

**OLEFIN POLYMERIZATION CATALYST
BASED ON METALLOCENE COMPLEXES
AND PERFLUORINATED OLIGOARYL DERIVATIVES OF ALUMINATES**

The invention relates to new catalyst compositions for olefin polymerization. In particular, the invention relates to new cocatalysts for activating metallocene complexes of transition metals as olefin polymerization catalysts.

Catalyst compositions comprising metallocene complexes activated by alkylalumoxane activators (or cocatalysts), were introduced to the art of polymerization catalysis in the mid-1970s. Alkylalumoxanes exhibit several inherent problems in use, such as a need for high (alumoxane):(metallocene) ratios to produce highly active catalyst compositions, high reactivity toward impurities (moisture, alcohols, etc.) and flammability. Accordingly, some of the developments in this area of catalysis involved a search for alternative cocatalysts capable of activating metallocene complexes.

The class of alkylalumoxanes comprises oligomeric linear and/or cyclic compounds represented by the formulas $R-[Al(R)-O]_n-AlR_2$ for linear oligomeric alumoxanes and $[-Al(R)-O-]_n$ for cyclic oligomeric alumoxanes where R is a C_1-C_8 alkyl group. If R is the methyl group, the compound is called methylalumoxane or MAO. MAO has been the most widely used cocatalyst in metallocene catalyst systems.

The invention relates to catalyst compositions for olefin polymerization comprising metallocene complexes and novel cocatalysts belonging to the group of perfluorinated oligoarylaluminates, perfluorinated oligoarylthioaluminates, and perfluorinated oligoarylaminoaluminates. Catalyst systems containing these cocatalysts and metallocene complexes are active in polymerization and copolymerization reactions of ethylene and alpha-olefins. The catalyst composition may be a homogeneous catalyst or a supported heterogeneous catalyst which takes the form of free flowing particles which comprise an activated metallocene catalyst. Contact of the cocatalyst and the metallocene complex can occur prior to, or

concurrently with, introduction of the metallocene complex into a polymerization reactor.

Metallocene complexes used in the catalyst compositions of this invention have the formula $Cp_xMA_yB_z$ in which Cp is an unsubstituted or substituted cyclopentadienyl group; M is zirconium, titanium or hafnium; and A and B belong to the group including a halogen atom, a hydrogen atom or an alkyl group. In the above formula of the metallocene compound, the preferred transition metal atom M is zirconium. In the above formula of the metallocene compound, the Cp group is an unsubstituted, a monosubstituted, disubstituted or a polysubstituted cyclopentadienyl group: and x is at least 1 and preferably is 2. The substituents on the cyclopentadienyl group can be preferably linear or branched C_1 - C_6 alkyl groups. The cyclopentadienyl groups can also be a part of a bicyclic or a tricyclic moiety such as indenyl, tetrahydroindenyl, fluorenyl or a partially hydrogenated fluorenyl group, as well as a part of other substituted bicyclic or tricyclic moieties. In the case when x is equal to 2, the cyclopentadienyl groups can be also bridged by polymethylene or dialkylsilyl groups such as $-CH_2-$, $-CH_2-CH_2-$, $-CR'R''-$ and $-CR'R''-CR'R''-$ where R' and R'' are alkyl groups of 1 to 4 carbon atoms or phenyl groups or hydrogen atoms, $-Si(CH_3)_2-$, $-Si(CH_3)_2-CH_2-CH_2-Si(CH_3)_2-$, and similar bridge groups. If the A and B substituents in the above formula of a metallocene compound are halogen atoms, they belong to the group of fluorine, chlorine, bromine or iodine; and y + z is 3 or less, provided that x + y + z equals the valence of M. If the substituents A and B in the above formula of the metallocene compound are alkyl groups, they are preferably linear or branched C_1 - C_8 alkyl groups, such as methyl, ethyl, *n*-propyl, isopropyl, *n*-butyl, isobutyl, *n*-pentyl, *n*-hexyl or *n*-octyl.

Suitable metallocene compounds include:

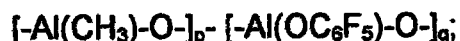
bis(cyclopentadienyl)metal dihalides,
bis(cyclopentadienyl)metal hydridohalides,
bis(cyclopentadienyl)metal monoalkyl monohalides,
bis(cyclopentadienyl)metal dialkyls,
bis(indenyl)metal diahalides
bis(tetrahydroindenyl)metal dihalides, and

bis(fluorenyl)metal dihalides,

wherein the metal is titanium, zirconium, or hafnium; halide atoms are preferably chlorine; and the alkyl groups are C₁-C₈ alkyl groups. Illustrative but nonlimiting examples of metallocene complexes include:

- 5 bis(cyclopentadienyl)zirconium dichloride,
bis(cyclopentadienyl)titanium dichloride,
bis(cyclopentadienyl)hafnium dichloride,
bis(cyclopentadienyl)zirconium dimethyl,
bis(cyclopentadienyl)hafnium dimethyl,
- 10 bis(cyclopentadienyl)zirconium hydrido-chloride,
bis(cyclopentadienyl)hafnium hydrido-chloride,
bis(*n*-butylcyclopentadienyl)zirconium dichloride,
bis(*n*-butylcyclopentadienyl)hafnium dichloride,
bis(*n*-butylcyclopentadienyl)zirconium dimethyl,
- 15 bis(*n*-butylcyclopentadienyl)hafnium dimethyl,
bis(*n*-butylcyclopentadienyl)zirconium hydrido-chloride,
bis(*n*-butylcyclopentadienyl)hafnium hydrido-chloride,
bis(1,3-dimethylcyclopentadienyl)zirconium dichloride,
bis(pentamethylcyclopentadienyl)zirconium dichloride,
- 20 cyclopentadienylzirconium trichloride,
bis(indenyl)zirconium dichloride,
bis(4,5,6,7-tetrahydro-1-indenyl)zirconium dichloride, and
ethylene[bis(4,5,6,7-tetrahydro-1-indenyl)]zirconium dichloride.

In the catalyst compositions of the invention one or more of these metallocene
25 complexes are contacted with a cocatalyst containing perfluorinated phenyl groups.
Some of these cocatalysts are oligomeric products belonging to the class including
perfluorinated arylaluminates, i.e., the compounds which can be represented by the
formula



30 perfluorinated arylthioaluminates, i.e., the compounds which can be represented by
the formula

$[-Al(CH_3)-O-]_p-[-Al(SC_6F_5)-O-]_q$; and

perfluorinated arylaminoaluminates, i.e., the compounds which can be represented by the formula

$[-Al(CH_3)-O-]_p-[-Al(NHC_6F_5)-O-]_q$;

5 where the q:p ratio varies from 1:10 to 1:0.

These oligomeric cocatalysts are produced by any of two alternative synthetic methods. In the first method, the cocatalysts are produced by reacting

alkylalumoxane $[Al(R)-O]_n$, where R is an alkyl group such a methyl, ethyl, *n*-propyl, *n*-butyl, isobutyl, *n*-hexyl or *n*-octyl group; with pentafluorophenol, C_6F_5OH ;

10 pentafluorothiophenol, C_6F_5SH ; or with pentafluoroaniline, $C_6F_5NH_2$. Illustrative but nonlimiting examples of the alkylalumoxanes include

methylalumoxane

modified methylalumoxane (oligomeric alkylalumoxane products containing both methyl and isobutyl groups),

15 isobutylalumoxane, and

n-octylalumoxane.

The reaction between the alkylalumoxane and any of the said perfluorinated agents can be carried out in solution in any nonpolar solvent, such as a paraffinic hydrocarbon, a cycloalkane or an aromatic hydrocarbon, in a broad range of

20 temperatures, from sub-zero to elevated temperatures. The optimum reaction temperatures are from 10 to 70°C. The reaction proceeds vigorously with the

formation of an alkane RH. In the case when the R group in the alkylalumoxane is methyl or ethyl, the alkane RH evolves as a gas. It can be assumed that the reaction can be described by the following equations:

25 $[-Al(R)-O-] + C_6F_5OH \rightarrow [-Al(OC_6F_5)-O-] + RH$

$[-Al(R)-O-] + C_6F_5SH \rightarrow [-Al(SC_6F_5)-O-] + RH$

$[-Al(R)-O-] + C_6F_5NH_2 \rightarrow [-Al(NHC_6F_5)-O-] + RH$

If an excess of the perfluorinated agent is used for the cocatalyst synthesis, it can be neutralized in a post-reaction with trimethylaluminum (TMA). The products of

30 the post-reaction, aluminum phenoxides, phenothioxides or phenomides, such as

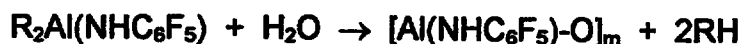
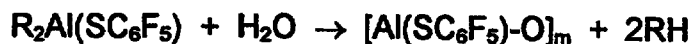
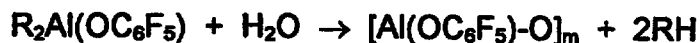
$\text{Me}_2\text{Al}(\text{OC}_6\text{F}_5)$, $\text{MeAl}(\text{O}-\text{C}_6\text{F}_5)_2$, etc., are, by themselves, inert in the polymerization reactions.

The second method for producing cocatalysts of this invention consists of two consecutive stages. In the first stage, the said perfluorinated agent is reacted with a trialkylaluminum compound. The trialkylaluminum compounds used for the preparation of the cocatalyst have the general formula of AlR_3 wherein R are alkyl groups such a methyl, ethyl, *n*-propyl, *n*-butyl, isobutyl, *n*-hexyl or *n*-octyl group. The preferred trialkylaluminum compound is TMA. The reaction can be carried out in solution in a non-polar solvent, such as a paraffinic hydrocarbon, a cycloalkane or an aromatic hydrocarbon, in a broad range of temperatures, from sub-zero to elevated temperatures. The optimum reaction temperatures are from 10 to 70°C. The reaction proceeds vigorously with the formation of an alkane RH. In the case when the R group in the alkylaluminum compound formula AlR_3 is methyl or ethyl, the alkane RH evolves as a gas. It can be assumed that the reactions can be described by the following equations:



and produces alkylaluminum pentafluorophenoxides, alkylaluminum pentafluorophenylsulfides (or pentafluorothiophenolates), and alkylaluminum pentafluoroanilides, respectively. The ratios between AlR_3 and the perfluorinated agent can vary from 10:1 to 1:2; the most preferred ratios are from 1:1 to 1:2.

In the second stage of the preparation of the cocatalyst, the product of the first stage is contacted with water. This stage of the reaction can also be carried out in a broad range of temperatures, from sub-zero to elevated temperatures. The optimum reaction temperatures are from 10 to 70°C. The reaction is relatively slow and requires, depending on temperature, from 15 to 60 minutes to come to completion. It can be monitored by observing a slow disappearance of drops of water on the bottom of the reaction vessel. The total amount of water can be added to the reaction vessel in one step or in several consecutive steps. It is believed that these reactions proceed as shown:



Depending on the ratio between AlR_3 and said perfluorinated agents in the first stage of the catalyst synthesis and the ratio between the products of the first stage and water, this method produces compounds which can be represented by the formulas:

$[-Al(R)-O-]_p-[-Al(OC_6F_5)-O-]_q$ (perfluorinated arylaluminates);

$[-Al(R)-O-]_p-[-Al(SC_6F_5)-O-]_q$ (perfluorinated arylthioaluminates); or

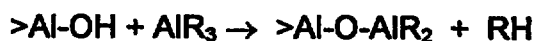
$[-Al(R)-O-]_p-[-Al(NHC_6F_5)-O-]_q$ (perfluorinated arylaminoaluminates);

where the q:p ratio varies from 1:10 to 1:0.

Another type of a cocatalyst of this invention containing perfluorinated phenyl groups is a solid material produced in the following sequence of two reactions:

(i) Solid $Al(OH)_3$ in a particulate form is slurried in an inert hydrocarbon and is reacted with a trialkylaluminum compound AlR_3 wherein the R groups are the same as

described above. The reaction can be carried out using any non-polar solvent, such as a paraffinic hydrocarbon, a cycloalkane or an aromatic hydrocarbon, in a broad range of temperatures, from sub-zero to elevated temperatures. The optimum reaction temperatures are from 10 to 70°C. The reaction proceeds vigorously with the formation of an alkane RH. In the case when the R groups in the trialkylaluminum compound are methyl or ethyl, the alkane RH evolves as a gas. It can be assumed that the reaction can be described by the following equation:



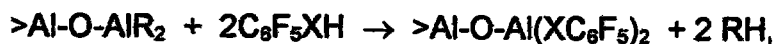
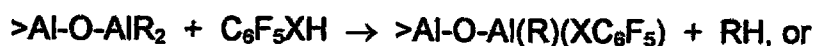
The reaction involves only OH groups on the surface of $Al(OH)_3$ crystals. To increase the fraction of such groups in $Al(OH)_3$, this solid material can be in advance ground or pulverized by any method suitable for grinding soft particular materials, including pulverization in a slurry with ultrasound equipment or with high-speed grinding devices. Experiments involving the measurement of evolved methane in reactions of $Al(OH)_3$ with TMA showed that approximately 20% of all Al atoms in well-ground $Al(OH)_3$ participate in the above reaction with AlR_3 . The reaction between $Al(OH)_3$ and AlR_3 can be carried out at the $[AlR_3]:[Al(OH)_3]$ ratio ranging from 1:1 to

0.2:1. In the case when this ratio is above 0.3:1, the excess of free AlR_3 should be removed from the slurry by any suitable means.

(ii) The slurry of step (i) is treated with a perfluorinated agent belonging to the group including pentafluorophenol, $\text{C}_6\text{F}_5\text{OH}$; pentafluorothiophenol, $\text{C}_6\text{F}_5\text{SH}$; and

5 pentafluoroaniline, $\text{C}_6\text{F}_5\text{NH}_2$. The agent is added to the slurry of step (i) in the amount corresponding to the molar ratio between the agent and the $>\text{Al-O-AlR}_2$ groups on the surface of $\text{Al}(\text{OH})_3$ ranging from 1:1 to 2:1. These reactions also can be carried out using any nonpolar solvent, such as a paraffinic hydrocarbon, a cycloalkane or an aromatic hydrocarbon [most often, the same solvent as that used in
10 step (i)], in a broad range of temperatures, from sub-zero to elevated temperatures.

The optimum reaction temperatures are from 10 to 70°C. The reaction results in the formation of an alkane RH and is assumed to proceed according to the equations:



15 depending on the ratio between the perfluorinated agent and the $>\text{Al-O-AlR}_2$ groups, where X is O, S, or NH for pentafluorophenol, pentafluorothiophenol, and pentafluoroaniline, respectively. The products of step (ii) and the catalyst compositions based on them are air-stable and are not flammable. The products of the step (ii) can be used, either as slurries in inert hydrocarbons, or after drying the
20 solids, as cocatalysts for metallocene complexes of transition metals in olefin polymerization reactions.

The catalyst compositions of the invention can contain perfluorinated phenylaluminates and metallocene complexes in the molar $[\text{Al}]_{\text{aluminate}}:[\text{M}]_{\text{metallocene}}$ ratio ranging from 20,000 to 1.0, preferably from 5,000 to 100.

25 The catalyst compositions may be formed prior to their introduction into a polymerization reactor or *in situ* in the reactor by contacting the cocatalyst with metallocene complex. If the catalyst composition is supported, the support may be contacted with the cocatalyst to form the first contact product and then with the metallocene complex to form the second contact product; or the support can be
30 contacted with the metallocene complex and then with the cocatalyst. Alternatively

the catalyst components, the metallocene complex and the cocatalyst, can be pre-contacted and then impregnated into the support.

When the catalyst of the invention is a supported particulate catalyst, it comprises 0.01 to 4.0 wt. %, preferably 0.1 to 2.0 wt. % of a transition metal, provided by a metallocene complex of the transition metal.

After impregnation or deposition of the and the metallocene complex aluminate into the support, excess solvent is removed by evaporation at elevated temperature.

The catalyst compositions of this invention can be fed to a solution reactor, a slurry reactor or a fluidized bed gas-phase reactor for polymerization and copolymerization of ethylene and alpha-olefins. The temperature of polymerization can range from 25° to 125°C, but more generally between 50° and 115°C, at pressures of less than 10000 psi.

The catalysts can be used, for example, to produce high density polyethylene or linear low density polyethylene which is a copolymer of ethylene and a higher alpha-olefin such as 1-butene, 1-pentene, 1-hexene, 1-octene, 4-methyl-1-pentene, etc.

Example 1

Pentafluorophenol (0.218 g, 1.185 mmol) was dissolved in 5 cc of purified toluene in a 25-cc glass bottle sealed with a rubber septum and methylalumoxane (MAO, 2.38 mmol, 0.5 cc 4.75 M solution in toluene) was added to it at the [OH groups in phenol]:[MAO] ratio of 0.5. Vigorous reaction (ca. 5 min at room temperature) with methane evolution (the gas was released from the bottle through a syringe needle) ensued resulting in the formation of colorless solution. Based on known structure of MAO, the reaction product can be described as an oligomer containing units of two types, $[Al(CH_3)O]$ and $[Al(OR)O]$ where R is a perfluorinated phenyl group C_6F_5 . The ratio between the contents of both groups is determined by the ratio between MAO and the phenol.

The above product was tested as a cocatalyst in combination with a bridged metallocene complex $C_2H_4(indenyl)_2ZrCl_2$ (0.00147 mmol) under ethylene/1-hexene copolymerization conditions. The copolymerization reaction was carried out in a 500-cc stainless-steel autoclave equipped with a stirrer, a thermocouple, and several

ports for adding reaction components. Prior to polymerization, the reactor was purged with nitrogen at 105-110°C for 1 hour. The copolymerization reaction was carried out at 80°C in *n*-heptane (230 cc) as a solvent, at a 0.64 mol/l 1-hexene concentration in solution and at a total reaction pressure of ca. 180 psig. TMA (1.35 mmol) was added to the mixture of the solvent and 1-hexene as an impurity scavenger. The amount of the above cocatalyst (expressed as mmol of Al) was 2.38 mmol and the [Al]:[Zr] ratio was 1620. The reaction produced, over a 19-min period, 25.6 g of an ethylene/1-hexene copolymer containing 1.8 mol.% of 1-hexene with a melt index of 7.7. Catalyst productivity was over 17,000 g PE/mmol Zr.

10 Example 2

The cocatalyst was prepared as described in Example 1 and was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1. The amount of the cocatalyst was 1.9 mmol and the [Al]:[Zr] ratio was 8200. The copolymerization reaction produced, over a 60-min period, 19.8 g of an ethylene/1-hexene copolymer containing 1.4 mol.% of 1-hexene with a melt index of 7.6. Catalyst productivity was over 67,000 g PE/mmol Zr.

Example 3

Pentafluorophenol (0.396 g, 2.15 mmol) was dissolved in 5 cc of toluene and was reacted, as described in Example 1, with MAO (1.9 mmol) for 1 hour at the [OH groups in phenol]:[MAO] ratio of 1.13. The cocatalyst was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1 (2.7 mmol of TMA was present in the reactor). The [Al]:[Zr] ratio was 8200. The copolymerization reaction produced, over a 60-min period, 34.2 g of an ethylene/1-hexene copolymer containing 1.5 mol.% of 1-hexene. Catalyst productivity was over 116,000 g PE/mmol Zr.

Example 4

Pentafluorophenol (0.565 g, 3.07 mmol) was dissolved in 5 cc of toluene and was reacted, as described in Example 1, with MAO (2.41 mmol) for 1 hour at the [OH groups in phenol]:[MAO] ratio of 1.27. This reaction product was completely inert when exposed to air and did not react with isopropanol. The cocatalyst was tested in

combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1 (2.7 mmol of TMA was present in the reactor). The [Al]:[Zr] ratio was 7450. The reaction produced, over a 20-min period, 14.1 g of an ethylene/1-hexene copolymer containing 1.6 mol.% of 1-hexene. Catalyst productivity was over 48,000 g PE/mmol Zr.

Example 5

Pentafluorophenol (0.591 g, 3.2 mmol) was dissolved in 3 cc of toluene and was reacted for 30 min with TMA (2.4 mmol) mixed with 3 cc of toluene. Based on known chemistry of reactions between trialkylaluminum compounds and phenols, formation of dimethylaluminum perfluoro phenoxide $Me_2Al(OC_6F_5)$ is expected in this reaction. Then neat water was added to the solution in an amount of 46 μ l (2.56 mmol) for 30 min to achieve an $[H_2O]:[Al]$ ratio of 0.8 and apparently to produce oligopentafluorophenylaluminate containing predominantly $[-Al(OC_6F_5)-O-]$ units. The reaction product was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1 at the [Al]:[Zr] ratio of 6800. The reaction produced, over a 60-min period, 20.1 g of an ethylene/1-hexene copolymer containing 1.5 mol.% of 1-hexene. Catalyst productivity was over 68,000 g PE/mmol Zr.

Example 6

Pentafluorothiophenol (0.220 g, 1.01 mmol) was dissolved in 3 cc of toluene and was reacted, as described in Example 1, with MAO (2.15 mmol) for 1 hour at the [SH groups in thiophenol]:[MAO] ratio of 0.51. The cocatalyst was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1. The [Al]:[Zr] ratio was 7300. The reaction produced, over a 120-min period, 10.6 g of an ethylene/1-hexene copolymer containing 1.7 mol.% of 1-hexene. Catalyst productivity was over 36,000 g PE/mmol Zr.

Example 7

Pentafluoroaniline (0.204 g, 1.2 mmol) was dissolved in 3 cc of toluene and was reacted, as described in Example 1, with MAO (2.19 mmol) for 1 hour at the $[NH_2 \text{ groups in aniline}]:[MAO]$ ratio of 0.55. The cocatalyst was tested in combination with

$C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1. The [Al]:[Zr] ratio was 7550. The reaction produced, over a 90-min period, 16.2 g of an ethylene/1-hexene copolymer containing 1.6 mol.% of 1-hexene. Catalyst productivity was over 55,000 g PE/mmol Zr.

Example 8

Pentafluoroaniline (0.412 g, 2.41 mmol) was dissolved in 3 cc of toluene and was reacted, as described in Example 1, with MAO (2.19 mmol) for 1 hour at the [NH₂ groups in aniline]:[MAO] ratio of 1.1. The cocatalyst was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00029 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1. The [Al]:[Zr] ratio was 7550. The reaction produced, over a 50-min period, 21.5 g of an ethylene/1-hexene copolymer containing 0.8 mol.% of 1-hexene. Catalyst productivity was over 73,000 g PE/mmol Zr.

Comparative Example 1

Pentafluorophenol (0.552 g, 3.0 mmol) was dissolved in 3 cc of toluene, the solution was flushed with purified nitrogen and slowly added to a 25-cc glass bottle sealed with a rubber septum containing 0.77 cc of 1.35 M solution of TMA in heptane mixed with 3 cc of toluene to reach the [phenol]:[Al] ratio of 3.0. A vigorous reaction resulted in a rapid methane evolution (the gas was released from the bottle through a syringe needle); the reaction product partially precipitated from solution. Based on known chemistry of reactions between trialkylaluminum compounds and phenols, formation of aluminum triphenoxide $Al(OC_6F_5)_3$ is expected in this reaction. The reaction product was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00145 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1 and was found inactive.

Comparative Example 2

Para-trifluoromethylphenol (0.194 g, 1.2 mmol) was dissolved in 5 cc of toluene and was reacted, as described in Example 1, with MAO (2.41 mmol) for 1 hour at the [OH groups in phenol]:[MAO] ratio of 0.5. The reaction product was tested in combination with $C_2H_4(indenyl)_2ZrCl_2$ (0.00147 mmol) in an ethylene/1-

hexene copolymerization reaction under condition of Example 1 at the [Al]:[Zr] ratio of 1640 and was found completely inactive.

Comparative Example 3

Phenol in an amount of 0.259 g (2.75 mmol) was dissolved in 3 cc of toluene and the solution was slowly added to a 50-cc glass bottle sealed with a rubber septum containing a mixture of 2.0 cc of 1.35 M solution of TMA in heptane and 5 cc of toluene. A reaction ensued resulting in a rapid methane evolution. Based on known chemistry of reactions between trialkylaluminum compounds and alcohols, formation of dimethylaluminum phenoxide $(\text{CH}_3)_2\text{Al}-\text{OC}_6\text{H}_5$ is expected in this reaction. Then neat water was added to the solution in two steps, first in an amount of 24 μl (1.35 mmol) to achieve an $[\text{H}_2\text{O}]:[\text{Al}]$ ratio of 0.5 and apparently to produce methylphenoxydialumoxane $(\text{C}_6\text{H}_5\text{O})(\text{CH}_3)\text{Al}-\text{O}-\text{Al}(\text{CH}_3)(\text{O C}_6\text{H}_5)$ and then, in the second step, in an amount of 22 μl (1.22 mmol) to reach the total $[\text{H}_2\text{O}]:[\text{Al}]$ ratio of 0.9:1. The reaction product was tested in combination with $\text{C}_2\text{H}_4(\text{indenyl})_2\text{ZrCl}_2$ (0.00147 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1 at the [Al]:[Zr] ratio of 1860 and was found to have a very poor activity, ca. 1,500 g/mmol Zr in a 120-min run.

Examples 1-8 show that aluminum derivatives containing $[-\text{Al}(\text{OC}_6\text{F}_5)-\text{O}-]$, $[-\text{Al}(\text{SC}_6\text{F}_5)-\text{O}-]$ and $[-\text{Al}(\text{NHC}_6\text{F}_5)-\text{O}-]$ groups with perfluorinated phenyl rings are effective as cocatalysts in olefin polymerization and copolymerization reactions with metallocene complexes whereas products of a similar structure derived from nonfluorinated phenols (Comparative Examples 2 and 3) do not make effective cocatalysts.

Example 9

Solid $\text{Al}(\text{OH})_3$ in an amount of 0.10 g (1.28 mmol) was slurried in 15 cc on *n*-heptane and was ground using a tissue tearor (Biospec Products, Model 985-370) at a stirring speed of ca. 30,000 rpm for 15 min. The slurry was placed in a 50-cc serum bottle, sealed with a rubber septum, flushed with purified nitrogen, and 0.90 cc of 1.42 M solution of TMA in heptane was added to it. The reaction resulted in evolution of methane (which was released from the bottle though a syringe needle) and produced

>Al-O-AlMe₂ species on the surface of solid Al(OH)₃. The slurry was separated from the solution containing unreacted TMA and was washed with purified *n*-heptane.

Separately, pentafluorophenol (0.152 g, 0.82 mmol) was dissolved in 5 cc of purified toluene in a 25-cc glass bottle sealed with a rubber septum, and the solution
5 was added to the bottle with the above reaction product of Al(OH)₃ and TMA. A vigorous reaction ensued with methane evolution. It produced >Al-O-Al(Me)(OC₆F₅) species on the surface of Al(OH)₃.

The above-described solid product was tested as a cocatalyst in combination with a metallocene complex C₂H₄(indenyl)₂ZrCl₂ (0.0015 mmol) under ethylene/1-
10 hexene copolymerization conditions described in Example 1. The reaction produced, over a 180-min period, 28.7 g of an ethylene/1-hexene copolymer containing 2.2 mol.% of 1-hexene with a melt index of 1.3 and a melting point of ca. 114°C.

Example 10

The cocatalyst was prepared as described in Example 9, except for the amount
15 of pentafluorophenol which was increased to 0.288 g (1.55 mmol). As a result, formation of >Al-O-Al(OC₆F₅)₂ species on the surface of Al(OH)₃ is expected in this case. The solid was tested as a cocatalyst in combination with C₂H₄(indenyl)₂ZrCl₂ (0.0015 mmol) in an ethylene/1-hexene copolymerization reaction under condition of Example 1. The reaction produced, over a 180-min period, 28.9 g of an ethylene/1-
20 hexene copolymer containing 2.0 mol.% of 1-hexene with a melt index of 1.7 and a melting point of ca. 115°C.

Thus it is apparent that there has been provided, in accordance with the invention a synthesis that fully satisfies the objects, aims, and advantages set forth above. While the invention has been described in conjunction with specific
25 embodiments thereof, it is evident that many alternatives, modifications, and variations will be apparent to those skilled in the art in light of the foregoing description. Accordingly, it is intended to embrace all such alternatives, modifications, and variations as fall within the spirit and broad scope of the appended claims.

**CLAIMS:**

1. A catalyst composition for polymerization of alpha-olefins comprising the contact product of a metallocene complex of a transition metal of the formula $Cp_xMA_yB_z$

5 wherein x is 1 or 2; M is titanium, zirconium or hafnium; Cp comprises a cyclopentadienyl group, a substituted cyclopentadienyl group, a cyclopentadienyl group that is a part of a bicyclic or a tricyclic moiety or, when x is 2, the two cyclopentadienyl groups are optionally bridged; and each of A and B is selected from the group consisting of a halogen atom, a hydrogen atom, an alkyl group, or combinations thereof; providing that
10 $x+y+z$ is equal to the valence of M; and

a cocatalyst with perfluorinated phenyl groups of the general formula

$-[Al(R)O]_p-[Al(XC_6F_5)O]_q-$, wherein R is an alkyl group, X is an oxygen atom, a sulfur atom or an NH group; and the p:q ratio varies from 10:1 to 0:1..

2. The catalyst composition of Claim 1 wherein x is 2.

3. The catalyst composition of Claim 2 wherein M is Zr.

4. The catalyst composition of Claim 3 wherein A and B are Cl.

5. The catalyst composition of Claims 1, 2, 3 or 4 wherein Cp comprises an n-butylcyclopentadienyl group, a tetrahydroindenyl group, two tetrahydroindenyl groups linked by an ethylene bridge, an indenyl group, or two indenyl groups linked by an ethylene bridge.

6. The catalyst composition of Claims 1, 2, 3 or 4 wherein Cp is a tetrahydroindenyl group and where the two tetrahydroindenyl groups are linked by a dimethylsilyl bridge.



7. The catalyst composition of Claims 1, 2, 3 or 4 wherein the alkyl group R in the phenylaluminate is selected from a group comprising methyl, ethyl, propyl, isopropyl, *n*-butyl, isobutyl, *n*-pentyl, isopentyl, *n*-hexyl, isohexyl, *n*-heptyl, isoheptyl, *n*-octyl, or isooctyl groups.

8. The catalyst composition of Claim 1 wherein the q:p ratio is 1.0.

9. The catalyst composition of Claim 1 wherein the q:p ratio is 0.1.

10. The catalyst component of Claim 1 wherein the catalyst composition comprising the contact product of a metallocene complex of a transition metal of the formula $Cp_xMA_yB_z$ and the perfluorinated cocatalyst of the formula $-[Al(R)O]_p-[Al(XC_6F_5)O]_q-$ is supported on an inert porous support.

11. The catalyst composition of Claim 1 wherein the perfluorinated cocatalysts of the formula $-[Al(R)O]_p-[Al(XC_6F_5)O]_q-$, wherein X is oxygen atom, a sulfur atom or an NH group, are produced by reacting an alkylalumoxane of the formula $-[Al(R)O]_{p+q}-$ with pentafluorophenol, pentafluorothiophenol, or pentafluoroaniline, respectively, in the amounts required to produce the cocatalysts at the p:q ratio from 10:1 to 0:1.

12. The catalyst composition of Claims 1, 2, 3 or 4 wherein R is the methyl group.

13. The catalyst composition of Claims 1, 2, 3, or 4 wherein the perfluorinated cocatalysts of the formula $-[Al(R)O]_p-[Al(XC_6F_5)O]_q-$, wherein X is oxygen atom, a sulfur atom or an NH group, are produced in steps comprising

- (i) reacting a trialkylaluminum compound of the formula AlR_3 with pentafluorophenol, pentafluorothiophenol, or pentafluoroaniline, respectively, in the amounts corresponding to the molar $[Al]:[perfluorinated\ agent]$ ratio from 2:1 to 1:1;
- (ii) reacting the product of step (i) with water at the molar $[AlR_3]:[H_2O]$ ratio of 2:1 to 1:1.



14. The catalyst composition of Claim 13 wherein the alkyl group R in the trialkylaluminum compound is selected from a group comprising methyl, ethyl, propyl, isopropyl, *n*-butyl, isobutyl, *n*-pentyl, isopentyl, *n*-hexyl, isohexyl, *n*-heptyl, isoheptyl, *n*-octyl, or isooctyl groups.

15. A catalyst composition for polymerization of alpha-olefins comprising the contact product of a metallocene complex of a transition metal of the formula $Cp_xMA_yB_z$

wherein x is 1 or 2; M is titanium, zirconium or hafnium; Cp is a cyclopentadienyl group, a substituted cyclopentadienyl group, a cyclopentadienyl group that is a part of a bicyclic or a tricyclic moiety or, when x is 2, the two cyclopentadienyl groups are optionally bridged; and each of A and B is selected from the group consisting of a halogen atom, a hydrogen atom, an alkyl group, or combinations thereof; providing that x+y+z is equal to the valence of M; and

a solid cocatalyst containing perfluorinated phenyl groups and produced in steps comprising

- (i) reacting solid $Al(OH)_3$ with a trialkylaluminum compound of the formula AlR_3 at a molar $[AlR_3]:[Al(OH)_3]$ ratio of 1:1 to 0.2:1;
- (ii) reacting the product of step (i) with pentafluorophenol, pentafluorothiophenol, or pentafluoroaniline in the amounts corresponding to the molar $[AlR_3]:[perfluorinated\ agent]$ ratio from 2:1 to 1:1.

16. In a process for activating a metallocene complex with an alkylalumoxane, the modification comprising

reacting the alkylalumoxane of the formula $[Al(R)-O]_n$ with a compound selected from the group consisting of pentafluorophenol, pentafluorothiophenol and pentafluoroaniline to form a contact product; and contacting the above contact product with said metallocene complex.



17. In a process for activating a metallocene complex with a reaction product of a trialkylaluminum compound and water, the modification comprising

contacting the trialkylaluminum compound with a compound selected from the group consisting of pentafluorophenol, pentafluorothiophenol and pentafluoroaniline
5 to form an intermediate product, reacting the intermediate product with water, and
contacting the above product with said metallocene complex.