

**MIXED CATALYSTS WITH 2,6-BIS(IMINO)PYRIDYL IRON COMPLEXES AND
BRIDGED HAFNOCENES**

INVENTORS: Matthew W. Holtcamp, Xuan Ye, Charles J. Harlan, Michelle E. Titone,
5 Matthew S. Bedoya, Subramaniam Kuppuswamy, Hasnain Rangwalla

PRIORITY CLAIM

This application claims priority to and the benefit of USSN 62/541,360, filed August 4,
2017 and EP 17196645.0, filed October 16, 2017 and are incorporated by reference in their
10 entirety.

FIELD OF THE INVENTION

The present invention relates to dual catalyst systems and processes for use thereof. In
particular, the catalyst system includes a bridged group 4 metallocene compound, a 2,6-
bis(imino)pyridyl iron complex, a support material and an activator. The catalyst system may
15 be used for olefin polymerization processes.

BACKGROUND OF THE INVENTION

Polyolefins are widely used commercially because of their robust physical properties.
For example, various types of polyethylenes, including high density, low density, and linear
low density polyethylenes, are some of the most commercially useful. Polyolefins are typically
20 prepared with a catalyst that polymerizes olefin monomers.

Low density polyethylene is generally prepared at high pressure using free radical
initiators. Low density polyethylene typically has a density at about 0.916-0.930 g/cm³.
Typical low density polyethylene produced using free radical initiators is known in the industry
as "LDPE". LDPE is also known as "branched" or "heterogeneously branched" polyethylene
25 because of the relatively large number of long chain branches extending from the main polymer
backbone. Polyethylene with a similar density that does not contain long chain branches is
known as "linear low density polyethylene" ("LLDPE") and is typically produced with
conventional Ziegler-Natta catalysts or with metallocene catalysts. "Linear" means that the
polyethylene has few, if any, long chain branches and typically has a g'vis value of 0.97 or
30 above, such as 0.98 or above. Polyethylenes having still greater density are the high density
polyethylenes ("HDPEs"), e.g., polyethylenes having densities greater than 0.940 g/cm³ and
are generally prepared with Ziegler-Natta or chrome catalysts. Very low density polyethylenes
("VLDPEs") can be produced by a number of different processes yielding polyethylenes
typically having a density 0.890 to 0.915 g/cm³.

Copolymers of polyolefins, such as polyethylene, have a comonomer, such as hexene, incorporated into the polyethylene backbone. These copolymers provide varying physical properties compared to polyethylene alone and are typically produced in a low pressure reactor, utilizing, for example, solution, slurry, or gas phase polymerization processes. Polymerization
5 may take place in the presence of catalyst systems such as those employing a Ziegler-Natta catalyst, a chromium based catalyst, or a metallocene catalyst.

A copolymer composition has a composition distribution, which refers to the distribution of comonomer in copolymer, typically in the copolymer backbone. When the amount of comonomer varies among the copolymer molecules, the composition is said to have
10 a “broad” composition distribution. When the amount of comonomer per 1000 carbons is similar among the copolymer molecules of different chain lengths, the composition distribution is said to be “narrow.”

The composition distribution influences the properties of a copolymer composition, for example, stiffness, toughness, environmental stress crack resistance, and heat sealing, among
15 other properties. The composition distribution of a polyolefin composition may be readily measured by, for example, Temperature Rising Elution Fractionation (TREF) or Crystallization Analysis Fractionation (CRYSTAF).

A composition distribution of a copolymer composition is influenced by the identity of the catalyst used to form the polyolefins of the composition. Ziegler-Natta catalysts and
20 chromium based catalysts produce compositions with broad composition distributions, whereas metallocene catalysts typically produce compositions with narrow composition distributions.

Furthermore, polyolefins, such as polyethylenes, which have high molecular weight, generally have desirable mechanical properties over their lower molecular weight counterparts. However, high molecular weight polyolefins can be difficult to process and can be costly to
25 produce. Polyolefin compositions having a bimodal molecular weight distribution are desirable because they can combine the advantageous mechanical properties of a high molecular weight fraction of the composition with the improved processing properties of a low molecular weight fraction of the composition. As used herein, “high molecular weight” is defined as a weight average molecular weight (Mw) value of 150,000 g/mol or more. “Low
30 molecular weight” is defined as an Mw value of less than 150,000 g/mol.

For example, useful bimodal polyolefin compositions include a first polyolefin having low molecular weight and high comonomer content (i.e., comonomer incorporated into the polyolefin backbone) while a second polyolefin has a high molecular weight and low comonomer content. As used herein, “low comonomer content” is defined as a polyolefin

having 6 wt% or less of comonomer based upon the total weight of the polyolefin. The high molecular weight fraction produced by the second catalyst compound may have a high comonomer content. As used herein, "high comonomer content" is defined as a polyolefin having greater than 6 wt% of comonomer based upon the total weight of the polyolefin.

5 There are several methods for producing bimodal or broad molecular weight distribution polyolefins, e.g., melt blending, polymerization in reactors in series or parallel configuration, or single reactor with bimetallic catalysts. However, methods such as melt blending suffer from the disadvantages brought by the need for complete homogenization of polyolefin compositions and high cost.

10 Furthermore, synthesizing these bimodal polyolefin compositions in a mixed catalyst system would involve a first catalyst to catalyze the polymerization of, for example, ethylene under substantially similar conditions as that of a second catalyst while not interfering with the catalysis of polymerization of the second catalyst. For example, two different metallocene catalysts may interfere with the polymerization catalysis of each other, resulting in reduced
15 catalytic activity, reduced molecular weight polyolefins, reduced comonomer incorporation, and potential fouling.

 There exists a need for catalyst systems that provide polyolefin compositions having novel combinations of comonomer content fractions and molecular weights. There is further a need for novel catalyst systems where a first catalyst does not negatively impact the
20 polymerization catalysis of a second catalyst or vice versa.

 Useful catalysts for olefin polymerization are often based on cyclopentadienyl transition metal catalyst compounds (metallocenes) as catalyst precursors combined with activators, typically an alumoxane or with an activator containing a non-coordinating anion. A typical metallocene catalyst system includes metallocene catalyst, activator, and optional
25 support. Supported catalyst systems are used in many polymerization processes, often in slurry or gas phase polymerization processes.

 Catalysts for olefin polymerization are often based on substituted metallocenes as catalyst precursors, which are activated either with the help of an alumoxane, or with an activator containing a non-coordinating anion.

30 For example, U.S. Patent No. 7,829,495 discloses $\text{Me}_2\text{Si}(\text{fluorenyl})(3\text{-nPr-Cp})\text{ZrCl}_2$ and U.S. Patent No. 7,179,876 discloses supported $(\text{nPrCp})_2\text{HfMe}_2$.

 Further, Stadelhofer, J.; Weidlein, J.; Haaland, A. *J. Organomet. Chem.* **1975**, 84, C1-C4 discloses preparation of potassium cyclopentadienide.

Metallocenes are often combined with other catalysts, or even other metallocenes, to attempt to modify polymer properties. See, for example, U.S. Patent Nos. 8,088,867 and 5,516,848 (which discloses the use of two different cyclopentadienyl based transition metal catalyst compounds activated with alumoxane or non-coordinating anions). See also WO 5 2016/171810, which discloses two metallocenes used to make ethylene copolymers.

Likewise, $\text{Me}_2\text{C}(\text{Cp})(\text{Me}_3\text{SiCH}_2\text{-Ind})\text{MCl}_2$ and $\text{Me}_2\text{C}(\text{Cp})(\text{Me}, \text{Me}_3\text{SiCH}_2\text{-Ind})\text{MCl}_2$, where M is Zr or Hf have been synthesized and screened for the syndiospecific polymerization of propylene; see Leino, R., Gomez, F.; Cole, A.; Waymouth, R. *Macromolecules* **2001**, *34*, 2072-2082.

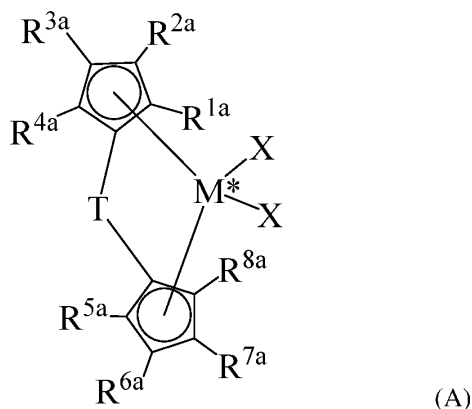
10 Additional references of interest include: Hong et al. in Immobilized $\text{Me}_2\text{Si}(\text{C}_5\text{Me}_4)(\text{N-t-Bu})\text{TiCl}_2/(\text{nBuCp})_2\text{ZrCl}_2$ Hybrid Metallocene Catalyst System for the Production of Poly(ethylene-co-hexene) with Pseudo-bimodal Molecular Weight and Inverse Comonomer Distribution, (Polymer Engineering and Science-2007, DOI 10.1002/pen, pages 131-139, published online in Wiley InterScience (www.interscience.wiley.com) 2007 Society of Plastics
15 Engineers); Kim, J. D. et al., J. Polym. Sci. Part A: Polym Chem., 38, 1427 (2000); Iedema, P.D. et al., Ind. Eng. Chem. Res., 43, 36 (2004); U.S. Patent Nos. 4,701,432; 5,032,562; 5,077,255; 5,135,526; 5,183,867; 5,382,630; 5,382,631; 5,516,848; 5,525,678; 6,069,213; 6,207,606; 6,380,311; 6,656,866; 6,828,394; 6,964,937; 6,956,094; 6,995,109; 7,041,617; 7,119,153; 7,129,302; 7,141,632; 7,172,987; 7,179,876; 7,192,902; 7,199,072; 7,199,073;
20 7,226,886; 7,285,608; 7,312,283; 7,355,058; 7,385,015; 7,396,888; 7,547,754; 7,572,875; 7,595,364; 7,619,047; 7,625,982; 7,662,894; 7,829,495; 7,855,253; 8,088,867; 8,110,518; 8,138,113; 8,268,944; 8,288,487; 8,329,834; 8,378,029; 8,383,754; 8,575,284; 8,598,061; 8,680,218; 8,785,551; 8,815,357; 8,846,841; 8,940,842; 8,957,168; 9,006,367; 9,079,993; 9,096,745; 9,163,098; 9,181,370; 9,217,049; 9,303,099; 9,447,265; U.S. Publications
25 2004/259722; 2006/275571; 2012/130032; 2014/031504; 2014/127427; 2015/322184; 2015/299352; 2016/032027; 2016/075803; 2017/114167; PCT Publications WO 97/35891; WO 98/49209; WO 00/12565; WO 2001/09200; WO 02/060957; WO 2004/046214; WO 2006/080817; WO 2007/067259; WO 2007/080365; WO 2009/146167; WO 2012/006272; WO 2012/158260; WO 2015/123168; WO 2016/172099; WO 2016/171807; EP 2 374 822; EP
30 2 003 166; EP 0 729 387; EP 0 676 418; EP 0 705 851; KR 20150058020; KR 101132180; Sheu, S., 2006, "Enhanced bimodal PE makes the impossible possible", <http://www.tappi.org/content/06asiaplace/pdfs-english/enhanced.pdf>; Chen et al., "Modeling and Simulation of Borstar Bimodal Polyethylene Process Based on Rigorous PC-SAFT Equation of State Model", Industrial & Engineering Chemical Research, 53, pp. 19905-19915,

(2014); A. Calhoun, et al. "Polymer Chemistry", Chapter 5, pages 77-87; and Stadelhofer, et al., J. Organomet. Chem, 1975, 84, pp. C1-C4.

There is still a need in the art for new and improved catalyst systems for the polymerization of olefins, in order to achieve increased activity or enhanced polymer properties, to increase conversion or comonomer incorporation, or to alter comonomer distribution. There is also a need for supported catalyst systems and processes for the polymerization of olefins (such as ethylene) using such catalyst systems to provide ethylene polymers having the unique properties of high stiffness, high toughness and good processability.

10 **SUMMARY OF THE INVENTION**

The present invention provides a supported catalyst system including a bridged group 4 metallocene compound, an iron compound, specifically a 2,6-bis(imino)pyridyl iron complex, a support material and an activator. The bridged group 4 metallocene compound is represented by the formula (A):



wherein:

M^* is a group 4 metal;

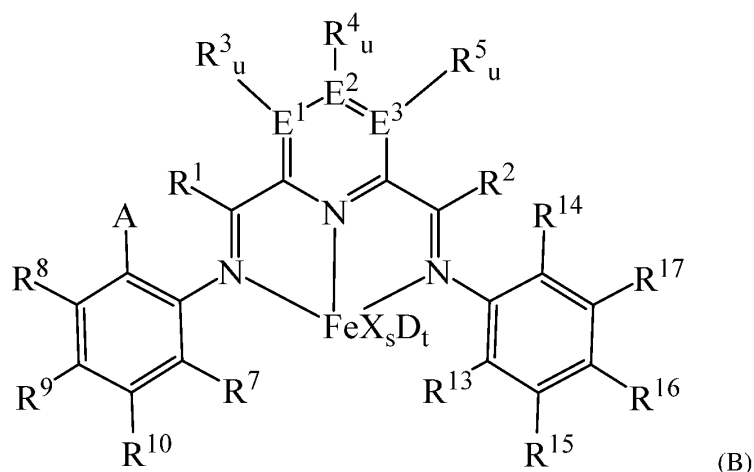
each of R^{1a} , R^{2a} , and R^{4a} is independently hydrogen, alkoxide or C_1 to C_{40} substituted or unsubstituted hydrocarbyl;

20 R^{3a} is independently hydrogen, alkoxide, C_1 to C_{40} substituted or unsubstituted hydrocarbyl, or $-R^{9a}-SiR'_3$ or $-R^{9a}-CR'_3$ where R^{9a} is C_1 to C_4 hydrocarbyl, and each R' is independently C_1 to C_{20} substituted or unsubstituted hydrocarbyl and at least one R' is C_1 to C_{20} substituted or unsubstituted hydrocarbyl;

25 each of R^{5a} , R^{6a} , and R^{8a} is independently hydrogen, halide, alkoxide or C_1 to C_{40} substituted or unsubstituted hydrocarbyl;

- R^{7a} is $-R^{9a}-SiR'_3$ or $-R^{9a}-CR'_3$ where R^{9a} is C_1 to C_4 hydrocarbyl, and each R' is independently C_1 to C_{20} substituted or unsubstituted hydrocarbyl, and at least one R' is H;
- T is a bridging group; and
- each X is independently a univalent anionic ligand, a diene ligand, an alkylidene ligand, or two
- 5 Xs are joined to form a metallocyclic ring.

The iron complex is represented by formula (B):



wherein:

- A is chlorine, bromine, iodine, $-CF_3$ or $-OR^{11}$;
- 10 each of R^1 and R^2 is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or five-, six- or seven-membered heterocyclyl comprising at least one atom selected from the group consisting of N, P, O and S;
- wherein each of R^1 and R^2 is optionally substituted by halogen, $-NR^{11}_2$, $-OR^{11}$ or $-SiR^{12}_3$;
- 15 wherein R^1 optionally bonds with R^3 , and R^2 optionally bonds with R^5 , in each case to independently form a five-, six- or seven-membered ring;
- R^7 is a C_1 - C_{20} alkyl;
- each of R^3_u , R^4_u , R^5_u , R^8 , R^9 , R^{10} , R^{15} , R^{16} , and R^{17} is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has
- 20 from 6 to 20 carbon atoms, $-NR^{11}_2$, $-OR^{11}$, halogen, $-SiR^{12}_3$ or five-, six- or seven-membered heterocyclyl comprising at least one atom selected from the group consisting of N, P, O and S; wherein R^3 , R^4 , R^5 , R^7 , R^8 , R^9 , R^{10} , R^{15} , R^{16} , and R^{17} are optionally substituted by halogen, $-NR^{11}_2$, $-OR^{11}$ or $-SiR^{12}_3$;

- wherein R³ optionally bonds with R⁴, R⁴ optionally bonds with R⁵, R⁷ optionally bonds with R¹⁰, R¹⁰ optionally bonds with R⁹, R⁹ optionally bonds with R⁸, R¹⁷ optionally bonds with R¹⁶, and R¹⁶ optionally bonds with R¹⁵, in each case to independently form a five-, six- or seven-membered carbocyclic or heterocyclic ring, the heterocyclic ring comprising at least one atom
- 5 from the group consisting of N, P, O and S;
- R¹³ is C₁-C₂₀-alkyl bonded with the aryl ring via a primary or secondary carbon atom;
- R¹⁴ is chlorine, bromine, iodine, -CF₃ or -OR¹¹, or C₁-C₂₀-alkyl bonded with the aryl ring;
- each R¹¹ is independently hydrogen, C₁-C₂₂-alkyl, C₂-C₂₂-alkenyl, C₆-C₂₂-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or -SiR¹²₃,
- 10 wherein R¹¹ is optionally substituted by halogen, or two R¹¹ radicals optionally bond to form a five- or six-membered ring;
- each R¹² is independently hydrogen, C₁-C₂₂-alkyl, C₂-C₂₂-alkenyl, C₆-C₂₂-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or two R¹² radicals optionally bond to form a five- or six-membered ring;
- 15 each of E¹, E², and E³ is independently carbon, nitrogen or phosphorus;
- each u is independently 0 if E¹, E², and/or E³ is nitrogen or phosphorus and is independently 1 if E¹, E², and/or E³ is carbon;
- each X is independently fluorine, chlorine, bromine, iodine, hydrogen, C₁-C₂₀-alkyl, C₂-C₁₀-alkenyl, C₆-C₂₀-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6
- 20 to 20 carbon atoms, -NR¹⁸₂, -OR¹⁸, -SR¹⁸, -SO₃R¹⁸, -OC(O)R¹⁸, -CN, -SCN, β-diketonate, -CO, -BF₄⁻, -PF₆⁻ or bulky non-coordinating anions, and the radicals X can be bonded with one another;
- each R¹⁸ is independently hydrogen, C₁-C₂₀-alkyl, C₂-C₂₀-alkenyl, C₆-C₂₀-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or -SiR¹⁹₃,
- 25 wherein R¹⁸ can be substituted by halogen or nitrogen- or oxygen-containing groups and two R¹⁸ radicals optionally bond to form a five- or six-membered ring;
- each R¹⁹ is independently hydrogen, C₁-C₂₀-alkyl, C₂-C₂₀-alkenyl, C₆-C₂₀-aryl or arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, wherein R¹⁹ can be substituted by halogen or nitrogen- or oxygen-containing groups or two R¹⁹ radicals
- 30 optionally bond to form a five- or six-membered ring;
- s is 1, 2, or 3;
- D is a neutral donor; and
- t is 0 to 2.

The present invention further provides a process for polymerization of monomers (such as olefin monomers) comprising contacting one or more monomers with the above supported catalyst systems.

5 The present invention further provides a process to produce ethylene polymer compositions comprising: i) contacting in a single reaction zone, in the gas phase or slurry phase, ethylene and C₃ to C₂₀ comonomer with a catalyst system comprising a support, an activator, and the catalyst system described above, and ii) obtaining an in-situ ethylene polymer composition having at least 50 mol% ethylene and a density of 0.890 g/cc or more, alternatively 0.935 g/cc or more.

10 The present invention further provides a process to produce ethylene polymer compositions comprising: i) contacting in a single reaction zone, in the gas phase or slurry phase, ethylene and C₃ to C₂₀ comonomer with a catalyst system comprising a support, an activator, and the catalyst system described above, and obtaining an ethylene polymer: a) an RCI_m greater than 20 and less than 35 and an Mw/Mn of 1 to 15; or b) an RCI_m greater than 15 50 and an Mw/Mn of greater than 5.

The present invention further provides polymer compositions produced by the methods and catalyst systems described herein.

BRIEF DESCRIPTION OF THE DRAWINGS

20 The Figure is a graph illustrating a temperature rising elution fractionation curve of the polymer from the mixed catalyst system of Table 1.

DETAILED DESCRIPTION

25 The present invention provides dual catalyst systems and processes for use thereof. In particular, the catalyst system includes a bridged group 4 metallocene compound, a 2,6-bis(imino)pyridyl iron complex, a support material and an activator. The catalyst system may be used for olefin polymerization processes. Catalyst systems of the present invention can provide increased activity or enhanced polymer properties, to increase conversion or comonomer incorporation, or to alter comonomer distribution. Catalyst systems and processes of the present invention can provide ethylene polymers having the unique properties of high stiffness, high toughness and good processability.

30 For purposes of the present invention, a "catalyst system" is a combination of at least two catalyst compounds, an activator, and a support material. The catalyst systems may further comprise one or more additional catalyst compounds. The terms "mixed catalyst system," "dual catalyst system," "mixed catalyst," and "supported catalyst system" may be used interchangeably herein with "catalyst system." For the purposes of the present invention, when

catalyst systems are described as comprising neutral stable forms of the components, it is well understood by one of ordinary skill in the art, that the ionic form of the component is the form that reacts with the monomers to produce polymers.

As used herein, the term “metallocene compound” includes compounds having two or
5 three Cp ligands (cyclopentadienyl and ligands isolobal to cyclopentadienyl) bound to at least one Zr or Hf metal atom, and one or more leaving group(s) bound to the at least one metal atom.

For purposes of the present invention in relation to all metallocene catalyst compounds, the term “substituted” means that a hydrogen group has been replaced with a hydrocarbyl
10 group, a heteroatom, or a heteroatom containing group. For example, methyl cyclopentadiene (Cp) is a Cp group substituted with a methyl group.

For purposes of the present invention, “alkoxides” include those where the alkyl group is a C₁ to C₁₀ hydrocarbyl. The alkyl group may be straight chain, branched, or cyclic. The alkyl group may be saturated or unsaturated. In some embodiments, the alkyl group may
15 comprise at least one aromatic group.

The term “complex” is used to describe molecules in which an ancillary ligand is coordinated to a central transition metal atom. The ligand is bulky and stably bonded to the transition metal so as to maintain its influence during use of the catalyst, such as polymerization. The ligand may be coordinated to the transition metal by covalent bond and/or
20 electron donation coordination or intermediate bonds. The transition metal complexes are generally subjected to activation to perform their polymerization function using an activator which is believed to create a cation as a result of the removal of an anionic group, often referred to as a leaving group, from the transition metal. “Complex,” as used herein, is also often referred to as “catalyst precursor,” “pre-catalyst,” “catalyst,” “catalyst compound,” “metal
25 compound,” “metal catalyst compound,” “transition metal compound,” or “transition metal complex.” These words are used interchangeably. “Activator” and “cocatalyst” are also used interchangeably.

The terms “hydrocarbyl radical,” “hydrocarbyl” and “hydrocarbyl group” are used interchangeably throughout this document. Likewise, the terms “group,” “radical,” and
30 “substituent” are also used interchangeably in this document. For purposes of the present invention, “hydrocarbyl radical” is defined to be C₁-C₁₀₀ radicals, that may be linear, branched, or cyclic, and when cyclic, aromatic or non-aromatic.

For purposes of the present invention, unless otherwise indicated, the term “substituted” means that a hydrogen group has been replaced with a heteroatom, or a heteroatom containing

group. For example, substituted hydrocarbyl radicals are radicals in which at least one hydrogen atom of the hydrocarbyl radical has been substituted with at least one functional group such as Cl, Br, F, I, NR^{*}₂, OR^{*}, SeR^{*}, TeR^{*}, PR^{*}₂, AsR^{*}₂, SbR^{*}₂, SR^{*}, BR^{*}₂, SiR^{*}₃, GeR^{*}₃, SnR^{*}₃, PbR^{*}₃, and the like (where R^{*} is H or a C₁ to C₂₀ hydrocarbyl group), or where
5 at least one heteroatom has been inserted within a hydrocarbyl ring.

The term “ring atom” means an atom that is part of a cyclic ring structure. By this definition, a benzyl group has six ring atoms and tetrahydrofuran has 5 ring atoms.

A “ring carbon atom” is a carbon atom that is part of a cyclic ring structure. By this definition, a benzyl group has six ring carbon atoms and para-methylstyrene also has six ring
10 carbon atoms.

The term “aryl” or “aryl group” means a six carbon aromatic ring and the substituted variants thereof, including but not limited to, phenyl, 2-methyl-phenyl, xylyl, 4-bromo-xylyl. Likewise, heteroaryl means an aryl group where a ring carbon atom (or two or three ring carbon atoms) has been replaced with a heteroatom, preferably, N, O, or S.

15 The term “arylalkyl” is an aryl-substituted alkyl radical and may be used interchangeably with the term “aralkyl.” Examples of aralkyl include benzyl, diphenylmethyl, triphenylmethyl, phenylethyl, and diphenylethyl.

A “heterocyclic ring” is a ring having a heteroatom in the ring structure as opposed to a heteroatom substituted ring where a hydrogen on a ring atom is replaced with a heteroatom.
20 For example, tetrahydrofuran is a heterocyclic ring and 4-N,N-dimethylamino-phenyl is a heteroatom substituted ring.

As used herein the term “aromatic” also refers to pseudoaromatic heterocycles which are heterocyclic substituents that have similar properties and structures (nearly planar) to aromatic heterocyclic ligands, but are not by definition aromatic; likewise, the term aromatic
25 also refers to substituted aromatics.

The term “continuous” means a system that operates without interruption or cessation. For example, a continuous process to produce a polymer would be one where the reactants are continually introduced into one or more reactors and polymer product is continually withdrawn.

As used herein, the numbering scheme for the Periodic Table groups is the new notation
30 as set out in Chemical and Engineering News, 63(5), 27, (1985).

An “olefin,” is a linear, branched, or cyclic compound of carbon and hydrogen having at least one double bond. For purposes of this specification and the claims appended thereto, when a polymer or copolymer is referred to as comprising an olefin, the olefin present in such polymer or copolymer is the polymerized form of the olefin. For example, when a copolymer

is said to have an “ethylene” content of 35 wt% to 55 wt%, it is understood that the mer unit in the copolymer is derived from ethylene in the polymerization reaction and said derived units are present at 35 wt% to 55 wt%, based upon the weight of the copolymer. A “polymer” has two or more of the same or different mer units. A “homopolymer” is a polymer having mer units that are the same. A “copolymer” is a polymer having two or more mer units that are different from each other. “Different” as used to refer to mer units indicates that the mer units differ from each other by at least one atom or are different isomerically. Accordingly, the definition of copolymer, as used herein, includes terpolymers and the like. An “ethylene polymer” or “ethylene copolymer” is a polymer or copolymer comprising at least 50 mol% ethylene derived units, a “propylene polymer” or “propylene copolymer” is a polymer or copolymer comprising at least 50 mol% propylene derived units, and so on.

For purposes of the present invention, an ethylene polymer having a density of 0.86 g/cm³ or less is referred to as an ethylene elastomer or elastomer; an ethylene polymer having a density of more than 0.86 to less than 0.910 g/cm³ is referred to as an ethylene plastomer or plastomer; an ethylene polymer having a density of 0.910 to 0.940 g/cm³ is referred to as a low density polyethylene; and an ethylene polymer having a density of more than 0.940 g/cm³ is referred to as a high density polyethylene (HDPE). Density is determined according to ASTM D 1505 using a density-gradient column on a compression-molded specimen that has been slowly cooled to room temperature (i.e., over a period of 10 minutes or more) and allowed to age for a sufficient time that the density is constant within +/- 0.001 g/cm³.

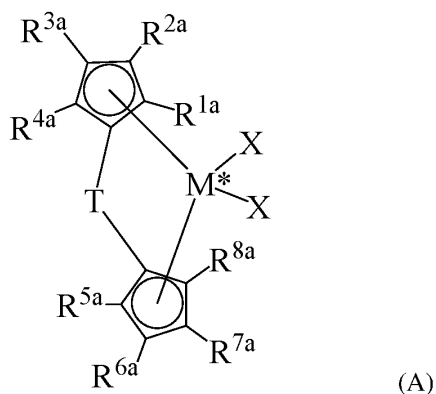
Polyethylene in an overlapping density range, i.e., 0.890 to 0.930 g/cm³, typically from 0.915 to 0.930 g/cm³, which is linear and does not contain long chain branching is referred to as “linear low density polyethylene” (LLDPE) and has been produced with conventional Ziegler-Natta catalysts, vanadium catalysts, or with metallocene catalysts in gas phase reactors and/or in slurry reactors and/or in solution reactors. “Linear” means that the polyethylene has no long chain branches, typically referred to as a branching index (g'_{vis}) of 0.97 or above, preferably 0.98 or above. Branching index, g'_{vis} , is measured by GPC-4D as described below.

For purposes of the present invention, ethylene shall be considered an alpha-olefin (α -olefin).

As used herein, M_n is number average molecular weight, M_w is weight average molecular weight, and M_z is z average molecular weight, wt% is weight percent, and mol% is mole percent. Unless otherwise noted, all average molecular weights (e.g., M_w , M_n , M_z) are reported in units of g/mol. Molecular weight distribution (MWD), also referred to as polydispersity index (PDI), is defined to be M_w divided by M_n .

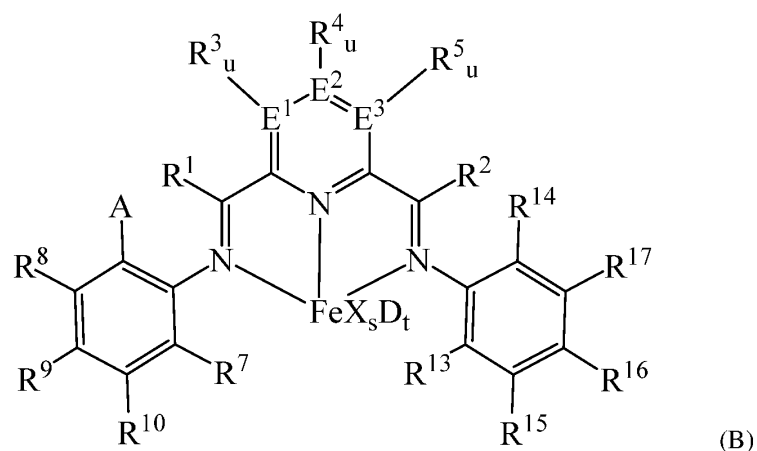
The following abbreviations may be used herein: Me is methyl, Et is ethyl, t-Bu and ^tBu are tertiary butyl, iPr and ⁱPr are isopropyl, Cy is cyclohexyl, THF (also referred to as thf) is tetrahydrofuran, Bn is benzyl, Ph is phenyl, Cp is cyclopentadienyl, Cp* is pentamethyl cyclopentadienyl, Ind is indenyl, Flu is fluorenyl, and MAO is methylalumoxane.

- 5 The present invention provides a supported catalyst system comprising: a bridged group 4 metallocene compound, an iron compound, specifically a 2,6-bis(imino)pyridyl iron complex, a support material and an activator. The bridged group 4 metallocene compound is represented by the formula (A):



- 10 wherein:
 M* is a group 4 metal;
 each of R^{1a}, R^{2a} and R^{4a} is independently hydrogen, alkoxide or C₁ to C₄₀ substituted or unsubstituted hydrocarbyl;
 R^{3a} is independently hydrogen, alkoxide, C₁ to C₄₀ substituted or unsubstituted hydrocarbyl, or
 15 –R^{9a}–SiR'₃ or –R^{9a}–CR'₃ where R^{9a} is C₁ to C₄ hydrocarbyl, and each R' is independently C₁ to C₂₀ substituted or unsubstituted hydrocarbyl and at least one R' is C₁ to C₂₀ substituted or unsubstituted hydrocarbyl;
 each of R^{5a}, R^{6a}, and R^{8a} is independently hydrogen, halide, alkoxide or C₁ to C₄₀ substituted or unsubstituted hydrocarbyl;
 20 R^{7a} is –R^{9a}–SiR'₃ or –R^{9a}–CR'₃ where R^{9a} is C₁ to C₄ hydrocarbyl, and each R' is independently C₁ to C₂₀ substituted or unsubstituted hydrocarbyl, and at least one R' is H;
 T is a bridging group; and
 each X is independently a univalent anionic ligand, a diene ligand, an alkylidene ligand, or two Xs are joined to form a metallocyclic ring.

- 25 The iron complex is represented by formula (B):



wherein:

A is chlorine, bromine, iodine, -CF₃ or -OR¹¹;

each of R¹ and R² is independently hydrogen, C₁-C₂₂-alkyl, C₂-C₂₂-alkenyl, C₆-C₂₂-aryl,
 5 arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms,
 or five-, six- or seven-membered heterocyclyl comprising at least one atom selected from the
 group consisting of N, P, O and S;

wherein each of R¹ and R² is optionally substituted by halogen, -NR¹¹₂, -OR¹¹ or -SiR¹²₃;

wherein R¹ optionally bonds with R³, and R² optionally bonds with R⁵, in each case to
 10 independently form a five-, six- or seven-membered ring;

R⁷ is a C₁-C₂₀ alkyl;

each of R³_u, R⁴_u, R⁵_u, R⁸, R⁹, R¹⁰, R¹⁵, R¹⁶, and R¹⁷ is independently hydrogen, C₁-C₂₂-alkyl,
 C₂-C₂₂-alkenyl, C₆-C₂₂-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has
 from 6 to 20 carbon atoms, -NR¹¹₂, -OR¹¹, halogen, -SiR¹²₃ or five-, six- or seven-membered
 15 heterocyclyl comprising at least one atom selected from the group consisting of N, P, O,
 and S;

wherein R³, R⁴, R⁵, R⁷, R⁸, R⁹, R¹⁰, R¹⁵, R¹⁶, and R¹⁷ are optionally substituted by halogen,
 -NR¹¹₂, -OR¹¹ or -SiR¹²₃;

wherein R³ optionally bonds with R⁴, R⁴ optionally bonds with R⁵, R⁷ optionally bonds with
 20 R¹⁰, R¹⁰ optionally bonds with R⁹, R⁹ optionally bonds with R⁸, R¹⁷ optionally bonds with R¹⁶,
 and R¹⁶ optionally bonds with R¹⁵, in each case to independently form a five-, six- or seven-
 membered carbocyclic or heterocyclic ring, the heterocyclic ring comprising at least one atom
 from the group consisting of N, P, O and S;

R¹³ is C₁-C₂₀-alkyl bonded with the aryl ring via a primary or secondary carbon atom;

25 R¹⁴ is chlorine, bromine, iodine, -CF₃ or -OR¹¹, or C₁-C₂₀-alkyl bonded with the aryl ring;

- each R¹¹ is independently hydrogen, C₁-C₂₂-alkyl, C₂-C₂₂-alkenyl, C₆-C₂₂-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or -SiR¹²₃, wherein R¹¹ is optionally substituted by halogen, or two R¹¹ radicals optionally bond to form a five- or six-membered ring;
- 5 each R¹² is independently hydrogen, C₁-C₂₂-alkyl, C₂-C₂₂-alkenyl, C₆-C₂₂-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or two R¹² radicals optionally bond to form a five- or six-membered ring;
- each of E¹, E², and E³ is independently carbon, nitrogen or phosphorus;
- each u is independently 0 if E¹, E², and/or E³ is nitrogen or phosphorus and is 1 if E¹, E², and/or
- 10 E³ is carbon;
- each X is independently fluorine, chlorine, bromine, iodine, hydrogen, C₁-C₂₀-alkyl, C₂-C₁₀-alkenyl, C₆-C₂₀-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, -NR¹⁸₂, -OR¹⁸, -SR¹⁸, -SO₃R¹⁸, -OC(O)R¹⁸, -CN, -SCN, β-diketonate, -CO, -BF₄⁻, -PF₆⁻ or bulky non-coordinating anions, and the radicals X can be bonded with one
- 15 another;
- each R¹⁸ is independently hydrogen, C₁-C₂₀-alkyl, C₂-C₂₀-alkenyl, C₆-C₂₀-aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or -SiR¹⁹₃, wherein R¹⁸ can be substituted by halogen or nitrogen- or oxygen-containing groups and two R¹⁸ radicals optionally bond to form a five- or six-membered ring;
- 20 each R¹⁹ is independently hydrogen, C₁-C₂₀-alkyl, C₂-C₂₀-alkenyl, C₆-C₂₀-aryl or arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, wherein R¹⁹ can be substituted by halogen or nitrogen- or oxygen-containing groups or two R¹⁹ radicals optionally bond to form a five- or six-membered ring;
- s is 1, 2, or 3;
- 25 D is a neutral donor; and
- t is 0 to 2, preferably 0, 1, or 2.

The present invention further provides a process for polymerization of olefin monomers which comprises contacting one or more monomers with the above supported catalyst systems.

- In embodiments, the above two catalyst components can have different hydrogen
- 30 responses (each having a different reactivity toward hydrogen) during the polymerization process. Hydrogen is often used in olefin polymerization to control the final properties of the polyolefin. The first catalyst component can show a more negative response to changes of hydrogen concentration in reactor than the second catalyst component. Owing to, *inter alia*, the differing hydrogen response of the catalyst components in the supported catalyst systems,

the properties of resulting polymer are controllable. Changes of hydrogen concentration in reactor may affect molecular weight, molecular weight distributions, and other properties of the resulting polyolefin when using a combination of such two catalyst components. Thus, the present invention further provides a multi-modal polyolefin obtained from polymerizations
5 using the above supported catalyst systems.

In at least one embodiment, catalyst A is a good comonomer (such as hexene) incorporator and yields polyethylene with higher molecular weight than catalyst B which under similar conditions yields lower molecular weight than catalyst A. Catalyst B can also incorporate less comonomer (such as hexene) under similar reaction conditions. When catalyst
10 A and catalyst B are combined on one support, an in-reactor blend of polyethylene is produced with a mix of low and high density resins in which the higher density resin (higher melting) is combined with lower density higher molecular weight resin. Catalyst A may be a single isomer or a combination of isomers, e.g., 2, 3, 4, 5, or 6 isomers, typically 1 or 2 isomers.

The two transition metal catalyst compounds may be used in any ratio. Preferred molar
15 ratios of (A) a bridged group 4 metallocene compound to (B) iron compound fall within the range of (A:B) 1:1000 to 1000:1, alternatively 1:100 to 500:1, alternatively 1:10 to 200:1, alternatively 1:1 to 100:1, and alternatively 1:1 to 75:1, and alternatively 5:1 to 50:1. The particular ratio chosen will depend on the exact catalyst compounds chosen, the method of activation, and the end product desired. In a particular embodiment, when using the two
20 catalyst compounds, where both are activated with the same activator, useful mole percents, based upon the molecular weight of the catalyst compounds, are 10 to 99.9% A to 0.1 to 90% B, alternatively 25 to 99% A to 0.5 to 50% B, alternatively 50 to 99% A to 1 to 25% B, and alternatively 75 to 99% A to 1 to 10% B.

For purposes of the present invention, one metallocene catalyst compound is considered
25 different from another if they differ by at least one atom. For example “bisindenyl zirconium dichloride” is different from “(indenyl)(2-methylindenyl) zirconium dichloride” which is different from “(indenyl)(2-methylindenyl) hafnium dichloride.” Catalyst compounds that differ only by isomer are considered the same for purposes of the present invention, e.g., *rac*-bis(1-methylindenyl)hafnium dimethyl is considered to be the same as *meso*-bis(1-methyl-
30 indenyl)hafnium dimethyl. Thus, as used herein, a single metallocene catalyst component having a racemic and/or meso isomer does not, itself, constitute two different metallocene catalyst components.

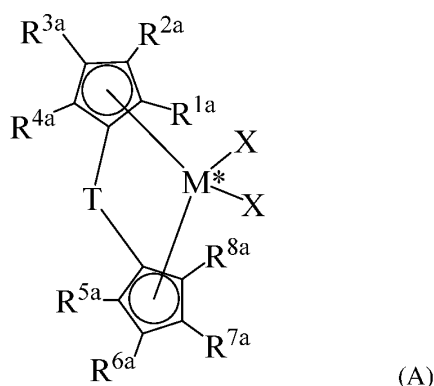
The present invention further provides a process to produce ethylene polymer compositions comprising: i) contacting in a single reaction zone, in the gas phase or slurry

phase, ethylene and C₃ to C₂₀ comonomer with a catalyst system comprising a support, an activator, and the catalysts described above, and obtaining an ethylene polymer having: a) an RCI_m greater than 30 and an Mw/Mn of greater than 3; or b) an RCI_m greater than 50 and an Mw/Mn of greater than 5. Without wishing to be bound by theory, it is believed that the ethylene polymer produced herein (i.e., an in-situ ethylene polymer composition) has at least two polymer components where the first component is derived from the catalyst represented by formula A and has more comonomer (such as hexene) and higher Mw as compared to the second component derived from the catalyst represented by formula B which has less comonomer (such as hexene) and lower Mw as compared to the first component as determined by 4D GPC.

Bridged Metallocenes

In aspects of the present invention, the supported catalyst systems comprise a transition metal complex represented by the formula (A):

The bridged group 4 metallocene compound is represented by the formula (A):



wherein:

M* is a group 4 metal;

each of R^{1a}, R^{2a}, and R^{4a} is independently hydrogen, alkoxide or C₁ to C₄₀ substituted or unsubstituted hydrocarbyl;

R^{3a} is independently hydrogen, alkoxide, C₁ to C₄₀ substituted or unsubstituted hydrocarbyl, or -R^{9a}-SiR'₃ or -R^{9a}-CR'₃ where R^{9a} is C₁ to C₄ hydrocarbyl, and each R' is independently C₁ to C₂₀ substituted or unsubstituted hydrocarbyl and at least one R' is C₁ to C₂₀ substituted or unsubstituted hydrocarbyl;

each of R^{5a}, R^{6a}, and R^{8a} is independently hydrogen, halide, alkoxide or C₁ to C₄₀ substituted or unsubstituted hydrocarbyl;

R^{7a} is $-R^{9a}-SiR'_3$ or $-R^{9a}-CR'_3$ where R^{9a} is a C_1 to C_4 hydrocarbyl, and each R' is independently C_1 to C_{20} substituted or unsubstituted hydrocarbyl, T is a bridging group; and each X is independently a univalent anionic ligand, a diene ligand, an alkylidene ligand, or two X s are joined to form a metallocyclic ring.

5 In a preferred embodiment of the invention, each R^{1a} , R^{2a} , and R^{4a} is independently hydrogen, or a substituted C_1 to C_{12} hydrocarbyl group or an unsubstituted C_1 to C_{12} hydrocarbyl group, preferably each R^{1a} , R^{2a} , and R^{4a} is independently a C_1 to C_{20} alkyl group, preferably hydrogen, methyl, ethyl, propyl, butyl, pentyl, hexyl, or an isomer thereof, preferably hydrogen or methyl.

10 In a preferred embodiment of the invention M^* of formula (A) is Hf or Zr, each R^{1a} , R^{2a} , R^{3a} and R^{5a} is a C_1 to C_{20} alkyl group and R^{4a} is $-CH_2SiR'_3$ or $-CH_2CR'_3$ where R' is C_1 to C_{20} alkyl or aryl.

In a preferred embodiment of the invention, R^{3a} is hydrogen, or a substituted C_1 to C_{12} hydrocarbyl group or an unsubstituted C_1 to C_{12} hydrocarbyl group, preferably R^{3a} is a C_1 to C_{20} alkyl group, preferably hydrogen, methyl, ethyl, propyl, butyl, pentyl, hexyl, or an isomer thereof, preferably hydrogen or methyl, or R^{3a} is $-R^{20}-SiR'_3$ or is $-R^{20}-CR'_3$ where R^{20} is hydrogen or a C_1 to C_4 hydrocarbyl (preferably CH_2 ; CH_2CH_2 , $(Me)CHCH_2$, $(Me)CH$), and each R' is independently hydrogen or a C_1 to C_{20} substituted or unsubstituted hydrocarbyl, preferably a substituted C_1 to C_{12} hydrocarbyl group or an unsubstituted C_1 to C_{12} hydrocarbyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, phenyl, biphenyl, or an isomer thereof, R' is a C_1 to C_{20} alkyl or aryl, such as methyl, methyl phenyl, phenyl, biphenyl, pentamethylphenyl, tetramethylphenyl, or di-*t*-butylphenyl, provided that at least one R' is not H, alternatively 2 R' are not H, alternatively 3 R' are not H.

Alternatively, R^{3a} is $-CH_2-SiMe_3$, $-CH_2-SiEt_3$, $-CH_2-SiPr_3$, $-CH_2-SiBu_3$, $-CH_2-SiCy_3$, $-CH_2-C(CH_3)_3$, $-CH_2-CH(CH_3)_2$, $-CH_2CPh_3$, $-CH_2(C_6Me_5)$, $-CH_2-C(CH_3)_2Ph$, $-CH_2-C(Cy)Ph_2$, $-CH_2-SiH(CH_3)_2$, $-CH_2SiPh_3$, $-CH_2-Si(CH_3)_2Ph$, $-CH_2-Si(CH_3)_2Ph$, $-CH_2-Si(CH_3)Ph_2$, $-CH_2-Si(Et)_2Ph$, $-CH_2-Si(Et)Ph_2$, $-CH_2-Si(CH_2)_3Ph$, $-CH_2-Si(CH_2)_4Ph$, $-CH_2-Si(Cy)Ph_2$, or $-CH_2-Si(Cy)_2Ph$.

Alternatively, each of R^{1a} , R^{2a} , R^{3a} , and R^{4a} is not H.

30 In a preferred embodiment of the invention, each of R^{5a} , R^{6a} and R^{8a} is independently hydrogen, or a substituted C_1 to C_{12} hydrocarbyl group or an unsubstituted C_1 to C_{12} hydrocarbyl group, preferably a C_1 to C_{20} alkyl group, preferably hydrogen, methyl, ethyl, propyl, butyl, pentyl, hexyl, or an isomer thereof, preferably a hydrogen or methyl.

In a preferred embodiment of the invention, R^{7a} is $-R^{20}-SiR'_3$ or is $-R^{20}-CR'_3$ where R^{20} is hydrogen or a C_1 to C_4 hydrocarbyl (preferably CH_2 , CH_2CH_2 , $(Me)CHCH_2$, $(Me)CH$), and each R' is independently hydrogen or a C_1 to C_{20} substituted or unsubstituted hydrocarbyl, preferably a substituted C_1 to C_{12} hydrocarbyl group or an unsubstituted C_1 to C_{12} hydrocarbyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, phenyl, biphenyl, or an isomer thereof, R' is a C_1 to C_{20} alkyl or aryl, such as methyl, methyl phenyl, phenyl, biphenyl, pentamethylphenyl, tetramethylphenyl, or di-*t*-butylphenyl, provided that at least one R' is not H, alternatively 2 R' are not H, alternatively 3 R' are not H;

Alternatively, R^{7a} is $-CH_2-SiMe_3$, $-CH_2-SiEt_3$, $-CH_2-SiPr_3$, $-CH_2-SiBu_3$, $-CH_2-SiCy_3$, $-CH_2-C(CH_3)_3$, $-CH_2-CH(CH_3)_2$, $-CH_2CPh_3$, $-CH_2(C_6Me_5)$, $-CH_2-C(CH_3)_2Ph$, $-CH_2-C(Cy)Ph_2$, $-CH_2-SiH(CH_3)_2$, $-CH_2SiPh_3$, $-CH_2-Si(CH_3)_2Ph$, $-CH_2-Si(CH_3)Ph_2$, $-CH_2-Si(Et)_2Ph$, $-CH_2-Si(Et)Ph_2$, $-CH_2-Si(CH_2)_3Ph$, $-CH_2-Si(CH_2)_4Ph$, $-CH_2-Si(Cy)Ph_2$, or $-CH_2-Si(Cy)_2Ph$.

Alternatively, R^{7a} is *n*-propyl, *n*-butyl, *n*-pentyl or *n*-hexyl.

Alternatively, R^{3a} and R^{7a} are independently $-R^{20}-SiR'_3$ or is $-R^{20}-CR'_3$ where R^{20} is a C_1 to C_4 hydrocarbyl (preferably CH_2 , CH_2CH_2 , $(Me)CHCH_2$, $(Me)CH$), and each R' is independently hydrogen, or a C_1 to C_{20} substituted or unsubstituted hydrocarbyl, preferably a substituted C_1 to C_{12} hydrocarbyl group or an unsubstituted C_1 to C_{12} hydrocarbyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, phenyl, biphenyl, or an isomer thereof, R' is a C_1 to C_{20} alkyl or aryl, such as methyl, methyl phenyl, phenyl, biphenyl, pentamethylphenyl, tetramethylphenyl, or di-*t*-butylphenyl; alternatively R^3 and R^9 are selected from the group consisting of: $-CH_2-SiMe_3$, $-CH_2-SiEt_3$, $-CH_2-SiPr_3$, $-CH_2-SiBu_3$, $-CH_2-SiCy_3$, $-CH_2-C(CH_3)_3$, $-CH_2-CH(CH_3)_2$, $-CH_2CPh_3$, $-CH_2(C_6Me_5)$, $-CH_2-C(CH_3)_2Ph$, $-CH_2-C(Cy)Ph_2$, $-CH_2-SiH(CH_3)_2$, $-CH_2SiPh_3$, $-CH_2-Si(CH_3)_2Ph$, $-CH_2-Si(CH_3)Ph_2$, $-CH_2-Si(Et)_2Ph$, $-CH_2-Si(Et)Ph_2$, $-CH_2-Si(CH_2)_3Ph$, $-CH_2-Si(CH_2)_4Ph$, $-CH_2-Si(Cy)Ph_2$, or $-CH_2-Si(Cy)_2Ph$.

Alternatively, each X may be, independently, a halide, a hydride, an alkyl group, an alkenyl group or an arylalkyl group.

Alternatively, each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, aryls, hydrides, amides, alkoxides, sulfides, phosphides, halides, dienes, amines, phosphines, ethers, and a combination thereof, (two X's may form a part of a fused ring or a ring system), preferably each X is independently selected from halides, aryls and C_1 to C_5 alkyl groups, preferably each X is a phenyl, methyl, ethyl, propyl, butyl, pentyl, or chloro group.

In any embodiment of the invention, T is a bridging group containing at least one Group 13, 14, 15, or 16 element, in particular boron or a Group 14, 15, or 16 element. Examples of suitable bridging groups include $P(=S)R^*$, $P(=Se)R^*$, $P(=O)R^*$, R^*_2C , R^*_2Si , R^*_2Ge , $R^*_2CCR^*_2$, $R^*_2CCR^*_2CR^*_2$, $R^*_2CCR^*_2CR^*_2CR^*_2$, $R^*C=CR^*$, $R^*C=CR^*CR^*_2$, $R^*_2CCR^*=CR^*CR^*_2$, $R^*C=CR^*CR^*=CR^*$, $R^*C=CR^*CR^*_2CR^*_2$, $R^*_2CSiR^*_2$, $R^*_2SiSiR^*_2$, $R^*_2SiOSiR^*_2$, $R^*_2CSiR^*_2CR^*_2$, $R^*_2SiCR^*_2SiR^*_2$, $R^*C=CR^*SiR^*_2$, $R^*_2CGeR^*_2$, $R^*_2GeGeR^*_2$, $R^*_2CGeR^*_2CR^*_2$, $R^*_2GeCR^*_2GeR^*_2$, $R^*_2SiGeR^*_2$, $R^*C=CR^*GeR^*_2$, R^*B , $R^*_2C-BR^*$, $R^*_2C-BR^*-CR^*_2$, $R^*_2C-O-CR^*_2$, $R^*_2CR^*_2C-O-CR^*_2CR^*_2$, $R^*_2C-O-CR^*_2CR^*_2$, $R^*_2C-O-CR^*=CR^*$, $R^*_2C-S-CR^*_2$, $R^*_2CR^*_2C-S-CR^*_2CR^*_2$, $R^*_2C-S-CR^*_2CR^*_2$, $R^*_2C-S-CR^*=CR^*$, $R^*_2C-Se-CR^*_2$, $R^*_2CR^*_2C-Se-CR^*_2CR^*_2$, $R^*_2C-Se-CR^*_2CR^*_2$, $R^*_2C-Se-CR^*=CR^*$, $R^*_2C-N=CR^*$, $R^*_2C-NR^*-CR^*_2$, $R^*_2C-NR^*-CR^*_2CR^*_2$, $R^*_2C-NR^*-CR^*=CR^*$, $R^*_2CR^*_2C-NR^*-CR^*_2CR^*_2$, $R^*_2C-P=CR^*$, $R^*_2C-PR^*-CR^*_2$, O, S, Se, Te, NR^* , PR^* , AsR^* , SbR^* , O-O, S-S, R^*N-NR^* , R^*P-PR^* , O-S, O- NR^* , O- PR^* , S- NR^* , S- PR^* , and R^*N-PR^* where R^* is hydrogen or a C_1 - C_{20} containing hydrocarbyl, substituted hydrocarbyl, halocarbyl, substituted halocarbyl, silylcarbyl or germylcarbyl substituent and optionally two or more adjacent R^* may join to form a substituted or unsubstituted, saturated, partially unsaturated or aromatic, cyclic or polycyclic substituent. Preferred examples for the bridging group T include CH_2 , CH_2CH_2 , $SiMe_2$, $SiPh_2$, $SiMePh$, $Si(CH_2)_3$, $Si(CH_2)_4$, O, S, NPh, PPh, NMe, PMe, NEt, NPr, NBu, PEt, PPr, $Me_2SiOSiMe_2$, and PBu. In a preferred embodiment of the invention in any embodiment of any formula described herein, T is represented by the formula ER^d_2 or $(ER^d_2)_2$, where E is C, Si, or Ge, and each R^d is, independently, hydrogen, halogen, C_1 to C_{20} hydrocarbyl (such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, nonyl, decyl, undecyl, or dodecyl) or a C_1 to C_{20} substituted hydrocarbyl, and two R^d can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system. Preferably, T is a bridging group comprising carbon or silica, such as dialkylsilyl, preferably T is selected from CH_2 , CH_2CH_2 , $C(CH_3)_2$, $SiMe_2$, cyclotrimethylenesilylene ($Si(CH_2)_3$), cyclopentamethylenesilylene ($Si(CH_2)_5$) and cyclotetramethylenesilylene ($Si(CH_2)_4$).

Useful asymmetric catalysts are preferably such that a mirror plane can not be drawn through the metal center and the cyclopentadienyl moieties bridged to the metal center are structurally different.

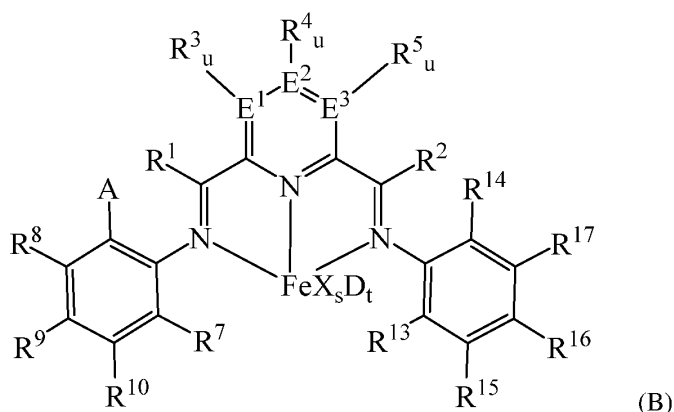
Catalyst compounds represented by formula (A) that are particularly useful in at least one embodiment of the present invention include one or more of: *Rac*/meso- $Me_2Si(3-Me_3Si-$

- CH₂-Cp)₂HfMe₂; rac-Me₂Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-Ph₂Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-PhMeSi(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-(CH₂)₄Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-(CH₂)₃Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; Me(H)Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; Ph(H)Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-(biphenyl)₂Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-(F-C₆H₄)₂Si(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-Me₂Ge(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac-Me₂Ge(3-Me₃Si-CH₂-Cp)₂HfMe₂; rac/meso-Ph₂Ge(3-Me₃Si-CH₂-Cp)₂HfMe₂; Me₂Si(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; Ph₂Si(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; Me₂Ge(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; Ph₂Ge(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; PhMeSi(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; (CH₂)₃Si(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; (CH₂)₄Si(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; Et₂Si(Me₄Cp)(3-Me₃Si-CH₂-Cp)HfMe₂; rac/meso-Me₂Si(3-nPrCp)₂HfMe₂; rac/meso-Ph₂Si(3-nPrCp)₂HfMe₂; rac/meso-PhMeSi(3-nPrCp)₂HfMe₂; rac/meso-(CH₂)₄Si(3-nPrCp)₂HfMe₂; rac/meso-(CH₂)₃Si(3-nPrCp)₂HfMe₂; Me(H)Si(3-nPrCp)₂HfMe₂; Ph(H)Si(3-nPrCp)₂HfMe₂; rac/meso-(biphenyl)₂Si(3-nPrCp)₂HfMe₂; rac/meso-(F-C₆H₄)₂Si(3-nPrCp)₂HfMe₂; rac/meso-Me₂Ge(3-nPrCp)₂HfMe₂; rac/meso-Ph₂Ge(3-nPrCp)₂HfMe₂; rac/meso-Me₂Si(3-nBuCp)₂HfMe₂; rac/meso-Ph₂Si(3-nBuCp)₂HfMe₂; rac/meso-PhMeSi(3-nBuCp)₂HfMe₂; rac/meso-(CH₂)₄Si(3-nBuCp)₂HfMe₂; rac/meso-(CH₂)₃Si(3-nBuCp)₂HfMe₂; Me(H)Si(3-nBuCp)₂HfMe₂; Ph(H)Si(3-nBuCp)₂HfMe₂; rac/meso-(biphenyl)₂Si(3-nBuCp)₂HfMe₂; rac/meso-(F-C₆H₄)₂Si(3-nBuCp)₂HfMe₂; rac/meso-Me₂Ge(3-nBuCp)₂HfMe₂; rac/meso-Ph₂Ge(3-nBuCp)₂HfMe₂; Me₂Si(Me₄Cp)(3-nPrCp)HfMe₂; Ph₂Si(Me₄Cp)(3-nPrCp)HfMe₂; Me₂Ge(Me₄Cp)(3-nPrCp)HfMe₂; Ph₂Ge(Me₄Cp)(3-nPrCp)HfMe₂; PhMeSi(Me₄Cp)(3-nPrCp)HfMe₂; (CH₂)₃Si(Me₄Cp)(3-nPrCp)HfMe₂; (CH₂)₄Si(Me₄Cp)(3-nPrCp)HfMe₂; Et₂Si(Me₄Cp)(3-nPrCp)HfMe₂; Me₂Si(Me₄Cp)(3-nBuCp)HfMe₂; Ph₂Si(Me₄Cp)(3-nBuCp)HfMe₂; Me₂Ge(Me₄Cp)(3-nBuCp)HfMe₂; Ph₂Ge(Me₄Cp)(3-nBuCp)HfMe₂; PhMeSi(Me₄Cp)(3-nBuCp)HfMe₂; (CH₂)₃Si(Me₄Cp)(3-nBuCp)HfMe₂; (CH₂)₄Si(Me₄Cp)(3-nBuCp)HfMe₂; Et₂Si(Me₄Cp)(3-nBuCp)HfMe₂; Me₂Si(3-CH₂-SiMe₃-Cp)₂HfMe₂; Ph₂Si(3-CH₂-SiMe₃-Cp)₂HfMe₂; PhMeSi(3-CH₂-SiMe₃-Cp)₂HfMe₂; SiMe₂(Me₄Cp)(3-nPrCp)HfMe₂; SiPh₂(Me₄Cp)(3-nPrCp)HfMe₂; Me₂Ge(Me₄Cp)(3-nPrCp)HfMe₂; Ph₂Ge(Me₄Cp)(3-nPrCp)HfMe₂; PhMeSi(Me₄Cp)(3-nPrCp)HfMe₂; Et₂Si(Me₄Cp)(3-nPrCp)HfMe₂; SiMe₂(EtMe₃Cp)(3-nPrCp)HfMe₂; SiMe₂(Me₄Cp)(3-nBuCp)HfMe₂; SiPh₂(Me₄Cp)(3-nBuCp)HfMe₂; Me₂Ge(Me₄Cp)(3-nBuCp)HfMe₂; Ph₂Ge(Me₄Cp)(3-nBuCp)HfMe₂; PhMeSi(Me₄Cp)(3-nBuCp)HfMe₂; Et₂Si(Me₄Cp)(3-nBuCp)HfMe₂; SiMe₂(EtMe₃Cp)(3-nBuCp)HfMe₂; SiMe₂(Me₄Cp)(3-CH₂-SiMe₃-Cp)HfMe₂; SiPh₂(Me₄Cp)(3-CH₂-SiMe₃-Cp)HfMe₂; Me₂Ge(Me₄Cp)(3-CH₂-SiMe₃-Cp)HfMe₂; Ph₂Ge(Me₄Cp)(3-CH₂-SiMe₃-Cp)HfMe₂;

- Cp)HfMe₂; PhMeSi(Me₄Cp)(3-CH₂-SiMe₃-Cp)HfMe₂; Et₂Si(Me₄Cp)(3-CH₂-SiMe₃-Cp)HfMe₂; SiMe₂(EtMe₃Cp)(3-CH₂-SiMe₃-Cp)HfMe₂; SiMe₂(Me₄Cp)(3-CH₂-SiPhMe₂-Cp)HfMe₂; SiPh₂(Me₄Cp)(3-CH₂-SiPhMe₂-Cp)HfMe₂; Me₂Ge(Me₄Cp)(3-CH₂-SiPhMe₂)HfMe₂; Ph₂Ge(Me₄Cp)(3-CH₂-SiPhMe₂)HfMe₂; PhMeSi(Me₄Cp)(3-CH₂-SiPhMe₂-Cp)HfMe₂; Et₂Si(Me₄Cp)(3-CH₂-SiPhMe₂-Cp)HfMe₂; SiMe₂(EtMe₃Cp)(3-CH₂-SiPh₃-Cp)HfMe₂; SiMe₂(Me₄Cp)(3-CH₂-SiPh₃-Cp)HfMe₂; SiPh₂(Me₄Cp)(3-CH₂-SiPh₃-Cp)HfMe₂; Me₂Ge(Me₄Cp)(3-CH₂-SiPh₃)HfMe₂; Ph₂Ge(Me₄Cp)(3-CH₂-SiPh₃)HfMe₂; PhMeSi(Me₄Cp)(3-CH₂-SiPh₃-Cp)HfMe₂; Et₂Si(Me₄Cp)(3-CH₂-SiPh₃-Cp)HfMe₂; SiMe₂(EtMe₃Cp)(3-CH₂-SiPh₃-Cp)HfMe₂; SiMe₂(2-Me,3-n-Pr-Ind)₂HfMe₂; SiPh₂(2-Me,3-n-Pr-Ind)₂HfMe₂; GeMe₂(2-Me,3-n-Pr-Ind)₂HfMe₂; GePh₂(2-Me,3-n-Pr-Ind)₂HfMe₂; SiPhMe(2-Me,3-n-Pr-Ind)₂HfMe₂; Et₂Si(2-Me,3-n-Pr-Ind)₂HfMe₂; SiMe₂(2-Me,3-n-Bu-Ind)₂HfMe₂; SiPh₂(2-Me,3-n-Bu-Ind)₂HfMe₂; GeMe₂(2-Me,3-n-Bu-Ind)₂HfMe₂; GePh₂(2-Me,3-n-Bu-Ind)₂HfMe₂; SiPhMe(2-Me,3-n-Bu-Ind)₂HfMe₂; Et₂Si(2-Me,3-n-Bu-Ind)₂HfMe₂; SiMe₂(2-Me,3-CH₂-SiMe₃-Ind)₂HfMe₂; SiPh₂(2-Me,3-CH₂-SiMe₃-Ind)₂HfMe₂; GeMe₂(2-Me,3-CH₂-SiMe₃-Ind)₂HfMe₂; GePh₂(2-Me,3-CH₂-SiMe₃-Ind)₂HfMe₂; SiPhMe(2-Me,3-CH₂-SiMe₃-Ind)₂HfMe₂; Et₂Si(2-Me,3-CH₂-SiMe₃-Ind)₂HfMe₂; SiMe₂(2-Me,3-CH₂-SiPhMe₂-Ind)₂HfMe₂; SiPh₂(2-Me,3-CH₂-SiPhMe₂-Ind)₂HfMe₂; GeMe₂(2-Me,3-CH₂-SiPhMe₂-Ind)₂HfMe₂; GePh₂(2-Me,3-CH₂-SiPhMe₂-Ind)₂HfMe₂; SiPhMe(2-Me,3-CH₂-SiPhMe₂-Ind)₂HfMe₂; Et₂Si(2-Me,3-CH₂-SiPhMe₂-Ind)₂HfMe₂; SiMe₂(2-Me,3-CH₂-SiPh₃-Ind)₂HfMe₂; SiPh₂(2-Me,3-CH₂-SiPh₃-Ind)₂HfMe₂; GeMe₂(2-Me,3-CH₂-SiPh₃-Ind)₂HfMe₂; GePh₂(2-Me,3-CH₂-SiPh₃-Ind)₂HfMe₂; SiPhMe(2-Me,3-CH₂-SiPh₃-Ind)₂HfMe₂; Et₂Si(2-Me,3-CH₂-SiPh₃-Ind)₂HfMe₂, and the alkyl or halide versions thereof, preferably where the Me₂ is replaced with Et₂, Cl₂, Br₂, I₂, or Ph₂.

Iron Compounds

- 25 The second catalyst compound of catalyst systems of the present invention is an iron complex represented by formula (B):



wherein:

A is chlorine, bromine, iodine, $-\text{CF}_3$ or $-\text{OR}^{11}$;

each of R^1 and R^2 is independently hydrogen, $\text{C}_1\text{-C}_{22}$ -alkyl, $\text{C}_2\text{-C}_{22}$ -alkenyl, $\text{C}_6\text{-C}_{22}$ -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or five-, six- or seven-membered heterocyclyl comprising at least one atom selected from the group consisting of N, P, O and S;

wherein each of R^1 and R^2 is optionally substituted by halogen, $-\text{NR}^{11}_2$, $-\text{OR}^{11}$ or $-\text{SiR}^{12}_3$;

wherein R^1 optionally bonds with R^3 , and R^2 optionally bonds with R^5 , in each case to independently form a five-, six- or seven-membered ring;

R^7 is a $\text{C}_1\text{-C}_{20}$ alkyl;

each of R^3_u , R^4_u , R^5_u , R^8 , R^9 , R^{10} , R^{15} , R^{16} , and R^{17} is independently hydrogen, $\text{C}_1\text{-C}_{22}$ -alkyl, $\text{C}_2\text{-C}_{22}$ -alkenyl, $\text{C}_6\text{-C}_{22}$ -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, $-\text{NR}^{11}_2$, $-\text{OR}^{11}$, halogen, $-\text{SiR}^{12}_3$ or five-, six- or seven-membered heterocyclyl comprising at least one atom selected from the group consisting of N, P, O, and S;

wherein R^3_u , R^4_u , R^5_u , R^7 , R^8 , R^9 , R^{10} , R^{15} , R^{16} , and R^{17} are optionally substituted by halogen, $-\text{NR}^{11}_2$, $-\text{OR}^{11}$ or $-\text{SiR}^{12}_3$;

wherein R^3 optionally bonds with R^4 , R^4 optionally bonds with R^5 , R^7 optionally bonds with R^{10} , R^{10} optionally bonds with R^9 , R^9 optionally bonds with R^8 , R^{17} optionally bonds with R^{16} , and R^{16} optionally bonds with R^{15} , in each case to independently form a five-, six- or seven-membered carbocyclic or heterocyclic ring, the heterocyclic ring comprising at least one atom from the group consisting of N, P, O and S;

R^{13} is $\text{C}_1\text{-C}_{20}$ -alkyl bonded with the aryl ring via a primary or secondary carbon atom;

R^{14} is chlorine, bromine, iodine, $-\text{CF}_3$ or $-\text{OR}^{11}$, or $\text{C}_1\text{-C}_{20}$ -alkyl bonded with the aryl ring;

- each R^{11} is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or $-SiR^{12}_3$, wherein R^{11} is optionally substituted by halogen, or two R^{11} radicals optionally bond to form a five- or six-membered ring;
- 5 each R^{12} is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or two R^{12} radicals optionally bond to form a five- or six-membered ring;
- each of E^1 , E^2 , and E^3 is independently carbon, nitrogen or phosphorus;
- each u is independently 0 if E^1 , E^2 , and/or E^3 is nitrogen or phosphorus and is 1 if E^1 , E^2 , and/or
- 10 E^3 is carbon;
- each X is independently fluorine, chlorine, bromine, iodine, hydrogen, C_1 - C_{20} -alkyl, C_2 - C_{10} -alkenyl, C_6 - C_{20} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, $-NR^{18}_2$, $-OR^{18}$, $-SR^{18}$, $-SO_3R^{18}$, $-OC(O)R^{18}$, $-CN$, $-SCN$, β -diketonate, $-CO$, $-BF_4^-$, $-PF_6^-$ or bulky non-coordinating anions, and the radicals X can be bonded with one
- 15 another;
- each R^{18} is independently hydrogen, C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_6 - C_{20} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or $-SiR^{19}_3$, wherein R^{18} can be substituted by halogen or nitrogen- or oxygen-containing groups and two R^{18} radicals optionally bond to form a five- or six-membered ring;
- 20 each R^{19} is independently hydrogen, C_1 - C_{20} -alkyl, C_2 - C_{20} -alkenyl, C_6 - C_{20} -aryl or arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, wherein R^{19} can be substituted by halogen or nitrogen- or oxygen-containing groups or two R^{19} radicals optionally bond to form a five- or six-membered ring;
- s is 1, 2, or 3;
- 25 D is a neutral donor;
- t is 0 to 2, preferably 0, 1, or 2;
- u is 1 or 0 depending on whether the E group is N, P, or C. For example, if E^1 is carbon, then u for R^3 is 1; if E^2 is nitrogen, then u for R^4 is 0; if E^3 is carbon, then u for R^5 is 1; and if E^1 , E^2 , and E^3 are carbon, all u are 1.
- 30 In preferred embodiments, each of A and R^{14} is chlorine; each of R^1 and R^2 is methyl; each of R^3 - R^5 is hydrogen; each of R^7 and R^9 is methyl; each of R^8 and R^{10} , and R^{15} - R^{17} is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, $-NR^{11}_2$, $-OR^{11}$, halogen, $-SiR^{12}_3$ or five-, six- or seven-membered heterocyclyl comprising at least one atom selected

from the group consisting of N, P, O and S; R^7 - R^{10} and R^{15} - R^{17} are optionally substituted by halogen, $-NR^{11}_2$, $-OR^{11}$ or $-SiR^{12}_3$; and wherein R^7 optionally bonds with R^{10} , R^{10} optionally bonds with R^9 , R^9 optionally bonds with R^8 , R^{17} optionally bonds with R^{16} , and R^{16} optionally bonds with R^{15} , in each case to independently form a five-, six- or seven-membered carbocyclic or heterocyclic ring, the heterocyclic ring comprising at least one atom selected from the group consisting of N, P, O and S; R^{13} is independently a C_1 - C_3 -alkyl bonded with the aryl ring via a primary or secondary carbon atom; each R^{11} is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl, arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or $-SiR^{12}_3$, wherein R^{11} is optionally substituted by halogen, or two R^{11} radicals optionally bond to form a five- or six-membered ring; each R^{12} is independently hydrogen, C_1 - C_{22} -alkyl, C_2 - C_{22} -alkenyl, C_6 - C_{22} -aryl or arylalkyl where alkyl has from 1 to 10 carbon atoms and aryl has from 6 to 20 carbon atoms, or two R^{12} radicals optionally bond to form a five- or six-membered ring; each of E^1 , E^2 , and E^3 is carbon; and each u is 1.

In at least one embodiment, D is a neutral donor such as a neutral Lewis base or Lewis acid, such as, for example, amines, alcohols, ethers, ketones, aldehydes, esters, sulfides or phosphines, which can be bonded with the iron center or can still be contained in the complex as residual solvent from the preparation of the iron complexes.

Catalyst compounds represented by formula (B) that are particularly useful in at least one embodiment of the present invention include one or more of: bis(2,6-[1-(2,6-dimethylphenylimino)ethyl]pyridineiron dichloride, bis(2,6-[1-(2,4,6-trimethylphenylimino)ethyl]pyridineiron dichloride, bis(2,6-[1-(2,6-dimethylphenylimino)ethyl]-ethyl]pyridineiron dichloride, 2-[1-(2,4,6-trimethylphenylimino)ethyl]-6-[1-(2,4-dichloro-6-methylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,6-dimethylphenylimino)ethyl]-6-[1-(2-chloro-6-methylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,4,6-trimethylphenylimino)ethyl]-6-[1-(2-chloro-6-methylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,6-diisopropylphenylimino)ethyl]-6-[1-(2-chloro-6-methylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,6-dimethylphenylimino)ethyl]-6-[1-(2-bromo-4,6-dimethylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,4,6-trimethylphenylimino)ethyl]-6-[1-(2-bromo-4,6-dimethylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,6-dimethylphenylimino)ethyl]-6-[1-(2-bromo-6-methylphenylimino)ethyl]pyridineiron dichloride, 2-[1-(2,4,6-trimethylphenylimino)ethyl]-6-[1-(2-bromo-6-methylphenylimino)ethyl]pyridineiron dichloride and 2-[1-(2,6-diisopropylphenylimino)ethyl]-6-[1-(2-bromo-6-methylphenylimino)ethyl]pyridineiron

dichloride or the dibromides or tribromides thereof (e.g., where dichloride in the list above is replaced with dibromide or tribromide).

Support Material

5 In embodiments of the present invention, the catalyst systems comprise a support material. Preferably, the support material is a porous support material, for example, talc, and inorganic oxides. Other support materials include zeolites, clays, organoclays, or any other organic or inorganic support material, or mixtures thereof. As used herein, "support" and "support material" are used interchangeably.

10 Preferably, the support material is an inorganic oxide in a finely divided form. Suitable inorganic oxide materials for use in the supported catalyst systems herein include Groups 2, 4, 13, and 14 metal oxides such as silica, alumina, and mixtures thereof. Other inorganic oxides that may be employed, either alone or in combination, with the silica or alumina are magnesia, titania, zirconia, and the like. Other suitable support materials, however, can be employed, for example, finely divided functionalized polyolefins such as finely divided polyethylene.

15 Particularly useful supports include magnesia, titania, zirconia, montmorillonite, phyllosilicate, zeolites, talc, clays, and the like. Also, combinations of these support materials may be used, for example, silica-chromium, silica-alumina, silica-titania, and the like. Preferred support materials include Al_2O_3 , ZrO_2 , SiO_2 , and combinations thereof, more preferably, SiO_2 , Al_2O_3 , or $\text{SiO}_2/\text{Al}_2\text{O}_3$.

20 It is preferred that the support material, most preferably, an inorganic oxide, has a surface area in the range of from about $10 \text{ m}^2/\text{g}$ to about $700 \text{ m}^2/\text{g}$, pore volume in the range of from about 0.1 cc/g to about 4.0 cc/g , and average particle size in the range of from about $5 \text{ }\mu\text{m}$ to about $500 \text{ }\mu\text{m}$. More preferably, the surface area of the support material is in the range of from about $50 \text{ m}^2/\text{g}$ to about $500 \text{ m}^2/\text{g}$, pore volume of from about 0.5 cc/g to about 3.5 cc/g ,

25 and average particle size of from about $10 \text{ }\mu\text{m}$ to about $200 \text{ }\mu\text{m}$. Most preferably, the surface area of the support material is in the range of from about $100 \text{ m}^2/\text{g}$ to about $400 \text{ m}^2/\text{g}$, pore volume from about 0.8 cc/g to about 3.0 cc/g , and average particle size is from about $5 \text{ }\mu\text{m}$ to about $100 \text{ }\mu\text{m}$. The average pore size of the support material useful in at least one embodiment of the present invention is in the range of from 10 to $1,000 \text{ }\text{\AA}$, preferably, 50

30 to about $500 \text{ }\text{\AA}$, and most preferably, 75 to about $350 \text{ }\text{\AA}$. In some embodiments, the support material is a high surface area, amorphous silica (surface area $\geq 300 \text{ m}^2/\text{gm}$, pore volume $\geq 1.65 \text{ cm}^3/\text{gm}$), and is marketed under the tradenames of DAVISON 952 or DAVISON 955 by the Davison Chemical Division of W. R. Grace and Company, are particularly useful. In other embodiments, DAVIDSON 948 is used.

In at least one embodiment of the present invention, the support material may be dry, that is, free of absorbed water. Drying of the support material can be achieved by heating or calcining at about 100°C to about 1000°C, preferably, at least about 600°C. When the support material is silica, it is typically heated to at least 200°C, preferably, about 200°C to about 850°C, and most preferably, at about 600°C; and for a time of about 1 minute to about 100 hours, from about 12 hours to about 72 hours, or from about 24 hours to about 60 hours. The calcined support material, preferably, has at least some reactive hydroxyl (OH) groups.

In a particularly useful embodiment, the support material is fluorided. Fluoriding agent containing compounds may be any compound containing a fluorine atom. Particularly desirable are inorganic fluorine containing compounds are selected from the group consisting of NH_4BF_4 , $(\text{NH}_4)_2\text{SiF}_6$, NH_4PF_6 , NH_4F , $(\text{NH}_4)_2\text{TaF}_7$, NH_4NbF_4 , $(\text{NH}_4)_2\text{GeF}_6$, $(\text{NH}_4)_2\text{SmF}_6$, $(\text{NH}_4)_2\text{TiF}_6$, $(\text{NH}_4)_2\text{ZrF}_6$, MoF_6 , ReF_6 , GaF_3 , SO_2ClF , F_2 , SiF_4 , SF_6 , ClF_3 , ClF_5 , BrF_5 , IF_7 , NF_3 , HF , BF_3 , NHF_2 and NH_4HF_2 . Of these, ammonium hexafluorosilicate and ammonium tetrafluoroborate are useful. Combinations of these compounds may also be used.

Ammonium hexafluorosilicate and ammonium tetrafluoroborate fluorine compounds are typically solid particulates as are the silicon dioxide supports. A desirable method of treating the support with the fluorine compound is to dry mix the two components by simply blending at a concentration of from 0.01 to 10.0 millimole F/g of support, desirably in the range of from 0.05 to 6.0 millimole F/g of support, and most desirably in the range of from 0.1 to 3.0 millimole F/g of support. The fluorine compound can be dry mixed with the support either before or after charging to a vessel for dehydration or calcining the support. Accordingly, the fluorine concentration present on the support is in the range of from 0.1 to 25 wt%, alternatively from 0.19 to 19 wt%, alternatively from 0.6 to 3.5 wt%, based upon the weight of the support.

The above two metal catalyst components described herein are generally deposited on the support material at a loading level of 10-100 micromoles of metal per gram of solid support; alternatively 20-80 micromoles of metal per gram of solid support; or 40-60 micromoles of metal per gram of support. But greater or lesser values may be used provided that the total amount of solid complex does not exceed the support's pore volume.

In at least one embodiment, the support material comprises a support material treated with an electron-withdrawing anion. The support material can be silica, alumina, silica-alumina, silica-zirconia, alumina-zirconia, aluminum phosphate, heteropolytungstates, titania, magnesia, boria, zinc oxide, mixed oxides thereof, or mixtures thereof; and the electron-withdrawing anion is selected from fluoride, chloride, bromide, phosphate, triflate, bisulfate, sulfate, or any combination thereof.

The electron-withdrawing component used to treat the support material can be any component that increases the Lewis or Brønsted acidity of the support material upon treatment (as compared to the support material that is not treated with at least one electron-withdrawing anion). In at least one embodiment, the electron-withdrawing component is an electron-withdrawing anion derived from a salt, an acid, or other compound, such as a volatile organic compound, that serves as a source or precursor for that anion. Electron-withdrawing anions can be sulfate, bisulfate, fluoride, chloride, bromide, iodide, fluorosulfate, fluoroborate, phosphate, fluorophosphate, trifluoroacetate, triflate, fluoroaluminate, fluorozirconate, fluorotitanate, phosphotungstate, or mixtures thereof, or combinations thereof. An electron-withdrawing anion can be fluoride, chloride, bromide, phosphate, triflate, bisulfate, or sulfate, and the like, or any combination thereof, at least one embodiment of this invention. In at least one embodiment, the electron-withdrawing anion is sulfate, bisulfate, fluoride, chloride, bromide, iodide, fluorosulfate, fluoroborate, phosphate, fluorophosphate, trifluoroacetate, triflate, fluoroaluminate, fluorozirconate, fluorotitanate, or combinations thereof.

Thus, for example, the support material suitable for use in the catalyst systems of the present invention can be one or more of fluorided alumina, chlorided alumina, bromided alumina, sulfated alumina, fluorided silica-alumina, chlorided silica-alumina, bromided silica-alumina, sulfated silica-alumina, fluorided silica-zirconia, chlorided silica-zirconia, bromided silica-zirconia, sulfated silica-zirconia, fluorided silica-titania, fluorided silica-coated alumina, sulfated silica-coated alumina, phosphated silica-coated alumina, and the like, or combinations thereof. In at least one embodiment, the activator-support can be, or can comprise, fluorided alumina, sulfated alumina, fluorided silica-alumina, sulfated silica-alumina, fluorided silica-coated alumina, sulfated silica-coated alumina, phosphated silica-coated alumina, or combinations thereof. In another embodiment, the support material includes alumina treated with hexafluorotitanic acid, silica-coated alumina treated with hexafluorotitanic acid, silica-alumina treated with hexafluorozirconic acid, silica-alumina treated with trifluoroacetic acid, fluorided boria-alumina, silica treated with tetrafluoroboric acid, alumina treated with tetrafluoroboric acid, alumina treated with hexafluorophosphoric acid, or combinations thereof. Further, any of these activator-supports optionally can be treated with a metal ion.

Non-limiting examples of cations suitable for use in the present invention in the salt of the electron-withdrawing anion include ammonium, trialkyl ammonium, tetraalkyl ammonium, tetraalkyl phosphonium, H⁺, [H(OEt₂)₂]⁺, or combinations thereof.

Further, combinations of one or more different electron-withdrawing anions, in varying proportions, can be used to tailor the specific acidity of the support material to a desired level.

Combinations of electron-withdrawing components can be contacted with the support material simultaneously or individually, and in any order that provides a desired chemically-treated support material acidity. For example, in at least one embodiment, two or more electron-withdrawing anion source compounds in two or more separate contacting steps.

5 In one embodiment of the present invention, one example of a process by which a chemically-treated support material is prepared is as follows: a selected support material, or combination of support materials, can be contacted with a first electron-withdrawing anion source compound to form a first mixture; such first mixture can be calcined and then contacted with a second electron-withdrawing anion source compound to form a second mixture; the
10 second mixture can then be calcined to form a treated support material. In such a process, the first and second electron-withdrawing anion source compounds can be either the same or different compounds.

 The method by which the oxide is contacted with the electron-withdrawing component, typically a salt or an acid of an electron-withdrawing anion, can include, but is not limited to,
15 gelling, co-gelling, impregnation of one compound onto another, and the like, or combinations thereof. Following a contacting method, the contacted mixture of the support material, electron-withdrawing anion, and optional metal ion, can be calcined.

 According to another embodiment of the present invention, the support material can be treated by a process comprising: (i) contacting a support material with a first electron-
20 withdrawing anion source compound to form a first mixture; (ii) calcining the first mixture to produce a calcined first mixture; (iii) contacting the calcined first mixture with a second electron-withdrawing anion source compound to form a second mixture; and (iv) calcining the second mixture to form the treated support material.

Activators

25 The supported catalyst systems may be formed by combining the above two metal catalyst components with activators in any manner known from the literature including by supporting them for use in slurry or gas phase polymerization. Activators are defined to be any compound which can activate any one of the catalyst compounds described above by converting the neutral metal catalyst compound to a catalytically active metal catalyst
30 compound cation. Non-limiting activators, for example, include alumoxanes, aluminum alkyls, ionizing activators, which may be neutral or ionic, and conventional-type cocatalysts. Preferred activators typically include alumoxane compounds, modified alumoxane compounds, and ionizing anion precursor compounds that abstract a reactive, σ -bound, metal

ligand making the metal catalyst compound cationic and providing a charge-balancing non-coordinating or weakly coordinating anion.

Alumoxane Activators

Alumoxane activators are utilized as activators in the catalyst systems described herein.

- 5 Alumoxanes are generally oligomeric compounds containing $-Al(R^1)-O-$ sub-units, where R^1 is an alkyl group. Examples of alumoxanes include methylalumoxane (MAO), modified methylalumoxane (MMAO), ethylalumoxane and isobutylalumoxane. Alkylalumoxanes and modified alkylalumoxanes are suitable as catalyst activators, particularly when the abstractable ligand is an alkyl, halide, alkoxide or amide. Mixtures of different alumoxanes and modified
- 10 alumoxanes may also be used. It may be preferable to use a visually clear methylalumoxane. A cloudy or gelled alumoxane can be filtered to produce a clear solution or clear alumoxane can be decanted from the cloudy solution. A useful alumoxane is a modified methyl alumoxane (MMAO) cocatalyst type 3A (commercially available from Akzo Chemicals, Inc. under the trade name Modified Methylalumoxane type 3A, covered under patent number U.S. Patent No.
- 15 5,041,584).

- When the activator is an alumoxane (modified or unmodified), some embodiments select the maximum amount of activator typically at up to a 5000-fold molar excess Al/M over the catalyst compound (per metal catalytic site). The minimum activator-to-catalyst-compound is a 1:1 molar ratio. Alternate preferred ranges include from 1:1 to 500:1, alternatively from
- 20 1:1 to 200:1, alternatively from 1:1 to 100:1, or alternatively from 1:1 to 50:1.

In an alternate embodiment, little or no alumoxane is used in the polymerization processes described herein. Preferably, alumoxane is present at zero mol%, alternatively the alumoxane is present at a molar ratio of aluminum to catalyst compound transition metal less than 500:1, preferably less than 300:1, preferably less than 100:1, preferably less than 1:1.

25 Non Coordinating Anion Activators

- The term “non-coordinating anion” (NCA) means an anion which either does not coordinate to a cation or which is only weakly coordinated to a cation thereby remaining sufficiently labile to be displaced by a neutral Lewis base. “Compatible” non-coordinating anions are those which are not degraded to neutrality when the initially formed complex
- 30 decomposes. Further, the anion will not transfer an anionic substituent or fragment to the cation so as to cause it to form a neutral transition metal compound and a neutral by-product from the anion. Non-coordinating anions can include those that are compatible, stabilize the transition metal cation in the sense of balancing its ionic charge at +1, and yet retain sufficient lability to permit displacement during polymerization.

It is within the scope of the present invention to use an ionizing activator, neutral or ionic, such as tri (n-butyl) ammonium tetrakis (pentafluorophenyl) borate, a tris perfluorophenyl boron metalloid precursor or a tris perfluoronaphthyl boron metalloid precursor, polyhalogenated heteroborane anions (WO 98/43983), boric acid (U.S. Pat. No. 5,942,459), or combination thereof. It is also within the scope of the present invention to use neutral or ionic activators alone or in combination with alumoxane or modified alumoxane activators.

For descriptions of useful activators please see U.S. Patent Nos. 8,658,556 and 6,211,105.

Preferred activators include N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluorobiphenyl)borate, N,N-dimethylanilinium tetrakis(perfluorophenyl)borate, N,N-dimethylanilinium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, triphenylcarbenium tetrakis(perfluorophenyl)borate, $[\text{Me}_3\text{NH}^+][\text{B}(\text{C}_6\text{F}_5)_4^-]$, 1-(4-(tris(pentafluorophenyl)borate)-2,3,5,6-tetrafluorophenyl)pyrrolidinium; and $[\text{Me}_3\text{NH}^+][\text{B}(\text{C}_6\text{F}_5)_4^-]$, 1-(4-(tris(pentafluorophenyl)borate)-2,3,5,6-tetrafluorophenyl) pyrrolidinium; and sodium tetrakis(pentafluorophenyl)borate, potassium tetrakis(pentafluorophenyl)borate, 4-(tris(pentafluorophenyl)borate)-2,3,5,6-tetrafluoropyridinium, solidium tetrakis(perfluorophenyl)aluminate, potassium tetrakis(pentafluorophenyl), and N,N-dimethylanilinium tetrakis(perfluorophenyl)aluminate.

In a preferred embodiment, the activator comprises a triaryl carbonium (such as triphenylcarbenium tetraphenylborate, triphenylcarbenium tetrakis(pentafluorophenyl)borate, triphenylcarbenium tetrakis-(2,3,4,6-tetrafluorophenyl)borate, triphenylcarbenium tetrakis(perfluoronaphthyl)borate, triphenylcarbenium tetrakis(perfluorobiphenyl)borate, triphenylcarbenium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate).

In another embodiment, the activator comprises one or more of trialkylammonium tetrakis(pentafluorophenyl)borate, N,N-dialkylanilinium tetrakis(pentafluorophenyl)borate, N,N-dimethyl-(2,4,6-trimethylanilinium) tetrakis(pentafluorophenyl)borate, trialkylammonium tetrakis-(2,3,4,6-tetrafluorophenyl) borate, N,N-dialkylanilinium tetrakis-(2,3,4,6-tetrafluorophenyl)borate, trialkylammonium tetrakis(perfluoronaphthyl)borate, N,N-dialkylanilinium tetrakis(perfluoronaphthyl)borate, trialkylammonium tetrakis(perfluorobiphenyl)borate, N,N-dialkylanilinium tetrakis(perfluorobiphenyl)borate,

trialkylammonium tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, N,N-dialkylanilinium
 tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, N,N-dialkyl-(2,4,6-trimethylanilinium)
 tetrakis(3,5-bis(trifluoromethyl)phenyl)borate, di-(i-propyl)ammonium
 tetrakis(pentafluorophenyl)borate, (where alkyl is methyl, ethyl, propyl, n-butyl, sec-butyl, or
 5 t-butyl).

The typical activator-to-catalyst ratio, e.g., all NCA activators-to-catalyst ratio is about
 a 1:1 molar ratio. Alternate preferred ranges include from 0.1:1 to 100:1, alternatively from
 0.5:1 to 200:1, alternatively from 1:1 to 500:1 alternatively from 1:1 to 1000:1. A particularly
 useful range is from 0.5:1 to 10:1, preferably 1:1 to 5:1.

10 Optional Scavengers or Co-Activators

In addition to the activator compounds, scavengers, chain transfer agents or co-
 activators may be used. Aluminum alkyl or organoaluminum compounds which may be
 utilized as co-activators include, for example, trimethylaluminum, triethylaluminum,
 triisobutylaluminum, tri-n-hexylaluminum, tri-n-octylaluminum, diethyl zinc, tri-n-
 15 butylaluminum, diisobutylaluminum hydride, or combinations thereof.

In some embodiments, the catalyst systems will additionally comprise one or more
 scavenging compounds. Here, the term “scavenger” means a compound that removes polar
 impurities from the reaction environment. These impurities adversely affect catalyst activity
 and stability. Typically, the scavenging compound will be an organometallic compound such
 20 as the Group-13 organometallic compounds of U.S. Patent Nos. 5,153,157; 5,241,025; and
 PCT Publication Nos. WO 91/09882; WO 94/03506; WO 93/14132; and WO 95/07941.
 Exemplary compounds include triethyl aluminum, triethyl borane, tri-*iso*-butyl aluminum,
 methyl alumoxane, *iso*-butyl alumoxane, and tri-n-octyl aluminum. Those scavenging
 compounds having bulky or C₆-C₂₀ linear hydrocarbyl substituents connected to the metal or
 25 metalloid center usually minimize adverse interaction with the active catalyst. Examples
 include triethyl aluminum, but more preferably, bulky compounds such as tri-*iso*-butyl
 aluminum, tri-*iso*-prenyl aluminum, and long-chain linear alkyl-substituted aluminum
 compounds, such as tri-n-hexyl aluminum, tri-n-octyl aluminum, or tri-n-dodecyl aluminum.
 When alumoxane is used as the activator, any excess over that needed for activation will
 30 scavenge impurities and additional scavenging compounds may be unnecessary. Alumoxanes
 also may be added in scavenging quantities with other activators, e.g., methylalumoxane,
 [Me₂HNPh]⁺[B(pfp)₄]⁻ or B(pfp)₃ (perfluorophenyl = pfp = C₆F₅).

Preferred aluminum scavengers include those where there is oxygen present. That is,
 the material per se or the aluminum mixture used as a scavenger, includes an aluminum/oxygen

species, such as an alumoxane or alkylaluminum oxides, e.g., dialkylaluminum oxides, such as bis(diisobutylaluminum) oxide. In one aspect, aluminum containing scavengers can be represented by the formula $((R_z-Al)_yO)_x$, wherein z is 1-2, y is 1-2, x is 1-100, and R is a C₁-C₁₂ hydrocarbyl group. In another aspect, the scavenger has an oxygen to aluminum (O/Al) molar ratio of from about 0.25 to about 1.5, more particularly from about 0.5 to about 1.

Preparation of Mixed Catalyst Systems

The above two metal catalysts can be combined to form a mixed catalyst system.

The two or more metal catalyst compounds can be added together in a desired ratio when combined, contacted with an activator, or contacted with a support material or a supported activator. The metal catalyst compounds may be added to the mixture sequentially or at the same time. The ratio of catalyst (A):(B) can vary depending on the balance of processability versus physical characteristics of the desired polymer. For example, the ratio (A):(B) can range from 1:10 to 10:1, such as 5:1 to 1:5 or 1:1.

More complex procedures are possible, such as addition of a first metal catalyst compound to a slurry including a support or a supported activator mixture for a specified reaction time, followed by the addition of the second metal catalyst compound solution, mixed for another specified time, after which the mixture may be recovered for use in a polymerization reactor, such as by spray drying. Lastly, another additive, such as 1-hexene in about 10 vol % can be present in the mixture prior to the addition of the first metal catalyst compound.

The first metal catalyst compound may be supported via contact with a support material for a reaction time. The resulting supported catalyst composition may then be mixed with mineral oil to form a slurry, which may or may not include an activator. The slurry may then be admixed with a second metal catalyst compound prior to introduction of the resulting mixed catalyst system to a polymerization reactor. The second metal catalyst compounds may be admixed at any point prior to introduction to the reactor, such as in a polymerization feed vessel or in-line in a catalyst delivery system.

The mixed catalyst system may be formed by combining a first metal catalyst compound (for example a metal catalyst compound useful for producing a first polymer attribute, such as a high molecular weight polymer fraction or high comonomer content) with a support and activator, desirably in a first diluent such as an alkane or toluene, to produce a supported, activated catalyst compound. The supported activated catalyst compound, either isolated from the first diluent or not, is then combined in one embodiment with a high viscosity diluent such as mineral or silicon oil, or an alkane diluent comprising from 5 to 99 wt% mineral or silicon oil to form a slurry of the supported metal catalyst compound, followed by, or

simultaneous to combining with a second metal catalyst compound (for example, a metal catalyst compound useful for producing a second polymer attribute, such as a low molecular weight polymer fraction or low comonomer content), either in a diluent or as the dry solid compound, to form a supported activated mixed catalyst system ("mixed catalyst system").

5 The mixed catalyst system thus produced may be a supported and activated first metal catalyst compound in a slurry, the slurry comprising mineral or silicon oil, with a second metal catalyst compound that is not supported and not combined with additional activator, where the second metal catalyst compound may or may not be partially or completely soluble in the slurry. In one embodiment, the diluent consists of mineral oil.

10 Mineral oil, or "high viscosity diluents," as used herein refers to petroleum hydrocarbons and mixtures of hydrocarbons that may include aliphatic, aromatic, and/or paraffinic components that are liquids at 23°C and above, and typically have a molecular weight of at least 300 amu to 500 amu or more, and a viscosity at 40°C of from 40 to 300 cSt or greater, or from 50 to 200 cSt in a particular embodiment. The term "mineral oil" includes

15 synthetic oils or liquid polymers, polybutenes, refined naphthenic hydrocarbons, and refined paraffins known in the art, such as disclosed in BLUE BOOK 2001, MATERIALS, COMPOUNDING INGREDIENTS, MACHINERY AND SERVICES FOR RUBBER 189 247 (J. H. Lippincott, D. R. Smith, K. Kish & B. Gordon eds. Lippincott & Peto Inc. 2001). Preferred mineral and silicon oils are those that exclude moieties that are reactive with

20 metallocene catalysts, examples of which include hydroxyl and carboxyl groups.

The diluent may comprise a blend of a mineral, silicon oil, and/or and a hydrocarbon selected from the group consisting of C₁ to C₁₀ alkanes, C₆ to C₂₀ aromatic hydrocarbons, C₇ to C₂₁ alkyl-substituted hydrocarbons, and mixtures thereof. When the diluent is a blend comprising mineral oil, the diluent may comprise from 5 to 99 wt% mineral oil. In some

25 embodiments, the diluent may consist essentially of mineral oil.

In one embodiment, the first metal catalyst compound is combined with an activator and a first diluent to form a catalyst slurry that is then combined with a support material. Until such contact is made, the support particles are preferably not previously activated. The first metal catalyst compound can be in any desirable form such as a dry powder, suspension in a

30 diluent, solution in a diluent, liquid, etc. The catalyst slurry and support particles are then mixed thoroughly, in one embodiment at an elevated temperature, so that both the first metal catalyst compound and the activator are deposited on the support particles to form a support slurry.

After the first metal catalyst compound and activator are deposited on the support, a second metal catalyst compound may then be combined with the supported first metal catalyst compound, wherein the second is combined with a diluent comprising mineral or silicon oil by any suitable means either before, simultaneous to, or after contacting the second metal catalyst compound with the supported first metal catalyst compound. In one embodiment, the first metal catalyst compound is isolated from the first diluent to a dry state before combining with the second metal catalyst compound. Preferably, the second metal catalyst compound is not activated, that is, not combined with any activator, before being combined with the supported first metal catalyst compound. The resulting solids slurry (including both the supported first and second metal catalyst compounds) is then preferably, mixed thoroughly at an elevated temperature.

A wide range of mixing temperatures may be used at various stages of making the mixed catalyst system. For example, in a specific embodiment, when the first metal catalyst compound and at least one activator, such as methylalumoxane, are combined with a first diluent to form a mixture, the mixture is preferably, heated to a first temperature of from 25°C to 150°C, preferably, from 50°C to 125°C, more preferably, from 75°C to 100°C, most preferably, from 80°C to 100°C and stirred for a period of time from 30 seconds to 12 hours, preferably, from 1 minute to 6 hours, more preferably, from 10 minutes to 4 hours, and most preferably, from 30 minutes to 3 hours.

Next, that mixture is combined with a support material to provide a first support slurry. The support material can be heated, or dehydrated if desired, prior to combining. In one or more embodiments, the first support slurry is mixed at a temperature greater than 50°C, preferably, greater than 70°C, more preferably, greater than 80°C and most preferably, greater than 85°C, for a period of time from 30 seconds to 12 hours, preferably, from 1 minute to 6 hours, more preferably, from 10 minutes to 4 hours, and most preferably, from 30 minutes to 3 hours. Preferably, the support slurry is mixed for a time sufficient to provide a collection of activated support particles that have the first metal catalyst compound deposited thereto. The first diluent can then be removed from the first support slurry to provide a dried supported first catalyst compound. For example, the first diluent can be removed under vacuum or by nitrogen purge.

Next, the second metal catalyst compound is combined with the activated first metal catalyst compound in the presence of a diluent comprising mineral or silicon oil in one embodiment. Preferably, the second metal catalyst compound is added in a molar ratio to the first metal catalyst compound in the range from 1:1 to 3:1. Most preferably, the molar ratio is

approximately 1:1. The resultant slurry (or first support slurry) is preferably, heated to a first temperature from 25°C to 150°C, preferably, from 50°C to 125°C, more preferably, from 75°C to 100°C, most preferably, from 80°C to 100°C and stirred for a period of time from 30 seconds to 12 hours, preferably, from 1 minute to 6 hours, more preferably, from 10 minutes to 4 hours, and most preferably, from 30 minutes to 3 hours.

The first diluent is an aromatic or alkane, preferably, hydrocarbon diluent having a boiling point of less than 200°C such as toluene, xylene, hexane, etc., may be removed from the supported first metal catalyst compound under vacuum or by nitrogen purge to provide a supported mixed catalyst system. Even after addition of the oil and/or the second (or other) catalyst compound, it may be desirable to treat the slurry to further remove any remaining solvents such as toluene. This can be accomplished by an N₂ purge or vacuum, for example. Depending upon the level of mineral oil added, the resultant mixed catalyst system may still be a slurry or may be a free flowing powder that comprises an amount of mineral oil. Thus, the mixed catalyst system, while a slurry of solids in mineral oil in one embodiment, may take any physical form such as a free flowing solid. For example, the mixed catalyst system may range from 1 to 99 wt% solids content by weight of the mixed catalyst system (mineral oil, support, all catalyst compounds and activator(s)) in one embodiment. The metallocene compound may be the first or second compound, typically the second compound.

Polymerization Process

In embodiments herein, the present invention provides polymerization processes where monomer (such as ethylene), and, optionally, comonomer (such as hexene), are contacted with a supported catalyst system comprising a catalyst compound represented by formula (A), a catalyst compound represented by formula (B), an activator, and a support material as described above.

Monomers useful herein include substituted or unsubstituted C₂ to C₄₀ alpha olefins, preferably, C₂ to C₂₀ alpha olefins, preferably, C₂ to C₁₂ alpha olefins, preferably, ethylene, propylene, butene, pentene, hexene, heptene, octene, nonene, decene, undecene, dodecene and isomers thereof. In a preferred embodiment of the invention, the monomers comprise ethylene and, optional, comonomers comprising one or more C₃ to C₄₀ olefins, preferably, C₄ to C₂₀ olefins, or preferably, C₆ to C₁₂ olefins. The C₃ to C₄₀ olefin monomers may be linear, branched, or cyclic. The C₃ to C₄₀ cyclic olefins may be strained or unstrained, monocyclic or polycyclic, and may, optionally, include heteroatoms and/or one or more functional groups.

Exemplary C₃ to C₄₀ comonomers include propylene, butene, pentene, hexene, heptene, octene, nonene, decene, undecene, dodecene, norbornene, norbornadiene, dicyclopentadiene,

cyclopentene, cycloheptene, cyclooctene, cyclooctadiene, cyclododecene, 7-oxanorbornene, 7-oxanorbornadiene, substituted derivatives thereof, and isomers thereof, preferably, hexene, heptene, octene, nonene, decene, dodecene, cyclooctene, 1,5-cyclooctadiene, 1-hydroxy-4-cyclooctene, 1-acetoxy-4-cyclooctene, 5-methylcyclopentene, cyclopentene, dicyclopentadiene, norbornene, norbornadiene, and their respective homologs and derivatives.

In a preferred embodiment one or more dienes are present in the polymer produced herein at up to 10 wt%, preferably, at 0.00001 to 1.0 wt%, preferably, 0.002 to 0.5 wt%, even more preferably, 0.003 to 0.2 wt%, based upon the total weight of the composition. In some embodiments 500 ppm or less of diene is added to the polymerization, preferably, 400 ppm or less, preferably, or 300 ppm or less. In other embodiments, at least 50 ppm of diene is added to the polymerization, or 100 ppm or more, or 150 ppm or more.

Preferred diolefin monomers useful in the present invention include any hydrocarbon structure, preferably, C₄ to C₃₀, having at least two unsaturated bonds, wherein at least two of the unsaturated bonds are readily incorporated into a polymer by either a stereospecific or a non-stereospecific catalyst(s). It is further preferred that the diolefin monomers be selected from alpha, omega-diene monomers (i.e., di-vinyl monomers). More preferably, the diolefin monomers are linear di-vinyl monomers, most preferably, those containing from 4 to 30 carbon atoms. Examples of preferred dienes include butadiene, pentadiene, hexadiene, heptadiene, octadiene, nonadiene, decadiene, undecadiene, dodecadiene, tridecadiene, tetradecadiene, pentadecadiene, hexadecadiene, heptadecadiene, octadecadiene, nonadecadiene, icosadiene, heneicosadiene, docosadiene, tricosadiene, tetracosadiene, pentacosadiene, hexacosadiene, heptacosadiene, octacosadiene, nonacosadiene, triacontadiene, particularly preferred dienes include 1,6-heptadiene, 1,7-octadiene, 1,8-nonadiene, 1,9-decadiene, 1,10-undecadiene, 1,11-dodecadiene, 1,12-tridecadiene, 1,13-tetradecadiene, and low molecular weight polybutadienes (Mw less than 1000 g/mol). Preferred cyclic dienes include cyclopentadiene, vinylnorbornene, norbornadiene, ethylidene norbornene, divinylbenzene, dicyclopentadiene or higher ring containing diolefins with or without substituents at various ring positions.

In a particularly preferred embodiment, a process provides polymerization of ethylene and at least one comonomer having from 3 to 8 carbon atoms, preferably, 4 to 8 carbon atoms. Particularly, the comonomers are propylene, 1-butene, 4-methyl-1-pentene, 3-methyl-1-pentene, 1-hexene and 1-octene, the most preferred being 1-hexene, 1-butene and 1-octene.

In a particularly preferred embodiment, a process provides polymerization of one or more monomers selected from the group consisting of propylene, 1-butene, 1-pentene, 3-

methyl-1-pentene, 4-methyl-1-pentene, 1-hexene, 1-octene, 1-decene, and combinations thereof.

Polymerization processes of the present invention can be carried out in any manner known in the art. Any suspension, homogeneous, bulk, solution, slurry, or gas phase
5 polymerization process known in the art can be used. Such processes can be run in a batch, semi-batch, or continuous mode. Gas phase polymerization processes and slurry processes are preferred. (A homogeneous polymerization process preferably is a process where at least 90 wt% of the product is soluble in the reaction media.) A bulk homogeneous process is particularly preferred. (A bulk process is preferably a process where monomer concentration
10 in all feeds to the reactor is 70 volume % or more.) Alternatively, no solvent or diluent is present or added in the reaction medium (except for the small amounts used as the carrier for the catalyst system or other additives, or amounts typically found with the monomer; e.g., propane in propylene).

In another embodiment, the process is a slurry process. As used herein, the term “slurry
15 polymerization process” preferably means a polymerization process where a supported catalyst is employed and monomers are polymerized on the supported catalyst particles. At least 95 wt% of polymer products derived from the supported catalyst are in granular form as solid particles (not dissolved in the diluent).

Suitable diluents/solvents for polymerization include non-coordinating, inert liquids.
20 Examples include straight and branched-chain hydrocarbons, such as isobutane, butane, pentane, isopentane, hexanes, isohexane, heptane, octane, dodecane, and mixtures thereof; cyclic and alicyclic hydrocarbons, such as cyclohexane, cycloheptane, methylcyclohexane, methylcycloheptane, and mixtures thereof, such as can be found commercially (Isopar™); perhalogenated hydrocarbons, such as perfluorinated C₄₋₁₀ alkanes, chlorobenzene, and aromatic
25 and alkylsubstituted aromatic compounds, such as benzene, toluene, mesitylene, and xylene. Suitable solvents also include liquid olefins, which may act as monomers or comonomers, including ethylene, propylene, 1-butene, 1-hexene, 1-pentene, 3-methyl-1-pentene, 4-methyl-1-pentene, 1-octene, 1-decene, and mixtures thereof. In a preferred embodiment, aliphatic hydrocarbon solvents are used as the solvent, such as isobutane, butane, pentane, isopentane,
30 hexanes, isohexane, heptane, octane, dodecane, and mixtures thereof; cyclic and alicyclic hydrocarbons, such as cyclohexane, cycloheptane, methylcyclohexane, methylcycloheptane, and mixtures thereof. In another embodiment, the solvent is not aromatic, preferably, aromatics are present in the solvent at less than 1 wt%, preferably, less than 0.5 wt%, preferably, less than 0 wt% based upon the weight of the solvents.

Gas phase polymerization

Generally, in a fluidized gas bed process used for producing polymers, a gaseous stream containing one or more monomers is continuously cycled through a fluidized bed in the presence of a catalyst under reactive conditions. The gaseous stream is withdrawn from the fluidized bed and recycled back into the reactor. Simultaneously, polymer product is withdrawn from the reactor and fresh monomer is added to replace the polymerized monomer. (See, for example, U.S. Patent Nos. 4,543,399; 4,588,790; 5,028,670; 5,317,036; 5,352,749; 5,405,922; 5,436,304; 5,453,471; 5,462,999; 5,616,661; and 5,668,228; all of which are fully incorporated herein by reference.)

Slurry phase polymerization

A slurry polymerization process generally operates between 1 to about 50 atmosphere pressure range (15 psi to 735 psi, 103 kPa to 5068 kPa) or even greater and temperatures in the range of 0°C to about 120°C. In a slurry polymerization, a suspension of solid, particulate polymer is formed in a liquid polymerization diluent medium to which monomer and comonomers, along with catalysts, are added. The suspension including diluent is intermittently or continuously removed from the reactor where the volatile components are separated from the polymer and recycled, optionally after a distillation, to the reactor. The liquid diluent employed in the polymerization medium is typically an alkane having from 3 to 7 carbon atoms, preferably a branched alkane. The medium employed should be liquid under the conditions of polymerization and relatively inert. When a propane medium is used, the process must be operated above the reaction diluent critical temperature and pressure. Preferably, a hexane or an isobutane medium is employed.

Polyolefin Products

The present invention further provides compositions of matter produced by the methods described herein.

In a preferred embodiment, a process described herein produces ethylene homopolymers or ethylene copolymers, such as ethylene-alpha-olefin (preferably C₃ to C₂₀) copolymers (such as ethylene-butene copolymers, ethylene-hexene and/or ethylene-octene copolymers).

Likewise, the process of the present invention produces ethylene copolymers. In a preferred embodiment, the copolymers produced herein have from 0 to 25 mol% (alternatively from 0.5 to 20 mol%, alternatively from 1 to 15 mol%, preferably from 3 to 10 mol%) of one or more C₃ to C₂₀ olefin comonomer, such as a C₃-C₂₀ alpha-olefin, (preferably C₃ to C₁₂ alpha-

olefin, preferably propylene, butene, hexene, octene, decene, dodecene, preferably propylene, butene, hexene, octene).

In a preferred embodiment, the monomer is ethylene and the comonomer is hexene, preferably from 1 to 15 mol% hexene, alternatively 1 to 10 mol%.

- 5 In a preferred embodiment, a method of the present invention provides an in-situ ethylene polymer composition having: 1) at least 50 mol% ethylene; and 2) a density of 0.91 g/cc or more, preferably 0.935 g/cc or more (ASTM 1505). Preferably, the copolymer has higher comonomer (e.g., hexene) content in the higher molecular weight (Mw) component of the resin as compared to the lower molecular weight (Mw) component, preferably at least 10%
10 higher, preferably at least 20% higher, preferably at least 30% higher as determined by GPC-4D. The dividing line between higher and lower Mw is the midpoint between the Mw's of two polymers each made using the same polymerization conditions as the product made using the two catalysts on a support, except that the first polymer is made without the catalyst represented by formula (A) and the second polymer is made without the catalyst represented by formula
15 (B). In the event such a midpoint cannot be determined because one or both single catalysts will not produce polymer at the required conditions then an Mw of 150,000 g/mol shall be used.

- The copolymer produced herein typically has a composition distribution breadth $T_{75}-T_{25}$, as measured by TREF, that is greater than 20°C, preferably greater than 30°C, preferably
20 greater than 40°C. The $T_{75}-T_{25}$ value represents the homogeneity of the composition distribution as determined by temperature rising elution fractionation. A TREF curve is produced as described below. Then the temperature at which 75% of the polymer is eluted is subtracted from the temperature at which 25% of the polymer is eluted, as determined by the integration of the area under the TREF curve. The $T_{75}-T_{25}$ value represents the difference. The
25 closer these temperatures comes together, the narrower the composition distribution.

- Typically, the polymers produced herein have an Mw of 5,000 to 1,000,000 g/mol (preferably 25,000 to 750,000 g/mol, preferably 50,000 to 500,000 g/mol), and/or an Mw/Mn of greater than 1 to 40 (alternatively 1.2 to 20, alternatively 1.3 to 10, alternatively 1.4 to 5, 1.5 to 4, alternatively 1.5 to 3) as determined by GPC-4D. Polymers produced herein typically
30 have an Mz/Mw from about 1 to about 10, such as from about 2 to about 6, such as from about 3 to about 5. Polymers produced herein typically have an Mz/Mn from about 1 to about 10, such as from about 2 to about 6, such as from about 3 to about 5. Furthermore, the ratio of other average molecular weight ratios can also be calculated to highlight how the distribution is affected. For instance, a trace amount of very high MW species in a polymer product can

preferentially raise M_z more than M_w and, therefore, result in a significantly higher ratio of M_z/M_w . Such difference in the effect on molecular weight distribution has been discovered to have profound effects on film toughness, such as tear property, through molecular orientation during the fabrication process.

5 In a preferred embodiment, the polymer produced herein has a unimodal or multimodal molecular weight distribution as determined by Gel Permeation Chromatography (GPC). By “unimodal” is meant that the GPC trace has one peak or two inflection points. By “multimodal” is meant that the GPC trace has at least two peaks or more than 2 inflection points. An inflection point is that point where the second derivative of the curve changes in sign (e.g.,
10 from negative to positive or vice versa).

In a preferred embodiment, the polymer produced herein has a bimodal molecular weight distribution as determined by Gel Permeation Chromatography (GPC). By “bimodal” is meant that the GPC trace has two peaks or at least 4 inflection points.

In another embodiment, the polymer produced herein has two peaks in the TREF
15 measurement (see below). Two peaks in the TREF measurement as used in this specification and the appended claims means the presence of two distinct normalized IR response peaks in a graph of normalized IR response (vertical or y axis) versus elution temperature (horizontal or x axis with temperature increasing from left to right) using the TREF method below. A “peak” in this context means where the general slope of the graph changes from positive to negative
20 with increasing temperature. Between the two peaks is a local minimum in which the general slope of the graph changes from negative to positive with increasing temperature. “General trend” of the graph is intended to exclude the multiple local minimums and maximums that can occur in intervals of 2°C or less. Preferably, the two distinct peaks are at least 3°C apart, more preferably at least 4°C apart, even more preferably at least 5°C apart. Additionally, both of the
25 distinct peaks occur at a temperature on the graph above 20°C and below 120°C where the elution temperature is run to 0°C or lower. This limitation avoids confusion with the apparent peak on the graph at low temperature caused by material that remains soluble at the lowest elution temperature. Two peaks on such a graph indicates a bi-modal composition distribution (CD). An alternate method for TREF measurement can be used if the method below does not
30 show two peaks, i.e., see B. Monrabal, “Crystallization Analysis Fractionation: A New Technique for the Analysis of Branching Distribution in Polyolefins,” Journal of Applied Polymer Science, Vol. 52, 491–499 (1994).

TREF Method

Temperature Rising Elution Fractionation (TREF) analysis is done using a Crystallization Elution Fractionation (CEF) instrument from Polymer Char, S.A., Valencia, Spain. The principles of CEF analysis and a general description of the particular apparatus used are given in the article Monrabal, B. et al. Crystallization Elution Fractionation. A New Separation Process for Polyolefin Resins. *Macromol. Symp.* 2007, 257, 71. In particular, a process conforming to the "TREF separation process" shown in Figure 1a of this article, in which $F_c=0$, was used. Pertinent details of the analysis method and features of the apparatus used are as follows.

The solvent used for preparing the sample solution and for elution was 1,2-Dichlorobenzene (ODCB) which was stabilized by dissolving 1.6 g of 2,6-bis(1,1-dimethylethyl)-4-methylphenol (butylated hydroxytoluene) in a 4-L bottle of fresh solvent at ambient temperature. The stabilized solvent was then filtered using a 0.1- μ m Teflon filter (Millipore). The sample (6–10 mg) to be analyzed was dissolved in 8 ml of ODCB metered at ambient temperature by stirring (Medium setting) at 150°C for 90 min. A small volume of the polymer solution was first filtered by an inline filter (stainless steel, 10 μ m), which is back-flushed after every filtration. The filtrate was then used to completely fill a 200- μ l injection-valve loop. The volume in the loop was then introduced near the center of the CEF column (15-cm long SS tubing, 3/8" o.d., 7.8 mm i.d.) packed with an inert support (SS balls) at 140°C, and the column temperature was stabilized at 125°C for 20 min. The sample volume was then allowed to crystallize in the column by reducing the temperature to 0°C at a cooling rate of 1°C/min. The column was kept at 0°C for 10 min before injecting the ODCB flow (1 ml/min) into the column for 10 min to elute and measure the polymer that did not crystallize (soluble fraction). The wide-band channel of the infrared detector used (Polymer Char IR5) generates an absorbance signal that is proportional to the concentration of polymer in the eluting flow. A complete TREF curve was then generated by increasing the temperature of the column from 0 to 140°C at a rate of 2°C/min while maintaining the ODCB flow at 1 ml/min to elute and measure the concentration of the dissolving polymer.

GPC 4D Procedure: Molecular Weight, Comonomer Composition and Long Chain Branching

Determination by GPC-IR Hyphenated with Multiple Detectors

Unless otherwise indicated, the distributions and the moments of molecular weight (M_w , M_n , M_w/M_n , etc.), the comonomer content (C_2 , C_3 , C_6 , etc.) and the branching index (g'_{vis}) are determined by using a high temperature Gel Permeation Chromatography (Polymer Char GPC-IR) equipped with a multiple-channel band-filter based Infrared detector IR5, an 18-

angle light scattering detector and a viscometer. Three Agilent PLgel 10- μ m Mixed-B LS columns are used to provide polymer separation. Aldrich reagent grade 1,2,4-trichlorobenzene (TCB) with 300 ppm antioxidant butylated hydroxytoluene (BHT) is used as the mobile phase. The TCB mixture is filtered through a 0.1- μ m Teflon filter and degassed with an online
 5 degasser before entering the GPC instrument. The nominal flow rate is 1.0 ml/min and the nominal injection volume is 200 μ L. The whole system including transfer lines, columns, and detectors are contained in an oven maintained at 145°C. The polymer sample is weighed and sealed in a standard vial with 80- μ L flow marker (Heptane) added to it. After loading the vial in the autosampler, polymer is automatically dissolved in the instrument with 8 ml added TCB
 10 solvent. The polymer is dissolved at 160°C with continuous shaking for about 1 hour for most PE samples or 2 hour for PP samples. The TCB densities used in concentration calculation are 1.463 g/ml at room temperature and 1.284 g/ml at 145°C. The sample solution concentration is from 0.2 to 2.0 mg/ml, with lower concentrations being used for higher molecular weight samples. The concentration (c), at each point in the chromatogram is calculated from the
 15 baseline-subtracted IR5 broadband signal intensity (I), using the following equation: $c = \beta I$, where β is the mass constant. The mass recovery is calculated from the ratio of the integrated area of the concentration chromatography over elution volume and the injection mass which is equal to the pre-determined concentration multiplied by injection loop volume. The conventional molecular weight (IR MW) is determined by combining universal calibration
 20 relationship with the column calibration which is performed with a series of monodispersed polystyrene (PS) standards ranging from 700 to 10M gm/mole. The MW at each elution volume is calculated with the following equation:

$$\log M = \frac{\log(K_{PS} / K)}{a + 1} + \frac{a_{PS} + 1}{a + 1} \log M_{PS}$$

where the variables with subscript "PS" stand for polystyrene while those without a subscript
 25 are for the test samples. In this method, $\alpha_{PS} = 0.67$ and $K_{PS} = 0.000175$ while α and K are for other materials as calculated and published in literature (Sun, T. et al. *Macromolecules*, 2001, 34, 6812), except that for purposes of the present invention, $\alpha = 0.695$ and $K = 0.000579$ for linear ethylene polymers, $\alpha = 0.705$ and $K = 0.0002288$ for linear propylene polymers, $\alpha = 0.695$ and $K = 0.000181$ for linear butene polymers, α is 0.695 and K is $0.000579 \cdot (1 - 0.0087 \cdot w_{2b} + 0.000018 \cdot (w_{2b})^2)$ for ethylene-butene copolymer where w_{2b} is a bulk weight
 30 percent of butene comonomer, α is 0.695 and K is $0.000579 \cdot (1 - 0.0075 \cdot w_{2b})$ for ethylene-hexene copolymer where w_{2b} is a bulk weight percent of hexene comonomer, and α is 0.695

and K is $0.000579 \cdot (1 - 0.0077 \cdot w_{2b})$ for ethylene-octene copolymer where w_{2b} is a bulk weight percent of octene comonomer. Concentrations are expressed in g/cm^3 , molecular weight is expressed in g/mole , and intrinsic viscosity (hence K in the Mark-Houwink equation) is expressed in dL/g unless otherwise noted.

- 5 The comonomer composition is determined by the ratio of the IR5 detector intensity corresponding to CH_2 and CH_3 channel calibrated with a series of PE and PP homo/copolymer standards whose nominal value are predetermined by NMR or FTIR. In particular, this provides the methyls per 1000 total carbons ($\text{CH}_3/1000\text{TC}$) as a function of molecular weight. The short-chain branch (SCB) content per 1000TC ($\text{SCB}/1000\text{TC}$) is then computed as a
- 10 function of molecular weight by applying a chain-end correction to the $\text{CH}_3/1000\text{TC}$ function, assuming each chain to be linear and terminated by a methyl group at each end. The weight % comonomer is then obtained from the following expression in which f is 0.3, 0.4, 0.6, 0.8, and so on for C_3 , C_4 , C_6 , C_8 , and so on co-monomers, respectively:

$$w_2 = f * \text{SCB}/1000\text{TC}.$$

- 15 The bulk composition of the polymer from the GPC-IR and GPC-4D analyses is obtained by considering the entire signals of the CH_3 and CH_2 channels between the integration limits of the concentration chromatogram. First, the following ratio is obtained

$$\text{Bulk IR ratio} = \frac{\text{Area of } \text{CH}_3 \text{ signal within integration limits}}{\text{Area of } \text{CH}_2 \text{ signal within integration limits}}.$$

- Then the same calibration of the CH_3 and CH_2 signal ratio, as mentioned previously in
- 20 obtaining the $\text{CH}_3/1000\text{TC}$ as a function of molecular weight, is applied to obtain the bulk $\text{CH}_3/1000\text{TC}$. A bulk methyl chain ends per 1000TC ($\text{bulk CH}_3\text{end}/1000\text{TC}$) is obtained by weight-averaging the chain-end correction over the molecular-weight range. Then

$$w_{2b} = f * \text{bulk CH}_3/1000\text{TC}$$

$$\text{bulk SCB}/1000\text{TC} = \text{bulk CH}_3/1000\text{TC} - \text{bulk CH}_3\text{end}/1000\text{TC}$$

- 25 and bulk $\text{SCB}/1000\text{TC}$ is converted to bulk w_2 in the same manner as described above.

The LS detector is the 18-angle Wyatt Technology High Temperature DAWN HELEOSII. The LS molecular weight (M) at each point in the chromatogram is determined by analyzing the LS output using the Zimm model for static light scattering (*Light Scattering from Polymer Solutions*; Huglin, M. B., Ed.; Academic Press, 1972.):

30
$$\frac{K_o c}{\Delta R(\theta)} = \frac{1}{MP(\theta)} + 2A_2 c.$$

Here, $\Delta R(\theta)$ is the measured excess Rayleigh scattering intensity at scattering angle θ , c is the polymer concentration determined from the IR5 analysis, A_2 is the second virial coefficient,

$P(\theta)$ is the form factor for a monodisperse random coil, and K_o is the optical constant for the system:

$$K_o = \frac{4\pi^2 n^2 (dn/dc)^2}{\lambda^4 N_A}$$

where N_A is Avogadro's number, and (dn/dc) is the refractive index increment for the system.

- 5 The refractive index, $n=1.500$ for TCB at 145°C and $\lambda=665\text{ nm}$. For analyzing polyethylene homopolymers, ethylene-hexene copolymers, and ethylene-octene copolymers, $dn/dc=0.1048\text{ ml/mg}$ and $A_2=0.0015$; for analyzing ethylene-butene copolymers, $dn/dc=0.1048*(1-0.00126*w_2)\text{ ml/mg}$ and $A_2=0.0015$ where w_2 is weight percent butene comonomer.
- 10 A high temperature Agilent (or Viscotek Corporation) viscometer, which has four capillaries arranged in a Wheatstone bridge configuration with two pressure transducers, is used to determine specific viscosity. One transducer measures the total pressure drop across the detector, and the other, positioned between the two sides of the bridge, measures a differential pressure. The specific viscosity, η_s , for the solution flowing through the viscometer
- 15 is calculated from their outputs. The intrinsic viscosity, $[\eta]$, at each point in the chromatogram is calculated from the equation $[\eta] = \eta_s/c$, where c is concentration and is determined from the IR5 broadband channel output. The viscosity MW at each point is calculated as $M = K_{ps} M^{\alpha_{ps}+1} / [\eta]$, where α_{ps} is 0.67 and K_{ps} is 0.000175.

- 20 The branching index (g'_{vis}) is calculated using the output of the GPC-IR5-LS-VIS method as follows. The average intrinsic viscosity, $[\eta]_{avg}$, of the sample is calculated by:

$$[\eta]_{avg} = \frac{\sum c_i [\eta]_i}{\sum c_i}$$

where the summations are over the chromatographic slices, i , between the integration limits.

- The branching index g'_{vis} is defined as $g'_{vis} = \frac{[\eta]_{avg}}{KM_v^\alpha}$, where M_v is the viscosity-average molecular weight based on molecular weights determined by LS analysis and the K and α are
- 25 for the reference linear polymer, which are, for purposes of the present invention, $\alpha=0.695$ and $K=0.000579$ for linear ethylene polymers, $\alpha=0.705$ and $K=0.0002288$ for linear propylene polymers, $\alpha=0.695$ and $K=0.000181$ for linear butene polymers, α is 0.695 and K is $0.000579*(1-0.0087*w_{2b}+0.000018*(w_{2b})^2)$ for ethylene-butene copolymer where w_{2b} is a bulk weight percent of butene comonomer, α is 0.695 and K is $0.000579*(1-0.0075*w_{2b})$

for ethylene–hexene copolymer where w_2b is a bulk weight percent of hexene comonomer, and α is 0.695 and K is $0.000579 \cdot (1 - 0.0077 \cdot w_2b)$ for ethylene–octene copolymer where w_2b is a bulk weight percent of octene comonomer. Concentrations are expressed in g/cm^3 , molecular weight is expressed in g/mole , and intrinsic viscosity (hence K in the Mark–Houwink equation) is expressed in dL/g unless otherwise noted. Calculation of the w_2b values is as discussed above.

The reversed-co-monomer index (RCI_m) is computed from x_2 (mol% co-monomer C_3 , C_4 , C_6 , C_8 , etc.), as a function of molecular weight, where x_2 is obtained from the following expression in which n is the number of carbon atoms in the comonomer (3 for C_3 , 4 for C_4 , 6 for C_6 , etc.):

$$x_2 = - \frac{200 w_2}{-100 n - 2 w_2 + n w_2}.$$

Then the molecular-weight distribution, $W(z)$ where $z = \log_{10} M$, is modified to $W'(z)$ by setting to 0 the points in W that are less than 5% of the maximum of W ; this is to effectively remove points for which the S/N in the composition signal is low. Also, points of W' for molecular weights below 2000 gm/mole are set to 0. Then W' is renormalized so that

$$1 = \int_{-\infty}^{\infty} W' dz$$

and a modified weight-average molecular weight (M_w') is calculated over the effectively reduced range of molecular weights as follows:

$$M_w' = \int_{-\infty}^{\infty} 10^z * W' dz.$$

The RCI_m is then computed as

$$\text{RCI}_m = \int_{-\infty}^{\infty} x_2 (10^z - M_w') W' dz.$$

A reversed-co-monomer index (RCI_w) is also defined on the basis of the weight fraction co-monomer signal ($w_2/100$) and is computed as follows:

$$\text{RCI}_w = \int_{-\infty}^{\infty} \frac{w_2}{100} (10^z - M_w') W' dz.$$

Note that in the above definite integrals the limits of integration are the widest possible for the sake of generality; however, in reality the function is only integrated over a finite range for which data is acquired, considering the function in the rest of the non-acquired range to be 0. Also, by the manner in which W' is obtained, it is possible that W' is a discontinuous function, and the above integrations need to be done piecewise.

Three co-monomer distribution ratios are also defined on the basis of the % weight (w_2) comonomer signal, denoted as CDR-1_w , CDR-2_w , and CDR-3_w , as follows:

$$\text{CDR-1,w} = \frac{w_2(M_z)}{w_2(M_w)}$$

$$\text{CDR-2,w} = \frac{w_2(M_z)}{w_2\left(\frac{M_w + M_n}{2}\right)}$$

$$\text{CDR-3,w} = \frac{w_2\left(\frac{M_z + M_w}{2}\right)}{w_2\left(\frac{M_w + M_n}{2}\right)}$$

where $w_2(M_w)$ is the % weight co-monomer signal corresponding to a molecular weight of M_w , $w_2(M_z)$ is the % weight co-monomer signal corresponding to a molecular weight of M_z , $w_2[(M_w+M_n)/2]$ is the % weight co-monomer signal corresponding to a molecular weight of $(M_w+M_n)/2$, and $w_2[(M_z+M_w)/2]$ is the % weight co-monomer signal corresponding to a molecular weight of $M_z+M_w/2$, where M_w is the weight-average molecular weight, M_n is the number-average molecular weight, and M_z is the z-average molecular weight.

Accordingly, the co-monomer distribution ratios can be also defined utilizing the % mole co-monomer signal, CDR-1,m, CDR-2,m, CDR-3,m, as:

$$\text{CDR-1,m} = \frac{x_2(M_z)}{x_2(M_w)}$$

$$\text{CDR-2,m} = \frac{x_2(M_z)}{x_2\left(\frac{M_w + M_n}{2}\right)}$$

$$\text{CDR-3,m} = \frac{x_2\left(\frac{M_z + M_w}{2}\right)}{x_2\left(\frac{M_w + M_n}{2}\right)}$$

where $x_2(M_w)$ is the % mole co-monomer signal corresponding to a molecular weight of M_w , $x_2(M_z)$ is the % mole co-monomer signal corresponding to a molecular weight of M_z , $x_2[(M_w+M_n)/2]$ is the % mole co-monomer signal corresponding to a molecular weight of $(M_w+M_n)/2$, and $x_2[(M_z+M_w)/2]$ is the % mole co-monomer signal corresponding to a molecular weight of $M_z+M_w/2$, where M_w is the weight-average molecular weight, M_n is the number-average molecular weight, and M_z is the z-average molecular weight.

An “in-situ polymer composition” (also referred to as an “in-situ blend” or a “reactor blend”) is the composition which is the product of a polymerization with two catalyst compounds in the same reactor described herein. Without wishing to be bound by theory it is thought that the two catalyst compounds produce a reactor blend (i.e., an interpenetrating

network) of two (or more) components made in the same reactors (or reactions zones) with the two catalysts. These sorts of compositions may be referred to as reactor blends, although the term may not be strictly accurate since there may be polymer species comprising components produced by each catalyst compound that are not technically a blend.

- 5 An “ex-situ blend” is a blend which is a physical blend of two or more polymers synthesized independently and then subsequently blended together typically using a melt-mixing process, such as an extruder. An ex-situ blend is distinguished by the fact that the polymer components are collected in solid form after exiting their respective synthesis processes, and then combined to form the blend; whereas for an *in-situ* polymer composition,
10 the polymer components are prepared within a common synthesis process and only the combination is collected in solid form.

In at least one embodiment, the polymer composition produced is an in-situ polymer composition.

- 15 In at least one embodiment, the polymer produced is an in-situ polymer composition having an ethylene content of 70 wt% or more, preferably 80 wt% or more, preferably 90 wt% or more and/or a density of 0.910 or more, alternatively 0.93 g/cc or more; alternatively 0.935 g/cc or more, alternatively 0.938 g/cc or more.

- In at least one embodiment of the present invention, the polymer produced is an in-situ polymer composition having a density of 0.910 g/cc or more, alternatively from 0.935 to 0.960
20 g/cc.

- In at least one embodiment of the present invention, the polymer produced by the processes described herein comprises ethylene and one or more comonomers and the polymer has: 1) an RCI_m greater than 30 (alternatively greater than 30 to 50), an Mw/Mn of greater than 3, and optionally a T₇₅-T₂₅ of 15 to 20°C; or 2) an RCI_m greater than 50 (alternatively
25 greater than 80), an Mw/Mn of greater than 5 (alternatively from 5 to 10), and optionally a T₇₅-T₂₅ of from 25 to 75°C, such as from 45 to 75°C, such as from 25 to 45°C.

In at least one embodiment of the present invention, when:

- 1) the compound represented by formula (A) is run under the same polymerization conditions as a supported two catalyst composition described herein, except that the compound
30 represented by formula (B) is absent, a polymer having an RCI_m of 20 or more is produced; and
2) the compound represented by formula (B) is run under the same polymerization conditions as step 1), except that the compound represented by formula (A) is absent, a polymer having an RCI_m of less than zero is produced.

In at least one embodiment of the present invention, a linear low density polyethylene may be produced by using the supported catalyst systems (C) described herein (e.g., having activator and two catalysts (A) and (B) supported on the same support) where the LLDPE has:
a) an RCI,m greater than 30 (alternatively greater than 30 to 50), an Mw/Mn of greater than 3
5 to less than 5, and optionally a T₇₅-T₂₅ of 15-20°C; or b) an RCI,m greater than 50 (alternatively greater than 80) and an Mw/Mn of greater than 5 (optionally of greater than 5 to 10) , and optionally a T₇₅-T₂₅ of from 25 to 75°C, such as from 45 to 75°C, such as from 25 to 45°C, provided that:

- 1) when the supported compound represented by formula (A) is run under the same
10 polymerization conditions as the supported catalyst system (C) except that the compound represented by formula (B) is absent, an ethylene polymer is produced having an RCI,m greater than 20; and
- 2) when the supported compound represented by formula (B) is run under the same conditions as step 1) except that the compound (A) is absent, an ethylene polymer is produced having a
15 negative RCI,m.

To obtain polymers having higher RCI,m's (such as 50 and above) select catalyst compounds represented by formula (A) that produce high comonomer content and or high Mw/Mn.

In at least one embodiment, a polymer of the present invention has a PDI of from 1 to
20 about 6, such as from 1 to 5, preferably from 1 to 4.

In at least one embodiment, a polymer of the present invention has a high degree of internal unsaturation. In at least one embodiment, a polymer has an internal unsaturation of less than 50% of the total unsaturations, such as less than 40% preferably less than 30%. Internal unsaturation can be promoted by increasing the amount of the catalyst represented by
25 formula (A) (as compared the amount of the catalyst represented by formula (B)) in a catalyst system of the present invention. Polymers having a high degree of internal unsaturation can provide a low content of long chain branching, such as g'vis of 0.95 or more. Internal unsaturation can disrupt the crystallization of ethylene chains and contribute to the amorphous phase of the PE resin which may contribute to stronger mechanical properties in the film.

30 Polymers of the present invention can also have a high degree of terminal unsaturation, e.g., vinylogous end groups. In at least one embodiment, a polymer has a terminal unsaturation of 50% or more of the total unsaturations, preferably 60% or more, preferably 70% or more, alternately from 50 to 90%, from 60 to 85%, from 60 to 80%. Terminal unsaturation can be promoted by increasing the amount of the catalyst represented by formula (B) (as compared

the amount of the catalyst represented by formula (A)) in a catalyst system of the present invention. Terminal unsaturation can provide reactive end groups of polymers for functionalization.

In at least one embodiment, a polymer of the present invention has a combination of
5 internal and terminal unsaturation of greater than 0.7 unsaturations per 1000 carbon atoms, such as greater than 0.8, preferably greater than 0.9.

In at least one embodiment, a polymer of the present invention has a ratio of terminal unsaturation to internal unsaturation of from 1 to 4, such as from 1 to 3, preferably from 1 to 2.

10 Unsaturation (internal and terminal) in a polymer can be determined by ¹H NMR with reference to *Macromolecules* 2014, 47, 3782 and *Macromolecules*, 2005, 38, 6988, but in event of conflict *Macromolecules*, 2014, 47, 3782 shall control. Peak assignments are determined referencing the solvent of tetrachloroethane-1,2 d₂ at 5.98 ppm. Specifically, percent internal
15 unsaturation is determined by adding Vy1+Vy2+trisubstituted olefins then dividing by total unsaturation.

In at least one embodiment, a polymer of the present invention has a g'vis of greater than 0.9, such as greater than 0.92, preferably greater than 0.95.

In at least one embodiment, a polymer of the present invention has a RCI_m greater than 50, such as greater than 55, preferably greater than 60.

20 End Uses

The multi-modal polyolefin produced by the processes disclosed herein and blends thereof are useful in such forming operations as film, sheet, and fiber extrusion and co-extrusion as well as blow molding, injection molding, and rotary molding. Films include blown or cast films formed by co-extrusion or by lamination useful as shrink film, cling film, stretch
25 film, sealing films, oriented films, snack packaging, heavy duty bags, grocery sacks, baked and frozen food packaging, medical packaging, industrial liners, membranes, etc., in food-contact and non-food contact applications. Fibers include melt spinning, solution spinning and melt blown fiber operations for use in woven or non-woven form to make filters, diaper fabrics, medical garments, geotextiles, etc. Extruded articles include medical tubing, wire and cable
30 coatings, pipe, geomembranes, and pond liners. Molded articles include single and multi-layered constructions in the form of bottles, tanks, large hollow articles, rigid food containers and toys, etc.

Specifically, any of the foregoing polymers, such as the foregoing ethylene copolymers or blends thereof, may be used in mono- or multi-layer blown, extruded, and/or shrink films.

These films may be formed by any number of well-known extrusion or coextrusion techniques, such as a blown bubble film processing technique, wherein the composition can be extruded in a molten state through an annular die and then expanded to form a uni-axial or biaxial orientation melt prior to being cooled to form a tubular, blown film, which can then be axially
5 slit and unfolded to form a flat film. Films may be subsequently unoriented, uniaxially oriented, or biaxially oriented to the same or different extents.

Blends

The polymers produced herein may be further blended with additional ethylene polymers (referred to as “second ethylene polymers” or “second ethylene copolymers”) and
10 use in film, molded part and other typical polyethylene applications.

In one aspect of the present invention, the second ethylene polymer is selected from ethylene homopolymer, ethylene copolymers, and blends thereof. Useful second ethylene copolymers can comprise one or more comonomers in addition to ethylene and can be a random copolymer, a statistical copolymer, a block copolymer, and/or blends thereof. The method of
15 making the second ethylene polymer is not critical, as it can be made by slurry, solution, gas phase, high pressure or other suitable processes, and by using catalyst systems appropriate for the polymerization of polyethylenes, such as Ziegler-Natta-type catalysts, chromium catalysts, metallocene-type catalysts, other appropriate catalyst systems or combinations thereof, or by free-radical polymerization. In a preferred embodiment, the second ethylene polymers are
20 made by the catalysts, activators and processes described in U.S. Patent Nos. 6,342,566; 6,384,142; 5,741,563; PCT Publication Nos. WO 03/040201; and WO 97/19991. Such catalysts are well known in the art, and are described in, for example, ZIEGLER CATALYSTS (Gerhard Fink, Rolf Mülhaupt and Hans H. Brintzinger, eds., Springer-Verlag 1995); Resconi et al.; and I, II METALLOCENE-BASED POLYOLEFINS (Wiley & Sons 2000). Additional useful
25 second ethylene polymers and copolymers are described at paragraph [00118] to [00126] at pages 30 to 34 of PCT/US2016/028271, filed April 19, 2016.

Experimental

Test Methods

¹H NMR

30 ¹H NMR data was collected at 120°C using a 10 mm CryoProbe with a Bruker spectrometer at a ¹H frequency of 400 MHz (available from Bruker Corporation, United Kingdom). Data were recorded using a maximum pulse width of 45°, 5 seconds between pulses and signal averaging 512 transients. Samples were prepared by dissolving 80 mg of sample in

3 mL of solvent heated at 140°C. Peak assignments are determined referencing the solvent of tetrachloroethane-1,2 d₂ at 5.98 ppm.

GPC 4D Procedure

Unless otherwise indicated, the distribution and the moments of molecular weight (M_w,
 5 M_n, M_z, M_w/M_n, etc.), the comonomer content (C₂, C₃, C₆, etc.) and the branching index (g') are determined by using a high temperature Gel Permeation Chromatography (Polymer Char GPC-IR) equipped with a multiple-channel band-filter based Infrared detector IR5, an 18-angle light scattering detector and a viscometer. Three Agilent PLgel 10-μm Mixed-B LS columns are used to provide polymer separation. Aldrich reagent grade 1,2,4-trichlorobenzene (TCB)
 10 with 300 ppm antioxidant butylated hydroxytoluene (BHT) is used as the mobile phase. The TCB mixture is filtered through a 0.1-μm Teflon filter and degassed with an online degasser before entering the GPC instrument. The nominal flow rate is 1.0 ml/min and the nominal injection volume is 200 μL. The whole system including transfer lines, columns, and detectors are contained in an oven maintained at 145°C. Given amount of polymer sample is weighed
 15 and sealed in a standard vial with 80-μL flow marker (Heptane) added to it. After loading the vial in the autosampler, polymer is automatically dissolved in the instrument with 8 ml added TCB solvent. The polymer is dissolved at 160°C with continuous shaking for about 1 hour for most polyethylene samples or 2 hours for polypropylene samples. The TCB densities used in concentration calculation are 1.463 g/ml at room temperature and 1.284 g/ml at 145°C. The
 20 sample solution concentration is from 0.2 to 2.0 mg/ml, with lower concentrations being used for higher molecular weight samples. The concentration (c), at each point in the chromatogram is calculated from the baseline-subtracted IR5 broadband signal intensity (I), using the following equation: $c = \beta I$, where β is the mass constant. The mass recovery is calculated from the ratio of the integrated area of the concentration chromatography over elution volume and
 25 the injection mass which is equal to the pre-determined concentration multiplied by injection loop volume. The conventional molecular weight (IR MW) is determined by combining universal calibration relationship with the column calibration which is performed with a series of monodispersed polystyrene (PS) standards ranging from 700 to 10M gm/mole. The MW at each elution volume is calculated with following equation:

$$30 \quad \log M = \frac{\log(K_{PS}/K)}{\alpha + 1} + \frac{\alpha_{PS} + 1}{\alpha + 1} \log M_{PS}$$

where the variables with subscript "PS" stand for polystyrene while those without a subscript are for the test samples. In this method, $\alpha_{PS}=0.67$ and $K_{PS}=0.000175$, while α and K for other materials are as calculated and published in literature (Sun, T. et al. *Macromolecules*, 2001, 34,

6812), except that for purposes of the present invention, $\alpha=0.695$ and $K=0.000579$ for linear ethylene polymers, $\alpha=0.705$ and $K=0.0002288$ for linear propylene polymers, $\alpha=0.695$ and $K=0.000181$ for linear butene polymers, α is 0.695 and K is $0.000579*(1-0.0087*w2b+0.000018*(w2b)^2)$ for ethylene-butene copolymer where $w2b$ is a bulk weight percent of butene comonomer, α is 0.695 and K is $0.000579*(1-0.0075*w2b)$ for ethylene-hexene copolymer where $w2b$ is a bulk weight percent of hexene comonomer, and α is 0.695 and K is $0.000579*(1-0.0077*w2b)$ for ethylene-octene copolymer where $w2b$ is a bulk weight percent of octene comonomer. Concentrations are expressed in g/cm^3 , molecular weight is expressed in $g/mole$, and intrinsic viscosity (hence K in the Mark-Houwink equation) is expressed in dL/g unless otherwise noted.

The comonomer composition is determined by the ratio of the IR5 detector intensity corresponding to CH_2 and CH_3 channel calibrated with a series of PE and PP homo/copolymer standards whose nominal values are predetermined by NMR or FTIR. In particular, this provides the methyls per 1000 total carbons ($CH_3/1000TC$) as a function of molecular weight. The short-chain branch (SCB) content per 1000TC ($SCB/1000TC$) is then computed as a function of molecular weight by applying a chain-end correction to the $CH_3/1000TC$ function, assuming each chain to be linear and terminated by a methyl group at each end. The weight % comonomer is then obtained from the following expression in which f is 0.3, 0.4, 0.6, 0.8, and so on for C_3 , C_4 , C_6 , C_8 , and so on co-monomers, respectively:

$$w2 = f * SCB/1000TC.$$

The bulk composition of the polymer from the GPC-IR and GPC-4D analyses is obtained by considering the entire signals of the CH_3 and CH_2 channels between the integration limits of the concentration chromatogram. First, the following ratio is obtained

$$\text{Bulk IR ratio} = \frac{\text{Area of } CH_3 \text{ signal within integration limits}}{\text{Area of } CH_2 \text{ signal within integration limits}}$$

Then the same calibration of the CH_3 and CH_2 signal ratio, as mentioned previously in obtaining the $CH_3/1000TC$ as a function of molecular weight, is applied to obtain the bulk $CH_3/1000TC$. A bulk methyl chain ends per 1000TC (bulk $CH_{3end}/1000TC$) is obtained by weight-averaging the chain-end correction over the molecular-weight range. Then

$$\begin{aligned} w2b &= f * \text{bulk } CH_3/1000TC \\ \text{bulk } SCB/1000TC &= \text{bulk } CH_3/1000TC - \text{bulk } CH_{3end}/1000TC \end{aligned}$$

and bulk $SCB/1000TC$ is converted to bulk $w2$ in the same manner as described above.

The LS detector is the 18-angle Wyatt Technology High Temperature DAWN HELEOSII. The LS molecular weight (M) at each point in the chromatogram is determined by

analyzing the LS output using the Zimm model for static light scattering (*Light Scattering from Polymer Solutions*; Huglin, M. B., Ed.; Academic Press, 1972.):

$$\frac{K_o c}{\Delta R(\theta)} = \frac{1}{MP(\theta)} + 2A_2 c.$$

Here, $\Delta R(\theta)$ is the measured excess Rayleigh scattering intensity at scattering angle θ , c is the polymer concentration determined from the IR5 analysis, A_2 is the second virial coefficient, $P(\theta)$ is the form factor for a monodisperse random coil, and K_o is the optical constant for the system:

$$K_o = \frac{4\pi^2 n^2 (dn/dc)^2}{\lambda^4 N_A}$$

where N_A is Avogadro's number, and (dn/dc) is the refractive index increment for the system.

The refractive index, $n=1.500$ for TCB at 145°C and $\lambda=665$ nm. For analyzing polyethylene homopolymers, ethylene-hexene copolymers, and ethylene-octene copolymers, $dn/dc=0.1048$ ml/mg and $A_2=0.0015$; for analyzing ethylene-butene copolymers, $dn/dc=0.1048*(1-0.00126*w_2)$ ml/mg and $A_2=0.0015$ where w_2 is weight percent butene comonomer.

A high temperature Agilent (or Viscotek Corporation) viscometer, which has four capillaries arranged in a Wheatstone bridge configuration with two pressure transducers, is used to determine specific viscosity. One transducer measures the total pressure drop across the detector, and the other, positioned between the two sides of the bridge, measures a differential pressure. The specific viscosity, η_s , for the solution flowing through the viscometer is calculated from their outputs. The intrinsic viscosity, $[\eta]$, at each point in the chromatogram is calculated from the equation $[\eta] = \eta_s/c$, where c is concentration and is determined from the IR5 broadband channel output. The viscosity MW at each point is calculated as $M = K_{ps} M^{\alpha_{ps}+1} / [\eta]$, where α_{ps} is 0.67 and K_{ps} is 0.000175.

The branching index (g'_{vis}) is calculated using the output of the GPC-IR5-LS-VIS method as follows. The average intrinsic viscosity, $[\eta]_{avg}$, of the sample is calculated by:

$$[\eta]_{avg} = \frac{\sum c_i [\eta]_i}{\sum c_i}$$

where the summations are over the chromatographic slices, i , between the integration limits.

The branching index g'_{vis} is defined as $g'_{vis} = \frac{[\eta]_{avg}}{KM_v^\alpha}$, where M_v is the viscosity-average molecular weight based on molecular weights determined by LS analysis and the K and α are for the reference linear polymer, which are, for purposes of the present invention, $\alpha=0.695$ and $K=0.000579$ for linear ethylene polymers, $\alpha=0.705$ and $K=0.0002288$ for linear propylene polymers, $\alpha=0.695$ and $K=0.000181$ for linear butene polymers, α is 0.695 and K is $0.000579*(1-0.0087*w2b+0.000018*(w2b)^2)$ for ethylene-butene copolymer where $w2b$ is a bulk weight percent of butene comonomer, α is 0.695 and K is $0.000579*(1-0.0075*w2b)$ for ethylene-hexene copolymer where $w2b$ is a bulk weight percent of hexene comonomer, and α is 0.695 and K is $0.000579*(1-0.0077*w2b)$ for ethylene-octene copolymer where $w2b$ is a bulk weight percent of octene comonomer. Concentrations are expressed in g/cm^3 , molecular weight is expressed in $g/mole$, and intrinsic viscosity (hence K in the Mark-Houwink equation) is expressed in dL/g unless otherwise noted. Calculation of the $w2b$ values is as discussed above.

The reversed-co-monomer index (RCI,m) is computed from $x2$ (mol% co-monomer C_3, C_4, C_6, C_8 , etc.), as a function of molecular weight, where $x2$ is obtained from the following expression in which n is the number of carbon atoms in the comonomer (3 for C_3 , 4 for C_4 , 6 for C_6 , etc.):

$$x2 = -\frac{200 w2}{-100 n - 2 w2 + n w2}.$$

Then the molecular-weight distribution, $W(z)$ where $z = \log_{10} M$, is modified to $W'(z)$ by setting to 0 the points in W that are less than 5 % of the maximum of W ; this is to effectively remove points for which the S/N in the composition signal is low. Also, points of W' for molecular weights below 2000 $gm/mole$ are set to 0. Then W' is renormalized so that

$$1 = \int_{-\infty}^{\infty} W' dz$$

and a modified weight-average molecular weight (M_w') is calculated over the effectively reduced range of molecular weights as follows:

$$M_w' = \int_{-\infty}^{\infty} 10^z * W' dz.$$

The RCI,m is then computed as

$$RCI,m = \int_{-\infty}^{\infty} x2 (10^z - M_w') W' dz.$$

A reversed-co-monomer index (RCI,w) is also defined on the basis of the weight fraction co-monomer signal ($w2/100$) and is computed as follows:

$$R_{Cl,w} = \int_{-\infty}^{\infty} \frac{w_2}{100} (10^z - M_w') W' dz.$$

Note that in the above definite integrals the limits of integration are the widest possible for the sake of generality; however, in reality the function is only integrated over a finite range for which data is acquired, considering the function in the rest of the non-acquired range to be 0. Also, by the manner in which W' is obtained, it is possible that W' is a discontinuous function, and the above integrations need to be done piecewise.

Three co-monomer distribution ratios are also defined on the basis of the % weight (w_2) comonomer signal, denoted as CDR-1,w, CDR-2,w, and CDR-3,w, as follows:

$$\begin{aligned} \text{CDR-1,w} &= \frac{w_2(M_z)}{w_2(M_w)} \\ \text{CDR-2,w} &= \frac{w_2(M_z)}{w_2\left(\frac{M_w + M_n}{2}\right)} \\ \text{CDR-3,w} &= \frac{w_2\left(\frac{M_z + M_w}{2}\right)}{w_2\left(\frac{M_w + M_n}{2}\right)} \end{aligned}$$

where $w_2(M_w)$ is the % weight co-monomer signal corresponding to a molecular weight of M_w , $w_2(M_z)$ is the % weight co-monomer signal corresponding to a molecular weight of M_z , $w_2[(M_w+M_n)/2]$ is the % weight co-monomer signal corresponding to a molecular weight of $(M_w+M_n)/2$, and $w_2[(M_z+M_w)/2]$ is the % weight co-monomer signal corresponding to a molecular weight of $M_z+M_w/2$, where M_w is the weight-average molecular weight, M_n is the number-average molecular weight, and M_z is the z-average molecular weight.

Accordingly, the co-monomer distribution ratios can be also defined utilizing the % mole co-monomer signal, CDR-1,m, CDR-2,m, CDR-3,m, as

$$\begin{aligned} \text{CDR-1,m} &= \frac{x_2(M_z)}{x_2(M_w)} \\ \text{CDR-2,m} &= \frac{x_2(M_z)}{x_2\left(\frac{M_w + M_n}{2}\right)} \\ \text{CDR-3,m} &= \frac{x_2\left(\frac{M_z + M_w}{2}\right)}{x_2\left(\frac{M_w + M_n}{2}\right)} \end{aligned}$$

where $x_2(M_w)$ is the % mole co-monomer signal corresponding to a molecular weight of M_w , $x_2(M_z)$ is the % mole co-monomer signal corresponding to a molecular weight of M_z ,

$x_2[(M_w+M_n)/2]$ is the % mole co-monomer signal corresponding to a molecular weight of $(M_w+M_n)/2$, and $x_2[(M_z+M_w)/2]$ is the % mole co-monomer signal corresponding to a molecular weight of $M_z+M_w/2$, where M_w is the weight-average molecular weight, M_n is the number-average molecular weight, and M_z is the z-average molecular weight.

5 All molecular weights are weight average (M_w) unless otherwise noted. All molecular weights are reported in g/mol unless otherwise noted.

Melt index (MI) also referred to as I2, reported in g/10 min, is determined according to ASTM D1238, 190°C, 2.16 kg load.

10 High load melt index (HLMI) also referred to as I21, reported in g/10 min, is determined according to ASTM D1238, 190°C, 21.6 kg load.

Melt index ratio (MIR) is MI divided by HLMI as determined by ASTM D1238.

Experimental

All reactions were performed in an inert N₂ purged glove box unless otherwise stated. All anhydrous solvents were purchased from Fisher Chemical and were degassed and dried
15 over molecular sieves prior to use. Deuterated solvents were purchased from Cambridge Isotope Laboratories and dried over molecular sieves prior to use. n-Butyl lithium (2.5 M solution in hexane), dimethylsilyl dichloride (Me₂SiCl₂) and methylmagnesium bromide (3.0 M solution in diethyl ether) were purchased from Sigma-Aldrich. Hafnium tetrachloride (HfCl₄) 99+% and (trimethylsilyl)methyl trifluoromethanesulfonate were procured from Strem
20 Chemicals and TCI America, respectively, and used as received. Potassium cyclopentadienide (KCp) was prepared according to literature methods. n-Butyl lithium (2.5 M solution in hexane), iodomethane, indene and methyl lithium (1.6 M solution in diethyl ether) were purchased from Sigma-Aldrich, and pentamethylcyclopentadienylzirconium trichloride (Cp*ZrCl₃) was purchased from Strem Chemicals and used as received. 1-Methylindene and
25 lithium-1-methylindene were prepared according to literature methods. The ¹H NMR measurements were recorded on a 400 MHz Bruker spectrometer.

Synthesis of (Trimethylsilyl) methylocyclopentadiene, (Me₃Si)CH₂CpH. A neat (trimethylsilyl)methyl trifluoromethanesulfonate (10.57g, 44.7 mmol) was dissolved in 150 mL of diethyl ether and cooled to -25°C, to this a solid potassium cyclopentadienide (4.66g,
30 44.7 mmol) was slowly added over a period of 5-10 minutes. The resulting mixture was stirred 5 hours at room temperature. Volatiles from the reaction mixture were carefully removed under dynamic vacuum to avoid evaporating the volatile (trimethylsilyl)methylocyclopentadiene, (Me₃Si)CH₂CpH. The reaction flask (250 mL round bottom flask) and frit with celite were weighted to calculate yield of the product after extraction. The crude materials were extracted

into pentane (3 x 10 mL) and used without any further purification. Based on above mathematical method, the yield is calculated as 5.55 g (81.6%). The ^1H NMR spectrum was recorded for the crude material to ensure the product formation. ^1H NMR (400 MHz, C_6D_6): δ -0.05 (9H, s, Si- CH_3), 1.77 (2H, d, $J_{\text{HH}}=1.2$ Hz, $\text{Me}_3\text{Si-CH}_2$), 2.83 (1H, sex, $J_{\text{HH}}=1.5$ Hz, Cp-CH), 5.80-6.49 (4H, m, Cp-CH) ppm.

Synthesis of Lithium (trimethylsilyl) methylcyclopentadienide, $(\text{Me}_3\text{Si})\text{CH}_2\text{CpLi}$.

A hexane solution of n-butyl lithium (14.6 mL, 36.5 mmol) was added drop-wise to a precooled solution (pentane and diethyl ether, 50/50 mL) of $(\text{Me}_3\text{Si})\text{CH}_2\text{CpH}$ (5.55 g, 36.5 mmol) over a period of 15-20 minutes at -25°C . The resulting mixture was gradually brought to room temperature and then continuously stirred overnight. Volatiles were removed in vacuo and remaining crude materials were thoroughly washed with pentane. The final materials were dried under vacuum to obtain a colorless crystalline solid of $(\text{Me}_3\text{Si})\text{CH}_2\text{CpLi}$ in 5.75 g (99.7%) yield. ^1H NMR (400 MHz, $\text{THF-}d_8$): δ -0.09 (9H, s, Si- CH_3), 1.84 (2H, s, $\text{Me}_3\text{Si-CH}_2$), 5.36 (2H, t, $J_{\text{HH}}=2.6$ Hz, Cp-H), 5.47 (2H, t, $J_{\text{HH}}=2.6$ Hz, Cp-H) ppm.

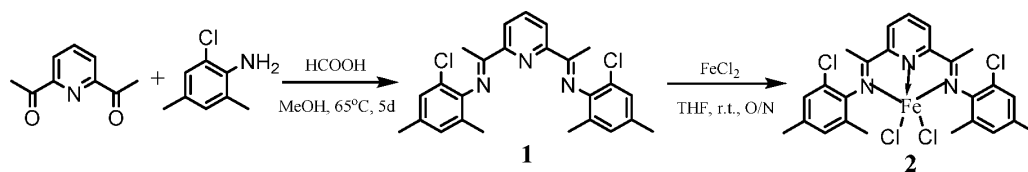
Synthesis of Dimethylsilyl-bis((trimethylsilyl) methylcyclopentadiene), $\text{Me}_2\text{Si}((\text{Me}_3\text{Si})\text{CH}_2\text{CpH})_2$. A neat Me_2SiCl_2 (340 mg, 2.6 mmol) was dissolved in 10 mL of THF and cooled to -25°C . A solid lithium (trimethylsilyl) methylcyclopentadienide was added to the above mixture and the resulting mixture was stirred overnight at room temperature to ensure completion of the reaction. Volatiles from the reaction mixture were removed in vacuo and subsequently triturated with pentane to remove trace of THF. The crude materials were extracted into pentane and followed by solvent removal under vacuum afforded a thick yellow viscous oil of $\text{Me}_2\text{Si}((\text{Me}_3\text{Si})\text{CH}_2\text{CpH})_2$ in 750 mg (80%) yield. ^1H NMR (400 MHz, C_6D_6): δ -0.15 (6H, bs, $\text{SiMe}_2\text{-CH}_3$), 0.05 (18H, s, $\text{SiMe}_3\text{-CH}_3$), 1.81-1.87 (4H, m, $\text{Me}_3\text{Si-CH}_2$), 3.26 (1H, s, Cp-H), 3.37 (1H, s, Cp-H), 5.99-6.82 (6H, m, Cp-H) ppm.

Synthesis of Lithium dimethylsilyl-bis((trimethylsilyl) methylcyclopentadienide) dimethoxyethane complex, $\text{Me}_2\text{Si}((\text{Me}_3\text{Si})\text{CH}_2\text{Cp})_2\text{Li}_2\cdot\text{dme}$. A hexane solution of n-butyl lithium (1.7 mL, 4.2 mmol, 2.5 M solution) was added drop-wise to a precooled solution of $\text{Me}_2\text{Si}((\text{Me}_3\text{Si})\text{CH}_2\text{CpH})_2$ (750 mg, 2.1 mmol) in 10 mL of dimethoxyethane over a period of 5-10 minutes at -25°C . The resulting mixture was gradually warmed to room temperature and then continuously stirred overnight. Volatiles from the reaction mixture were removed in vacuo, and triturated with pentane to remove DME. The crude materials were thoroughly washed with pentane to remove any soluble impurities, and dried under vacuum to give the colorless crystalline solid of $\text{Me}_2\text{Si}((\text{Me}_3\text{Si})\text{CH}_2\text{Cp})_2\text{Li}_2\cdot\text{dme}$ in 830 mg (93%) yield. ^1H NMR

(400 MHz, THF- d_8): δ 0.2 (18H, s, SiMe₃-CH₃), 0.93 (6H, bs, SiMe₂-CH₃), 2.26 (4H, s, Me₃Si-CH₂), 2.57 (4H, s, dme-CH₂), 2.77 (6H, s, dme-OCH₃), 5.94-6.15 (6H, m, Cp-H) ppm.

- Synthesis of *Rac-meso*-dimethylsilyl-bis((trimethylsilyl)methylcyclopentadienide)hafnium dichloride, Me₂Si((Me₃Si)CH₂Cp)₂HfCl₂.** A solid
- 5 HfCl₄ (570 mg, 1.8 mmol) was added to a precooled diethyl ether (20 mL) solution of Me₂Si((Me₃Si)CH₂Cp)₂Li₂·dme (830 mg, 1.8 mmol) at -25°C. The resulting mixture was stirred overnight at room temperature. Volatiles from the reaction mixture were removed in vacuo, and then extracted into dichloromethane. Solvent removal under vacuum gave a yellow crystalline solid of Me₂Si((Me₃Si)CH₂Cp)₂HfCl₂ in 1.02 g (94%) yield. The ¹H NMR
- 10 spectrum of final material integrated a ~1:1 ratio of *rac/meso* isomers. ¹H NMR (400 MHz, CD₂Cl₂): δ -0.05 (18H, s, SiMe₃-CH₃), -0.04 (18H, s, SiMe₃-CH₃), -0.64 (3H, s, SiMe₂-CH₃, *meso*), -0.65 (6H, s, SiMe₂-CH₃, *rac*), -0.68 (3H, s, SiMe₂-CH₃, *meso*), 2.08-2.18 (8H, m, Me₃Si-CH₂), 5.14 (2H, t, *J*_{HH}=2.6 Hz, Cp-H), 5.28 (2H, t, *J*_{HH}=2.6 Hz, Cp-H), 5.64 (2H, t, *J*_{HH}=2.7 Hz, Cp-H), 5.77 (2H, t, *J*_{HH}=2.7 Hz, Cp-H), 6.19 (2H, t, *J*_{HH}=2.7 Hz, Cp-H), 6.34 (2H,
- 15 t, *J*_{HH}=2.7 Hz, Cp-H) ppm.

- Synthesis of *Rac-meso*-dimethylsilyl-bis((trimethylsilyl)methylcyclopentadienide)hafnium dimethyl, Me₂Si((Me₃Si)CH₂Cp)₂HfMe₂.** An ethereal
- 20 solution of MeMgBr (1.12 mL, 3.34 mmol) was added drop wise to a precooled diethyl ether solution of Me₂Si((Me₃Si)CH₂Cp)₂HfCl₂ (1.01 g, 1.65 mmol) over a period of 3-5 minutes at -25°C. The resulting mixture was stirred overnight at room temperature to ensure completion of the reaction. Insoluble materials were filtered through a pad of celite. Volatiles from the filtrate were removed under vacuum, and then the crude materials were extracted into pentane. Solvent removal in vacuo afforded a sticky yellow material of Me₂Si((Me₃Si)CH₂Cp)₂HfMe₂ in 660 g (71%) yield. The ¹H NMR spectrum of final material integrated a ~1:1 ratio of
- 25 *rac/meso* isomers. ¹H NMR (400 MHz, C₆D₆): δ -0.25 (3H, s, Hf-CH₃, *meso*), δ -0.24 (6H, s, Hf-CH₃, *rac*), δ -0.20 (3H, s, Hf-CH₃, *meso*), 0.03 (18H, s, SiMe₃-CH₃), 0.04 (18H, s, SiMe₃-CH₃), 0.19 (3H, s, SiMe₂-CH₃, *meso*), 0.20 (6H, s, SiMe₂-CH₃, *rac*), 0.22 (3H, s, SiMe₂-CH₃, *meso*), 2.06 (4H, s, Me₃Si-CH₂, *rac*), 2.09 (4H, d, *J*_{HH}=3.1 Hz, Me₃Si-CH₂, *meso*), 5.03 (2H, t, *J*_{HH}=2.2 Hz, Cp-H), 5.10 (2H, t, *J*_{HH}=2.2 Hz, Cp-H), 5.34 (2H, t, *J*_{HH}=2.6 Hz, Cp-H), 5.44 (2H,
- 30 t, *J*_{HH}=2.6 Hz, Cp-H), 6.26 (2H, t, *J*_{HH}=2.6 Hz, Cp-H), 6.31 (2H, t, *J*_{HH}=2.6 Hz, Cp-H) ppm.



(1E,1'E)-1,1'-(pyridine-2,6-diyl)bis(N-(2-chloro-4,6-dimethylphenyl)ethan-1-imine) (1). In the drybox, 2-Chloro-4,6-dimethylaniline (8.66mL, 9.52g, 61.2mmol) was added to a stirring solution of 2,6-Diacetylpyridine (5.00g, 30.6mmol) in methanol (75mL) then formic acid (3 drops) was added. Temperature was increased to 60°C and the mixture was stirred for 5 days at 60°C. The light yellow precipitate was collected via vacuum filtration and rinsed with cold methanol. Residual solvent was removed under vacuum. Yield: 4.43g, 10.10mmol, 33.02%.

Synthesis of 2,6-Bis-[1-(2-chloro,4,6-dimethylphenylimino)ethyl]pyridine. A Solid 2,6-diacetylpyridine (5.0 g, 31 mmol) was dissolved in methanol (100 mL) and to this a solid 2-chloro, 4,6-dimethyl aniline (9.537 g, 62 mmol) and formic acid (0.5 mL) were added. The resulting mixture was stirred at room temperature for 48 hours, and colorless solid precipitated out during the course of reaction. Colorless crystalline solids were filtered out and washed with cold methanol. The ¹H NMR spectrum of the crude material showed a 1:1 ratio of 2,6-Bis-[1-(2-chloro,4,6-dimethylphenylimino)ethyl]pyridine and starting material 2-chloro, 4,6-dimethyl aniline. 2,6-Bis-[1-(2-chloro,4,6-dimethylphenylimino)ethyl]pyridine was purified by column chromatography with a mixture of hexane/ethyl acetate (8:2 ratio) as eluent and solvent removal resulted in colorless crystalline solid (2.5 g) (18.6 %) yield. ¹H NMR (400 MHz, CD₂Cl₂): δ 2.06 (6H, s, CH₃), 2.29 (6H, s, CH₃), 2.31 (6H, s, CH₃), 6.99 (2H, s, Ar-CH), 7.11 (2H, s, Ar-CH), 7.95 (1H, t, Ar-CH), 8.47 (2H, d, Ar-CH) ppm.

Synthesis of 2,6-Bis-[1-(2-chloro,4,6-dimethylphenylimino)ethyl]pyridine iron dichloride. 2,6-Bis-[1-(2-chloro,4,6-dimethylphenylimino)ethyl]pyridine was dissolved in THF (40 mL) and cooled to -25°C, to this a solid pre-dried iron chloride was added. The resulting mixture was stirred overnight at room temperature. The resulting mixture color turned to blue from brown during the course of reaction, and the expected iron complex precipitated as blue solid. The blue iron compound was filtered and washed with hexane. The crude materials were further re-dissolved in dichloromethane to remove any insoluble iron containing impurities and ionic compounds formed during the course of reaction, which could not be identified by ¹H NMR measurements because of their faster relaxation rate (paramagnetic nature) on NMR timescale. Solvent removal under reduced pressure resulted in blue crystalline solid of 2,6-Bis-[1-(2-chloro,4,6-dimethylphenylimino)ethyl]pyridine iron dichloride (1.89 g)

(81.9 %) yield. ^1H NMR (400 MHz, CD_2Cl_2): δ -23.2, -21.0, 3.7, 9.1, 12.2, 15.3, 18.4, 19.3, 22.0, 22.2, 32.9, 33.9, 81.9, 84.2 (bs) ppm.

Supported Catalyst Syntheses

SMAO is methylalumoxane supported on silica ES-70 (PQ Corporation, Conshohocken, Pennsylvania) that has been calcined at 875°C and was prepared as follows:

In a 4L stirred vessel in the drybox methylaluminoxane (MAO) (30 wt% in toluene) is added along with 2400 g of toluene. This solution is then stirred at 60 RPM for 5 minutes. ES-70 silica that has been calcined at 875°C was then added to the vessel. This slurry is heated at 100°C and stirred at 120 RPM for 3 hours. The temperature was then lowered and the mixture was allowed to cool to ambient temperature over 2 hours. The stirrer was then set to 8 RPM and placed under vacuum for 72 hours. After emptying the vessel and sieving the supported MAO, 1014g was obtained.

Supported Catalysts

Catalyst (1): *Rac-meso*- dimethylsilyl-bis((trimethylsilyl) methylcyclopentadienide)hafnium dimethyl, $\text{Me}_2\text{Si}((\text{Me}_3\text{Si})\text{CH}_2\text{Cp})_2\text{HfMe}_2$

Supported Catalyst 1

A 1.0g amount of prepared SMAO was stirred in 10 mL of toluene using a Celstir™ flask. *r/m*-dimethylsilyl bis(trimethylsilylmethylene-cyclopentadienide) hafnium dimethyl (22.7 mg, 40 μmol) was added to the slurry and stirred for three hours. The mixture was filtered, washed with several 10 mL portions of hexane and then dried under vacuum, yielding 0.87 g of white silica.

Catalyst (2): (1E,1'E)-1,1'-(pyridine-2,6-diyl)bis(N-(2-chloro-4,6-dimethylphenyl)ethan-1-imine)- FeCl_2

Supported Catalyst 1:2

A 1.0 g amount of prepared SMAO was stirred in 10 mL of toluene using a Celstir™ flask. Dimethylsilyl bis(trimethylsilylmethylene-cyclopentadienide)hafnium dimethyl (18.1 mg, 0.032 mmol) and 2,6-Bis[1-(2-chloro-4,6-dimethylphenylimino)ethyl]pyridine iron(II) dichloride (4.5 mg, 0.008 mmol) were added to the slurry and stirred for three hours. The mixture was filtered, washed with several 10 mL portions of hexane and then dried under vacuum, yielding 0.90 g of light yellow silica.

Polymerization with Supported Catalyst Systems

A 2 L autoclave was heated to 110°C and purged with N_2 for at least 30 minutes. It was then charged with dry NaCl (350 g; Fisher, S271-10 dehydrated at 180°C and subjected to several pump/purge cycles and finally passed through a 16 mesh screen prior to use) and

SMAO- (5 g) at 105°C and stirred for 30 minutes. The temperature was adjusted to 85°C. At a pressure of 2 psig N₂, dry, degassed 1-hexene (2.0 mL) was added to the reactor with a syringe then the reactor was charged with N₂ to a pressure of 20 psig. A mixture of H₂ and N₂ was flowed into reactor (200 square centimeter per minute flow rate; 10% H₂ in N₂) while stirring the bed.

Thereafter, the catalysts indicated in Table 1 were injected into the reactor with ethylene at a pressure of 220 psig; ethylene flow was allowed over the course of the run to maintain constant pressure in the reactor. 1-hexene was fed into the reactor as a ratio to ethylene flow (0.1 g/g). Hydrogen was fed to the reactor as a ratio to ethylene flow (0.5 mg/g). The hydrogen and ethylene ratios were measured by on-line GC analysis. Polymerizations were halted after 1 hour by venting the reactor, cooling to room temperature then exposing to air. The salt was removed by washing with water two times; the polymer was isolated by filtration, briefly washed with acetone and dried in air for at least two days. Results are shown in Table 1. The data illustrate that the mixed catalyst system of Catalyst 1:Catalyst 2 provides a bimodal polyethylene composition as illustrated by the TREF curve and Mw/Mn value of 4.92. In addition, the polyethylene composition has high linearity as indicated by g'(vis) of 0.982. Furthermore, hexene incorporation is greater than 10 wt% and productivity is greater than 7,000 gP/gsup.Cat.

Table 1: Slurry Phase Polymerization of Ethylene and 1-Hexene

Example	Supported Catalyst	MI dg/min	MIR	Mw g/mol	Mn g/mol	Mw/Mn	Hexene wt%	Activity gP/gsup. Cat.	g'(vis)
1	Catalyst 1: Catalyst 2	1.49	107	69710	13864	5.03	10.82	7652	0.982
2	Catalyst 1	2.5	25	82706	18689	4.43	10.1	11211	1

Table 2: Gas Phase Polymerization of Ethylene and 1-Hexene

Example	Supported Catalyst	MI dg/min	MIR	RCI,m (kg/mol)	CDR2,m	T ₇₅ -T ₂₅ (°C)
1	Catalyst 1: Catalyst 2	1.49	107	64.1	1.02	50.4
2	Catalyst 1	2.5	25	-7.1	0.92	63.7

Table 3. Level of Unsaturation (Internal (I) and Terminal (T)) for Polyethylenes

	Catalyst 1:2	Catalyst 2
Unsaturation per 1000C		
Vy1 and Vy2 (I)	0.14	0.13
Vy5 (T)	0.08	0.07
Tri-substituted olefins (I)	0.08	0.06
Vinyls (T)	0.66	0.02
Vinylidenes (T)	0.06	0.02
total internal unsaturations	0.22	0.19
Total unsaturations	0.94	0.3
% vinyl of total unsaturations	70.2	6.7
% internal of total unsaturations	23	63
Ratio of vinyls/internals	3	0.067

Catalyst systems of the present disclosure can provide increased activity or enhanced polymer properties, to increase conversion or comonomer incorporation, or to alter comonomer distribution. Catalyst systems and processes of the present disclosure can provide ethylene polymers having the unique properties of high stiffness, high toughness and good processability.

All documents described herein are incorporated by reference herein, including any priority documents and/or testing procedures to the extent they are not inconsistent with this text. As is apparent from the foregoing general description and the specific embodiments, while embodiments of the present invention have been illustrated and described, various modifications can be made without departing from the spirit and scope of the present invention. Accordingly, it is not intended that the present invention be limited thereby. Likewise, the term “comprising” is considered synonymous with the term “including.” Likewise whenever a composition, an element or a group of elements is preceded with the transitional phrase “comprising,” it is understood that we also contemplate the same composition or group of elements with transitional phrases “consisting essentially of,” “consisting of,” “selected from the group of consisting of,” or “I” preceding the recitation of the composition, element, or elements and vice versa, e.g., the terms “comprising,” “consisting essentially of,” “consisting of” also include the product of the combinations of elements listed after the term.