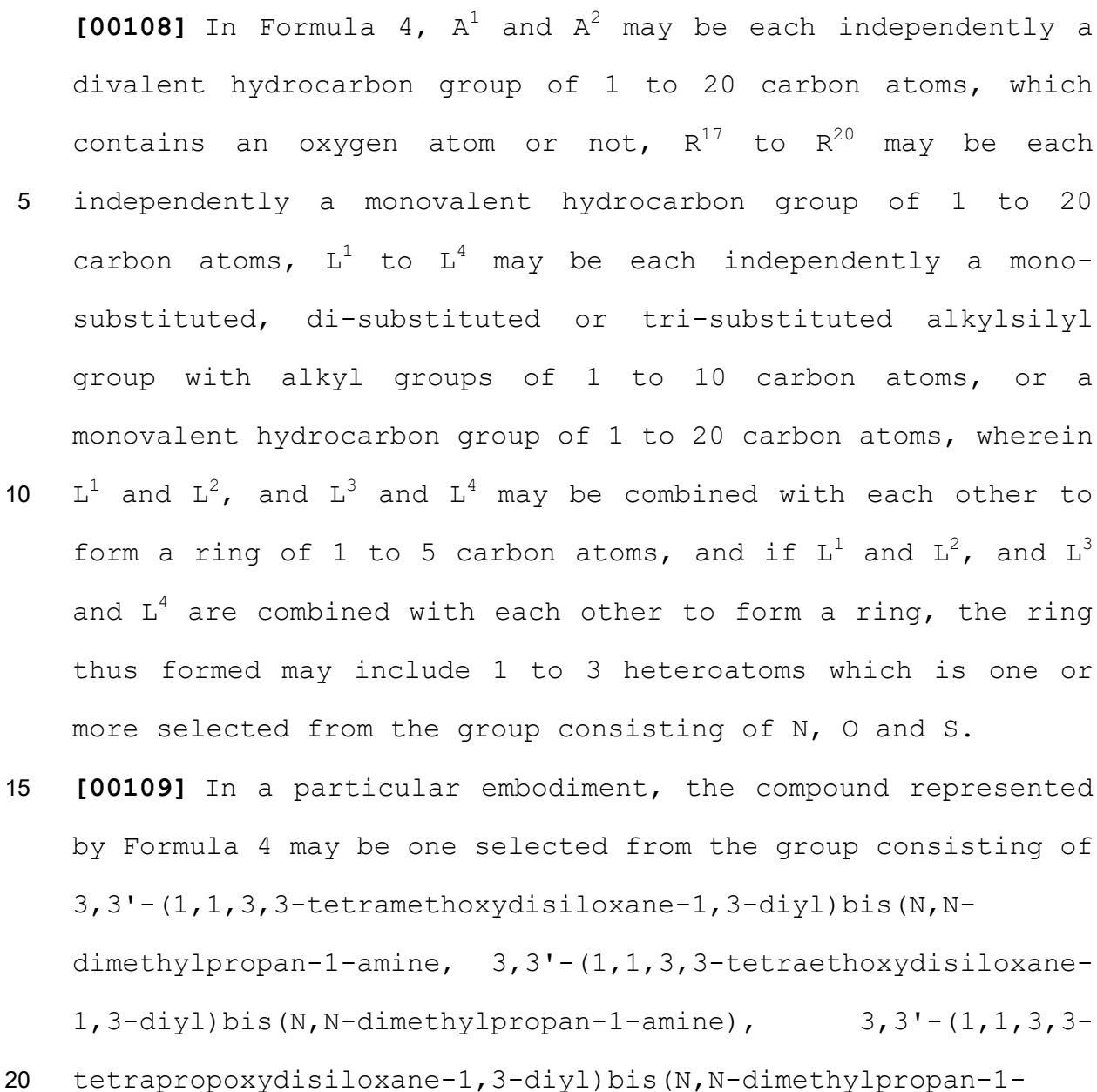


or , where  $R^{13}$ ,  $R^{14}$ ,  $R^{15}$  and  $R^{16}$  may be each independently hydrogen or an alkyl group of 1 to 10 carbon atoms.

**[00105]** In a particular embodiment, the compound represented by Formula 3 may be one selected from the group consisting of N-(3-(1H-imidazol-1-yl)propyl)-3-(triethoxysilyl)-N-(3-(triethoxysilyl)propyl)propan-1-amine and 3-(4,5-dihydro-1H-imidazol-1-yl)-N,N-bis(3-(triethoxysilyl)propyl)propan-1-amine.

**[00106]** In another embodiment, the amine-containing alkoxy silane-based modifier may be a compound represented by Formula 4 below.

**[00107]** [Formula 4]

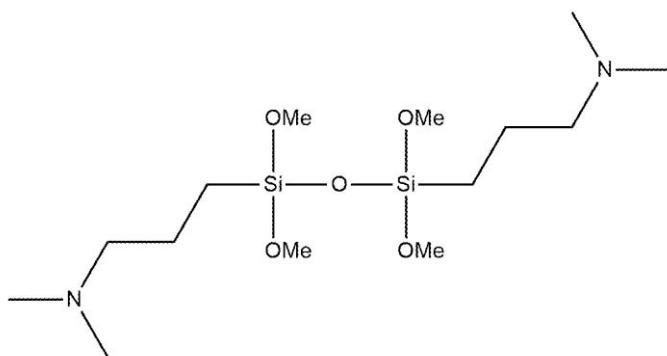


amine), 3,3'-(1,1,3,3-tetramethoxydisiloxane-1,3-  
 diyl)bis(N,N-diethylpropan-1-amine), 3,3'-(1,1,3,3-  
 tetramethoxydisiloxane-1,3-diyl)bis(N,N-dipropylpropan-1-  
 amine), 3,3'-(1,1,3,3-tetraethoxydisiloxane-1,3-diyl)bis(N,N-  
 5 diethylpropan-1-amine), 3,3'-(1,1,3,3-tetrapropoxydisiloxane-  
 1,3-diyl)bis(N,N-diethylpropan-1-amine), 3,3'-(1,1,3,3-  
 tetraethoxydisiloxane-1,3-diyl)bis(N,N-dipropylpropan-1-  
 amine), 3,3'-(1,1,3,3-tetrapropoxydisiloxane-1,3-  
 diyl)bis(N,N-dipropylpropan-1-amine), 3,3'-(1,1,3,3-  
 10 tetramethoxydisiloxane-1,3-diyl)bis(N,N-diethylmethan-1-  
 amine), 3,3'-(1,1,3,3-tetraethoxydisiloxane-1,3-diyl)bis(N,N-  
 diethylmethan-1-amine), 3,3'-(1,1,3,3-tetrapropoxydisiloxane-  
 1,3-diyl)bis(N,N-diethylmethan-1-amine), 3,3'-(1,1,3,3-  
 tetramethoxydisiloxane-1,3-diyl)bis(N,N-dimethylmethan-1-  
 15 amine), 3,3'-(1,1,3,3-tetramethoxydisiloxane-1,3-  
 diyl)bis(N,N-dipropylmethan-1-amine), 3,3'-(1,1,3,3-  
 tetrapropoxydisiloxane-1,3-diyl)bis(N,N-dimethylmethan-1-  
 amine), 3,3'-(1,1,3,3-tetrapropoxydisiloxane-1,3-  
 diyl)bis(N,N-dipropylmethan-1-amine), 3,3'-(1,1,3,3-  
 20 tetraethoxydisiloxane-1,3-diyl)bis(N,N-dimethylmethan-1-  
 amine), 3,3'-(1,1,3,3-tetraethoxydisiloxane-1,3-diyl)bis(N,N-  
 dipropylmethan-1-amine), N,N'-((1,1,3,3-  
 tetramethoxydisiloxane-1,3-diyl)bis(propan-3,1-  
 diyl))bis(1,1,1-trimethyl-N-(trimethylsilyl)silanamine),  
 25 N,N'-((1,1,3,3-tetraethoxydisiloxane-1,3-diyl)bis(propan-3,1-

diyl))bis(1,1,1-trimethyl-N-(trimethylsilyl)silanamine),  
 N,N'-((1,1,3,3-tetrapropoxydisiloxane-1,3-diyl)bis(propan-  
 3,1-diyl))bis(1,1,1-trimethyl-N-(trimethylsilyl)silanamine),  
 N,N'-((1,1,3,3-tetramethoxydisiloxane-1,3-diyl)bis(propan-  
 5 3,1-diyl))bis(1,1,1-trimethyl-N-phenylsilanamine), N,N'-  
 ((1,1,3,3-tetraethoxydisiloxane-1,3-diyl)bis(propan-3,1-  
 diyl))bis(1,1,1-trimethyl-N-phenylsilanamine), N,N'-  
 ((1,1,3,3-tetrapropoxydisiloxane-1,3-diyl)bis(propan-3,1-  
 diyl))bis(1,1,1-trimethyl-N-phenylsilanamine), 1,3-bis(3-(1H-  
 10 imidazol-1-yl)propyl)-1,1,3,3-tetramethoxydisiloxane, 1,3-  
 bis(3-(1H-imidazol-1-yl)propyl)-1,1,3,3-tetraethoxydisiloxane,  
 and 1,3-bis(3-(1H-imidazol-1-yl)propyl)-1,1,3,3-  
 tetrapropoxydisiloxane.

**[00110]** More particularly, the compound represented by  
 15 Formula 4 may be a compound represented by Formula 4-1 below.

**[00111]** [Formula 4-1]

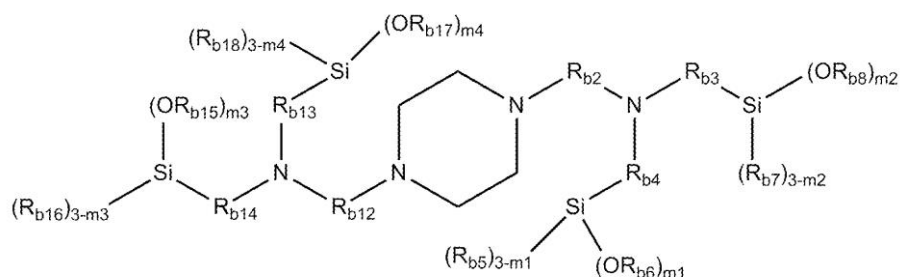


**[00112]** In Formula 4-1, Me is a methyl group.

**[00113]** In another embodiment, the amine-containing  
 20 alkoxydisilane-based modifier may be a compound represented by

Formula 5 below.

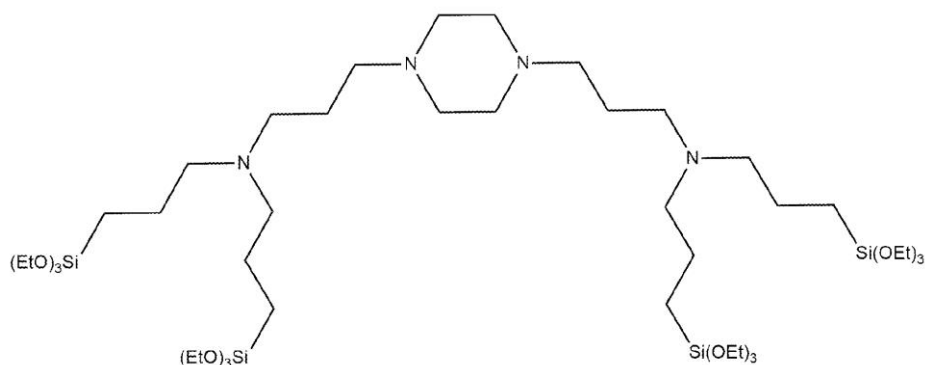
**[00114]** [Formula 5]



**[00115]** In Formula 5,  $R_{b2}$  to  $R_{b4}$  are each independently an  
 5 alkylene group of 1 to 10 carbon atoms,  $R_{b5}$  to  $R_{b8}$  are each  
 independently an alkyl group of 1 to 10 carbon atoms,  $R_{b13}$  and  
 $R_{b14}$  are each independently an alkylene group of 1 to 10  
 carbon atoms,  $R_{b15}$  to  $R_{b18}$  are each independently an alkyl  
 group of 1 to 10 carbon atoms, and  $m1$ ,  $m2$ ,  $m3$  and  $m4$  are each  
 10 independently an integer of 1 to 3.

**[00116]** Particularly, the compound represented by Formula 5  
 may be a compound represented by Formula 5-1 below.

**[00117]** [Formula 5-1]

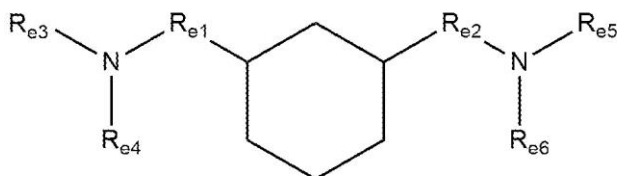


15 **[00118]** In Formula 5-1, Et is an ethyl group.

**[00119]** In another embodiment, the amine-containing

alkoxysilane-based modifier may be a compound represented by Formula 6 below.

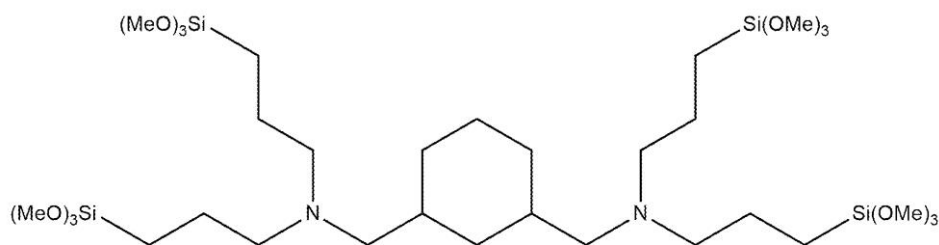
**[00120]** [Formula 6]



5 **[00121]** In Formula 6,  $R_{e1}$  and  $R_{e2}$  are each independently an alkylene group of 1 to 10 carbon atoms,  $R_{e3}$  to  $R_{e6}$  are each independently hydrogen, an alkyl group of 1 to 10 carbon atoms or  $-R_{e7}SiR_{e8}R_{e9}R_{e10}$ , where at least one among  $R_{e3}$  to  $R_{e6}$  is  $-R_{e7}SiR_{e8}R_{e9}R_{e10}$ , wherein  $R_{e7}$  is a single bond or an alkylene group of 1 to 10 carbon atoms,  $R_{e8}$  to  $R_{e10}$  are each independently an alkyl group of 1 to 10 carbon atoms or an alkoxy group of 1 to 10 carbon atoms, where at least one among  $R_{e8}$  to  $R_{e10}$  is an alkoxy group of 1 to 10 carbon atoms.

15 **[00122]** Particularly, the compound represented by Formula 6 may be a compound represented by Formula 6-1 below.

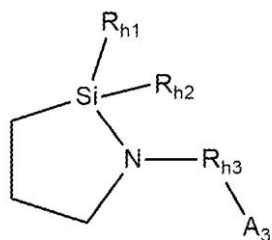
**[00123]** [Formula 6-1]



**[00124]** In Formula 6-1, Me is a methyl group.

**[00125]** In another embodiment, the amine-containing alkoxysilane-based modifier may be a compound represented by Formula 7 below.

**[00126]** [Formula 7]



5

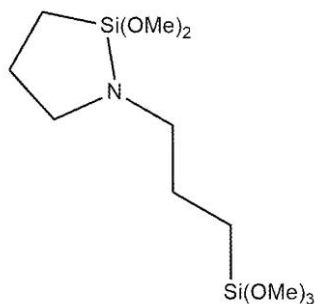
**[00127]** In Formula 7,  $R_{h1}$  and  $R_{h2}$  are each independently an alkyl group of 1 to 10 carbon atoms or an alkoxy group of 1 to 10 carbon atoms,  $R_{h3}$  is a single bond or an alkylene group of 1 to 10 carbon atoms, and  $A_3$  is  $-\text{Si}(\text{R}_{h4}\text{R}_{h5}\text{R}_{h6})$  or  $-\text{N}[\text{Si}(\text{R}_{h7}\text{R}_{h8}\text{R}_{h9})]_2$ , where  $R_{h4}$  to  $R_{h9}$  are each independently an alkyl group of 1 to 10 carbon atoms or an alkoxy group of 1 to 10 carbon atoms.

10

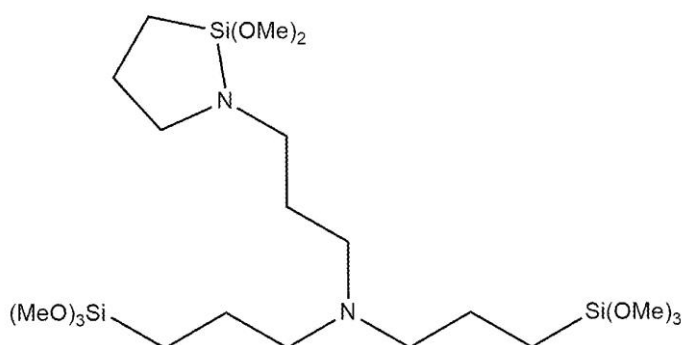
**[00128]** Particularly, the compound represented by Formula 7 may be a compound represented by Formula 7-1 or Formula 7-2 below.

15

**[00129]** [Formula 7-1]



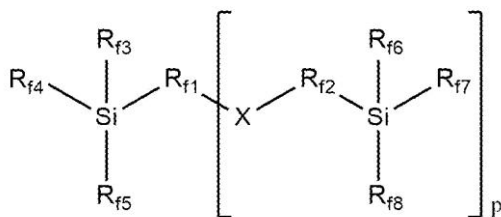
**[00130]** [Formula 7-2]



**[00131]** In Formulae 7-1 and 7-2, Me is a methyl group.

**[00132]** In another embodiment, the non-amine-containing  
5 alkoxy silane-based modifier may be a compound represented by  
Formula 8 below.

**[00133]** [Formula 8]



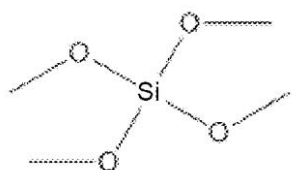
**[00134]** In Formula 8, X is O or S, R<sub>f1</sub> and R<sub>f2</sub> are each  
10 independently a single bond or an alkylene group of 1 to 10  
carbon atoms,

**[00135]** R<sub>f3</sub> to R<sub>f8</sub> are each independently hydrogen, an alkyl  
group of 1 to 10 carbon atoms, an alkoxy group of 1 to 10  
carbon atoms, an aryl group of 6 to 10 carbon atoms, a  
15 cycloalkyl group of 5 to 10 carbon atoms or an aralkyl group  
of 7 to 14 carbon atoms, and p is an integer of 0 or 1, where  
if p is 0, R<sub>f1</sub> is an alkyl group of 1 to 10 carbon atoms or

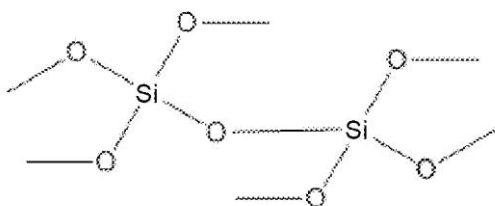
an alkoxy group of 1 to 10 carbon atoms.

**[00136]** Particularly, the compound represented by Formula 9 may be a compound represented by Formula 9-1 or Formula 9-2 below.

5 **[00137]** [Formula 9-1]

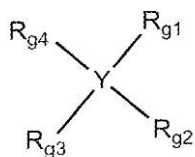


**[00138]** [Formula 9-2]



**[00139]** In another embodiment, the non-amine-containing  
10 alkoxysilane-based modifier may be a compound represented by Formula 10 below.

**[00140]** [Formula 10]

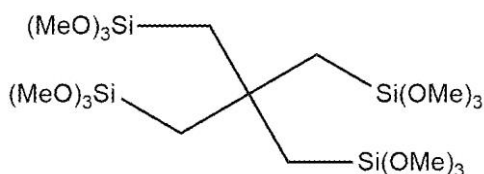


**[00141]** In Formula 10, R<sub>g1</sub> to R<sub>g4</sub> are each independently  
15 hydrogen, an alkyl group of 1 to 10 carbon atoms, an alkoxy group of 1 to 10 carbon atoms, an aryl group of 6 to 12 carbon atoms or -R<sub>g5</sub>Si(OR<sub>g6</sub>)<sub>r</sub>(R<sub>g7</sub>)<sub>3-r</sub>, where at least one among

$R_{g1}$  to  $R_{g4}$  is  $-R_{g5}Si(OR_{g6})_r(R_{g7})_{3-r}$ , wherein  $R_{g5}$  is a single bond or an alkylene group of 1 to 10 carbon atoms,  $R_{g6}$  and  $R_{g7}$  are each independently an alkyl group of 1 to 10 carbon atoms,  $r$  is 1 to 3, and  $Y$  is C or N, where if  $Y$  is N,  $R_{g4}$  is not present.

**[00142]** Particularly, the compound represented by Formula 10 may be a compound represented by Formula 10-1 below.

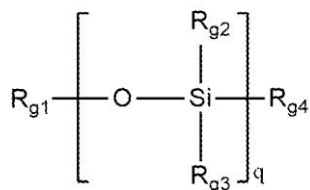
**[00143]** [Formula 10-1]



**[00144]** In Formula 10-1, Me is a methyl group.

**[00145]** In another embodiment, the non-amine-containing alkoxy silane-based modifier may be a compound represented by Formula 11 below.

**[00146]** [Formula 11]



**[00147]** In Formula 11,  $R_{g1}$  to  $R_{g3}$  are each independently an alkyl group of 1 to 10 carbon atoms or an alkoxy group of 1 to 10 carbon atoms,  $R_{g4}$  is an alkoxy group of 1 to 10 carbon atoms, and  $q$  is an integer of 2 to 100.

**[00148]** Particularly, in Formula 11,  $R_{g1}$  to  $R_{g3}$  are each

independently an alkyl group of 1 to 6 carbon atoms or an alkoxy group of 1 to 6 carbon atoms,  $R_{q4}$  is an alkoxy group of 1 to 6 carbon atoms, and q is an integer of 2 to 50.

5 **[00149]** Main parameter of modified conjugated diene-based polymer

**[00150]** In addition, the modified conjugated diene-based polymer according to an embodiment of the present invention may have the N content in a polymer of 150 ppm or more based  
10 on a weight according to NSX analysis and may have the Si content in a polymer of 180 ppm or more based on a weight according to ICP analysis.

**[00151]** Particularly, the modified conjugated diene-based polymer may have the Si content in a polymer based on a  
15 weight according to ICP analysis of 180 ppm or more, preferably, 190 ppm or more, more preferably, 200 ppm or more.

**[00152]** The Si content may be derived from the modifier, derived from the compound represented by Formula 1 and the modifier in some cases, and the Si content is may be a  
20 functional group present in a modified conjugated diene-based polymer, i.e., a main factor expected to improve the affinity with a filler, while improving processability.

**[00153]** According to an embodiment of the present invention, the modified conjugated diene-based polymer has the N content  
25 in a polymer according to NSX analysis of 150 ppm or more,

preferably, 160 ppm or more, more preferably, 170 ppm or more. The modified conjugated diene-based polymer may have the relatively high content of N atoms by the preparation method of serving the repeated presence of the functional group derived from the compound represented by Formula 1, for example, amine group, and may have a structure in which the functional group derived from the compound represented by Formula 1 is coupled with a polymer first chain through a derived unit from a modifier which is bonded to at least one terminal of the first chain, thereby markedly improving the affinity with a filler, for example, silica and dispersibility during a compounding process and achieving excellent viscoelasticity properties and at the same time, markedly improved processability.

**[00154]** In addition, due to such high content of N atoms, the modified conjugated diene-based polymer according to an embodiment of the present invention may have the molar ratio (N/Si) of N atoms and Si atoms of 0.75 or more. Generally, a polymer modified by a modifier may include an Si atom and an N atom due to a modification polymerization initiator, a modified monomer, etc., but as described above, since the polymer according to an embodiment of the present invention includes the repeating unit derived from the compound represented by Formula 1, the N content may be relatively large, and as consequent symbolic meaning, the molar ratio of

the N atom and the Si atom may be 0.75 or more, preferably, 0.77 or more, or 0.78 or more, more preferably, 0.8 or more, most optically, 0.9 or more. Through this, the processability improving effects according to the improvement  
5 of dispersibility during compounding may be optimized.

**[00155]** Also, according to an embodiment of the present invention, the modified conjugated diene-based polymer may have the change ratio of a mooney viscosity ( $MV_R$ ) according to Mathematical Formula 1 of 20% or less.

10 **[00156]** [Mathematical Formula 1]

$$MV_R = [(MV_f - MV_i)/MV_i] \times 100$$

**[00157]** In Mathematical Formula 1,  $MV_R$  is the change ratio of mooney viscosity,  $MV_f$  is a mooney viscosity at 100°C after standing the polymer at 25°C for 30 days, and  $MV_i$  is an  
15 initial mooney viscosity at 100°C of the polymer.

**[00158]** The change ratio of a mooney viscosity may be an index of noticing that the increase of the mooney viscosity generated during storage after preparation as well as processability, and the polymer according to the present  
20 invention may have improved processability, furthermore, excellent storage stability due to a low change ratio of a mooney viscosity even though storing for a long time, due to the structural characteristics with specific bonding structure of the second chain including the repeating unit  
25 derived from the compound represented by Formula 1, a derived

unit from a modifier and the first chain of the polymer.

**[00159]** The change ratio of a mooney viscosity is the change ratio between the initial mooney viscosity of a polymer and the mooney viscosity of the polymer after storing for 30 days at room temperature, and in the present invention, a polymer with 20% or less, preferably, 15% or less is provided. Here, the mooney viscosity is a mooney viscosity at 100°C, and may be measured by a common method applied in this technical field.

10

**[00160]** General details

**[00161]** In another embodiment, the modified conjugated diene-based polymer according to an embodiment of the present invention may have a number average molecular weight (Mn) of 1,000 g/mol to 2,000,000 g/mol, 10,000 g/mol to 1,000,000 g/mol, or 100,000 g/mol to 800,000 g/mol, a weight average molecular weight (Mw) of 1,000 g/mol to 3,000,000 g/mol, 10,000 g/mol to 2,000,000 g/mol, or 100,000 g/mol to 2,000,000 g/mol, and a peak average molecular weight (Mp) of 1,000 g/mol to 3,000,000 g/mol, 10,000 g/mol to 2,000,000 g/mol, or 100,000 g/mol to 2,000,000 g/mol. Within the ranges, excellent effects of rotation resistance and wet skid resistance may be achieved. In another embodiment, the modified conjugated diene-based polymer may have molecular weight distribution (PDI; MWD; Mw/Mn) of 1.0 to 3.0, or 1.1

25

to 2.5, or 1.1 to 2.0, and within this range, excellent effects of tensile properties, viscoelasticity properties, and balance between physical properties may be achieved.

5 [00162] Also, the modified conjugated diene-based polymer may have a mooney viscosity at 100°C of 30 or more, 40 to 150, or 40 to 140, and within this range, excellent effects of processability and productivity may be achieved.

[00163] Here, the mooney viscosity may be measured using a mooney viscometer. Particularly, the mooney viscosity may be  
10 measured by using MV-2000E of Monsanto Co. using Large Rotor at a rotor speed of  $2 \pm 0.02$  rpm at 100°C. In this case, a polymer was stood at room temperature ( $23 \pm 3^\circ\text{C}$ ) for 30 minutes or more, and  $27 \pm 3$  g of the polymer was collected and put in a die cavity, and then, Platen was operated while applying  
15 torque for measurement.

[00164] In addition, the vinyl content of the modified conjugated diene-based polymer may be 5 wt% or more, 10 wt% or more, or 10 wt% to 60 wt%. Here, the vinyl content may  
20 mean the amount of not 1,4-added but 1,2-added conjugated diene-based monomer with respect to 100 wt% of a conjugated diene-based copolymer composed of a monomer having a vinyl group and an aromatic vinyl-based monomer.

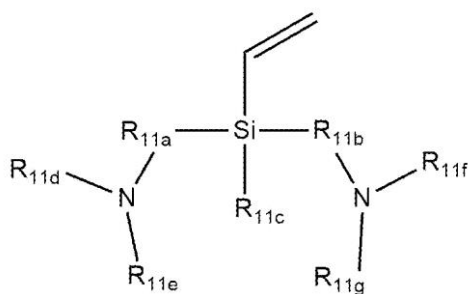
25 [00165] Method for preparing modified conjugated diene-based

**polymer**

[00166] In addition, the present invention provides a method for preparing a modified conjugated diene-based polymer.

[00167] The method for preparing the modified conjugated diene-based polymer according to an embodiment of the present invention is characterized in including polymerizing a conjugated diene-based monomer, or a conjugated diene-based monomer and an aromatic vinyl-based monomer in the presence of a polymerization initiator in a hydrocarbon solvent to prepare an active first chain (S1); reacting the active first chain with an alkoxy silane-based modifier to prepare a modified active first chain (S2); and reacting the modified active first chain and a macromonomer including a repeating unit derived from a compound represented by Formula 1 (S3) below.

[00168] [Formula 1]



[00169] In Formula 1, R<sub>11a</sub> to R<sub>11c</sub> are the same as described above.

[00170] In addition, the modifier, the conjugated diene-based monomer and the aromatic vinyl-based monomer are the same as

described above.

**[00171]** The hydrocarbon solvent is not specifically limited, but may be, for example, one or more selected from the group  
5 consisting of n-pentane, n-hexane, n-heptane, isooctane, cyclohexane, toluene, benzene and xylene.

**[00172]** The polymerization initiator is not specifically limited, but may be, for example, one or more selected from the group consisting of methyllithium, ethyllithium,  
10 propyllithium, isopropyllithium, n-butyllithium, s-butyllithium, t-butyllithium, hexyllithium, n-decyllithium, t-octyllithium, phenyllithium, 1-naphthyl lithium, n-eicosyl lithium, 4-butylphenyl lithium, 4-tolyl lithium, cyclohexyl lithium, 3,5-di-n-heptylcyclohexyl lithium, 4-cyclopentyl  
15 lithium, naphthyl sodium, naphthyl potassium, lithium alkoxide, sodium alkoxide, potassium alkoxide, lithium sulfonate, sodium sulfonate, potassium sulfonate, lithium amide, sodium amide, potassium amide, and lithium isopropylamide.

**[00173]** According to an embodiment of the present invention, the polymerization initiator may be used in 0.01 mmol to 10 mmol, 0.05 mmol to 5 mmol, 0.1 mmol to 2 mmol, 0.1 mmol to 1 mmol, or 0.15 to 0.8 mmol based on total 100 g of the monomer. Here, 100g of the monomer may represent the total amount of  
25 the conjugated diene-based monomer, or the conjugated diene-

based monomer and the aromatic vinyl-based monomer.

**[00174]** S1 step

**[00175]** The polymerization of step (S1) may be, for example,  
5 an anionic polymerization, and particularly, a living anionic  
polymerization by which an anionic active part is included at  
the polymerization terminal through a propagation  
polymerization reaction by anions. In addition, the  
polymerization of step (S1) may be a polymerization with  
10 heating, an isothermal polymerization, or a polymerization at  
a constant temperature (adiabatic polymerization). Here, the  
polymerization at a constant temperature means a  
polymerization method including a step of polymerizing using  
self-generated heat of reaction without optionally applying  
15 heat after adding a polymerization initiator, and the  
polymerization with heating means a polymerization method  
including injecting the polymerization initiator and then,  
increasing the temperature by optionally applying heat. The  
isothermal polymerization means a polymerization method by  
20 which the temperature of a polymer is kept constant by  
increasing heat by applying heat or taking heat after adding  
the polymerization initiator.

**[00176]** In addition, according to an embodiment of the  
present invention, the polymerization of step (S1) may be  
25 performed by further adding a diene-based compound of 1 to 10

carbon atoms in addition to the conjugated diene-based monomer, and in this case, effects of preventing the formation of gel on the wall of a reactor during operation for a long time may be achieved. The diene-based compound  
5 may be, for example, 1,2-butadiene.

**[00177]** The polymerization of step (S1) may be performed in a temperature range of, for example, 80°C or less, -20°C to 80°C, 0°C to 80°C, 0°C to 70°C, or 10°C to 70°C, and within the range, the molecular weight distribution of a polymer is  
10 controlled narrow, and the improving effects of physical properties were excellent.

**[00178]** The active polymer chain prepared by step (S1) may mean a polymer in which a polymer anion and an organometallic cation are coupled.

15  
**[00179]** Meanwhile, the polymerization of step (S1) may be performed by including a polar additive, and the polar additive may be added in a ratio of 0.001 g to 50 g, 0.001 g to 10 g or 0.005 g to 0.1 g based on total 100 g of the  
20 monomer. In another embodiment, the polar additive may be added in a ratio of 0.001 g to 10 g, 0.005 g to 5 g, 0.005 g to 4 g based on total 1 mmol of the polymerization initiator.

**[00180]** The polar additive may be, for example, one or more selected from the group consisting of tetrahydrofuran, 2,2-  
25 di(2-tetrahydrofuryl)propane, diethyl ether, cyclopentyl

ether, dipropyl ether, ethylene methyl ether, ethylene dimethyl ether, diethyl glycol, dimethyl ether, tert-butoxy ethoxy ethane, bis(3-dimethylaminoethyl)ether, (dimethylaminoethyl) ethyl ether, trimethylamine, triethylamine, tripropylamine, N,N,N',N'-tetramethylethylenediamine, sodium mentholate and 2-ethyl tetrahydrofurfuryl ether, preferably, 2,2-di(2-tetrahydrofuryl)propane, triethylamine, tetramethylethylenediamine, sodium mentholate or 2-ethyl tetrahydrofurfuryl ether. If the polar additive is included, and if a conjugated diene-based monomer and an aromatic vinyl-based monomer are copolymerized, the difference of their reaction rates may be compensated, and effects of inducing easy formation of a random copolymer may be achieved.

**[00181]** S2 step

**[00182]** The (S2) step is a step of reacting the active first chain with a modifier to prepare a modified active first chain, and here, the reaction may be modification or coupling reaction, and in this case, the modifier may be used in an amount of 0.01 mmol to 10 mmol based on total 100 g of the monomer. In another embodiment, the modifier may be used in a molar ratio of 1:0.1 to 10, 1:0.1 to 5, or 1:0.1 to 1:3, based on 1 mol of the polymerization initiator in step (S1).

**[00183]** S3 step

**[00184]** In addition, the (S3) step is a step of reacting the active first chain with a macromonomer including the repeating unit derived from the compound represented by Formula 1 to prepare a modified conjugated diene-based polymer.

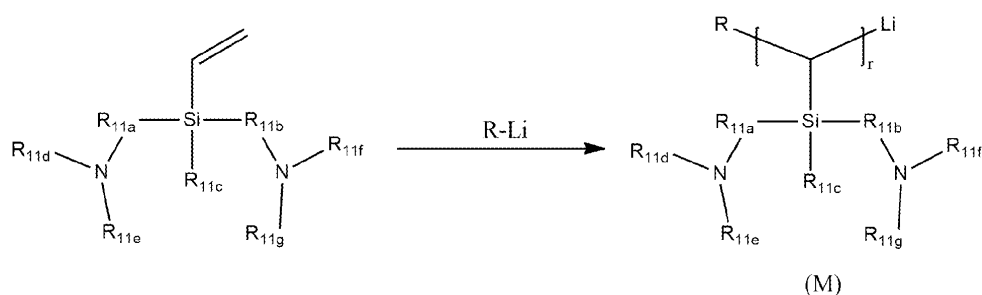
**[00185]** Meanwhile, the preparation method according to an embodiment of the present invention may further include a step of preparing a macromonomer prior to the (S3) step, and the step for preparing the macromonomer may be performed by performing polymerization reaction of the compound represented by Formula 1 or the compound represented by Formula 1 and a conjugated diene-based monomer in the presence of an organolithium compound in a hydrocarbon solvent. In this case, the polymerization reaction may be a living anionic polymerization to give an anionic active part at the polymerization terminal by the propagation polymerization reaction by anions, and the macromonomer may be a living anion terminal of which one terminal is capable of acting as a monomer.

**[00186]** Here, the organolithium compound may be an alkyl lithium compound, and may particularly be methyl lithium, ethyl lithium, propyl lithium, isopropyl lithium, n-butyl lithium, s-butyl lithium, t-butyl lithium, hexyl lithium, n-decyl lithium, t-octyl lithium, phenyl lithium, 1-naphthyl lithium, n-eicosyl

lithium, 4-butylphenyl lithium, 4-tolyl lithium, cyclohexyl lithium, 3,5-di-n-heptylcyclohexyl lithium, or 4-cyclopentyl lithium, more particularly, n-butyllithium.

**[00187]** In an embodiment, the macromonomer may be prepared through Reaction 1 below and may be a compound having a structure represented by Formula M below.

**[00188]** [Reaction 1]



**[00189]** In Reaction 1,  $R_{11a}$  to  $R_{11g}$  are the same as defined in Formula 1,  $R-Li$  is an alkyllithium compound, and  $R$  is an alkyl group derived from the alkyllithium.

**[00190]** In addition, the macromonomer may include 1 to 80, 1 to 60, or 1 to 50 repeating units derived from the compound represented by Formula 1, and for example, in Formula M,  $r$  may be 1 to 80, 1 to 60, or 1 to 50. In this case, the processability, tensile properties and viscoelasticity properties of the modified conjugated diene-based polymer including the second chain derived from the macromonomer may be excellent in balance.

**[00191]** Meanwhile, the (S3) step may be for preparing a

modified conjugated diene-based polymer by reacting the modified active polymer and the macromonomer, i.e., the functional group derived from a modifier in the modified active polymer and the living anion terminal of the macromonomer.

**[00192]** Particularly, the modified active polymer first chain prepared in the (S2) step includes the functional group derived from a modifier, and the functional group derived from the modifier includes an alkoxy group not reacted with a polymer chain but remaining, and accordingly, through the reaction of the living anion terminal of the macromonomer and the alkoxy group, the modified conjugated diene-based polymer may be prepared.

**[00193]** In addition, the macromonomer may be used in 0.1 to 4.0 mol, 0.1 to 2.0 mol, or 0.5 to 1.5 mol based on 1 mol of the polymerization initiator.

**[00194]** Meanwhile, as a conventional method for additionally introducing a functional group to a polymer, an active polymer has been modified with a modifier, and performing condensation reaction of reacting a compound capable of condensing with the Si-O bond of the modifier has been applied. However, if such condensation reaction is used, the bond between a material having an additional functional group and the modified active polymer is formed as -Si-O-Si, and

there are probability of arising hydrolysis during subsequent steam stripping step, washing step or storing, and accordingly, there are problems of separating the bond around a condensation bonding part, and at last, the losing a functional group.

[00195] On the contrary, in the modified conjugated diene-based polymer prepared by the preparation method according to the present invention, the living terminal of the macromonomer reacts with the Si-O-R group of the modifier to form a Si-C bond, and this bond is a bond not undergoing hydrolysis reaction like a condensed bond and is free from separation. Accordingly, there may be advantages in that storage stability is improved, and the generation of defects of losing an initially introduced functional group does not arise.

#### [00196] Rubber Composition

[00197] Also, the present invention provides a rubber composition including the modified conjugated diene-based polymer.

[00198] The rubber composition may include the modified conjugated diene-based polymer in an amount of 10 wt% or more, 10 wt% to 100 wt%, or 20 wt% to 90 wt%, and within this range, mechanical properties such as tensile strength and abrasion resistance are excellent, and effects of excellent balance

between physical properties may be achieved.

**[00199]** In addition, the rubber composition may further include other rubber component, as necessary, in addition to the modified conjugated diene-based polymer, and in this case, 5 the rubber component may be included in an amount of 90 wt% or less based on the total weight of the rubber composition. In a particular embodiment, the rubber component may be included in an amount of 1 part by weight to 900 parts by weight based on 100 parts by weight of the modified 10 conjugated diene-based polymer.

**[00200]** The rubber component may be, for example, a natural rubber or a synthetic rubber, and may particularly be a natural rubber (NR) including cis-1,4-polyisoprene; a modified natural rubber which is obtained by modifying or 15 purifying a common natural rubber, such as an epoxidized natural rubber (ENR), a deproteinized natural rubber (DPNR), and a hydrogenated natural rubber; and a synthetic rubber such as a styrene-butadiene copolymer (SBR), a polybutadiene (BR), a polyisoprene (IR), a butyl rubber (IIR), an ethylene- 20 propylene copolymer, a polyisobutylene-co-isoprene, a neoprene, a poly(ethylene-co-propylene), a poly(styrene-co-butadiene), a poly(styrene-co-isoprene), a poly(styrene-co-isoprene-co-butadiene), a poly(isoprene-co-butadiene), a poly(ethylene-co-propylene-co-diene), a polysulfide rubber, 25 an acryl rubber, a urethane rubber, a silicone rubber, an

epichlorohydrin rubber, and a halogenated butyl rubber, and any one among them or mixtures of two or more thereof may be used.

**[00201]** The rubber composition may include a filler of 0.1 parts by weight to 200 parts by weight, or 10 parts by weight to 120 parts by weight based on 100 parts by weight of the modified conjugated diene-based polymer of the present invention. The filler may be, for example, a silica-based filler, particularly, wet silica (hydrated silicate), dry silica (anhydrous silicate), calcium silicate, aluminum silicate, or colloid silica. Preferably, the filler may be wet silica which has the most significant improving effect of destruction characteristics and compatible effect of wet grip. In addition, the rubber composition may further include a carbon-based filler, as necessary.

**[00202]** In another embodiment, if silica is used as the filler, a silane coupling agent may be used together for the improvement of reinforcing and low exothermic properties. Particular examples of the silane coupling agent may include

|                                          |        |
|------------------------------------------|--------|
| bis(3-triethoxysilylpropyl)tetrasulfide, | bis(3- |
| triethoxysilylpropyl)trisulfide,         | bis(3- |
| triethoxysilylpropyl)disulfide,          | bis(2- |
| triethoxysilylethyl)tetrasulfide,        | bis(3- |
| trimethoxysilylpropyl)tetrasulfide,      | bis(2- |
| trimethoxysilylethyl)tetrasulfide,       | 3-     |

mercaptopropyltrimethoxysilane, 3-  
 mercaptopropyltriethoxysilane, 2-  
 mercaptoethyltrimethoxysilane, 2-mercaptoethyltriethoxysilane,  
 3-trimethoxysilylpropyl-N,N-dimethylthiocarbamoyltetrasulfide,  
 5 3-triethoxysilylpropyl-N,N-dimethylthiocarbamoyltetrasulfide,  
 2-triethoxysilylethyl-N,N-dimethylthiocarbamoyltetrasulfide,  
 3-trimethoxysilylpropylbenzothiazolyltetrasulfide, 3-  
 triethoxysilylpropylbenzolyltetrasulfide, 3-  
 triethoxysilylpropylmethacrylatemonosulfide, 3-  
 10 trimethoxysilylpropylmethacrylatemonosulfide, bis(3-  
 diethoxymethylsilylpropyl) tetrasulfide, 3-  
 mercaptopropyldimethoxymethylsilane,  
 dimethoxymethylsilylpropyl-N,N-  
 dimethylthiocarbamoyltetrasulfide, or  
 15 dimethoxymethylsilylpropylbenzothiazolyltetrasulfide, and any  
 one among them or mixtures of two or more thereof may be used.  
 Preferably, bis(3-triethoxysilylpropyl)polysulfide or 3-  
 trimethoxysilylpropylbenzothiazyltetrasulfide may be used in  
 consideration of the improving effect of reinforcing  
 20 properties.

**[00203]** In addition, in the rubber composition according to  
 an embodiment of the present invention, since a modified  
 conjugated diene-based polymer in which a functional group  
 having high affinity with silica is introduced into an active  
 25 part is used as a rubber component, the compounding amount of

the silane coupling agent may be smaller than a common case. Thus, the silane coupling agent may be used in an amount of 1 part by weight to 20 parts by weight, or 5 parts by weight to 15 parts by weight based on 100 parts by weight of silica.

5 Within the above amount range, effects as a coupling agent may be sufficiently exhibited, and preventing effects of gelation of a rubber component may be achieved.

**[00204]** The rubber composition according to an embodiment of the present invention may be sulfur crosslinkable, and so may  
10 further include a vulcanizing agent. The vulcanizing agent may particularly be a sulfur powder and may be included in an amount of 0.1 parts by weight to 10 parts by weight based on 100 parts by weight of the rubber component. Within the above amount range, elasticity and strength required for a  
15 vulcanized rubber composition may be secured, and at the same time, an excellent low fuel consumption ratio may be achieved.

**[00205]** The rubber composition according to an embodiment of the present invention may further include various additives used in a common rubber industry in addition to the above  
20 components, particularly, a vulcanization accelerator, a process oil, an antioxidant, a plasticizer, an antiaging agent, a scorch preventing agent, a zinc white, stearic acid, a thermosetting resin, or a thermoplastic resin.

**[00206]** The vulcanization accelerator may include, for  
25 example, thiazole-based compounds such as 2-

mercaptobenzothiazole (M), dibenzothiazyl disulfide (DM), and N-cyclohexyl-2-benzothiazylsulfenamide (CZ), or guanidine-based compounds such as diphenylguanidine (DPG), in an amount of 0.1 parts by weight to 5 parts by weight based on 100 parts by weight of the rubber component.

**[00207]** The process oil acts as a softener in a rubber composition and may include, for example, a paraffin-based, naphthene-based, or aromatic compound. An aromatic process oil may be used in consideration of tensile strength and abrasion resistance, and a naphthene-based or paraffin-based process oil may be used in consideration of hysteresis loss and properties at a low temperature. The process oil may be included in an amount of 100 parts by weight or less based on 100 parts by weight of the rubber component. Within the above-described range, the deterioration of the tensile strength and low exothermic properties (low fuel consumption ratio) of the vulcanized rubber may be prevented.

**[00208]** The antioxidant may include, for example, 2,6-di-*t*-butyl paracresol, dibutylhydroxytoluenyl, 2,6-bis((dodecylthio)methyl)-4-nonylphenol or 2-methyl-4,6-bis((octylthio)methyl)phenol, and may be used in an amount of 0.1 parts by weight to 6 parts by weight based on 100 parts by weight of the rubber component.

**[00209]** The antiaging agent may include, for example, N-isopropyl-N'-phenyl-p-phenylenediamine, N-(1,3-

dimethylbutyl)-N'-phenyl-p-phenylenediamine, 6-ethoxy-2,2,4-trimethyl-1,2-dihydroquinoline, or a condensate of diphenylamine and acetone at a high temperature, in an amount of 0.1 parts by weight to 6 parts by weight based on 100 parts by weight of the rubber component.

[00210] The rubber composition according to an embodiment of the present invention may be obtained by mulling using a mulling apparatus such as a banbury mixer, a roll, and an internal mixer according to a compounding prescription. A rubber composition having low exothermic properties and good abrasion properties may be obtained by a vulcanization process after a molding process.

[00211] Therefore, the rubber composition may be useful to the manufacture of each member of a tire such as a tire tread, an under tread, a side wall, a carcass coating rubber, a belt coating rubber, a bead filler, a chafer, and a bead coating rubber, or to the manufacture of rubber products in various industries such as a vibration-proof rubber, a belt conveyor, and a hose.

[00212] Also, the present invention provides a tire manufactured using the rubber composition.

[00213] The tire may include a tire or a tire tread.

[00214] **Examples**

[00215] Hereinafter, the present invention will be explained in more detail referring to embodiments. However, embodiments according to the present invention may be modified into various other types, and the scope of the present invention should not be limited to the embodiments described below. The embodiments of the present invention are provided for completely explaining the present invention to a person having an average knowledge in the art.

**[00216] Experiment #1**

**[00217] Preparation Example 1**

[00218] To a 500 ml, round-bottom flask, 100 ml of tetrahydrofuran and 1 g of n-butyllithium (10 wt% in n-hexane) were added, N,N,N',N',1-pentamethyl-1-vinylsilanedi-  
amine (molar ratio of 3 mol in contrast to 1 mol of [act. Li]) was added, followed by reacting at 10°C for 30 minutes to prepare a solution containing a macromonomer (15.6 mmol/l). Through GC analysis, N,N,N',N',1-pentamethyl-1-vinylsilanedi-  
amine was not detected after the reaction, and the achievement of the reaction was secured.

**[00219] Preparation Example 2**

[00220] A solution containing a macromonomer (15.6 mmol/l) was prepared by the same method in Preparation Example 1 except for reacting N,N,N',N'-tetraethyl-1-methyl-1-vinylsilanedi-  
amine (molar ratio of 3 mol in contrast to 1 mol

of [act. Li]) instead of N,N,N',N',1-pentamethyl-1-vinylsilanedi-  
amine in Preparation Example 1. Through GC  
analysis, N,N,N',N'-tetraethyl-1-methyl-1-vinylsilanedi-  
amine was not detected after the reaction, and the achievement of  
5 the reaction was secured.

**[00221] Example 1**

**[00222]** To a 20 L, autoclave reactor, 3 kg of n-hexane, 215 g  
of styrene, 745 g of 1,3-butadiene and 1.29 g of 2,2-bis(2-  
10 oxolanyl)propane as a polar additive were injected, then, 3.2  
g of n-butyllithium (10 wt% in n-hexane) was injected, the  
internal temperature of the reactor was adjusted to 60°C, and  
an adiabatic reaction with heating was performed. After  
about 30 minutes lapse, 39 g of 1,3-butadiene was injected  
15 for capping the terminals of a polymer with butadiene. After  
about 10 minutes, N,N-diethyl-3-(trimethoxysilyl)propan-1-  
amine was injected as a modifier and reacted for 15 minutes  
(molar ratio of [DTP]:[act. Li] = 1.5:1, molar ratio of  
[modifier]:[act. Li] = 0.7:1). Then, the solution containing  
20 the macromonomer prepared in Preparation Example 1 was added  
and reacted for 15 minutes (molar ratio of [act.  
Li]:[macromonomer] = 1:1), and the reaction was quenched  
using ethanol. 33 g of a solution in which 30 wt% of  
Wingstay K antioxidant was dissolved in hexane was added  
25 thereto. The polymer thus obtained was injected into hot

water heated using steam and stirred to remove solvents and roll dried to remove remaining solvents and water to prepare a modified styrene-butadiene copolymer.

5    **[00223] Example 2**

**[00224]** A modified styrene-butadiene copolymer was prepared by performing the same method in Example 1 except for adding the solution containing a macromonomer prepared in Preparation Example 2 as the macromonomer in Example 1 (molar  
10    ratio of [act. Li]:[macromonomer] = 1:1).

**[00225] Example 3**

**[00226]** A modified styrene-butadiene copolymer was prepared by performing the same method in Example 1 except for using  
15    N,N-bis(3-(triethoxysilyl)propyl)-3,6,9,12,15-pentaoxanonadecan-1-amine instead of N,N-diethyl-3-(trimethoxysilyl)propan-1-amine as a modifier in Example 1 (molar ratio of [modifier]:[act Li] = 0.7:1).

20    **[00227] Example 4**

**[00228]** A modified styrene-butadiene copolymer was prepared by performing the same method in Example 1 except for using  
3,3'-(1,1,3,3-tetramethoxydisiloxane-1,3-diyl)bis(N,N-diethylpropan-1-amine) instead of N,N-diethyl-3-(trimethoxysilyl)propan-1-amine as a modifier in Example 1  
25

(molar ratio of [modifier]:[act Li] = 0.7:1).

**[00229] Example 5**

**[00230]** A modified styrene-butadiene copolymer was prepared  
5 by performing the same method in Example 1 except for using  
3,3'-(piperazine-1,4-diyl)bis(N,N-bis(3-  
triethoxysilyl)propyl)propan-1-amine) instead of N,N-diethyl-  
3-(trimethoxysilyl)propan-1-amine as a modifier in Example 1  
(molar ratio of [modifier]:[act Li] = 0.7:1), and adding the  
10 solution containing a macromonomer prepared in Preparation  
Example 2 as a macromonomer (molar ratio of [act.  
Li]:[macromonomer] = 1:1).

**[00231] Comparative Example 1**

15 **[00232]** A modified styrene-butadiene copolymer was prepared  
by performing the same method in Example 1 except for using  
the solution containing a macromonomer prepared in  
Preparation Example 1 instead of the n-butyllithium in  
Example 1 such that the mol of the macromonomer injected was  
20 the same as the n-butyllithium in Example 1, performing the  
adiabatic reaction with heating, not performing a subsequent  
step of adding a modifier and a macromonomer and reacting,  
and quenching the reaction after capping with butadiene.

25 **[00233] Comparative Example 2**

**[00234]** To a 20 L, autoclave reactor, 3 kg of n-hexane, 215 g of styrene, 745 g of 1,3-butadiene and 1.29 g of 2,2-bis(2-oxolanyl)propane as a polar additive were injected, then, 3.2 g of n-butyllithium (10 wt% in n-hexane) was injected, the internal temperature of the reactor was adjusted to 60°C, and an adiabatic reaction with heating was performed. After about 30 minutes lapse, 39 g of 1,3-butadiene was injected for capping the terminals of a polymer with butadiene. After about 10 minutes, N,N-diethyl-3-(trimethoxysilyl)propan-1-amine was injected as a modifier and reacted for 15 minutes (molar ratio of [DTP]:[act. Li] = 1.5:1, molar ratio of [modifier]:[act. Li] = 0.7:1). Then, the reaction was quenched using ethanol. 33 g of a solution in which 30 wt% of Wingstay K antioxidant was dissolved in hexane was added thereto. The polymer thus obtained was injected into hot water heated using steam and stirred to remove solvents and roll dried to remove remaining solvents and water to prepare a modified styrene-butadiene copolymer.

### 20 **[00235] Comparative Example 3**

**[00236]** A modified styrene-butadiene copolymer was prepared by performing the same method in Comparative Example 2 except for using 3,3'-(1,1,3,3-tetramethoxydisiloxane-1,3-diyl)bis(N,N-diethylpropan-1-amine) instead of N,N-diethyl-3-(trimethoxysilyl)propan-1-amine as a modifier in Comparative

Example 2 (molar ratio of [modifier]:[act. Li] = 0.7:1).

**[00237] Comparative Example 4**

**[00238]** A modified styrene-butadiene copolymer was prepared  
5 by performing the same method in Comparative Example 2 except  
for using N,N-bis(3-(triethoxysilyl)propyl)-3,6,9,12,15-  
pentaioxanonadecan-1-amine instead of N,N-diethyl-3-  
(trimethoxysilyl)propan-1-amine as a modifier in Comparative  
Example 2 (molar ratio of [modifier]:[act. Li] = 0.7:1).

10

**[00239] Comparative Example 5**

**[00240]** A modified styrene-butadiene copolymer was prepared  
by performing the same method in Comparative Example 2 except  
for using the solution containing a macromonomer prepared in  
15 Preparation Example 1 instead of the n-butyllithium in  
Comparative Example 2 such that the mol of the macromonomer  
injected was the same as the n-butyllithium in Comparative  
Example 2, and performing the adiabatic reaction with heating  
(molar ratio of [DTP]:[act. Li] = 1.5:1, molar ratio of  
20 [modifier]:[act Li] = 0.7:1).

**[00241] Comparative Example 6**

**[00242]** A modified styrene-butadiene copolymer was prepared  
by performing the same method in Comparative Example 5 except  
25 for using the solution containing a macromonomer prepared in

Preparation Example 2 instead of the solution containing a macromonomer prepared in Preparation Example 1 in Comparative Example 5, performing the adiabatic reaction with heating, using 3,3'-(piperazine-1,4-diyl)bis(N,N-bis(3-(triethoxysilyl)propyl)propan-1-amine instead of N,N-diethyl-3-(trimethoxysilyl)propan-1-amine as a modifier, and reacting for 15 minutes (molar ratio of [DTP]:[act Li] = 1.5:1, molar ratio of [modifier]:[act. Li] = 0.7:1).

10 **[00243] Evaluation of properties of polymers**

**[00244]** With respect to each of the modified styrene-butadiene copolymers prepared in the Examples and Comparative Examples, the styrene unit and vinyl contents in each polymer, a weight average molecular weight ( $M_w$ ,  $\times 10^3$  g/mol), a number average molecular weight ( $M_n$ ,  $\times 10^3$  g/mol), molecular weight distribution (PDI, MWD), mooney viscosity (MV), the change rate of mooney viscosity, and the Si and N contents were measured, respectively. The results are shown in Table 1 below.

20 **[00245] 1) Styrene unit and vinyl contents (wt%)**

**[00246]** The styrene unit (SM) and vinyl contents in each polymer were measured and analyzed using Varian VNMRs 500 MHz NMR.

**[00247]** When measuring NMR, 1,1,2,2-tetrachloroethane was used as a solvent, and styrene unit and vinyl contents were

calculated by calculating a solvent peak as 5.97 ppm, and regarding 7.2-6.9 ppm as random styrene peaks, 6.9-6.2 ppm as block styrene peaks, 5.8-5.1 ppm as 1,4-vinyl peaks, and 5.1-4.5 ppm as 1,2-vinyl peaks.

5

**[00248]** 2) Weight average molecular weight ( $M_w$ ,  $\times 10^3$  g/mol), number average molecular weight ( $M_n$ ,  $\times 10^3$  g/mol), and molecular weight distribution (PDI, MWD)

**[00249]** By gel permeation chromatography (GPC) analysis, a  
10 weight average molecular weight ( $M_w$ ) and a number average molecular weight ( $M_n$ ) were measured and a molecular weight distribution curve was obtained. In addition, molecular weight distribution (PDI, MWD,  $M_w/M_n$ ) was calculated from each molecular weight thus measured. Particularly, GPC was  
15 conducted using two columns of PLgel Olexis (Polymer Laboratories Co.) and one column of PLgel mixed-C (Polymer Laboratories Co.) in combination, and polystyrene (PS) as a GPC standard material for calculating the molecular weights. A solvent for measuring GPC was prepared by mixing  
20 tetrahydrofuran with 2 wt% of an amine compound.

**[00250]** 3) Mooney viscosity

**[00251]** The mooney viscosity (MV, (ML1+4, @100°C) MU) was measured by using MV-2000 (ALPHA Technologies Co.) using  
25 Large Rotor at a rotor speed of  $2 \pm 0.02$  rpm at 100°C. In this

case, a specimen used was stood at room temperature ( $23\pm 3^{\circ}\text{C}$ ) for 30 minutes or more, and  $27\pm 3$  g of the specimen was collected and put in a die cavity, and then, Platen was operated for 4 minutes for measurement.

5

**[00252]** 4) Si content

**[00253]** The Si content was measured by an ICP analysis method, which used an inductively coupled plasma optical emission spectroscopy (ICP-OES; Optima 7300DV). Particularly,  
10 measurement was performed by adding about 0.7 g of a specimen to a platinum (Pt) crucible and adding about 1 mL of concentrated sulfuric acid (98 wt%, electronic grade) thereto, heating at  $300^{\circ}\text{C}$  for 3 hours, incinerating the specimen in an electrical furnace (Thermo Scientific, Lindberg Blue M) by  
15 the following program of steps 1 to 3:

**[00254]** 1) step 1: initial temp  $0^{\circ}\text{C}$ , rate (temp/hr)  $180^{\circ}\text{C/hr}$ , temp (holdtime)  $180^{\circ}\text{C}$  (1hr)

**[00255]** 2) step 2: initial temp  $180^{\circ}\text{C}$ , rate (temp/hr)  $85^{\circ}\text{C/hr}$ , temp (holdtime)  $370^{\circ}\text{C}$  (2hr)

20 **[00256]** 3) step 3: initial temp  $370^{\circ}\text{C}$ , rate (temp/hr)  $47^{\circ}\text{C/hr}$ , temp (holdtime)  $510^{\circ}\text{C}$  (3hr),

**[00257]** adding 1 mL of concentrated nitric acid (48 wt%) and 20  $\mu\text{l}$  of concentrated hydrofluoric acid (50 wt%) to a residue, sealing the platinum crucible and shaking for 30 minutes or  
25 more, adding 1 mL of boric acid to the specimen, storing at

0°C for 2 hours or more, diluting in 30 mL of ultrapure water, and performing incineration.

**[00258]** 5) N content

5 **[00259]** The N content was measured through an NSX analysis method using a quantitative analyzer of a trace amount of nitrogen (NSX-2100H). Particularly, the quantitative analyzer of a trace amount of nitrogen (Auto sampler, Horizontal furnace, PMT & Nitrogen detector) was turned on,  
10 carrier gas flow amounts were set to 250 ml/min for Ar, 350 ml/min for O<sub>2</sub>, and 300 ml/min for ozonizer, a heater was set to 800°C, and the analyzer was stood for about 3 hours for stabilization. After stabilizing the analyzer, a calibration curve of calibration curve ranges of 5 ppm, 10 ppm, 50 ppm,  
15 100 ppm and 500 ppm was made using Nitrogen standard (AccuStandard S-22750-01-5 ml), and an area corresponding to each concentration was obtained. Then, by using the ratios of concentrations to areas, a straight line was made. After that, a ceramic boat holding 20 mg of a specimen was put in  
20 the auto sampler of the analyzer and measurement was conducted to obtain an area. By using the area of the specimen thus obtained and the calibration curve, the N content was calculated.

**[00260]** [Table 1]

| Division                 |                                   | Example |      |      |          |          | Comparative Example |          |          |               |          |      |
|--------------------------|-----------------------------------|---------|------|------|----------|----------|---------------------|----------|----------|---------------|----------|------|
|                          |                                   | 1       | 2    | 3    | 4        | 5        | 1                   | 2        | 3        | 4             | 5        | 6    |
| NMR<br>(wt%)             | SM                                | 20.9    | 20.8 | 21.0 | 21<br>.0 | 21<br>.3 | 20<br>.6            | 21<br>.0 | 21<br>.3 | 20<br>.9      | 21<br>.0 | 20.8 |
|                          | Vinyl                             | 50.2    | 50.2 | 49.7 | 50<br>.1 | 50<br>.0 | 50<br>.5            | 50<br>.2 | 50<br>.1 | 50<br>.4<br>7 | 50<br>.0 | 50.6 |
| GPC                      | Mn<br>( $\times 10^3$ ,<br>g/mol) | 396     | 373  | 410  | 38<br>5  | 50<br>5  | 36<br>5             | 40<br>5  | 38<br>0  | 40<br>2       | 35<br>3  | 502  |
|                          | Mw<br>( $\times 10^3$ ,<br>g/mol) | 523     | 485  | 660  | 55<br>1  | 88<br>4  | 40<br>2             | 51<br>4  | 46<br>7  | 65<br>1       | 46<br>9  | 889  |
|                          | PDI                               | 1.32    | 1.30 | 1.61 | 1.<br>43 | 1.<br>75 | 1.<br>10            | 1.<br>27 | 1.<br>23 | 1.<br>62      | 1.<br>33 | 1.77 |
| Mooney<br>viscosity (MV) |                                   | 63      | 61   | 80   | 73       | 96       | 41                  | 62       | 53       | 96            | 58       | 98   |
| Si content<br>(ppm)      |                                   | 430     | 418  | 500  | 49<br>2  | 66<br>3  | 23<br>1             | 78       | 15<br>5  | 16<br>2       | 41<br>3  | 641  |
| N content<br>(ppm)       |                                   | 382     | 380  | 377  | 41<br>9  | 50<br>5  | 23<br>0             | 39       | 77       | 42            | 37<br>2  | 489  |

**[00261]** As shown in Table 1 above, Si and N atoms were present in the polymer molecules in Examples 1 to 5, and the N content and Si content were markedly increased in contrast to Comparative Example 1 to Comparative Example 4. In this case, Comparative Example 1 corresponded to a polymer prepared without using the modifier suggested in the present invention, and Comparative Examples 2 to 4 corresponded to polymers prepared without using the macromonomer suggested in the present invention. From the presence of N atoms and Si atoms in the polymers of Examples 1 to 5 and marked increase of the N content and Si content in contrast to Comparative Examples 1 to 4, it could be anticipated that the modified

conjugated diene-based polymer according to the present invention includes a second chain including a repeating unit derived from a compound represented by Formula 1; and a derived unit from an amine-containing alkoxy silane-based modifier, and it could be confirmed that the modified conjugated diene-based polymer according to the present invention was prepared by the preparation method of reacting the macromonomer including the derived repeating unit of the compound represented by Formula 1 with the modified active polymer first chain after modification reaction, the N atoms and Si atoms may be included in the high contents in a polymer.

**[00262] Evaluation of properties of rubber molded article**

**[00263]** In order to compare and analyze the physical properties of rubber compositions including the modified styrene-butadiene copolymers prepared in the Examples and Comparative Examples, and molded articles manufactured therefrom, tensile properties and viscoelasticity properties were measured, respectively, and the results are shown in Table 3 below.

**[00264] 1) Preparation of rubber specimen**

**[00265]** Blending was performed using each of the modified or unmodified conjugated diene-based polymers of the Examples, Comparative Examples and Reference Examples as a raw material

rubber under the compounding conditions shown in Table 2 below. The raw materials in Table 2 are represented by parts by weight based on 100 parts by weight of the raw material rubber.

5 **[00266]** [Table 2]

| Division             | Raw material              | Amount (parts by weight) |
|----------------------|---------------------------|--------------------------|
| First stage mulling  | Rubber                    | 100                      |
|                      | Silica                    | 70                       |
|                      | Coupling agent (X50S)     | 11.2                     |
|                      | Process oil               | 37.5                     |
|                      | zinc oxide                | 3                        |
|                      | Stearic acid              | 2                        |
|                      | Antioxidant               | 2                        |
|                      | Antiaging agent           | 2                        |
|                      | wax                       | 1                        |
| Second stage mulling | Sulfur                    | 1.5                      |
|                      | Rubber accelerator        | 1.75                     |
|                      | Vulcanization accelerator | 2                        |

**[00267]** Particularly, the rubber specimen was mulled via a first stage mulling and a second stage mulling. In the first stage mulling, a raw material rubber, silica (filler), an organic silane coupling agent (X50S, Evonik), a process oil (TADE oil), zinc oxide (ZnO), stearic acid, an antioxidant (TMQ (RD)) (2,2,4-trimethyl-1,2-dihydroquinoline polymer), an antiaging agent (6PPD ((dimethylbutyl)-N-phenyl-phenylenediamine) and wax (Microcrystalline Wax) were mulled

10

using a banbury mixer equipped with a temperature controlling apparatus. In this case, the initial temperature of a mulling apparatus was controlled to 70°C, and after finishing mixing, a first compound mixture was obtained at a discharge  
5 temperature of 145°C to 155°C. In the second stage mulling, the first compound mixture was cooled to room temperature, and the first compound mixture, sulfur, a rubber accelerator (diphenylguanidine (DPG)), and a vulcanization accelerator (N-cyclohexyl-2-benzothiazylsulfenamide (CZ)) were added to  
10 the mulling apparatus and mixed at a temperature of 100°C or less to obtain a second compound mixture. Then, via a curing process at 160°C for 20 minutes, a rubber specimen was formed.

**[00268]** 2) Tensile properties

15 **[00269]** For measuring the tensile properties, each test specimen was manufactured and tensile stress when stretched by 300% (300% modulus) of each specimen was measured according to an ASTM 412 tensile test method. Particularly, tensile properties were measured using a Universal Test  
20 Machin 4204 tensile tester (Instron Co.) in a rate of 50 cm/min at room temperature.

**[00270]** 3) Viscoelasticity properties

**[00271]** The viscoelasticity properties were secured by  
25 measuring viscoelasticity behavior on thermodynamic

deformation at each measurement temperature (-60°C-60°C) with a frequency of 10 Hz by using a dynamic mechanical analyzer (GABO Co.) in a film tension mode and securing a  $\tan \delta$  value. From the resultant values, if a  $\tan \delta$  value at a low temperature of 0°C increases, wet skid resistance becomes better, and if a  $\tan \delta$  at a high temperature of 60°C decreases, hysteresis loss decreases, and low rotation resistance (fuel consumption ratio) becomes better. The resultant values in Table 3 were indexed (%) based on the resultant values of Comparative Example 1, and thus, the higher numerical value means better results.

**[00272]** 4) Processability properties

**[00273]** By measuring the mooney viscosity (MV, (ML1+4, @100°C) MU) of the first compound mixture obtained during 1) preparation of rubber specimen, the processability properties of each polymer was compared and analyzed, and in this case, the lower the measured value of the moony viscosity is, the better the processability properties are. The resultant values in Table 3 were indexed (%) based on the resultant values of Comparative Example 2, and thus, the higher numerical value means better results.

**[00274]** Particularly, by using MV-2000 (ALPHA Technologies Co.) using Large Rotor at a rotor speed of  $2 \pm 0.02$  rpm at 100°C, each first compound mixture was stood at room

temperature (23±3°C) for 30 minutes or more, and 27±3 g was collected and put in a die cavity, and then, Platen was operated for 4 minutes for measurement.

**[00275]** [Table 3]

| Division                            |                        | Example |     |     |     |     | Comparative Example |     |     |     |     |     |
|-------------------------------------|------------------------|---------|-----|-----|-----|-----|---------------------|-----|-----|-----|-----|-----|
|                                     |                        | 1       | 2   | 3   | 4   | 5   | 1                   | 2   | 3   | 4   | 5   | 6   |
| 300% modulus (kgf/cm <sup>2</sup> ) |                        | 162     | 161 | 164 | 160 | 165 | 148                 | 149 | 147 | 152 | 161 | 164 |
| Viscoelasticity properties          | tan δ (at 0°C, Index)  | 100     | 101 | 103 | 100 | 99  | 100                 | 96  | 99  | 97  | 98  | 99  |
|                                     | tan δ (at 60°C, Index) | 118     | 119 | 124 | 122 | 121 | 100                 | 97  | 98  | 102 | 118 | 120 |
| Processability properties (Index)   |                        | 103     | 102 | 104 | 104 | 102 | 94                  | 100 | 98  | 102 | 74  | 72  |

5

**[00276]** As shown in Table 3, it was confirmed that the modified styrene-butadiene copolymers of Examples 1 to 5 in which the reaction with the macromonomer was performed after the modification reaction using the modifier according to an embodiment of the present invention, showed excellent processability properties and at the same time, excellent tensile properties and viscoelasticity properties when compared with Comparative Examples 1 to 6.

10

**[00277]** Particularly, Examples 1 to 5 showed improved viscoelasticity properties and markedly improved processability, while showing equal or better tensile properties when compared with Comparative Examples 5 and 6. In this case, Comparative Example 5 and Comparative Example 6 corresponded to modified styrene-butadiene copolymers

15

prepared by the same method in Example 1 and Example 5, respectively, except for using the macromonomers in Example 1 and Example 5 as modification initiators, but not performing the step of reacting with the macromonomers after modification reaction.

**[00278]** Though the difference in the preparation methods in Example 1 and Example 5 from Comparative Example 5 and Comparative Example 6, and the same containing level of the Si content and N content in polymers, through the marked difference of effects of Example 1 and Example 5 from Comparative Example 5 and Comparative Example 6, it could be anticipated that the modified conjugated diene-based polymer of the present invention is a copolymer having a different structure from Comparative Example 5 and Comparative Example 6, for example, a structure like a graft copolymer through the coupling of the second chain including the repeating unit derived from the compound represented by Formula 1 derived from the macromonomer with the modified polymer first chain via the derived unit from a modifier. It could be confirmed that tensile properties, viscoelasticity properties and processability properties were markedly excellent in balance due to such structural difference (refer to Table 1 and Table 3).

## **[00279] Experiment #2**

**[00280] Preparation Example 3**

**[00281]** To a 500 ml, round-bottom flask, 100 ml of tetrahydrofuran and 1 g of n-butyllithium (10 wt% in n-hexane) were added, then, N,N,N',N',1-pentamethyl-1-  
5 vinylsilandiamine (molar ratio of 3 mol in contrast to 1 mol of [act. Li]) was added, followed by reacting at 10°C for 30 minutes to prepare a solution containing a macromonomer (15.6 mmol/l). Through GC analysis, the achievement of the reaction was secured through that N,N,N',N',1-pentamethyl-1-  
10 vinylsilandiamine was not detected after the reaction.

**[00282] Preparation Example 4**

**[00283]** A solution containing a macromonomer (15.6 mmol/l) was prepared by the same method in Preparation Example 1  
15 except for reacting N,N,N',N'-tetraethyl-1-methyl-1-vinylsilandiamine (molar ratio of 3 mol in contrast to 1 mol of [act. Li]) instead of N,N,N',N',1-pentamethyl-1-vinylsilandiamine as a modifier in Preparation Example 3. Through GC analysis, the achievement of the reaction was  
20 secured through that N,N,N',N'-tetraethyl-1-methyl-1-vinylsilandiamine was not detected after the reaction, and molecular weight analysis was conducted by the same method in Preparation Example 1.

25 **[00284] Example 6**

[00285] To a 20 L, autoclave reactor, 3 kg of n-hexane, 215 g of styrene, 745 g of 1,3-butadiene and 1.29 g of 2,2-bis(2-oxolanyl)propane as a polar additive were injected, then, 3.2 g of n-butyllithium (10 wt% in n-hexane) was injected, the  
5 internal temperature of the reactor was adjusted to 60°C, and an adiabatic reaction with heating was performed. After about 30 minutes lapse, 39 g of 1,3-butadiene was injected for capping the terminals of a polymer with butadiene. After about 10 minutes, tetramethoxysilane was injected as a  
10 modifier and reacted for 15 minutes (molar ratio of [DTP]:[act. Li] = 1.5:1, molar ratio of [modifier]:[act. Li] = 0.7:1). Then, the solution containing the macromonomer prepared in Preparation Example 1 was added and reacted for 15 minutes (molar ratio of [act. Li]:[macromonomer] = 1:1),  
15 and the reaction was quenched using ethanol. 33 g of a solution in which 30 wt% of Wingstay K antioxidant was dissolved in hexane was added thereto. The polymer thus obtained was injected into hot water heated using steam and stirred to remove solvents and roll dried to remove remaining  
20 solvents and water to prepare a modified styrene-butadiene copolymer.

#### [00286] Example 7

[00287] A modified styrene-butadiene copolymer was prepared  
25 by performing the same method in Example 6 except for using

3,3,7,7-tetramethoxy-5,5-bis((trimethoxysilyl)methyl)-2,8-dioxa-3,7-disilanonane instead of tetramethoxysilane as a modifier in Example 6 (molar ratio of [modifier]:[act Li] = 0.2:1).

5

**[00288] Example 8**

**[00289]** A modified styrene-butadiene copolymer was prepared by performing the same method in Example 6 except for using dodecamethyl pentaorthosilicate instead of tetramethoxysilane as a modifier in Example 6 (molar ratio of [modifier]:[act Li] = 0.2:1).

**[00290] Example 9**

**[00291]** A modified styrene-butadiene copolymer was prepared by performing the same method in Example 6 except for adding the solution containing a macromonomer prepared in Preparation Example 2 as a macromonomer in Example 6 (molar ratio of [modifier]:[act Li] = 1:1).

20 **[00292] Comparative Example 7**

**[00293]** A modified styrene-butadiene copolymer was prepared by performing the same method in Example 6 except for using the solution containing a macromonomer prepared in Preparation Example 1 instead of the n-butyllithium in Example 6 such that the mol of the macromonomer injected was

the same as the n-butyllithium in Example 6, performing the adiabatic reaction with heating, not performing a subsequent step of adding a modifier and a macromonomer and reacting, and quenching the reaction after capping with butadiene.

5

**[00294] Comparative Example 8**

**[00295]** To a 20 L, autoclave reactor, 3 kg of n-hexane, 215 g of styrene, 745 g of 1,3-butadiene and 1.29 g of 2,2-bis(2-oxolanyl)propane as a polar additive were injected, then, 3.2  
10 g of n-butyllithium (10 wt% in n-hexane) was injected, the internal temperature of the reactor was adjusted to 60°C, and an adiabatic reaction with heating was performed. After about 30 minutes lapse, 39 g of 1,3-butadiene was injected for capping the terminals of a polymer with butadiene. After  
15 about 10 minutes, tetramethoxysilane was injected as a modifier and reacted for 15 minutes (molar ratio of [DTP]:[act. Li] = 1.5:1, molar ratio of [modifier]:[act. Li] = 0.7:1). Then, the reaction was quenched using ethanol. 33 g of a solution in which 30 wt% of Wingstay K antioxidant was  
20 dissolved in hexane was added thereto. The polymer thus obtained was injected into hot water heated using steam and stirred to remove solvents and roll dried to remove remaining solvents and water to prepare a modified styrene-butadiene copolymer.

25

**[00296] Comparative Example 9**

**[00297]** A modified styrene-butadiene copolymer was prepared by performing the same method in Comparative Example 8 except for using the solution containing a macromonomer prepared in Preparation Example 1 instead of the n-butyllithium in Comparative Example 8 such that the mol of the macromonomer injected was the same as the n-butyllithium in Comparative Example 8, and performing the adiabatic reaction with heating.

**[00298] Evaluation of properties of polymers**

**[00299]** With respect to each of the modified styrene-butadiene copolymers prepared in the Examples and Comparative Examples, the styrene unit and vinyl contents in each polymer, a weight average molecular weight ( $M_w$ ,  $\times 10^3$  g/mol), a number average molecular weight ( $M_n$ ,  $\times 10^3$  g/mol), molecular weight distribution (PDI, MWD), mooney viscosity (MV), the Si content and the N content were measured, respectively by the same method in Experiment #1. The results are shown in Table 4 below.

**[00300] [Table 4]**

| Division  |                             | Example |     |     |     | Comparative Example |     |     |
|-----------|-----------------------------|---------|-----|-----|-----|---------------------|-----|-----|
|           |                             | 6       | 7   | 8   | 9   | 7                   | 8   | 9   |
| NMR (wt%) | SM                          | 21      | 21  | 21  | 21  | 21                  | 21  | 21  |
|           | Vinyl                       | 50      | 50  | 50  | 50  | 50                  | 50  | 50  |
| GPC       | Mn ( $\times 10^3$ , g/mol) | 405     | 360 | 420 | 406 | 365                 | 403 | 395 |
|           | Mw ( $\times 10^3$ , g/mol) | 559     | 569 | 777 | 557 | 402                 | 544 | 545 |

|                       |        |      |      |      |      |      |      |      |
|-----------------------|--------|------|------|------|------|------|------|------|
|                       | g/mol) |      |      |      |      |      |      |      |
|                       | PDI    | 1.38 | 1.58 | 1.85 | 1.37 | 1.10 | 1.35 | 1.38 |
| Mooney viscosity (MV) |        | 70   | 72   | 111  | 69   | 41   | 67   | 68   |
| Si content (ppm)      |        | 416  | 534  | 530  | 410  | 220  | 78   | 401  |
| N content (ppm)       |        | 330  | 415  | 400  | 331  | 234  | –    | 332  |

**[00301]** As shown in Table 4 above, in Examples 6 to 9, the N content and Si content in polymers were largely increased in contrast to Comparative Example 7 and Comparative Example 8.

5 In this case, Comparative Example 7 corresponded to a polymer prepared without using the modifier, and Comparative Example 8 corresponded to a polymer prepared without using the macromonomer suggested in the present invention. From the marked increase of the Si content and N content in the

10 polymers in Examples 6 to 9 in contrast to Comparative Examples 7 and 8, it could be anticipated that the modified conjugated diene-based polymer according to the present invention includes the second chain including the repeating unit derived from the compound represented by Formula 1; and

15 the derived unit from the non-amine-containing alkoxysilane-based modifier.

**[00302] Evaluation of properties of rubber molded article**

**[00303]** In order to compare and analyze the physical

20 properties of rubber compositions including the modified styrene-butadiene copolymers prepared in the Examples and

Comparative Examples, and molded articles manufactured therefrom, tensile properties and viscoelasticity properties were measured, respectively, by the same method in Experiment #1, and the results are shown in Table 5 below. The rubber  
5 molded article (specimen) was also manufactured by the same method in Experiment #1.

**[00304]** [Table 5]

| Division                          |                               | Example |     |     |     | Comparative Example |     |     |
|-----------------------------------|-------------------------------|---------|-----|-----|-----|---------------------|-----|-----|
|                                   |                               | 6       | 7   | 8   | 9   | 7                   | 8   | 9   |
| 300% modulus (Index)              |                               | 163     | 162 | 160 | 165 | 148                 | 152 | 165 |
| Viscoelasticity properties        | tan $\delta$ (at 0°C, Index)  | 102     | 105 | 104 | 105 | 100                 | 102 | 99  |
|                                   | tan $\delta$ (at 60°C, Index) | 113     | 115 | 116 | 112 | 100                 | 91  | 112 |
| Processability properties (Index) |                               | 102     | 101 | 99  | 98  | 92                  | 100 | 86  |

**[00305]** In Table 5 above, the resultant values of  
10 viscoelasticity properties were indexed (%) based on the resultant values of Comparative Example 7, and the processability properties were indexed based (%) on the resultant values of Comparative Example 8, and the higher values mean the better properties.

15 **[00306]** As shown in Table 5, it was confirmed that the modified styrene-butadiene copolymers of Examples 6 to 9 which were obtained by reacting with the macromonomer after modification reaction using the modifier according to an

embodiment of the present invention, showed excellent processability properties and at the same time, excellent tensile properties and viscoelasticity properties when compared with Comparative Examples 7 to 9.

5   **[00307]** Particularly, Example 6 showed equally excellent tensile properties, improved viscoelasticity properties and markedly improved processability properties when compared with Comparative Example 9. In this case, Comparative Example 9 was the modified styrene-butadiene copolymer  
10 prepared by the same method in Example 6 except for using the macromonomer as a modification initiator in Example 6.

**[00308]** Though the difference in the preparation methods in Example 6 and Comparative Example 9, and the same containing  
15 level of the Si content and N content in polymers, through the marked difference of effects of Example 6 and Comparative Example 9, it could be anticipated that the modified conjugated diene-based polymer of the present invention is a polymer having a different structure from Comparative Example  
20 9, for example, a structure like a graft copolymer through the coupling of the second chain including the repeating unit derived from the compound represented by Formula 1 derived from the macromonomer with the modified polymer first chain via the derived unit from the modifier. It could be  
25 confirmed that tensile properties, viscoelasticity properties

and processability properties were markedly excellent in balance due to such structural difference (refer to Table 4 and Table 5).

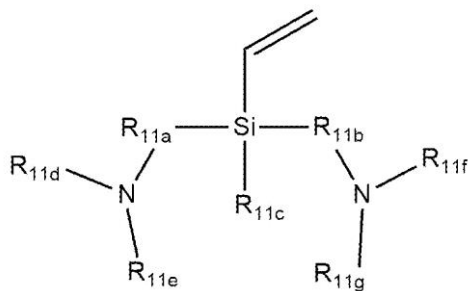
## CLAIMS

1. A modified conjugated diene-based polymer comprising:

a first chain comprising a repeating unit derived from  
5 a conjugated diene-based monomer; a second chain comprising a  
repeating unit derived from a compound represented by the  
following Formula 1; and a derived unit from an alkoxysilane-  
based modifier,

wherein the first chain and the second chain are  
10 coupled by the derived unit from the modifier:

[Formula 1]



in Formula 1,

R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or a  
15 substituted with a substituent or unsubstituted alkylene  
group of 1 to 20 carbon atoms; a substituted with a  
substituent or unsubstituted cycloalkylene group of 5 to 20  
carbon atoms; or a substituted with a substituent or  
unsubstituted arylene group of 6 to 20 carbon atoms, wherein  
20 the substituent is an alkyl group of 1 to 10 carbon atoms, a  
cycloalkyl group of 5 to 10 carbon atoms, or an aryl group of

6 to 20 carbon atoms,

R<sub>11c</sub> is an alkyl group of 1 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; or a heterocyclic group of 3 to 20 carbon atoms, and

R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 20 carbon atoms; an alkenyl group of 2 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; a heterocyclic group of 3 to 20 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

2. The modified conjugated diene-based polymer of claim 1, wherein

in Formula 1,

R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or an unsubstituted alkylene group of 1 to 10 carbon atoms,

R<sub>11c</sub> is an alkyl group of 1 to 10 carbon atoms, and

R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 10 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

5

3. The modified conjugated diene-based polymer of claim 1, wherein

in Formula 1,

R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or an  
10 unsubstituted alkylene group of 1 to 6 carbon atoms,

R<sub>11c</sub> is an alkyl group of 1 to 6 carbon atoms, and

R<sub>11d</sub> to R<sub>11g</sub> are each independently an alkyl group of 1 to 6 carbon atoms; or a substituted trialkylsilyl group with an alkyl group of 1 to 6 carbon atoms.

15

4. The modified conjugated diene-based polymer of claim 1, wherein the first chain further comprises a repeating unit derived from an aromatic vinyl-based monomer.

20 5. The modified conjugated diene-based polymer of claim 1, wherein the second chain further comprises a derived unit from a conjugated diene-based monomer.

6. The modified conjugated diene-based polymer of claim 1,  
25 wherein a number average molecular weight (M<sub>n</sub>) is 1,000 g/mol

to 2,000,000 g/mol, a weight average molecular weight (Mw) is 1,000 g/mol to 3,000,000 g/mol, and a peak average molecular weight (Mp) is 1,000 g/mol to 3,000,000 g/mol.

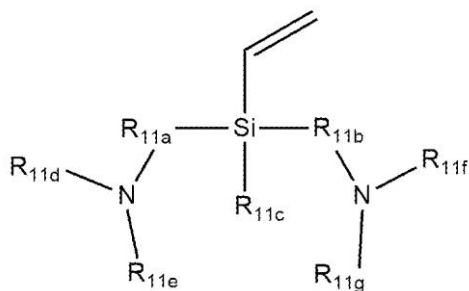
5 7. A method for preparing the modified conjugated diene-based polymer of claim 1, the method comprising:

polymerizing a conjugated diene-based monomer, or a conjugated diene-based monomer and an aromatic vinyl-based monomer in the presence of a polymerization initiator in a  
10 carbon solvent to prepare an active first chain (S1);

reacting the active first chain with an alkoxysilane-based modifier to prepare a modified active first chain (S2);  
and

reacting the modified active first chain and a  
15 macromonomer comprising a repeating unit derived from a compound represented by the following Formula 1 (S3):

[Formula 1]



in Formula 1,

20 R<sub>11a</sub> and R<sub>11b</sub> are each independently a single bond or a substituted with a substituent or unsubstituted alkylene

group of 1 to 20 carbon atoms; a substituted with a substituent or unsubstituted cycloalkylene group of 5 to 20 carbon atoms; or a substituted with a substituent or unsubstituted arylene group of 6 to 20 carbon atoms, wherein  
5 the substituent is an alkyl group of 1 to 10 carbon atoms, a cycloalkyl group of 5 to 10 carbon atoms, or an aryl group of 6 to 20 carbon atoms,

$R_{11c}$  is an alkyl group of 1 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of  
10 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms; a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; or a heterocyclic group of 3 to 20 carbon atoms, and

15  $R_{11d}$  to  $R_{11g}$  are each independently an alkyl group of 1 to 20 carbon atoms; an alkenyl group of 2 to 20 carbon atoms; an alkynyl group of 2 to 20 carbon atoms; a heteroalkyl group of 1 to 20 carbon atoms; a heteroalkenyl group of 2 to 20 carbon atoms; a heteroalkynyl group of 2 to 20 carbon atoms;  
20 a cycloalkyl group of 5 to 20 carbon atoms; an aryl group of 6 to 20 carbon atoms; a heterocyclic group of 3 to 20 carbon atoms; or a mono-substituted, di-substituted or tri-substituted alkylsilyl group with alkyl groups of 1 to 10 carbon atoms.

25

8. The method for preparing the modified conjugated diene-based polymer of claim 7, wherein the macromonomer further comprises a derived unit from a conjugated diene-based monomer.

5

9. The method for preparing the modified conjugated diene-based polymer of claim 7, wherein the macromonomer is prepared by low-degree polymerization reaction of the compound represented by Formula 1, or the compound  
10 represented by Formula 1 and a conjugated diene-based monomer in the presence of an organolithium compound in a hydrocarbon solvent.

10. The method for preparing the modified conjugated diene-based polymer of claim 7, wherein the modifier is used in 0.1  
15 mol to 10 mol based on 1 mol of the polymerization initiator.

11. The method for preparing the modified conjugated diene-based polymer of claim 7, wherein the macromonomer is used in  
20 0.1 to 4.0 mol based on 1 mol of the polymerization initiator.

12. A rubber composition comprising the modified conjugated diene-based polymer of claim 1, and a filler.

25 13. The rubber composition of claim 12, wherein the rubber

composition comprises 0.1 parts by weight to 200 parts by weight of the filler based on 100 parts by weight of the modified conjugated diene-based polymer.