

Title: POLYMACROMONOMER AND PROCESS FOR PRODUCTION THEREOF

Inventors Patrick Brant, Andrew Narvaez, Donna Crowther

Priority Claim

[0001] This application is a continuation in part of USSN 12/143,663 filed June 20, 2008, which is incorporated by reference herein.

Field of the Invention

This invention relates to polymacromonomers having lower amounts of C₂ to C₁₈ olefin monomers and processes to produce such polymacromonomers.

Background of the Invention

Polyolefins are of great interest in industry as they have many uses in many different areas. For example, polyolefins, such as polyethylene and polypropylene, are often used in everything from waxes and plasticizers to films and structural components. Of late many have been interested in modifying the architecture of such polyolefins in the hopes of obtaining new and better combinations of properties. One method of controlling polyolefin architecture is to select monomers that will impart specific characteristics or tailoring the monomers used. For example, several have tried to produce large "monomers" called "macromonomers" or "macromers" having amounts of vinyl, vinylidene or vinylene termination that can be polymerized with smaller olefins such as ethylene or propylene to impart long chain branching, structural properties, etc. to a polyolefin. Typically, vinyl macromonomers are found more useful or easier to use than vinylene or vinylidene macromonomers. Examples of methods to produce various vinyl terminated macromonomers are disclosed in US 6,117,962; US 6,555,635; Small, Brookhart, Bennett, J Am Chem Soc 120, 1998, 4049; and Britovsek, et al. Chem. Comm. 1998, 849; Su, et al. Organomet. 25, 2006, 666. See also B.L. Small and M. Brookhart, "Polymerization of Propylene by a New Generation of Iron Catalysts: Mechanisms of Chain Initiation, Propagation, and Termination" Macromol. 32 1999, 2322; "Metallocene-Based Branch-Block Thermoplastic Elastomers", E.J. Markel, W. Weng, A.J. Peacock, and A.H. Dekmezian, Macromol. 33 2000, 8541-8548; and A.E. Cherian, E.B. Lobkovski, and G.W. Coates, Macromol 38 2005, 6259-6268.

Others have tried processes that produce a macromonomer then polymerize it with another smaller olefin, such as ethylene or propylene. Examples include US 6,573,350, US 2004-0138392 A1, US 2004-0127614 A1, US 7,223,822, and Lutz et al, Polymer 47, 2006, 1063-1072. Similar examples of macromonomer re-insertion type polymerizations include US 6,225,432 and T. Shiono, et al. Macromolecules 32, 1999, 3723. Typically these polymerizations result in a rather low amount of the macromonomer being inserted into the growing polymer chain. For example, Shiono et al. report incorporating up to 3.8 mol% of atactic polypropylene macromonomer (Mn 630) in isotactic polypropylene having Mn of approximately 213,000.

Others have suggested in-situ variations where the macromonomer is produced in the same reactor that the polymerization occurs in, such that the macromonomer is consumed as it is produced. Examples include US 7,294,681, US 2004-0127614, and US 7,223,822, as well as tandem polymerization catalysts such as discussed by Bazan and coworkers (Chemical Rev 2005, 105, 1001-

1020 and references therein). In many cases, long chain branched polyolefins can be produced in-situ under conditions that favor macromonomer production and its consumption in subsequently growing chains (See Chemical Rev 2005, 105, 1001-1020 and references therein).

In other areas, low molecular weight polymers and oligomers of larger monomers (typically referred to as polyalphaolefins), such as octene, decene and dodecene, have been made for uses in lubricants and additives. For examples please see WO 2007/011459 A1 and US 6,706,828. Others have made various polyalphaolefins, such as polydecene, using various metallocene catalysts not typically known to produce polymers or oligomers with any specific tacticity. Examples include WO 96/2375 1, EP 0 613 873, US 5,688,887, US 6,043,401, US 2003/0055184, US 6,548,724, US 5,087,788, US 6,414,090, US 6,414,091, US 4,704,491, US 6,133, 209, and US 6,713,438. Many of these polyalphaolefin molecules have terminal unsaturation that is typically hydrogenated or functionalized prior to use as a lubricant or fuel additive.

Others (VanderHart, et al. *Macromol. Chem. Phys.* 2004, 205, 1877-1885) have made poly(1-octadecene) using titanium tetrachloride supported on magnesium dichloride activated by triethylaluminum. Specifically, VanderHart et al. homopolymerize C₁₈H₃₆ (Mw = 252.3; MWD 1.0) to obtain product having a broad composition distribution.

Others have focused on making comb polymers through anionic polymerization. The comb polymers can be made into model comb polyolefins through hydrogenation. See Hadjichristidis, Lohse et al (see *Anionic homo- and copolymerization of styrenic triple-tailed polybutadiene macromonomers* Nikopoulou A, Iatrou H, Lohse DJ, Hadjichristidis N *Journal of Polymer Science Part A-Polymer Chemistry* 45 (16): 3513-3523 AUG 15 2007; and "*Linear Rheology of Comb Polymers with Star-like Backbones: Melts and Solutions*", *Rheologica Acta*, 2006, vol. 46, no. 2, pp.273-286.)

Likewise, J.F. Lahitte, et al. *Homopolymerization of Allyl or Undecenyl Polystyrene Macromonomers via Coordination Polymerization Catalyst System*, Polym. Preprint, ACS, Div. Polym. Chem. 2003 44(2) 46-47, disclose polystyryl macromonomers that produce glassy products.

Others (Lahitte, et al. *Macromol Rap Comm.* 25, 2004, 1010-1014) have made polymers of vinyl terminated polystyrene-containing macromonomers using cyclopentadienyl titanium trifluoride in combination with methylalumoxane in toluene at 50°C. See also Lutz, et al. *Polymer*, 47, 2006, 1063-1072 where macromonomers of ω -allyl polystyrene, ω -undecenyl polystyrene or α,ω -undecenyl polystyrene were polymerized with ethylene using a coordination catalyst. The macromonomers were incorporated into the olefin chains at levels of about 2.1 to 15.6wt%.

Additional references of interest include: Chen, et al. *JPS, Part B Polym. Phys.* 38, 2965-2975 (2000); Schulze, et al. *Macromolecules*, 2003, 36, 4719-4726; Ciolino, et al. *Journal of Polymer Science: Part A: Polymer Chemistry*, Vol. 42, 2462-2473 (2001); Djalali, et al. *Macromol. Rapid. Commun.* 20, 444-449 (1999); US 6,197,910; WO 93/21242; and WO 93/12151.

Summary of the Invention

This invention relates to a polymacromonomer comprising (alternately consisting essentially of, alternately consisting of) at least one macromonomer and from 0 to 20wt% of a C₂ to C₁₈ comonomer,

wherein the hydrocarbon macromonomer has:

- 1) from 20 to 600 carbon atoms, (as determined from GPC-DRI Mn)
- 2) an Mn of 280 g/mol or more (as determined by ^1H NMR),
- 3) an Mw of 400 g/mol or more (as determined by GPC),
- 4) an Mz of 600 g/mol or more (as determined by GPC),
- 5) an Mw/Mn of 1.5 or more, (Mw determined by GPC, Mn determined by ^1H NMR)
- 6) at least 70% vinyl termination (relative to total unsaturation) (as determined by $^1\text{HNMR}$),
- 7) a melting point of 60°C or more (DSC, second melt), and
- 8) less than 5wt% aromatic containing monomer (based upon the weight of the macromonomer)

as determined by ^1H NMR; and

wherein the polymacromonomer has:

- a) a g value of less than 0.6 (as determined by GPC),
- b) an Mw of greater than 20,000 g/mol (as determined by GPC),
- c) an Mn of greater than 10,000 g/mol (as determined by $^1\text{HNMR}$),
- d) a branching index $(g')_{\text{vis}}$ of less than 0.5 (as determined by GPC), and
- e) a melting point of 50°C or more (DSC second melt),
- f) less than 20% vinyl termination (relative to total unsaturation) (as determined by $^1\text{HNMR}$),
- g) and where the polymacromonomer comprises at least 70wt% macromonomer, based upon the

weight of the polymacromonomer, and

h) less than 5wt% aromatic containing monomer (based upon the weight of the polymacromonomer) as determined by ^1H NMR.

In another embodiment, this invention relates to a polymacromonomer comprising (alternately consisting essentially of, alternately consisting of) at least one macromonomer and from 0 to 20wt% of a C_2 to C_{18} comonomer, wherein the polymacromonomer has:

- a) a g value of less than 0.6,
- b) an Mw of greater than 20,000 g/mol,
- c) an Mn of greater than 10,000 g/mol,
- d) a branching index $(g')_{\text{vis}}$ of less than 0.5,
- e) optionally, a melting point of 0°C or more,
- f) less than 20% vinyl termination (relative to total unsaturation),
- g) and where the polymacromonomer comprises at least 70wt% macromonomer, based upon the

weight of the polymacromonomer, and

h) less than 5wt% aromatic containing monomer (based upon the weight of the polymacromonomer) wherein the macromonomer comprises one or more of:

i) propylene co-oligomer having an Mn of 300 to 30,000 g/mol (as measured by ^1H NMR) comprising 10 to 90 mol% propylene and 10 to 90 mol% of ethylene, wherein the oligomer has at least X% allyl chain ends (relative to total unsaturations), where: 1) $X = (-0.94 (\text{mol}\% \text{ ethylene incorporated}) + 100)$, when 10 to 60 mol% ethylene is present in the co-oligomer, and 2) $X = 45$, when greater than 60

and less than 70 mol% ethylene is present in the co-oligomer, and 3) $X = (1.83 * (\text{mol\% ethylene incorporated}) - 83)$, when 70 to 90 mol% ethylene is present in the co-oligomer; and/or

ii) propylene oligomer, comprising more than 90 mol% propylene and less than 10 mol% ethylene, wherein the oligomer has: at least 93% allyl chain ends, an Mn of about 500 to about 20,000 g/mol (as measured by ^1H NMR), an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0, and less than 1400 ppm aluminum; and/or

iii) propylene oligomer, comprising at least 50 mol% propylene and from 10 to 50 mol% ethylene, wherein the oligomer has: at least 90% allyl chain ends, Mn of about 150 (preferably 250) to about 10,000 g/mol (as measured by ^1H NMR), and an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.3:1.0, wherein monomers having four or more carbon atoms are present at from 0 to 3 mol%; and/or

iv) propylene oligomer, comprising at least 50 mol% propylene, from 0.1 to 45 mol% ethylene, and from 0.1 to 5 mol% C₄ to C₁₂ olefin, wherein the oligomer has: at least 87% allyl chain ends (alternately at least 90%), an Mn of about 150 (preferably 250) to about 10,000 g/mol, (as measured by ^1H NMR), and an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0; and/or

v) propylene oligomer, comprising at least 50 mol% propylene, from 0.1 to 45wt% ethylene, and from 0.1 to 5 mol% diene, wherein the oligomer has: at least 90% allyl chain ends, an Mn of about 150 to about 10,000 g/mol (as measured by ^1H NMR), and an isobutyl chain end to allylic vinyl group ratio of 0.7:1 to 1.35:1.0; and/or

vi) a homooligomer, comprising propylene, wherein the oligomer has: at least 93% allyl chain ends, an Mn of about 500 to about 20,000 g/mol (as measured by ^1H NMR), an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.2:1.0, and less than 1400 ppm aluminum.

This invention further relates to a homogeneous process to make such oligomers i) to vi) and thereafter produce polymacromonomers, by contacting the oligomer and up to 40wt% C₂ to C₁₂ comonomer in the feedstream entering the reactor (preferably from 0 to 30wt%, preferably from 0 to 20wt%, preferably from 0 to 10wt%, preferably from 0 to 5wt%, preferably from 0 to 1wt% of C₂ to C₁₂ comonomer), with a catalyst system capable of polymerizing vinyl terminated macromonomer (preferably comprising activator and a compound represented by the formula I, II, III, or IV below). For more detailed information on oligomers i) to vi) and processes to make them, please see USSN 12/143,663, filed June 20, 2008, incorporated by reference herein.

This invention relates to a polymacromonomer comprising (alternately consisting essentially of, alternately consisting of) at least one macromonomer and from 0 to 20wt% of a C₂ to C₁₈ comonomer, wherein the hydrocarbon macromonomer has:

- 1) from 20 to 600 carbon atoms, (as determined by GPC-DRI Mn)
- 2) an Mn of 280 g/mol or more (as determined by ^1H NMR),
- 3) an Mw of 400 g/mol or more (as determined by GPC),
- 4) an Mz of 600 g/mol or more (as determined by GPC),
- 5) an Mw/Mn of 1.5 or more, (Mw determined by GPC, Mn determined by ^1H NMR)

6) at least 70% vinyl termination (relative to total unsaturation) (as determined by $^1\text{HNMR}$),
7) a heat of melting (Hm) of 20 J/g or less (preferably 15 J/g or less), and
8) less than 5wt% aromatic containing monomer (based upon the weight of the macromonomer)
as determined by $^1\text{H NMR}$; and

5 wherein the polymacromonomer has:

- a) a g value of less than 0.6 (as determined by GPC),
- b) an Mw of greater than 20,000 g/mol (as determined by GPC),
- c) an Mn of greater than 10,000 g/mol (as determined by $^1\text{HNMR}$),
- d) a branching index $(g')_{\text{vis}}$ of less than 0.5 (as determined by GPC),

10 e) an Hm of 20 J/g or less, preferably 15 J/g or less,

- f) less than 20% vinyl termination (relative to total unsaturation) (as determined by $^1\text{HNMR}$),

g) and where the polymacromonomer comprises at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and

15 h) less than 5wt% aromatic containing monomer (based upon the weight of the polymacromonomer).

This invention also relates to a process to produce polymacromonomer comprising contacting macromonomer and up to 40wt% C_2 to C_{18} comonomer in the feedstream entering the reactor (preferably from 0 to 30wt%, preferably from 0 to 20wt%, preferably from 0 to 10wt%, preferably from 0 to 5wt%, preferably from 0 to 1wt% of C_2 to C_{18} comonomer), with a catalyst system capable of polymerizing
20 vinyl terminated macromonomer, under polymerization conditions of a temperature of 60 to 130°C and a reaction time of 1 to 90 minutes, wherein the weight ratio of all comonomer present in the reactor to all macromonomer present in the reactor is 2:1 or less and where conversion of macromonomer to polymacromonomer is 70wt% or more (as determined by infrared spectroscopy (IR) on samples taken at the entrance and exit of the reactor, specifically one should perform an IR of the macromonomer as it
25 enters reactor and find resonance peak of the vinyl group, then measure the same peak on samples taken at the reactor exit and the volume should be 70% consumed).

This invention further relates to a process, preferably an in-line process, preferably a continuous process, to produce polymacromonomer, comprising introducing monomer and catalyst system into a reactor, obtaining a reactor effluent containing macromonomer, removing (such as flashing off) solvent,
30 unused monomer and other volatiles, obtaining macromonomer, introducing macromonomer and catalyst system into a reaction zone (such as a reactor (such as a batch, CSTR or tubular reactor), an extruder, a pipe and/or a pump) and obtaining polymacromonomer. Reaction zone and reactor may be used synonymously herein.

This invention also relates to a two stage process to obtain polymacromonomer comprising
35 contacting olefin monomer with a catalyst system, obtaining macromonomer and thereafter contacting the macromonomer with a catalyst system and thereafter obtaining polymacromonomer.

Brief Description of the Figures

Figure 1 is a chart of the range of chemical shift assignments for the polymacromonomer

prepared in Example 1.

Figure 2 is an illustration of ^{13}C NMR nomenclature of the resonances specific to homopolyethylene macromonomers inserted to make the polymacromonomer (e.g. no comonomer).

Figure 3 is an illustration of a naming convention described herein.

5 Figure 4 is a graph of R_g versus MW for Example 2 as determined by GPC-MALLS.

Figure 5 is an overlay of the ^1H NMR spectra for $\text{PE}_{\text{mac-1}}$ (bottom) showing the vinyl groups and the ^1H NMR spectra for Example 1 showing the lack of vinyl groups.

Definitions

A catalyst system is defined to comprise a catalyst compound plus an activator.

10 For the purposes of this invention and the claims thereto when a polymer is referred to as comprising an olefin, the olefin present in the polymer is the polymerized form of the olefin. Likewise when catalyst components 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. In addition, a reactor is any container(s) in which a chemical
15 reaction occurs.

As used herein, the new numbering scheme for the Periodic Table Groups is used as published in CHEMICAL AND ENGINEERING NEWS, 63(5), 27 (1985).

For purposes of this invention, the term "oligomer" is defined to have an M_n of from 100 to 1200 g/mol as measured by ^1H NMR. The term "polymer" is defined to have an M_n of more than 1200 g/mol
20 as measured by ^1H NMR. When an oligomer is referred to as comprising an olefin, the olefin present in the oligomer is the oligomerized form of the olefin. A co-oligomer is an oligomer comprising at least two different monomer units (such as propylene and ethylene). A homo-oligomer is an oligomer comprising units of the same monomer (such as propylene). A propylene oligomer/ polymer/
25 macromonomer/ polymacromonomer is an oligomer/ polymer/ macromonomer/ polymacromonomer having at least 50 mol% of propylene, respectively. As used herein, M_n is number average molecular weight (measured by ^1H NMR according to the procedure described in the Experimental section below), M_w is weight average molecular weight (measured by Gel Permeation Chromatography according to the
30 procedure described in the Experimental section below), and M_z is z average molecular weight (measured by Gel Permeation Chromatography according to the procedure described in the Experimental section below), wt% is weight percent, and mol% is mole percent. Molecular weight distribution (MWD) is defined to be M_w divided by M_n . Unless otherwise noted, all molecular weight units (e.g., M_w , M_n , M_z) are g/mol.

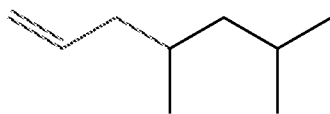
The term "vinyl termination", also referred to as allyl chain end(s)" or "vinyl content" is defined to be an oligomer or polymer having at least one terminus represented by formula I:



allylic vinyl end group

35 where the "...." represents the oligomer or polymer chain. In a preferred embodiment the allyl chain end

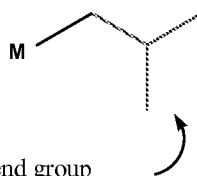
is represented by the formula II:



allylic vinyl end group

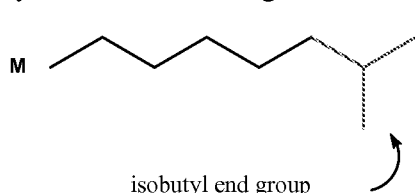
The amount of allyl chain ends (also called % vinyl termination) is determined using ^1H NMR at 120°C using deuterated tetrachloroethane as the solvent on a 500 MHz machine and in selected cases confirmed by ^{13}C NMR. Resconi has reported proton and carbon assignments (neat perdeuterated tetrachloroethane used for proton spectra while a 50:50 mixture of normal and perdeuterated tetrachloroethane was used for carbon spectra; all spectra were recorded at 100°C on a Bruker AM 300 spectrometer operating at 300 MHz for proton and 75.43 MHz for carbon) for vinyl terminated propylene oligomers in J American Chemical Soc 114 1992, 1025-1032 that are useful herein.

"Isobutyl chain end" is defined to be an oligomer having at least one terminus represented by the formula:

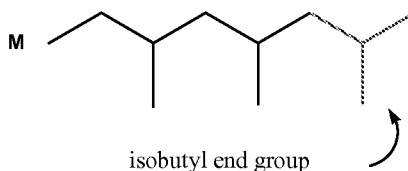


isobutyl end group

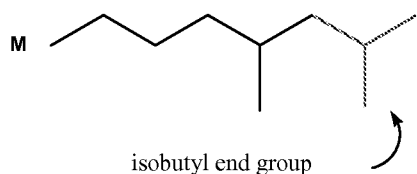
where M represents the oligomer chain. In a preferred embodiment, the isobutyl chain end is represented by one of the following formulae:



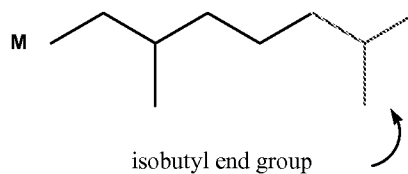
isobutyl end group



isobutyl end group



isobutyl end group



isobutyl end group

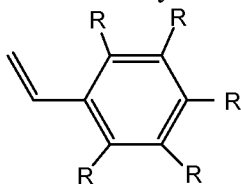
where M represents the oligomer chain.

The percentage of isobutyl end groups is determined using ^{13}C NMR (as described in the example section) and the chemical shift assignments in Resconi et al, J Am. Chem. Soc. 1992, 114, 1025-1032 for 100% propylene oligomers and set forth in Figure 2 for E-P oligomers.

The "isobutyl chain end to allylic vinyl group ratio" is defined to be the ratio of the percentage of isobutyl chain ends to the percentage of allylic vinyl groups.

An "aromatic containing monomer" is a C_4 to C_{36} hydrocarbyl group containing at least one aromatic group. Examples include styrene, alpha-methyl styrene, para-methyl-styrene, and 4-(dichloromethylsilyl)diphenylethylene. An aromatic group is defined to be a cyclic group having at least one pair of conjugated double bonds. Examples include cyclopentadiene, indene, fluorene, and benzene.

A "styrenic" monomer is a monomer comprising a styrene unit, such as:



wherein each R is, individually, hydrogen or a C₁ to C₁₂ hydrocarbyl group, or C₁ to C₁₂ substituted hydrocarbyl group, preferably substituted with a halogen (such as Br or Cl).

5 A reaction zone is any vessel where a reaction occurs, such as glass vial, a polymerization reactor, reactive extruder, tubular reactor and the like.

As used herein 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.

10 Detailed Description

In another embodiment, this invention relates to a polymacromonomer comprising at least one macromonomer and from 0.1 to 20wt% (preferably 0.5 to 15wt%, preferably 1 to 10wt%, preferably 1 to 5wt%, preferably from 0 to 5 mol%) of a C₂ to C₁₈ comonomer (preferably a C₂ to C₁₂ comonomer, preferably ethylene, propylene, butene, hexene, 4-methyl pentene-1, and 3-methyl pentene-1 and / or norbornene) wherein the macromonomer has:

1) from 20 to 800 carbon atoms (preferably from 20 to 700, preferably from 20 to 600, preferably from 20 to 500, preferably from 20 to 400, preferably from 20 to 300, preferably from 20 to 200, preferably from 30 to 175),

2) an Mn of 280 g/mol or more, (preferably from 280 to 15,000, preferably from 280 to 10,000, preferably from 280 to 12,000, preferably from 280 to 8,000, preferably 280 to 6,000, preferably 300 to 5,000, preferably 350 to 3,000, preferably 350 to 2,000),

3) an Mw of 400 g/mol or more (preferably from 400 to 50,000, preferably from 400 to 20,000, preferably from 450 to 15,000, preferably 450 to 10,000, preferably 450 to 5,000, preferably 450 to 3,000),

4) an Mz of 600 g/mol or more, (preferably from 600 to 35,000, preferably from 600 to 30,000, preferably from 600 to 25,000, preferably from 600 to 20,000, preferably from 600 to 15,000, preferably 600 to 10,000, preferably 600 to 5,000, preferably 750 to 3,000),

5) an Mw/Mn of 1.5 or more, (preferably 1.5 to 7, preferably from 1.5 to 6, preferably from 1.6 to 5, preferably from 1.8 to 4, preferably from 1.5 to 3, preferably from 1.5 to 2.5),

6) vinyl termination (also referred to as vinyl content) of 70% or more, relative to total unsaturations, (as measured by ¹H NMR) (preferably 75% or more, preferably 80% or more, preferably 85% or more, preferably 90% or more, preferably 95% or more, preferably 98% or more), and

7) a melting point T_m of 60°C or more (preferably 70°C or more, preferably 80°C or more, preferably 90°C or more, preferably 100°C or more, preferably 110°C or more, preferably 120°C or more, preferably 130°C or more) or alternately an H_m of 20 J/g or less, preferably 15 J/g or less,

8) from 0 to 10wt% aromatic containing monomer, such as styrenic monomer, (preferably 0 to 5wt%, preferably 0 to 1wt%, alternately 0wt%), based upon the weight of the macromonomer; and wherein the polymacromonomer has:

a) a g value of less than 0.6 (preferably less than 0.5, preferably less than 0.4, preferably less than 0.3, alternately less than 0.2),

b) an M_w of greater than 30,000 g/mol (preferably 40,000 to 3,000,000, preferably 60,000 to 1,500,000),

c) an M_n of greater than 20,000 g/mol (preferably 40,000 to 2,000,000, preferably 60,000 to 1,000,000),

d) a branching index $(g')_{vis}$ of less than 0.5 (preferably less than 0.4, preferably less than 0.3, preferably less than 0.2),

e) a melting point of 50°C or more (preferably 60°C or more, preferably 70°C or more, preferably 80°C or more, preferably 90°C or more, preferably 100°C or more, preferably 120°C or more), or alternately an Hm of 20 J/g or less, preferably 15 J/g or less, and

f) from 0 to 10wt% aromatic containing monomer, such as styrenic monomer, (preferably 0 to 5wt%, preferably 0 to 1wt%, alternately 0wt%), based upon the weight of the polymacromonomer.

In a preferred embodiment the macromonomer is not aromatic (comprises less than 5wt% aromatic containing monomers, preferably less than 1wt%, preferably 0wt%), preferably is not styrenic (comprises less than 5wt% styrenic monomers, preferably less than 1wt%, preferably 0wt%).

In a preferred embodiment, the macromonomer used herein has:

1) from 20 to 800 carbon atoms (preferably from 20 to 700, preferably from 20 to 600, preferably from 20 to 500, preferably from 20 to 400, preferably from 20 to 300, preferably from 20 to 200, preferably from 30 to 175),

2) an M_n of 280 g/mol or more, (preferably from 280 to 15,000, preferably from 280 to 10,000, preferably from 280 to 12,000, preferably from 280 to 8,000, preferably 280 to 6,000, preferably 300 to 5,000, preferably 350 to 3,000, preferably 350 to 2,000),

3) an M_w of 400 g/mol or more (preferably from 400 to 50,000, preferably from 400 to 20,000, preferably from 450 to 15,000, preferably 450 to 10,000, preferably 450 to 5,000, preferably 450 to 3,000),

4) an M_z of 600 g/mol or more, (preferably from 600 to 35,000, preferably from 600 to 30,000, preferably from 600 to 25,000, preferably from 600 to 20,000, preferably from 600 to 15,000, preferably 600 to 10,000, preferably 600 to 5,000, preferably 750 to 3,000),

5) an M_w/M_n of 1.5 or more, (preferably 1.5 to 7, preferably from 1.5 to 6, preferably from 1.6 to 5, preferably from 1.8 to 4, preferably from 1.5 to 3, preferably from 1.5 to 2.5),

6) a vinyl content of 70% or more, relative to total unsaturations, (preferably 70% or more, preferably 80% or more, preferably 85% or more, preferably 90% or more, preferably 95% or more, preferably 97% , preferably 98% or more, preferably 99% or more)

7) a melting point (DSC, second melt) of 60°C or more (preferably 70°C or more, preferably

80°C or more, preferably 90°C or more, preferably 100°C or more, preferably 110°C or more, preferably 120°C or more, preferably 130°C or more) or alternately an Hm of 20 J/g or less, preferably 15 J/g or less; and

8) from 0 to 10wt% of aromatic containing monomer, such as styrenic monomer (preferably 0 to 5wt%, preferably 0 to 1wt%, alternately 0wt%) based upon the weight of the macromonomer. (Aromatic content in a polymer is determined by ¹HNMR).

Mw, Mz, and Number of carbon atoms are determined by GPC according to the procedure described in the Experimental section below. Mn is determined by ¹HNMR according to the procedure described in the Experimental section below. Branching index (g')_{vis} is determined according to the procedure described in the Experimental section below. Vinyl content (%) is determined as described above and in the Experimental section below. Melting point is determined by differential scanning calorimetry as described in the Experimental section below. "g value" is determined by the GPC procedure described in the Experimental section below and according to the methods in Macromolecules, 2001, 34, 6812-6820.

In another embodiment, the macromonomer used herein is a propylene homo-oligomer, comprising propylene and less than 0.5wt% comonomer, preferably 0wt% comonomer, wherein the oligomer has:

- i) at least 93% allyl chain ends (preferably at least 95%, preferably at least 97%, preferably at least 98%);
- ii) a number average molecular weight (Mn) of about 500 to about 20,000 g/mol, as measured by ¹H NMR (preferably 500 to 15,000, preferably 600 to 10,000, preferably 800 to 8,000 g/mol, preferably 900 to 7,000, preferably 1000 to 6,000, preferably 1000 to 5,000);
- iii) an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.3:1.0;
- iv) less than 1400 ppm aluminum, (preferably less than 1200 ppm, preferably less than 1000 ppm, preferably less than 500 ppm, preferably less than 100 ppm).

In another embodiment, the macromonomer used herein is a propylene co-oligomer having an Mn of 300 to 30,000 g/mol as measured by ¹H NMR (preferably 400 to 20,000, preferably 500 to 15,000, preferably 600 to 12,000, preferably 800 to 10,000, preferably 900 to 8,000, preferably 900 to 7,000 g/mol), comprising 10 to 90 mol% propylene (preferably 15 to 85 mol%, preferably 20 to 80 mol%, preferably 30 to 75 mol%, preferably 50 to 90 mol%) and 10 to 90 mol% (preferably 85 to 15 mol%, preferably 20 to 80 mol%, preferably 25 to 70 mol%, preferably 10 to 50 mol%) of one or more alpha-olefin comonomers (preferably ethylene, butene, hexene, or octene, preferably ethylene), wherein the oligomer has at least X% allyl chain ends (relative to total unsaturations), where: 1) $X = (-0.94 (\text{mol\% ethylene incorporated}) + 100 \{ \text{alternately } 1.20 (-0.94 (\text{mol\% ethylene incorporated}) + 100), \text{ alternately } 1.50(-0.94 (\text{mol\% ethylene incorporated}) + 100) \})$, when 10 to 60 mol% ethylene is present in the co-oligomer, and 2) $X = 45$ (alternately 50, alternately 60), when greater than 60 and less than 70 mol% ethylene is present in the co-oligomer, and 3) $X = (1.83 * (\text{mol\% ethylene incorporated}) - 83, \{ \text{alternately } 1.20 [1.83 * (\text{mol\% ethylene incorporated}) - 83], \text{ alternately } 1.50 [1.83 * (\text{mol\% ethylene incorporated}) -$

83}], when 70 to 90 mol% ethylene is present in the co-oligomer. Alternately X is 80% or more, preferably 85% or more, preferably 90% or more, preferably 95% or more.

In an alternate embodiment any of oligomers i) to vi) have at least 80% isobutyl chain ends (based upon the sum of isobutyl and n-propyl saturated chain ends), preferably at least 85% isobutyl chain ends, preferably at least 90% isobutyl chain ends. Alternately, any of oligomers i) to vi) have an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0, preferably 0.9:1 to 1.20:1.0, preferably 0.9:1.0 to 1.1:1.0.

In another embodiment, the macromonomer used herein is a propylene oligomer, comprising more than 90 mol% propylene (preferably 95 to 99 mol%, preferably 98 to 99 mol%) and less than 10 mol% ethylene (preferably 1 to 4 mol%, preferably 1 to 2 mol%), wherein the oligomer has:

at least 93% allyl chain ends (preferably at least 95%, preferably at least 97%, preferably at least 98%);

a number average molecular weight (Mn) of about 400 to about 30,000 g/mol, as measured by ¹H NMR (preferably 500 to 20,000, preferably 600 to 15,000, preferably 700 to 10,000 g/mol, preferably 800 to 9,000, preferably 900 to 8,000, preferably 1000 to 6,000);

an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0, and

less than 1400 ppm aluminum, (preferably less than 1200 ppm, preferably less than 1000 ppm, preferably less than 500 ppm, preferably less than 100 ppm).

In another embodiment, the macromonomer used herein is a propylene oligomer, comprising:

at least 50 (preferably 60 to 90, preferably 70 to 90) mol% propylene and from 10 to 50 (preferably 10 to 40, preferably 10 to 30) mol% ethylene, wherein the oligomer has:

at least 90% allyl chain ends (preferably at least 91%, preferably at least 93%, preferably at least 95%, preferably at least 98%);

an Mn of about 150 to about 20,000 g/mol, as measured by ¹H NMR (preferably 200 to 15,000, preferably 250 to 15,000, preferably 300 to 10,000, preferably 400 to 9,500, preferably 500 to 9,000, preferably 750 to 9,000); and

an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.3:1.0, wherein monomers having four or more carbon atoms are present at from 0 to 3 mol% (preferably at less than 1 mol%, preferably less than 0.5 mol%, preferably at 0 mol%).

In another embodiment, the macromonomer used herein is a propylene oligomer, comprising:

at least 50 (preferably at least 60, preferably 70 to 99.5, preferably 80 to 99, preferably 90 to 98.5) mol% propylene, from 0.1 to 45 (preferably at least 35, preferably 0.5 to 30, preferably 1 to 20, preferably 1.5 to 10) mol% ethylene, and from 0.1 to 5 (preferably 0.5 to 3, preferably 0.5 to 1) mol% C₄ to C₁₂ olefin (such as butene, hexene or octene, preferably butene), wherein the oligomer has:

at least 90% allyl chain ends (preferably at least 91%, preferably at least 93%, preferably at least 95%, preferably at least 98%);

a number average molecular weight (Mn) of about 150 to about 15,000 g/mol, as measured by ¹H NMR (preferably 200 to 12,000, preferably 250 to 10,000, preferably 300 to 10,000, preferably 400 to

9500, preferably 500 to 9,000, preferably 750 to 9,000); and

an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0.

In another embodiment, the macromonomer used herein is a propylene oligomer, comprising:

at least 50 (preferably at least 60, preferably 70 to 99.5, preferably 80 to 99, preferably 90 to 98.5) mol% propylene, from 0.1 to 45 (preferably at least 35, preferably 0.5 to 30, preferably 1 to 20, preferably 1.5 to 10) mol% ethylene, and from 0.1 to 5 (preferably 0.5 to 3, preferably 0.5 to 1) mol% diene (such as C₄ to C₁₂ alpha-omega dienes (such as butadiene, hexadiene, octadiene), norbornene, ethylidene norbornene, vinylnorbornene, norbornadiene, and dicyclopentadiene), wherein the oligomer has:

at least 90% allyl chain ends (preferably at least 91%, preferably at least 93%, preferably at least 95%, preferably at least 98%);

a number average molecular weight (Mn) of about 150 to about 20,000 g/mol, as measured by ¹H NMR (preferably 200 to 15,000, preferably 250 to 12,000, preferably 300 to 10,000, preferably 400 to 9,500, preferably 500 to 9,000, preferably 750 to 9,000); and

an isobutyl chain end to allylic vinyl group ratio of 0.7:1 to 1.35:1.0.

Any of the macromonomers (preferably the oligomers i) to vi)) prepared herein preferably have less than 1400 ppm aluminum, preferably less than 1000 ppm aluminum, preferably less than 500 ppm aluminum, preferably less than 100 ppm aluminum, preferably less than 50 ppm aluminum, preferably less than 20 ppm aluminum, preferably less than 5 ppm aluminum.

In another preferred embodiment, the macromonomer is amorphous, isotactic or syndiotactic, preferably isotactic. In another embodiment, the macromonomer is a propylene homopolymer or propylene homo-oligomer that may be amorphous, isotactic or syndiotactic, preferably isotactic. In another embodiment, the macromonomer is a propylene copolymer or propylene co-oligomer that may be amorphous, isotactic or syndiotactic, preferably isotactic. Amorphous is defined to mean a heat of fusion of less than 10 J/g. Isotactic is defined to be at least 50% isotactic pentads (as determined by ¹³CNMR as described below) preferably at least 60%, preferably at least 70%, preferably at least 80% isotactic pentads. Syndiotactic is defined to be at least 50% syndiotactic pentads (as determined by ¹³CNMR as described below) preferably at least 60%, preferably at least 70%, preferably at least 80% syndiotactic pentads.

In any of the embodiments described herein the macromonomer contains only, or consists essentially of or consists of, C₂ to C₁₈ linear alpha olefin monomer units (preferably C₂ to C₁₂, preferably ethylene, propylene, butene, octene, decene, or dodecene, preferably ethylene and propylene). In another embodiment the macromonomer does not comprise any styrene based monomer units. In another embodiment the macromonomer does not comprise any cyclic monomer units. In another embodiment the macromonomer does not comprise any aromatic monomer units. In another embodiment the macromonomer comprises 1wt% or less of a styrenic monomer unit, a cyclic monomer unit or an aromatic monomer unit, preferably less than 0.5wt%, preferably 0wt%, based upon the weight of the macromonomer.

In another embodiment the macromonomer comprises less than 30wt% amorphous material, preferably less than 20wt%, preferably less than 10wt%, preferably less than 5wt% amorphous material, based upon the weight of the macromonomer. Percent amorphous material is determined by subtracting the percent crystallinity from 100. The percent crystallinity (X%) is calculated using the formula: [area under the DSC curve (in J/g) / H° (in J/g)] * 100, where H° is the heat of fusion for the homopolymer of the major monomer component. These values for H° are to be obtained from the *Polymer Handbook, Fourth Edition*, published by John Wiley and Sons, New York 1999, except that a value of 290 J/g is used as the equilibrium heat of fusion (H°) for 100% crystalline polyethylene, a value of 140 J/g is used as the equilibrium heat of fusion (H°) for 100% crystalline polybutene, and a value of 207 J/g (H°) is used as the heat of fusion for a 100% crystalline polypropylene. The DSC curve is obtained as described in the Experimental section below.

In another embodiment, the macromonomer (particularly oligomers i) to iv)) has a glass transition temperature (T_g) of 0°C or less (as determined by differential scanning calorimetry as described below), preferably -10°C or less, more preferably -20°C or less, more preferably -30°C or less, more preferably -50°C or less.

In another embodiment, the macromonomer (particularly oligomers i) to iv)) has a melting point (DSC first melt) of from 60 to 130°C, alternately 50 to 100°C. In another embodiment, the oligomers described herein have no detectable melting point by DSC following storage at ambient temperature (23°C) for at least 48 hours.

In another embodiment, the macromonomer (particularly oligomers i) to iv)) is a liquid at 25°C.

In another embodiment, any macromonomer described herein may have a heat of fusion of 50 J/g or more, preferably 75 J/g or more, preferably 100 J/g or more, as determined by differential scanning calorimetry as described in the Experimental section below.

In another embodiment, any macromonomer described herein may have a percent crystallinity of 50% or more, preferably 60% or more, preferably 70% or more, as determined by DSC as described in the Experimental section below.

In another embodiment, any macromonomer described herein contains less than 1000 ppm of a group 4 metal (preferably less than 750 ppm of Ti, Hf and/or Zr). Alternately, the macromonomer contains less than 1000 ppm of lithium (preferably less than 750 ppm of lithium).

In a preferred embodiment, any macromonomer described herein comprises less than 3wt% of functional groups selected from hydroxide, aryls and substituted aryls, halogens, alkoxys, carboxylates, esters, acrylates, oxygen, nitrogen, and carboxyl, preferably less than 2wt%, more preferably less than 1wt%, more preferably less than 0.5wt%, more preferably less than 0.1wt%, more preferably 0wt%, based upon the weight of the macromonomer.

In another embodiment, the macromer described herein is a propylene oligomer or polymer. In some embodiments the propylene oligomer or polymer has one or more of the following properties:

a) a g'_{vis} of 0.95 or less, preferably 0.90 or less, preferably 0.85 or less, preferably 0.80 or less, preferably 0.75 or less, preferably 0.70 or less); and/or

b) an Mw of 5,000 to 100,000 g/mol (preferably 15,000 to 100,000, preferably 20,000 to 75,000 g/mol); and/or

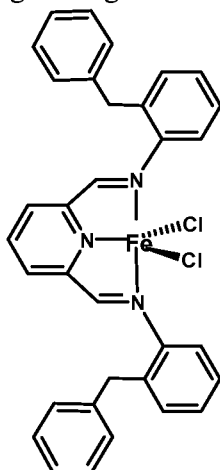
c) a melting point of 90°C or more (alternately 100°C or more, alternately 140°C or more). In a preferred embodiment the propylene oligomer or polymer is isotactic. Such propylene oligomers or polymers are known in the art and can be made using metallocene catalysts such as dimethylsilyl-bis(2-methyl,4-phenyl-indenyl)hafniumdimethyl or the catalyst compounds described in US 7,279,536, typically used in combination with N, N- dimethylanilinium tetra (perfluorophenyl)borate or N, N-dimethylanilinium tetrakis (heptafluoronaphthyl)borate.

In a preferred embodiment, the macromonomer is a copolymer of ethylene and propylene, preferably having a Hm of 20 J/g or less (preferably 15 J/g or less) comprising from 65 to 80wt% ethylene and from 20 to 35wt% propylene, preferably having an Mw of from 5,000 to 100,000 g/mol, preferably 20,000 to 80,000 g/mol. Such copolymers are known in the art and can be made using metallocene catalysts such as (pentamethylcyclopentadienyl)(1,3-dimethylindenyl)hafnium dimethyl, typically used in combination with N, N- dimethylanilinium tetra (perfluorophenyl)borate or N, N-dimethylanilinium tetrakis (heptafluoronaphthyl)borate.

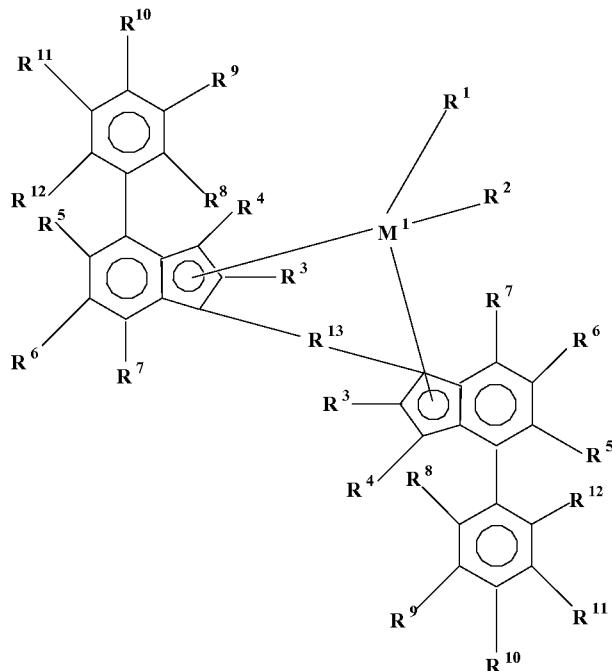
Macromonomers useful herein may be made by process known in the art to produce vinyl terminated macromonomers, including those described in US 6,117,962, US 6,555,635, Small, Brookhart, Bennett, JACS 120, 1998, 4049, Britovsek, et al. Chem. Comm. 1998, 849., Su, et al. Organomet. 25, 2006, 666.

In a preferred embodiment, the macromonomers can be produced using one or more activators in combination with one or more of the catalyst compounds described in: 1) G.J.P. Britovsek, V.C. Gibson, S.J. McTavish, G.A. Solan, B.S. Kimberley, P.J. Maddox, A.J.P. White, Williams, *Chem. Comm.* 1998, 849; 2) Journal of Organometallic Chemistry, 648, 2002, 55; 3) *Iron Complexes Bearing 2-Imino-1,10-phenanthrolinyl Ligands as Highly Active Catalysts for Ethylene Oligomerization*, *Organometallics*, 2006, 666-677; and 4) "Novel Olefin Polymerization Catalysts Based on Iron and Cobalt", *Chem. Commun.* 1998, 849.

Particularly useful catalyst compounds to make vinyl terminated ethylene macromonomers (preferably crystalline, e.g. having at least 40% crystallinity) include those represented by the formula:



Particularly useful catalyst compounds to make vinyl terminated isotactic propylene macromonomers (preferably crystalline, e.g. having at least 40% crystallinity) include those represented by the formula:

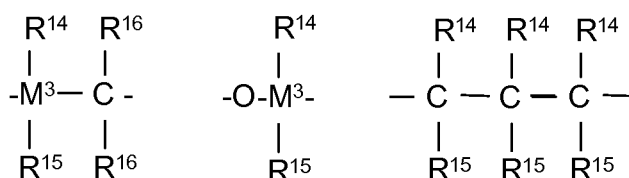
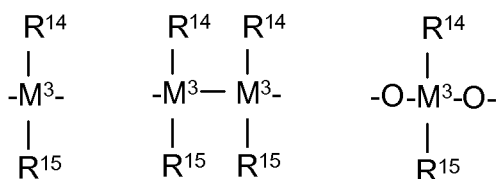


where M^1 is selected from titanium, zirconium, hafnium, vanadium, niobium, tantalum, chromium, molybdenum, or tungsten (preferably zirconium and/or hafnium);

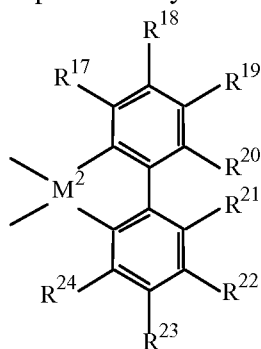
R^1 and R^2 are identical or different and are selected from hydrogen atoms, C1-C10 alkyl groups, C1-C10 alkoxy groups, C6-C10 aryl groups, C6-C10 aryloxy groups, C2-C10 alkenyl groups, C2-C40 alkenyl groups, C7-C40 arylalkyl groups, C7-C40 alkylaryl groups, C8-C40 arylalkenyl groups, OH groups or halogen atoms; or conjugated dienes that are optionally substituted with one or more hydrocarbyl, tri(hydrocarbyl)silyl groups or hydrocarbyl tri(hydrocarbyl)silylhydrocarbyl groups (preferably R^1 and R^2 are an alkyl such as methyl or ethyl or are a halide such as chloride);

R_3 - R_{12} are the same or different and are selected from hydrogen atoms, halogen atoms, C1-C10 halogenated or unhalogenated alkyl groups, C6-C10 halogenated or unhalogenated aryl groups, C2-C10 halogenated or unhalogenated alkenyl groups, C7-C40 halogenated or unhalogenated arylalkyl groups, C7-C40 halogenated or unhalogenated alkylaryl groups, C8-C40 halogenated or unhalogenated arylalkenyl groups, $-NR'2$, $-SR'$, $-OR'$, $-OSiR'3$ or $-PR'2$ radicals in which R' is one of a halogen atom, a C1-C10 alkyl group, or a C6-C10 aryl group; or two or more adjacent radicals R^5 to R^7 together with the atoms connecting them can form one or more rings (preferably R^3 is methyl, ethyl or butyl), and adjacent radicals R^{11} and R^{12} can form one or more saturated or aromatic rings (preferably R^{11} and R^{12} combine with the phenyl ring to form a substituted or unsubstituted naphthyl group), in an advantageous embodiment, R^9 and R^{11} are a C1 to C20 hydrocarbyl group, or a C3 to C12 alkyl group, advantageously a t-butyl group;

R^{13} is selected from:



$-B(R^{14})-$, $-Al(R^{14})-$, $-Ge-$, $-Sn-$, $-O-$, $-S-$, $-SO-$, $-SO_2-$, $-N(R^{14})-$, $-CO-$, $-P(R^{14})-$, $-P(O)(R^{14})-$, $-B(NR^{14}R^{15})-$ and $-B[N(SiR^{14}R^{15}R^{16})_2]-$, R^{14} , R^{15} and R^{16} are each independently selected from hydrogen, halogen, C1-C20 alkyl groups, C6-C30 aryl groups, C1-C20 alkoxy groups, C2-C20 alkenyl groups, C7-C40 arylalkyl groups, C8-C40 arylalkenyl groups and C7-C40 alkylaryl groups, or R^{14} and R^{15} , together with the atom(s) connecting them, form a ring; and M^3 is selected from carbon, silicon, germanium and tin, or R^{13} is represented by the formula:

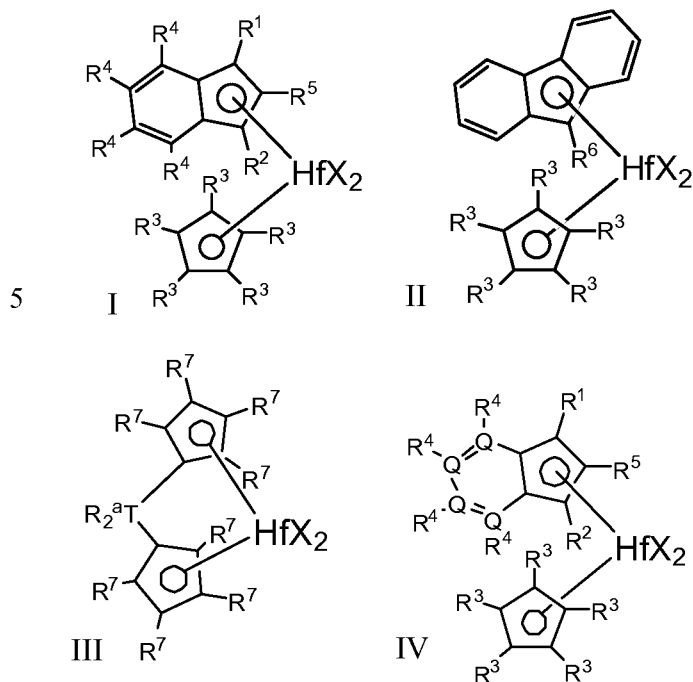


wherein R^{17} to R^{24} are as defined for R^1 and R^2 , or two or more adjacent radicals R^{17} to R^{24} , including R^{20} and R^{21} , together with the atoms connecting them form one or more rings; M^2 is carbon, silicon, germanium, or tin (preferably R^{13} is dimethyl silyl or diphenylsilyl).

Particularly useful catalyst compounds to make vinyl terminated isotactic propylene macromonomers (preferably crystalline, e.g. having at least 40% crystallinity) include those represented by the formula: $rac-Me_2Si-bis(2-R-indenyl)MX_2$ or $rac-Me_2Si-bis(2-R,4-Ph-indenyl)MX_2$, where R is an alkyl group (such as methyl), Ph is phenyl or substituted phenyl, M is Hf, Zr or Ti, and X is a halogen or alkyl group (such as Cl or methyl). Examples include dimethylsilyl-bis(2-methyl-indenyl)zirconium dimethyl (or dichloride), dimethylsilyl-bis(2-methyl,4-phenyl-indenyl)zirconium dimethyl (or dichloride), dimethylsilyl-bis(2-methyl,4-(3',5'-di-t-butyl-phenyl)-indenyl)zirconium dimethyl (or dichloride), dimethylsilyl-bis(2-methyl,4-naphthyl-indenyl)zirconium dimethyl (or dichloride), and dimethylsilyl-bis(2-methyl,4-(3',5'-di-t-butyl-naphthyl)-indenyl)zirconium dimethyl (or dichloride), or alternately the compounds where zirconium is replaced by hafnium. Other useful catalysts compounds include: $(CpMe_4)(1,3-dimethyl\ Ind)Hf\ Me_2$; $(CpMe_4)(1-iPr\ Ind)Hf\ Me_2$; $(CpMe_4)(1-iPr,3-nPr\ Ind)Hf\ Me_2$; $(CpMe_5)((1,3-dimethyl\ Ind)Hf\ Me_2)$; $(CpMe_5)((1,3-di-n-propyl\ Ind)Hf\ Me_2)$; $(CpMe_5)((1,2,3-$

trimethyl Ind)Hf Me₂, where Cp = cyclopentadienyl, Ind = indenyl, Me = methyl, iPr = isopropyl, and nPr = n-propyl.

In a preferred embodiment, the oligomers i) to iv) can be produced using a catalyst system comprising an activator and a catalyst compound represented by the following formulae:



where

Hf is hafnium;

- 10 each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system);
- 15 each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms);
- each R¹ is, independently, hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R¹ may the same or different as R²;
- 20 each R² is, independently, hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided that at least one of R¹ or R² is not hydrogen, preferably both of R¹ and R² are not hydrogen, preferably R¹ and/or R² are not branched;
- 25 each R³ is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that at least three R³ groups are not hydrogen (alternately four R³ groups are not hydrogen, alternately five R³ groups are not hydrogen);

{Alternately, when the catalyst compound is to be used to make the homo-oligomer then each R^3 is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that: 1) all five R^3 groups are methyl, or 2) four R^3 groups are not hydrogen and at least one R^3 group is a C_2 to C_8 substituted or unsubstituted hydrocarbyl (preferably at least two, three, four or five R^3 groups are a C_2 to C_8 substituted or unsubstituted hydrocarbyl)};

each R^4 is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH_2SiR' , where R' is a C_1 to C_{12} hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl);

R^5 is hydrogen or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

R^6 is hydrogen or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

each R^7 is, independently, hydrogen, or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven R^7 groups are not hydrogen, alternately at least eight R^7 groups are not hydrogen, alternately all R^7 groups are not hydrogen, (preferably the R^7 groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen);

N is nitrogen;

T is a bridge, preferably, Si or Ge, preferably Si;

each R^a , is independently, hydrogen, halogen or a C_1 to C_{20} hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system;

and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.

The term "substituted" means that a hydrogen group has been replaced with a hydrocarbyl group, a heteroatom or a heteroatom containing group. For example methyl cyclopentadiene (Cp) is a Cp group substituted with a methyl group and ethyl alcohol is an ethyl group substituted with an -OH group.

In an alternate embodiment, at least one R^4 group is not hydrogen, alternately at least two R^4 groups are not hydrogen, alternately at least three R^4 groups are not hydrogen, alternately at least four R^4 groups are not hydrogen, alternately all R^4 groups are not hydrogen.

Catalyst compounds that are particularly useful include one or more of:

(1,3-Dimethylindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,

(1,3,4,7-Tetramethylindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,

- (1,3-Dimethylindenyl)(tetramethylcyclopentadienyl)Hafniumdimethyl,
 (1,3-Diethylindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 (1,3-Dipropylindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 (1-Methyl,3-propyllindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 5 (1,3-Dimethylindenyl)(tetramethylpropylcyclopentadienyl)Hafniumdimethyl,
 (1,2,3-Trimethylindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 (1,3-Dimethylbenzindenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 (2,7-Bis t-butylfluorenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 (9-Methylfluorenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 10 (2,7,9-Trimethylfluorenyl)(pentamethylcyclopentadienyl)Hafniumdimethyl,
 μ -Dihydrosilyl(bis tetramethylcyclopentadienyl)Hafniumdimethyl,
 μ -Dihydrosilyl(bis tetramethylcyclopentadienyl)Hafniumdimethyl,
 μ -Dimethylsilyl(tetramethylcyclopentadienyl)(3-propyltrimethylcyclopentadienyl) Hafniumdimethyl,
 and
 15 μ -Dicyclopropylsilyl(bis tetramethylcyclopentadienyl)Hafniumdimethyl.

In an alternate embodiment, the "dimethyl" after the transition metal in the list of catalyst compounds above is replaced with a dihalide (such as dichloride or difluoride) or a bisphenoxide, particularly for use with an alumoxane activator.

Activators

- 20 Useful activators include alumoxanes and non-coordinating anion activators, whether neutral or ionic. Examples include alkylalumoxane, such as methylalumoxane, ethyl alumoxane, butyl alumoxane, isobutyl alumoxane; modified alumoxanes such as modified alkyl alumoxanes, including modified methyl alumoxane and the like. Mixtures of different alumoxanes and modified alumoxanes may also be used. Alumoxanes may be produced by the hydrolysis of the respective trialkylaluminum compound.
- 25 MMAO may be produced by the hydrolysis of trimethylaluminum and a higher trialkylaluminum such as triisobutylaluminum. MMAO's are generally more soluble in aliphatic solvents and more stable during storage. There are a variety of methods for preparing alumoxane and modified alumoxanes, non-limiting examples of which are described in U.S. Patent No. 4,665,208, 4,952,540, 5,091,352, 5,206,199, 5,204,419, 4,874,734, 4,924,018, 4,908,463, 4,968,827, 5,308,815, 5,329,032, 5,248,801, 5,235,081, 30 5,157,137, 5,103,031, 5,391,793, 5,391,529, 5,693,838, 5,731,253, 5,731,451, 5,744,656, 5,847,177, 5,854,166, 5,856,256 and 5,939,346 and European publications EP-A-0 561 476, EP-B1-0 279 586, EP-A-0 594-218 and EP-B1-0 586 665, and PCT publications WO 94/10180 and WO 99/15534, all of which are herein fully incorporated by reference. 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 35 decanted from the cloudy solution. Another 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 US 5,041,584). When the activator is an alumoxane (modified or unmodified), some embodiments select the maximum amount of activator at a

5000-fold molar excess Al/M over the catalyst precursor (per metal catalytic site). The minimum activator-to-catalyst-precursor is typically a 1:1 molar ratio.

Aluminum alkyl or organoaluminum compounds which may be utilized as activators (or scavengers) herein include trimethylaluminum, triethylaluminum, triisobutylaluminum, tri-n-hexylaluminum, tri-n-octylaluminum and the like. If used as scavengers they are typically present at a ratio of 10:1 up to 100:1 mole:mole.

In another embodiment, the activator may be an ionizing or stoichiometric activator, neutral or ionic, such as tri (n-butyl) ammonium tetrakis (pentafluorophenyl) boron, a trisperfluorophenyl boron metalloid precursor or a trisperfluoronaphthyl boron metalloid precursor, polyhalogenated heteroborane anions (WO 98/43983), boric acid (U.S. Patent No. 5,942,459) or combination thereof. It is also within the scope of this invention to use neutral or ionic activators alone or in combination with alumoxane or modified alumoxane activators.

Examples of neutral stoichiometric activators include tri-substituted boron, tellurium, aluminum, gallium and indium or mixtures thereof. The three substituent groups are each independently selected from alkyls, alkenyls, halogen, substituted alkyls, aryls, arylhalides, alkoxy and halides. Preferably, the three groups are independently selected from halogen, mono or multicyclic (including halosubstituted) aryls, alkyls, and alkenyl compounds and mixtures thereof, preferred are alkenyl groups having 1 to 20 carbon atoms, alkyl groups having 1 to 20 carbon atoms, alkoxy groups having 1 to 20 carbon atoms and aryl groups having 3 to 20 carbon atoms (including substituted aryls). More preferably, the three groups are alkyls having 1 to 4 carbon groups, phenyl, naphthyl or mixtures thereof. Even more preferably, the three groups are halogenated, preferably fluorinated, aryl groups. Most preferably, the neutral stoichiometric activator is trisperfluorophenyl boron or trisperfluoronaphthyl boron.

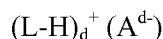
Ionic stoichiometric activator compounds may contain an active proton, or some other cation associated with, but not coordinated to, or only loosely coordinated to, the remaining ion of the ionizing compound. Such compounds and the like are described in European publications EP-A-0 570 982, EP-A-0 520 732, EP-A-0 495 375, EP-B1-0 500 944, EP-A-0 277 003 and EP-A-0 277 004, and U.S. Patent Nos. 5,153,157, 5,198,401, 5,066,741, 5,206,197, 5,241,025, 5,384,299 and 5,502,124 and U.S. Patent Application Serial No. 08/285,380, filed August 3, 1994, all of which are herein fully incorporated by reference.

Ionic catalysts can be preparedly reacting a transition metal compound with some neutral Lewis acids, such as $B(C_6F_5)_3$, which upon reaction with the hydrolyzable ligand (X) of the transition metal compound forms an anion, such as $[B(C_6F_5)_3(X)]^-$, which stabilizes the cationic transition metal species generated by the reaction. The catalysts can be, and preferably are, prepared with activator components which are ionic compounds or compositions. However preparation of activators utilizing neutral compounds is also contemplated by this invention.

Compounds useful as an activator component in the preparation of the ionic catalyst systems used in the process of this invention comprise a cation, which is preferably a Bronsted acid capable of donating a proton, and a compatible non-coordinating anion which anion is relatively large (bulky),

capable of stabilizing the active catalyst species (the Group 4 cation) which is formed when the two compounds are combined and said anion will be sufficiently labile to be displaced by olefinic diolefinic and acetylenically unsaturated substrates or other neutral Lewis bases such as ethers, nitriles and the like. Two classes of compatible non-coordinating anions have been disclosed in EPA 277,003 and EPA 277,004 published 1988: 1) anionic coordination complexes comprising a plurality of lipophilic radicals covalently coordinated to and shielding a central charge-bearing metal or metalloid core, and 2) anions comprising a plurality of boron atoms such as carboranes, metallacarboranes and boranes.

In a preferred embodiment, the stoichiometric activators include a cation and an anion component, and may be represented by the following formula:



wherein L is a neutral Lewis base;

H is hydrogen;

$(L-H)^+$ is a Bronsted acid

A^{d-} is a non-coordinating anion having the charge d-

d is an integer from 1, 2 or 3.

The cation component, $(L-H)_d^+$ may include Bronsted acids such as protons or protonated Lewis bases or reducible Lewis acids capable of protonating or abstracting a moiety, such as an alkyl or aryl, from the bulky ligand metallocene containing transition metal catalyst precursor, resulting in a cationic transition metal species.

The activating cation $(L-H)_d^+$ may be a Bronsted acid, capable of donating a proton to the transition metal catalytic precursor resulting in a transition metal cation, including ammoniums, oxoniums, phosphoniums, silyliums, and mixtures thereof, preferably ammoniums of methylamine, aniline, dimethylamine, diethylamine, N-methylaniline, diphenylamine, trimethylamine, triethylamine, N,N-dimethylaniline, methyldiphenylamine, pyridine, p-bromo N,N-dimethylaniline, p-nitro-N,N-dimethylaniline, phosphoniums from triethylphosphine, triphenylphosphine, and diphenylphosphine, oxoniums from ethers such as dimethyl ether diethyl ether, tetrahydrofuran and dioxane, sulfoniums from thioethers, such as diethyl thioethers and tetrahydrothiophene, and mixtures thereof. The activating cation $(L-H)_d^+$ may also be a moiety such as silver, tropylium, carbeniums, ferroceniums and mixtures, preferably carboniums and ferroceniums. Most preferably $(L-H)_d^+$ is triphenyl carbonium.

The anion component A^{d-} include those having the formula $[M^{k+}Q_n]^{d-}$ wherein k is an integer from 1 to 3; n is 2, 3, 4, 5 or 6; $n - k = d$; M is an element selected from Group 13 of the Periodic Table of the Elements, preferably boron or aluminum, and Q is independently a hydride, bridged or unbridged dialkylamido, halide, alkoxide, aryloxy, hydrocarbyl, substituted hydrocarbyl, halocarbyl, substituted halocarbyl, and halosubstituted-hydrocarbyl radicals, said Q having up to 20 carbon atoms with the proviso that in not more than 1 occurrence is Q a halide. Preferably, each Q is a fluorinated hydrocarbyl group having 1 to 20 carbon atoms, more preferably each Q is a fluorinated aryl group, and most preferably each Q is a pentafluoryl aryl group. Examples of suitable A^{d-} also include diboron compounds as disclosed in U.S. Pat. No. 5,447,895, which is fully incorporated herein by reference.

Examples of useful activators include: is N,N-dimethylanilinium tetra(perfluorophenyl)borate, N,N-dimethylanilinium tetrakis(perfluoronaphthyl)borate, N,N-dimethylanilinium tetrakis(perfluorobiphenyl)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, and triphenylcarbenium tetra(perfluorophenyl)borate.

The term "non-coordinating anion" (NCA) means an anion which either does not coordinate to said cation or which is only weakly coordinated to said 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 decomposes. Further, the anion will not transfer an anionic substituent or fragment to the cation so as to cause it to form a neutral four coordinate metallocene compound and a neutral by-product from the anion. Non-coordinating anions useful in accordance with this invention are those that are compatible, stabilize the metallocene cation in the sense of balancing its ionic charge at +1, yet retain sufficient lability to permit displacement by an ethylenically or acetylenically unsaturated monomer during polymerization. These types of cocatalysts sometimes use tri-isobutyl aluminum or tri-octyl aluminum as a scavenger.

Invention process also can employ cocatalyst compounds or activator compounds that are initially neutral Lewis acids but form a cationic metal complex and a noncoordinating anion, or a zwitterionic complex upon reaction with the invention compounds. For example, tris(pentafluorophenyl) boron or aluminum act to abstract a hydrocarbyl or hydride ligand to yield an invention cationic metal complex and stabilizing noncoordinating anion, see EP-A-0 427 697 and EP-A-0 520 732 for illustrations of analogous Group-4 metallocene compounds. Also, see the methods and compounds of EP-A-0 495 375. For formation of zwitterionic complexes using analogous Group 4 compounds, see U.S. Patents 5,624,878; 5,486,632; and 5,527,929.

When the cations of noncoordinating anion precursors are Bronsted acids such as protons or protonated Lewis bases (excluding water), or reducible Lewis acids such as ferrocenium or silver cations, or alkali or alkaline earth metal cations such as those of sodium, magnesium or lithium, the catalyst-precursor-to-activator molar ratio may be any ratio. Combinations of the described activator compounds may also be used for activation. For example, tris(perfluorophenyl) boron can be used with methylalumoxane.

In general the catalyst compounds and the activator are combined in ratios of about 1:10,000 to about 10:1. When alumoxane or aluminum alkyl activators are used, the catalyst-to-activator molar ratio may be from 1:5000 to 10:1, alternatively from 1:1000 to 10:1; alternatively, 1:500 to 2:1; or 1:300 to 1:1. When ionizing activators are used, the catalyst-to-activator molar ratio is from 10:1 to 1:10; 5:1 to 1:5; 2:1 to 1:2; or 1.2:1 to 1:1. Multiple activators may be used, including using mixes of alumoxanes or aluminum alkyls with ionizing activators.

In an alternate embodiment, other additives may be used, such as diethyl zinc, in combination with the catalyst compounds and activators.

Polymerization Processes to Make Macromonomer

The catalysts and catalyst systems described above may be used to produce the macromonomers in a solution, bulk, gas or slurry polymerization process or a combination thereof, preferably a solution phase (preferably a continuous solution phase) polymerization process. (For convenience the processes described herein will be referred to as polymerizations, even though they may produce an oligomer). A supercritical process can also be used, preferably a supercritical process above the melting point of the macromonomers being produced is used, preferably a supercritical process above the cloud point of the polymerization system is used. For more information on the details of the supercritical process (including definitions of cloud point and polymerization system) please see WO 2004/026921. In another embodiment, the processes disclosed in US 7,432,336 (incorporated by reference herein) may be used. For example a continuous polymerizations may be carried out in a stainless steel continuous autoclave reactor equipped with a stirrer, steam heating/water cooling element and a pressure controller. Solvent, macromonomer and comonomer (if any) are typically first chilled to -15°C prior to entering a manifold, and then pumped into the reactor. The preactivated catalyst solution is fed into the reactor from a dry box through metering pumps in a separate line. Solvent (such as hexanes) are pumped into the reactor at a desired rate to control the residence time.

In one embodiment, the catalyst systems described herein may be used in combination with one or more of monomers having from 2 to 30 carbon atoms, preferably 2-12 carbon atoms, and more preferably 2 to 8 carbon atoms in one or more reactors in series or in parallel to produce the macromonomers described herein. (Preferred monomers include one or more of ethylene, propylene, butene-1, pentene-1, 4-methyl-pentene-1, hexene-1, octene-1, decene-1, 4-methyl-pentene-1, 3-methyl-pentene-1, or a combination thereof.) The catalyst component and activator may be delivered as a solution or slurry, either separately to the reactor, activated in-line just prior to the reactor, or preactivated and pumped as an activated solution or slurry to the reactor. The polymerizations are carried out in either single reactor operation, in which monomer, comonomers, catalyst/activator, scavenger, and optional modifiers are added continuously to a single reactor or in series reactor operation, in which the above components are added to each of two or more reactors connected in series. The catalyst components can be added to the first reactor in the series. The catalyst component may also be added to both reactors, with one component being added to first reaction and another component to other reactors. Typically the polymerizations occur at a temperature of 30 to 150°C , preferably 35 to 120°C , preferably 40 to 100°C , alternately 40 to 150°C , alternately 45 to 120°C , alternately 50 to 100°C . Typically the polymerizations occur at a residence time of 1 second to 3 hours, preferably 1 minutes to 90 minutes, preferably 1 minute to 30 minutes, preferably 1 minute to 15 minutes.

The polymerization may occur in gas phase, such as, in a fluidized gas bed process used for producing polymers, where 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.)

In some cases, slurry phase polymerization system may also be used herein. 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 catalyst 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.

In one embodiment, a preferred polymerization technique useful in the invention is referred to as a particle form polymerization, or a slurry process where the temperature is kept below the temperature at which the polymer goes into solution. Such technique is well known in the art, and described in for instance U.S. Patent No. 3,248,179 which is fully incorporated herein by reference. The preferred temperature in the particle form process is within the range of about 85°C to about 110°C. Two preferred polymerization methods for the slurry process are those employing a loop reactor and those utilizing a plurality of stirred reactors in series, parallel, or combinations thereof. Non-limiting examples of slurry processes include continuous loop or stirred tank processes. Also, other examples of slurry processes are described in U.S. Patent No. 4,613,484, which is herein fully incorporated by reference.

In another embodiment, the slurry process is carried out continuously in a loop reactor. The catalyst, as a slurry in isobutane or as a dry free flowing powder, is injected regularly to the reactor loop, which is itself filled with circulating slurry of growing polymer particles in a diluent of isobutane containing monomer and comonomer. Hydrogen, optionally, may be added as a molecular weight control. (In one embodiment 500 ppm or less of hydrogen is added, or 400 ppm or less or 300 ppm or less. In other embodiments at least 50 ppm of hydrogen is added, or 100 ppm or more, or 150 ppm or more.)

A homogeneous (solution or bulk) batch or continuous process may also be used herein. Generally this involves polymerization in a continuous reactor in which the polymer formed and the starting monomer and catalyst materials supplied, are agitated to reduce or avoid concentration gradients. Suitable processes operate above the melting point of the polymers at high pressures, from 1 to 3000 bar (10-30,000 MPa), in which the monomer acts as diluent or in solution polymerization using a solvent. The reactor temperature depends on the catalyst used. In general, the reactor temperature preferably can vary between about 30°C and about 160°C, more preferably from about 40°C to about 120°C, and most preferably from about 50°C to about 110°C. In parallel reactor operation, the temperatures of the two

reactors are independent. The pressure can vary from about 1 mm Hg to 2500 bar (25,000 MPa), preferably from 0.1 bar to 1600 bar (1-16,000 MPa), most preferably from 1.0 to 500 bar (10-5000MPa).

Each of these processes may also be employed in single reactor, parallel or series reactor configurations, in batch or continuous mode. The liquid processes comprise contacting olefin monomers with the above described catalyst system in a suitable diluent or solvent and allowing said monomers to react for a sufficient time to produce the desired polymers. Hydrocarbon solvents are suitable, both aliphatic and aromatic. Alkanes, such as hexane, pentane, isopentane, and octane, are preferred.

The process can be carried out in a continuous stirred tank reactor, batch reactor or plug flow reactor, or more than one reactor operated in series or parallel. These reactors may have or may not have internal cooling or heating and the monomer feed may or may not be refrigerated. See the general disclosure of U.S. patent 5,001,205 for general process conditions. See also, international application WO 96/33227 and WO 97/22639. All documents are incorporated by reference for US purposes for description of polymerization processes, metallocene selection and useful scavenging compounds.

For more information on the processes to produce oligomers i) to vi) please see USSN 12/143,663, filed June 20, 2008.

In a preferred embodiment, the propylene co-oligomer of oligomers i) to vi) may be produce by a homogenous process, said process having productivity of at least 4.5×10^3 g/mmol/hr, wherein the process comprises:

contacting, at a temperature of from 35°C to 150°C, propylene, 0.1 to 70 mol% ethylene and from 0 to about 5wt% hydrogen in the presence of a catalyst system comprising an activator and at least one metallocene compound represented by the formulae I, II, III or IV above, where: Hf is hafnium; each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system); each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms); each R^1 is, independently, a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R^1 may the same or different as R^2 ; each R^2 is, independently, a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, preferably R^1 and/or R^2 are not branched; each R^3 is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that at least three R^3 groups are not hydrogen (alternately four R^3 groups are not hydrogen, alternately five R^3 groups are not hydrogen); each R^4 is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or

unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH₂SiR', where R' is a C₁ to C₁₂ hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl);

5 R⁵ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl; R⁶ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl; each R⁷ is, independently, hydrogen, or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven R⁷ groups

10 are not hydrogen, alternately at least eight R⁷ groups are not hydrogen, alternately all R⁷ groups are not hydrogen, (preferably the R⁷ groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen); N is nitrogen; T is a bridge, preferably, Si or Ge, preferably Si; each R^a, is independently, hydrogen, halogen or a C₁ to C₂₀ hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic,

15 partially saturated, or saturated cyclic or fused ring system; and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.

In a preferred embodiment, the propylene homo-oligomer of oligomers i) to vi) may be produced by a homogeneous process, said process having a productivity of at least 4.5 x 10⁶ g/mol/min, wherein the

20 process comprises:

contacting, at a temperature of from 30°C to 120°C, propylene, 0 mol% comonomer and from 0 to about 5wt% hydrogen in the presence of a catalyst system comprising an activator and at least one metallocene compound represented by the formulae I, II, III or IV disclosed above wherein: Hf is hafnium; each X is, independently, selected from the group consisting of hydrocarbyl radicals having

25 from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system); each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms); each

30 R¹ is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R¹ may be the same or different as R²; each R² is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, preferably R¹ and/or R² are not branched; each R³ is,

35 independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that: 1) all five R³ groups are methyl, or 2) four R³ groups are not hydrogen and at least one R³ group is a C₂ to C₈

substituted or unsubstituted hydrocarbyl (preferably at least two, three, four or five R^3 groups are a C_2 to C_8 substituted or unsubstituted hydrocarbyl); each R^4 is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH_2SiR' , where R' is a C_1 to C_{12} hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl); R^5 is hydrogen or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl; R^6 is hydrogen or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl; each R^7 is, independently, hydrogen, or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven R^7 groups are not hydrogen, alternately at least eight R^7 groups are not hydrogen, alternately all R^7 groups are not hydrogen, (preferably the R^7 groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen); N is nitrogen;

T is a bridge, preferably, Si or Ge, preferably Si; each R^a , is independently, hydrogen, halogen or a C_1 to C_{20} hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system; and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.

In a particularly preferred embodiment, the macromonomer is made in a first reactor then transferred to a second reactor, reaction zone, or reaction extruder where it is polymerized to form the polymacromonomer.

Process to Polymerize Macromonomer to Make Polymacromonomer

In another embodiment this invention relates to a process to produce polymacromonomer comprising contacting macromonomer and from 0 to 40wt% of comonomer of C_2 to C_{18} olefin (preferably alpha-olefin) in the feedstream (preferably from 0 to 30wt%, preferably from 0 to 20wt%, preferably from 0 to 10wt%, preferably from 0 to 5wt%, preferably from 0.5 to 1wt% of C_2 to C_{18} comonomer) with a catalyst system capable of polymerizing vinyl terminated macromonomer (preferably wherein the macromonomer is as described above (preferably having: 1) from 20 to 1500 carbon atoms, 2) an Mn of 280 or more, 3) an Mw of 450 or more, 4) an Mz of 600 or more, 5) an Mw/Mn of 1.5 or more, 6) 70% or more vinyl termination, 7) less than 10wt% styrenic monomer, and 8) optionally, a melting point T_m of 60°C or more (or optionally virtually amorphous); at a temperature of 60 to 130°C (alternately from 70 to 120°C, alternately from 75 to 115°C)) and at reaction time of from 1 minute to 90 minutes (alternately from 1 to 60min, alternately from 1 to 45 min), wherein the molar ratio of all comonomer present in the reactor to all macromonomer present in the reaction zone is 3:1 or less, preferably 2:1 or less, preferably 1:1 or less. In a preferred embodiment the consumption of macromonomer is 70wt% or more, preferably

75% or more, preferably 80% or more, preferably 90% or more, based upon the weight of macromonomer entering the reactor in the feedstream as compared to the amount of macromonomer recovered after the polymerization at the exit of the reactor, as described above.

The catalysts and catalyst systems described below may be used to produce the polymacromonomers in a solution, bulk, gas or slurry polymerization process or a combination thereof, preferably a solution phase or slurry phase polymerization process. The general polymerization process and conditions described above for preparing macromonomers may be also be used for preparing the polymacromonomers. A supercritical process can also be used, preferably a supercritical process above the melting point of the macromonomers being produced is used, preferably a supercritical process above the cloud point of the polymerization system is used. For more information on the details of the supercritical process (including definitions of cloud point and polymerization system) please see WO 2004/026921.

In an alternate embodiment, other additives may be used, such as diethyl zinc, in combination with the catalyst compounds (preferably more than one, such as two) and activators.

This invention further relates to a process, preferably an in-line process, preferably a continuous process, to produce polymacromonomer, comprising introducing monomer and catalyst system into a reactor, obtaining a reactor effluent containing macromonomer, removing unused monomer and/or other volatiles, optionally removing (such as flashing off) solvent, obtaining macromonomer (such as those described herein) essentially free of residual monomer, introducing macromonomer and catalyst system into a reaction zone (such as a reactor, an extruder, a pipe and/or a pump) and obtaining polymacromonomer (such as those described herein).

This invention also relates to a two stage process to obtain polymacromonomer comprising contacting olefin monomer with a catalyst system, obtaining macromonomer and thereafter contacting the macromonomer with a catalyst system and thereafter obtaining polymacromonomer.

In a preferred embodiment, the temperature of the polymerization may be from 60 to 150°C, preferably 70 to 140°C, preferably 80 to 130°C.

In a preferred embodiment, the reaction time of the polymerization is from 1 minute to 9 hours, preferably 10 min to 3 hours, preferably 20 min to 2 hours, preferably 30 to 90 min, alternately 5 min to 3 hours, alternately 10 min to 2 hours, alternately 15 min to 90 min.

In a preferred embodiment the reactor contains less than 90wt% diluent or solvent, preferably less than 85wt%, preferably less than 80wt%, based upon the weight of the solvent and monomers entering the reactor.

In a preferred embodiment the weight ratio of macromonomer to catalyst compound (including activator) entering the reactor is 10:1 to 20,000:1, preferably 100:1 to 15000:1, preferably 500:1 to 10000:1, preferably 50:1 to 15000:1, preferably 100:1 to 10000:1.

In a preferred embodiment, the comonomer contains only, or consists essentially of or consists of, C₂ to C₁₈ (alternately C₂ to C₁₂) linear alpha olefin monomer units (preferably ethylene, propylene, butene, octene, decene, or dodecene, preferably ethylene and propylene). In another embodiment the

comonomer does not comprise any styrenic monomer. In another embodiment the comonomer does not comprise any cyclic monomer. In another embodiment the macromonomer does not comprise any aromatic containing monomer (also called aromatic monomer units). In another embodiment the comonomer comprises 1wt% or less of a styrenic monomer, a cyclic monomer or an aromatic containing monomer, preferably less than 0.5wt%, preferably 0wt%, based upon the weight of the comonomer entering the reaction zone.

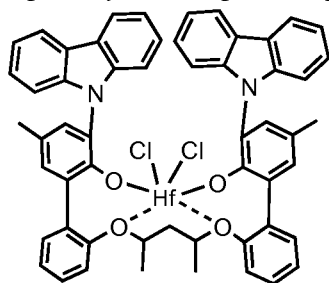
In a preferred embodiment the polymacromonomer comprises at least 15wt% propylene, alternately at least 20% propylene, alternately at least 50% propylene, alternately 100wt% propylene (with the balance being made up of one or more of ethylene and/or C₄ to C₁₂ olefin monomers (preferably linear alpha olefin monomers, preferably ethylene, butene, hexene, and octene).

In a preferred embodiment the polymacromonomer comprises at least 70wt% ethylene, alternately at least 80% ethylene, alternately at least 90% ethylene, alternately 100wt% ethylene (with the balance being made up of one or more of C₃ to C₁₂ olefin monomers (preferably linear alpha olefin monomers, preferably propylene, butene, hexene, and octene).

In another embodiment the macromonomer can be copolymerized with an alpha-omega diene, such as 1,5-hexadiene, 1,7-octadiene, or a cyclic diene such as norbornadiene or cyclopentadiene.

In a preferred embodiment, the polymacromonomers can be produced using one or more activators (including all activators described above) in combination with one or more catalyst compounds capable of polymerizing vinyl terminated macromonomers. A catalyst compound or catalyst system is determined to be capable of polymerizing vinyl terminated macromonomers by taking the catalyst compound (plus an activator) or the catalyst system in question and combining it with 1-octene at the reactor conditions in question (such as 80°C). If the catalyst compound or catalyst system can polymerize 1-octene to a number average molecular weight of 1000 or more, then the catalyst system can perform in the instant invention.

Catalysts useful to polymerize the macromonomers include those described in US 7,126,031, especially the compound represented by the formula:



Other useful catalysts include dimethylsilyl (cyclopentadienyl) (cyclododecylamido) titanium dimethyl, dibenzylmethyl(cyclopentadienyl)(fluorenyl)hafnium dimethyl, dimethylgermanium bisindenyl hafnium dimethyl, diphenylmethyl(cyclopentadienyl)(fluorenyl)hafnium dimethyl.

Further useful catalysts include the racemic versions of: dimethylsilyl (2-methyl-4-phenylindenyl) zirconium dichloride, dimethylsilyl (2-methyl-4-phenylindenyl) zirconium dimethyl,

dimethylsilyl (2-methyl-4-phenylindenyl) hafnium dichloride, dimethylsilyl (2-methyl-4-phenylindenyl) hafnium dimethyl, dimethylsilyl bis(indenyl)hafnium dimethyl, dimethylsilyl bis(indenyl)hafnium dichloride, dimethylsilyl bis(indenyl)zirconium dimethyl, dimethylsilyl bis(indenyl)zirconium dichloride.

Further useful catalysts include the racemic isomers of: dimethylsilanediylbis(2-methylindenyl)metal dichloride; dimethylsilanediylbis(indenyl)metal dichloride; dimethylsilanediylbis(indenyl)metal dimethyl; dimethylsilanediylbis(tetrahydroindenyl)metal dichloride; dimethylsilanediylbis(tetrahydroindenyl)metal dimethyl; dimethylsilanediylbis(indenyl)metal diethyl; and dibenzylsilanediylbis(indenyl)metal dimethyl; wherein the metal is chosen from Zr, Hf, or Ti.

Preferred activators for use with the above catalyst compounds include: dimethylaniliniumtetrakis(pentafluorophenyl) borate, N,N-dimethylanilinium tetra(perfluorophenyl)borate, triphenylcarbonium perfluorotetraphenylborate, dimethylanilinium perfluorotetranaphthylborate, 4-tert-butylanilinium bis(pentafluorophenyl)bis(perfluoro-2-naphthyl)borate, 4-tert-butylanilinium (pentafluorophenyl)tris(perfluoro-2-naphthyl)borate, dimethylanilinium tetrakis(perfluoro-2-naphthyl)borate, dimethylanilinium tetrakis(3,5 (pentafluorophenyl)perfluorophenyl)borate); and tris-perfluorophenyl boron.

Additional activators useful in combination with the catalyst compounds described above to make the polymacromonomers include those described above for use in making the macromonomers. Likewise the processes for producing the polymacromonomers may generally be used to produce the polymacromonomers.

Polymacromonomer

In a preferred embodiment, the degree of polymerization for the polymacromonomer is 3 or more, alternately 5 or more, alternately 6 or more, alternately 10 or more, alternately 100 or more, alternately 150 or more, alternately 200 or more.

In another embodiment, at least 70% of the macromonomer is consumed in the polymerization, preferably at least 75%, preferably at least 80%, preferably at least 85%, preferably at least 90%, preferably at least 95%, preferably at least 98%, as determined by ¹H NMR described in the Experimental section below.

In a preferred embodiment, the polymacromonomer has:

a) a g value of less than 0.5 (preferably less than 0.4, preferably less than 0.3, preferably less than 0.25),

b) an Mw of greater than 20,000 g/mol (preferably 30,000 to 1,000,000, preferably 40,000 to 700,000),

c) an Mn of greater than 8,000 g/mol (preferably 15,000 to 400,000, preferably 30,000 to 200,000),

d) a branching index (g'_{vis}) of less than 0.5 (preferably less than 0.4, preferably less than 0.3, preferably less than 0.2, preferably less than 0.1, preferably less than 0.05), and

e) a melting point of 50°C or more, preferably 60°C or more, preferably 70°C or more, preferably 80°C or more, preferably 90°C or more, preferably 100°C or more, preferably 120°C or more, preferably

from 50 to 200°C, or alternately an Hm of 20 J/g or less, preferably 15 J/g or less.

In another embodiment, the polymacromonomer contains less than 1000 ppm of a group 4 metal (preferably less than 750 ppm or Ti, Hf and/or Zr, preferably less than 500 ppm). Alternately, the polymacromonomer contains less than 1000 ppm of lithium (preferably less than 750 ppm of lithium, preferably less than 500 ppm of lithium).

In a preferred embodiment, the polymacromonomer comprises less than 3wt% of functional groups selected from hydroxide, aryls and substituted aryls, halogens, alkoxys, carboxylates, esters, acrylates, oxygen, nitrogen, and carboxyl, preferably less than 2wt%, more preferably less than 1wt%, more preferably less than 0.5wt%, more preferably less than 0.1wt%, more preferably 0wt%, based upon the weight of the polymacromonomer.

In another preferred embodiment, the polymacromonomer is amorphous, isotactic or syndiotactic, preferably isotactic. In another embodiment, the polymacromonomer is a propylene homopolymer or propylene homo-oligomer that may be amorphous, isotactic or syndiotactic, preferably isotactic. In another embodiment, the polymacromonomer is a propylene copolymer or propylene co-oligomer that may be amorphous, isotactic or syndiotactic, preferably isotactic.

In another embodiment the macromonomer comprises less than 30wt% amorphous material, preferably less than 20wt%, preferably less than 10wt%, preferably less than 5wt%.

In another embodiment, any polymacromonomer described herein may have a heat of fusion of 60 J/g or more, preferably 70 J/g or more, preferably 90 J/g or more, preferably 120 J/g or more, preferably 160 J/g or more or 15 J/g or less. In a preferred embodiment, the polymacromonomer comprises two or more different macromonomers, preferably three or more different macromonomers, preferably four or more different macromonomers. By different macromonomers is meant that the macromonomers differ in composition (such as monomer content or comonomer distribution within the macromonomer) or molecular weight. For example, in an embodiment, the polymacromonomer can comprise a propylene macromonomer and an ethylene macromonomer, or a propylene macromonomer and an ethylene-propylene macromonomer, or an ethylene macromonomer and an propylene-ethylene macromonomer. In a particularly preferred embodiment, the entire spectrum from 100% polyethylene macromonomer to 100% polypropylene macromonomer with propylene rich and ethylene rich variations in between is available, including amorphous and crystalline variations. Table 1 below sets out some particularly preferred combinations of macromonomers, where Vinyl-PE is a ethylene macromonomer, preferably having crystalline structure (e.g. a Tm of 60°C or more) and 0 to 10wt% comonomer, and any of the properties described above, Vinyl-aPP is a propylene macromonomer with an amorphous content of at least 10% (preferably at least 50%, preferably at least 95%) and preferably having from 0 to 10wt% comonomer, Vinyl iPP is a propylene macromonomer with an isotactic pentad content of at least 50% and preferably having from 0 to 10wt% comonomer and/or a melting point of at least 70°C and preferably having from 0 to 10wt% comonomer, Vinyl-EP is an ethylene-propylene macromonomer having 10 to 50wt% propylene and 90 to 50wt% ethylene. Vinyl-PS is a styrene macromonomer, having from 0 to 50wt% comonomer. Vinyl-pe is a is an propylene-ethylene macromonomer having 10 to

50wt% ethylene and 90 to 50wt% propylene. Where the macromonomers have the same name in the table, please consider that they differ in another means, such as molecular weight or crystallinity.

Macromonomer	Vinyl-PE	Vinyl-aPP	Vinyl-iPP	Vinyl-EP	Vinyl-PS	Vinyl-pe
Vinyl-PE	X	X	X	X	X	X
Vinyl-aPP	X	X	X	X	X	X
Vinyl-iPP	X	X	X	X	X	X
Vinyl-EP	X	X	X	X	X	X
Vinyl-PS	X	X	X	X	X	X
Vinyl -pe	X	X	X	X	X	X

In a preferred embodiment, the polymacromonomer comprises at least two macromonomers where the first macromonomer comprises 60wt% or more of ethylene and the second macromonomer comprises 60wt% or more of propylene.

In another embodiment, a termacromonomer is present to produce a polymacromonomer having three different macromonomers, such as Vinyl-aPP+Vinyl-PE+vinyl-EP.

Alternately, the polymacromonomer can comprise macromonomers that differ in molecular weight (Mw) by at least 200 g/mol, alternately by at least 300 g/mol, alternately by at least 1000 g/mol, alternately by at least 3000 g/mol, alternately by at least 5000 g/mol. In another embodiment, at least 50wt% (preferably at least 60wt%, preferably at least 70wt%, preferably at least 80wt%) of the monomers in the macromonomers differ by in molecular weight (Mw) by at least 200 g/mol, alternately by at least 300 g/mol, alternately by at least 1000 g/mol, alternately by at least 3000 g/mol, alternately by at least 5000 g/mol.

Alternately, the polymacromonomer can comprise macromonomers that differ in monomer content where the monomers differ by at least one carbon, alternately by at least 2 carbons, alternately by at least 4 carbons, alternately by at least 6 carbons. In another embodiment, at least 50wt% (preferably at least 60wt%, preferably at least 70wt%, preferably at least 80wt%) of the monomers in the macromonomers differ by at least one carbon, alternately by at least 2 carbons, alternately by at least 4 carbons, alternately by at least 6 carbons.

Alternately, the polymacromonomer can comprise macromonomers that differ in total comonomer content by at least 2wt%, preferably by at least 5wt%, preferably by at least 10wt%, preferably by at least 15wt%, preferably by at least 20wt%.

In another embodiment, the polymacromonomer comprises at least two different macromonomers where one macromonomer has a Tm of 60°C or more (preferably 70°C or more, preferably 80°C or more, preferably 90°C or more, preferably 100°C or more, preferably 110°C or more, preferably 120°C or more, preferably 130°C or more) and the second monomer has an Hm of 20 J/g or less, preferably 15 J/g or less. Preferably both monomers also have: 1) from 20 to 600 carbon atoms; 2) an Mn of 280 g/mol or more; 3) an Mw of 400 g/mol or more; 4) an Mz of 600 g/mol or more; 5) an Mw/Mn of 1.5 or more; 6) at least 70% vinyl termination (relative to total unsaturation); and 7) less than

5wt% aromatic containing monomer. Preferably the first and second macromonomers are ethylene based (preferably each macromonomer comprises at least 50wt% ethylene, preferably at least 60wt%).

In additional embodiments, one could manipulate the polymerization conditions such that blocks of macromonomers can be made (e.g. pulsing in different macromonomers at certain time intervals). For example, propylene macromonomers could be polymerized then a large amount of ethylene macromonomer could be polymerized to create a diblock polymacromonomer, or a mixture of polymacromonomers could be made.

In another embodiment this invention relates to:

1. A polymacromonomer comprising at least one macromonomer and from 0 to 20wt% of a C₂ to C₁₈ comonomer, wherein the macromonomer has:

- 1) from 20 to 800 carbon atoms,
- 2) an Mn of 280 g/mol or more,
- 3) an Mw of 400 g/mol or more,
- 4) an Mz of 600 g/mol or more,
- 5) an Mw/Mn of 1.5 or more,
- 6) vinyl termination of at least 70% (as determined by ¹H NMR) relative to total unsaturations,
- 7) a melting point (Tm) of 60°C or more or an Hm of 20 J/g or less, and
- 8) less than 10wt% aromatic containing monomer, based upon the weight of the macromonomer;

and

wherein the polymacromonomer has:

- a) a g value of less than 0.6,
- b) an Mw of greater than 30,000 g/mol,
- c) an Mn of greater than 20,000 g/mol,
- d) a branching index (g')_{vis} of less than 0.5,
- e) a melting point of 50°C or more or an Hm of 20 J/g or less,
- f) less than 25% vinyl terminations (as measured by ¹H NMR) relative to total unsaturations,
- g) at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and
- h) from 0 to 20wt% aromatic containing monomer, based upon the weight of the polymacromonomer.

2. The polymacromonomer of paragraph 1 wherein the polymacromonomer contains 0wt% aromatic containing monomer.

3. The polymacromonomer of paragraph 1 or 2 wherein the polymacromonomer contains 0wt% styrenic monomer.

4. The polymacromonomer of paragraph 1, 2 or 3 wherein the macromonomer is isotactic.

5. The polymacromonomer of paragraph 1, 2, 3, or 4 wherein the polymacromonomer comprises at least 70wt% macromonomer comprising at least 50wt% propylene.

6. The polymacromonomer of claim 1, 2, 3, 4, or 5 wherein the polymacromonomer comprises at least 70wt% macromonomer comprising at least 50wt% ethylene.

7. The polymacromonomer of any of paragraphs 1 to 6 wherein the polymacromonomer comprises two or more different macromonomers.
8. The polymacromonomer of paragraph 7 wherein the macromonomers differ in molecular weight (Mw) by at least 200 g/mol.
- 5 9. The polymacromonomer of paragraph 7 or 8 wherein the first macromonomer has a melting point of 60°C or more and the second macromonomer has an Hm of 20 J/g or less.
10. The polymacromonomer of any of paragraphs 1 to 10 wherein the macromonomer comprises a propylene polymer having a g'_{vis} of 0.95 or less.
11. The polymacromonomer of any of paragraphs 1 to 11 wherein the macromonomer comprises a
10 copolymer of 65 to 80wt% ethylene and 20 to 35wt% propylene (based upon the weight of the copolymer) and has a Hm of 15 J/g or less.
12. A polymacromonomer comprising at least one macromonomer and from 0 to 20wt% of a C₂ to C₁₈ comonomer, wherein the polymacromonomer has:
- a) a g value of less than 0.6,
- 15 b) an Mw of greater than 30,000 g/mol,
- c) an Mn of greater than 20,000 g/mol,
- d) a branching index $(g')_{vis}$ of less than 0.5,
- e) less than 25% vinyl terminations (as measured by ¹H NMR) relative to total unsaturations,
- f) at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and
- 20 g) from 0 to 20wt% aromatic containing monomer, based upon the weight of the polymacromonomer; and the macromonomer comprises one or more of:
- i) propylene co-oligomer having an Mn of 300 to 30,000 g/mol comprising 10 to 90 mol% propylene and 10 to 90 mol% of ethylene, wherein the oligomer has at least X% allyl chain ends (relative to total unsaturations), where: 1) $X = (-0.94 (\text{mol\% ethylene incorporated}) + 100)$, when 10 to 60 mol%
25 ethylene is present in the co-oligomer, and 2) $X = 45$, when greater than 60 and less than 70 mol% ethylene is present in the co-oligomer, and 3) $X = (1.83 * (\text{mol\% ethylene incorporated}) - 83)$, when 70 to 90 mol% ethylene is present in the co-oligomer; and/or
- ii) propylene oligomer, comprising more than 90 mol% propylene and less than 10 mol% ethylene, wherein the oligomer has: at least 93% allyl chain ends, an Mn of about 500 to about 20,000
30 g/mol, an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0, and less than 1400 ppm aluminum; and/or
- iii) propylene oligomer, comprising at least 50 mol% propylene and from 10 to 50 mol% ethylene, wherein the oligomer has: at least 90% allyl chain ends, Mn of about 150 to about 10,000 g/mol, and an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.3:1.0, wherein monomers
35 having four or more carbon atoms are present at from 0 to 3 mol%; and/or
- iv) propylene oligomer, comprising at least 50 mol% propylene, from 0.1 to 45 mol% ethylene, and from 0.1 to 5 mol% C₄ to C₁₂ olefin, wherein the oligomer has: at least 87% allyl chain ends

(alternately at least 90%), an Mn of about 150 to about 10,000 g/mol, and an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0; and/or

v) propylene oligomer, comprising at least 50 mol% propylene, from 0.1 to 45wt% ethylene, and from 0.1 to 5 mol% diene, wherein the oligomer has: at least 90% allyl chain ends, an Mn of about 150 to about 10,000 g/mol, and an isobutyl chain end to allylic vinyl group ratio of 0.7:1 to 1.35:1.0; and/or

vi) a homooligomer, comprising propylene, wherein the oligomer has: at least 93% allyl chain ends, an Mn of about 500 to about 20,000 g/mol, an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.2:1.0, and less than 1400 ppm aluminum.

13. The polymacromonomer of paragraph 12 wherein the macromonomer is a propylene co-oligomer having an Mn of 300 to 30,000 g/mol comprising 10 to 90 mol% propylene and 10 to 90 mol% of ethylene, wherein the oligomer has at least X% allyl chain ends (relative to total unsaturations), where: 1) $X = (-0.94 (\text{mol\% ethylene incorporated}) + 100)$, when 10 to 60 mol% ethylene is present in the co-oligomer, and 2) $X = 45$, when greater than 60 and less than 70 mol% ethylene is present in the co-oligomer, and 3) $X = (1.83 * (\text{mol\% ethylene incorporated}) - 83)$, when 70 to 90 mol% ethylene is present in the co-oligomer;

14. The polymacromonomer of any of paragraphs 1 to 13 wherein the macromonomers are liquid at 25°C.

15. A process to produce the polymacromonomers of paragraphs 1 to 14 comprising contacting macromonomer and up to 40wt% of C₂ to C₁₈ comonomer with a catalyst system capable of polymerizing vinyl terminated macromonomer, wherein the macromonomer has:

- 1) from 20 to 800 carbon atoms,
- 2) an Mn of 280 g/mol or more,
- 3) an Mw of 400 g/mol or more,
- 4) an Mz of 600 g/mol or more,
- 5) an Mw/Mn of 1.5 or more,
- 6) at least 70% vinyl termination (as measured by ¹H NMR) relative to total unsaturations,
- 7) a melting point T_m of 60°C or more or an H_m of 20 J/g or less, and
- 8) less than 20wt% aromatic containing monomer;

under polymerization conditions of a temperature of 60 to 130°C and a reaction time of 1 to 90 minutes, wherein the molar ratio of all comonomer present in the reactor to all macromonomer present in the reactor is 3:1 or less and where conversion of macromonomer to polymacromonomer is 70wt% or more; and

obtaining a polymacromonomer having:

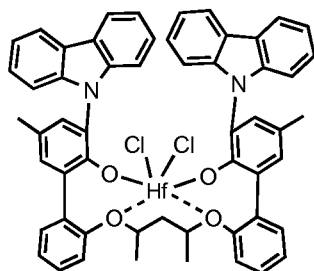
- a) a g value of less than 0.6,
- b) an Mw of greater than 30,000 g/mol,
- c) an Mn of greater than 20,000 g/mol,
- d) a branching index (g')_{vis} of less than 0.5, and
- e) a melting point of 50°C or more or an H_m of 20 J/g or less,

- f) less than 25% vinyl termination (as measured by ^1H NMR) relative to total unsaturations,
 g) at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and
 h) from 0 to 20wt% aromatic containing monomer, based upon the weight of the polymacromonomer.

16. The process of paragraph 15 wherein the degree of polymerization of the polymacromonomer is 6 or more.

17. The process of paragraph 15 wherein the degree of polymerization of the polymacromonomer is 100 or more.

18. The process of paragraph 15, 16, or 17 wherein the catalyst system capable of polymerizing vinyl terminated macromonomer comprises the compound represented by the formula:



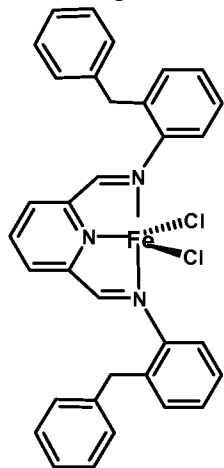
19. The process of paragraph 15, 16, 17, or 18 wherein the catalyst system capable of polymerizing vinyl terminated macromonomer comprise one or more of:

dimethylsilyl (cyclopentadienyl) (cyclododecylamido) titanium dimethyl,
 15 dibenzylmethyl(cyclopentadienyl)(fluorenyl)hafnium dimethyl,
 diphenylmethyl(cyclopentadienyl)(fluorenyl)hafnium dimethyl, dimethylgermanium bisindenyl hafnium
 dimethyl, rac-dimethylsilyl (2-methyl-4-phenylindenyl) zirconium dichloride, rac-dimethylsilyl (2-
 methyl-4-phenylindenyl) zirconium dimethyl, rac-dimethylsilyl (2-methyl-4-phenylindenyl) hafnium
 20 dichloride, rac-dimethylsilyl (2-methyl-4-phenylindenyl) hafnium dimethyl, rac-dimethylsilyl
 bis(indenyl)hafnium dimethyl, rac-dimethylsilyl bis(indenyl)hafnium dichloride, rac-dimethylsilyl
 bis(indenyl)zirconium dimethyl, rac-dimethylsilyl bis(indenyl)zirconium dichloride, ac-
 dimethylsilanediylbis(2-methylindenyl)metal dichloride; rac-dimethylsilanediylbis(indenyl)metal
 dichloride; rac-dimethylsilanediylbis(indenyl)metal dimethyl; rac-
 25 dimethylsilanediylbis(tetrahydroindenyl)metal dimethyl; rac-dimethylsilanediylbis(indenyl)metal diethyl;
 and rac-dibenzylsilanediylbis(indenyl)metal dimethyl; wherein the metal is chosen from Zr, Hf, or Ti.

20. The process of claim any of paragraphs 15 to 19 wherein the catalyst system capable of
 polymerizing vinyl terminated macromonomer comprises one or more of:
 dimethylaniliniumtetrakis(pentafluorophenyl) borate, N,N-dimethylanilinium
 30 tetra(perfluorophenyl)borate, triphenylcarbonium perfluorotetraphenylborate, dimethylanilinium
 perfluorotetranaphthylborate, 4-tert-butylanilinium bis(pentafluorophenyl)bis(perfluoro-2-naphthyl)borate,
 4-tert-butylanilinium (pentafluorophenyl)tris(perfluoro-2-naphthyl)borate, dimethylanilinium
 tetrakis(perfluoro-2-naphthyl)borate, dimethylanilinium tetrakis(3,5

(pentafluorophenyl)perfluorophenylborate); and tris-perfluorophenyl boron.

21. The process of any of paragraphs 15 to 20 further comprising preparing the macromonomer by contacting monomer with a catalyst system comprising activator and catalyst represented by the formula:



5 or $\text{rac-Me}_2\text{Si-bis(2-R-indenyl)MX}_2$ or $\text{rac-Me}_2\text{Si-bis(2-R,4-Ph-indenyl)MX}_2$, where R is an alkyl group, Ph is phenyl or substituted phenyl, M is Hf, Zr or Ti, and X is a halogen or alkyl group.

22. A process to produce polymacromonomers comprising contacting macromonomer and up to 40wt% of C_2 to C_{18} comonomer with a catalyst system capable of polymerizing vinyl terminated
10 macromonomer, wherein the macromonomer is produced by homogenous process for making the propylene co-oligomer of paragraph 12 or 13, said process having productivity of at least 4.5×10^3 g/mmol/hr, wherein the process comprises:

contacting, at a temperature of from 35°C to 150°C , propylene, 0.1 to 70 mol% ethylene and from 0 to about 5wt% hydrogen in the presence of a catalyst system comprising an activator and at least one
15 metallocene compound represented by the formula I, II, III, or IV above: where Hf is hafnium;

each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system);

20 each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms);

each R^1 is, independently, a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R^1 may the same or different as R^2 ;

25 each R^2 is, independently, a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, preferably R^1 and/or R^2 are not branched;

each R^3 is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that at

least three R^3 groups are not hydrogen (alternately four R^3 groups are not hydrogen, alternately five R^3 groups are not hydrogen);

each R^4 is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH_2SiR' , where R' is a C_1 to C_{12} hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl);

R^5 is hydrogen or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

R^6 is hydrogen or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

each R^7 is, independently, hydrogen, or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven R^7 groups are not hydrogen, alternately at least eight R^7 groups are not hydrogen, alternately all R^7 groups are not hydrogen, (preferably the R^7 groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen);

N is nitrogen;

T is a bridge, preferably, Si or Ge, preferably Si;

each R^a , is independently, hydrogen, halogen or a C_1 to C_{20} hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system;

and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.

23. A process to produce polymacromonomers comprising contacting macromonomer and up to 40wt% of C_2 to C_{18} comonomer with a catalyst system capable of polymerizing vinyl terminated macromonomer, wherein the macromonomer is produced by a homogenous process for making the propylene homo-oligomer of paragraph 12 or 13, said process having a productivity of at least 4.5×10^6 g/mol/min, wherein the process comprises:

contacting, at a temperature of from 30°C to 120°C, propylene, 0 mol% comonomer and from 0 to about 5wt% hydrogen in the presence of a catalyst system comprising an activator and at least one metallocene compound represented by the formula I, II, III, or IV above: where Hf is hafnium;

each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system);

each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms);

each R¹ is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R¹ may be the same or different as R²;

each R² is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, preferably R¹ and/or R² are not branched;

each R³ is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear

alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that: 1) all five R³ groups are methyl, or 2) four R³ groups are not hydrogen and at least one R³ group is a C₂ to C₈ substituted or unsubstituted hydrocarbyl (preferably at least two, three, four or five R³ groups are a C₂ to C₈ substituted or unsubstituted hydrocarbyl);

each R⁴ is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH₂SiR', where R' is a C₁ to C₁₂ hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl);

R⁵ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

R⁶ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

each R⁷ is, independently, hydrogen, or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven

R⁷ groups are not hydrogen, alternately at least eight R⁷ groups are not hydrogen, alternately all R⁷ groups are not hydrogen, (preferably the R⁷ groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen);

N is nitrogen;

T is a bridge, preferably, Si or Ge, preferably Si;

each R^a is, independently, hydrogen, halogen or a C₁ to C₂₀ hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system;

and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.

Experimental

All molecular weights are number average in g/mol unless otherwise noted.

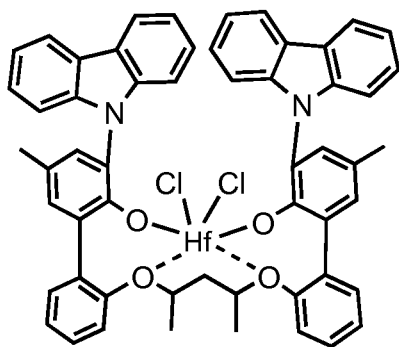
Materials

Catalyst 1 is 1,1'diphenylmethylene(cyclopentadienyl)(fluorenyl)hafnium dimethyl,

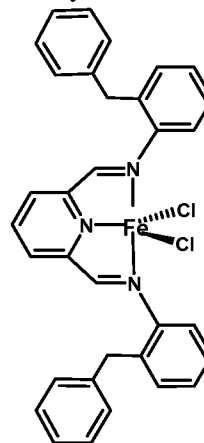
Catalyst 2 is *rac*-dimethylsilylbis(indenyl)hafnium dimethyl,

Catalyst 3 is *rac*-dimethylsilylbis(2-methyl 4-phenyl indenyl)hafnium dimethyl,

Catalyst 4 is:



Catalyst 5 is:



Catalyst 4 was prepared according to the procedures in US 7,126,031. Catalyst 5 was prepared and purified according to the procedure in G.J.P. Britovsek, V.C. Gibson, S.J. McTavish, G.A. Solan, B.S. Kimberley, P.J. Maddox, A.J.P. White, Williams, *Chem. Comm.* 1998, 849.

Activator A is N, N- dimethylanilinium tetra (perfluorophenyl)borate.

Activator B is methylalumoxane (30wt% in toluene) purchased from Albemarle.

Characterization

Gel Permeation Chromatography

M_w, M_z number of carbon atoms, g value and g'_{vis} are determined by using a High Temperature Size Exclusion Chromatograph (either from Waters Corporation or Polymer Laboratories), equipped with three in-line detectors, a differential refractive index detector (DRI), a light scattering (LS) detector, and a viscometer. Experimental details, including detector calibration, are described in: T. Sun, P. Brant, R. R. Chance, and W. W. Graessley, *Macromolecules*, Volume 34, Number 19, 6812-6820, (2001) and references therein. Three Polymer Laboratories PLgel 10mm Mixed-B LS columns are used. The nominal flow rate is 0.5 cm³/min, and the nominal injection volume is 300 μL. The various transfer lines, columns and differential refractometer (the DRI detector) are contained in an oven maintained at 145°C. Solvent for the experiment is prepared by dissolving 6 grams of butylated hydroxy toluene as an antioxidant in 4 liters of Aldrich reagent grade 1, 2, 4 trichlorobenzene (TCB). The TCB mixture is then filtered through a 0.7 μm glass pre-filter and subsequently through a 0.1 μm Teflon filter. The TCB is then degassed with an online degasser before entering the Size Exclusion Chromatograph. Polymer solutions are prepared by placing dry polymer in a glass container, adding the desired amount of TCB, then heating the mixture at 160°C with continuous agitation for about 2 hours. All quantities are measured gravimetrically. The TCB densities used to express the polymer concentration in mass/volume units are 1.463 g/ml at room temperature and 1.324 g/ml at 145°C. The injection concentration is from 0.75 to 2.0 mg/ml, with lower concentrations being used for higher molecular weight samples. Prior to running each sample the DRI detector and the injector are purged. Flow rate in the apparatus is then

increased to 0.5 ml/minute, and the DRI is allowed to stabilize for 8 to 9 hours before injecting the first sample. The LS laser is turned on 1 to 1.5 hours before running the samples. The concentration, c , at each point in the chromatogram is calculated from the baseline-subtracted DRI signal, I_{DRI} , using the following equation:

$$c = K_{DRI} I_{DRI} / (dn/dc)$$

where K_{DRI} is a constant determined by calibrating the DRI, and (dn/dc) is the refractive index increment for the system. The refractive index, $n = 1.500$ for TCB at 145°C and $\lambda = 690$ nm. For purposes of this invention and the claims thereto $(dn/dc) = 0.104$ for propylene polymers, 0.098 for butene polymers and 0.1 otherwise. Units on parameters throughout this description of the SEC method are such that concentration is expressed in g/cm^3 , molecular weight is expressed in g/mole , and intrinsic viscosity is expressed in dL/g .

The LS detector is a Wyatt Technology High Temperature mini-DAWN. The molecular weight, M , at each point in the chromatogram is determined by analyzing the LS output using the Zimm model for static light scattering (M.B. Huglin, LIGHT SCATTERING FROM POLYMER SOLUTIONS, Academic Press, 1971):

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

Here, $\Delta R(\theta)$ is the measured excess Rayleigh scattering intensity at scattering angle θ , c is the polymer concentration determined from the DRI analysis, A_2 is the second virial coefficient [for purposes of this invention, $A_2 = 0.0006$ for propylene polymers, 0.0015 for butene polymers and 0.001 otherwise], $(dn/dc) = 0.104$ for propylene polymers, 0.098 for butene polymers and 0.1 otherwise, $P(\theta)$ 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 $\lambda = 690$ nm.

A high temperature 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 following equation:

$$\eta_s = c[\eta] + 0.3(c[\eta])^2$$

where c is concentration and was determined from the DRI output.

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

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

where the summations are over the chromatographic slices, i , between the integration limits. The branching index g'_{vis} is defined as:

$$g'_{\text{vis}} = \frac{[\eta]_{\text{avg}}}{kM_v^\alpha}$$

5 where, for purpose of this invention and claims thereto, $\alpha = 0.695$ and $k = 0.000579$ for linear ethylene polymers, $\alpha = 0.705$ $k = 0.000262$ for linear propylene polymers, and $\alpha = 0.695$ and $k = 0.000181$ for linear butene polymers. M_v is the viscosity-average molecular weight based on molecular weights determined by LS analysis.

10 "g" also called a "g value" is defined to be $Rg_{\text{pm}}^2/Rg_{\text{ls}}^2$, where Rg_{pm} is the radius of gyration for the polymacromonomer, Rg_{ls} is the radius of gyration for the linear standard, and $Rg_{\text{ls}} = K_s M^{0.58}$ where K_s is the power law coefficient (0.023 for linear polyethylene, 0.0171 for linear polypropylene, and 0.0145 for linear polybutene), and M is the molecular weight as described above, $Rg_{\text{pm}} = K_T M^{\alpha_s}$. α_s is the size coefficient for the polymacromonomer, K_T is the power law coefficient for the polymacromonomer. See Macromolecules, 2001, 34, 6812-6820, for guidance on selecting a linear
15 standards having the molecular weight and comonomer content, and determining K coefficients and α exponents.

¹³C NMR

¹³C NMR data was collected at 120°C in a 10 mm probe using a Varian spectrometer with a ¹Hydrogen frequency of at least 400 MHz. A 90 degree pulse, an acquisition time adjusted to give a
20 digital resolution between 0.1 and 0.12 Hz, at least a 10 second pulse acquisition delay time with continuous broadband proton decoupling using swept square wave modulation without gating was employed during the entire acquisition period. The spectra were acquired using time averaging to provide a signal to noise level adequate to measure the signals of interest. Samples were dissolved in tetrachloroethane-d₂ at concentrations between 10 to 15wt% prior to being inserted into the spectrometer
25 magnet. Prior to data analysis spectra were referenced by setting the chemical shift of the (-CH₂)_n signal where $n > 6$ to 29.9 ppm. Chain ends for quantization were identified using the signals shown in the table below. N-butyl and n-propyl were not reported due to their low abundance (less than 5%) relative to the chain ends shown in the table below.

Chain End	¹³ CNMR Chemical Shift
P~i-Bu	23.5 to 25.5 and 25.8 to 26.3 ppm
E~i-Bu	39.5 to 40.2 ppm
P~Vinyl	41.5 to 43 ppm
E~Vinyl	33.9 to 34.4 ppm

30 Polypropylene microstructure is determined by ¹³C-NMR spectroscopy, including the concentration of isotactic and syndiotactic diads ([m] and [r]), triads ([mm] and [rr]), and pentads ([mmmm] and [rrrr]). The designation "m" or "r" describes the stereochemistry of pairs of contiguous

5 CONFIGURATION (Academic Press, New York 1969) and J. Randall in POLYMER SEQUENCE DETERMINATION, ¹³C-NMR METHOD (Academic Press, New York, 1977).

10 polymer is generally described as isotactic.

15 propylene triads in the copolymer:

$$\text{mm Fraction} = \frac{\text{PPP(mm)}}{\text{PPP(mm)} + \text{PPP(mr)} + \text{PPP(rr)}}$$

projection diagrams:



line 67). For further information on how the mm triad tacticity can be determined from a ^{13}C -NMR spectrum, see 1) J. A. Ewen, CATALYTIC POLYMERIZATION OF OLEFINS: PROCEEDINGS OF THE INTERNATIONAL SYMPOSIUM ON FUTURE ASPECTS OF OLEFIN POLYMERIZATION, T. Keii and K. Soga, Eds. (Elsevier, 1986), pp. 271-292; and 2) U.S. Patent Application US2004/054086 (paragraphs [0043] to [0054]).

¹H NMR

¹H NMR data was collected at either room temperature or 120°C (for purposes of the claims, 120°C shall be used) in a 5 mm probe using a Varian spectrometer with a ¹Hydrogen frequency of at least 400 MHz. Data was recorded using a maximum pulse width of 45°, 8 seconds between pulses and signal averaging 120 transients. Spectral signals were integrated and the number of unsaturation types per 1000 carbons was calculated by multiplying the different groups by 1000 and dividing the result by the total number of carbons.

The ¹HNMR chemical shift regions for the olefin types are defined to be between the following spectral regions.

<u>Unsaturation Type</u>	<u>Region (ppm)</u>	<u>Number of hydrogens per structure</u>
Vinyl	4.95-5.10	2
Vinylidene	4.70-4.84	2
Vinylene	5.31-5.55	2
Trisubstituted	5.11-5.30	1

Differential Scanning Calorimetry (DSC)

Crystallization temperature (T_c), melting temperature (or melting point, T_m), glass transition temperature (T_g) and heat of fusion (H_f) are measured using Differential Scanning Calorimetry (DSC) on a commercially available instrument (e.g., TA Instruments 2920 DSC). Typically, 6 to 10 mg of molded polymer or plasticized polymer are sealed in an aluminum pan and loaded into the instrument at room temperature. Data are acquired by heating the sample to at least 30°C above its melting temperature, typically 220°C for polypropylene, at a heating rate of 10°C/min. The sample is held for at least 5 minutes at this temperature to destroy its thermal history. Then the sample is cooled from the melt to at least 50°C below the crystallization temperature, typically -100°C for polypropylene, at a cooling rate of 20°C/min. The sample is held at this temperature for at least 5 minutes, and finally heated at 10°C/min to acquire additional melting data (second heat). The endothermic melting transition (first and second heat) and exothermic crystallization transition are analyzed according to standard procedures. The melting temperatures (T_m) reported are the peak melting temperatures from the second heat unless otherwise specified. For polymers displaying multiple peaks, the melting temperature is defined to be the peak melting temperature from the melting trace associated with the largest endothermic calorimetric response (as opposed to the peak occurring at the highest temperature). Likewise, the crystallization temperature is defined to be the peak crystallization temperature from the crystallization trace associated with the largest exothermic calorimetric response (as opposed to the peak occurring at the highest temperature).

Areas under the DSC curve are used to determine the heat of transition (heat of fusion, H_f , upon melting or heat of crystallization, H_c , upon crystallization), which can be used to calculate the degree of crystallinity (also called the percent crystallinity). The percent crystallinity (X%) is calculated using the formula: [area under the curve (in J/g) / H° (in J/g)] * 100, where H° is the ideal heat of fusion for a perfect crystal of the homopolymer of the major monomer component. These values for H° are to be obtained from the *Polymer Handbook, Fourth Edition*, published by John Wiley and Sons, New York

1999, except that a value of 290 J/g is used for H°(polyethylene), a value of 140 J/g is used for H°(polybutene), and a value of 207 J/g is used for H°(polypropylene).

Heat of melting (Hm) is determined using the DSC procedure above except that the sample is cooled to -100°C, held for 5 minutes then heated at 10°C/min to 200°C. Hm is measured on the first melt, not the second melt. The Hm sample must have been aged at least 48 hours at room temperature and should not be heated to destroy thermal history.

Ethylene content

Ethylene content in ethylene copolymers is determined by ASTM D 5017-96, except that the minimum signal-to-noise should be 10,000:1. Propylene content in propylene copolymers is determined by following the approach of Method 1 in Di Martino and Kelchermans, *J. Appl. Polym. Sci.* **56**, 1781 (1995), and using peak assignments from Zhang, *Polymer* **45**, 2651 (2004) for higher olefin comonomers.

Example 1

Three vinyl-PE-Macromonomers were prepared using Catalyst 5 and Activator B. Catalyst solutions were prepared in a nitrogen purged Vacuum Atmospheres dry box by adding nearly equimolar (1.00:1.05) quantities of the iron complex and activator to 4 mL dry toluene in a 10 mL glass vial. The mixture was stirred for 5 min. and then transferred to a clean, oven dried catalyst tube. The basic polymerization procedure for synthesis of vinyl PE_{mac}-1 is as follows: 2 mL 25wt% Tri n-octylaluminum-in-hexanes scavenger and 400 mL hexanes were added to a 2L stainless steel autoclave reactor. The reactor was heated to 100°C. During this time the catalyst tube was attached to the reactor. Once the reactor temperature equilibrated at 100°C, the catalyst solution was flushed from the catalyst tube into the reactor with 300 mL hexanes. Following this addition, the reactor was pressurized with 200 psig ethylene. In this example, polymerization was carried out for 12 minutes, after which time the reactor was cooled and depressurized. Once the reactor was depressurized, yet maintained under positive pressure via a gentle dry nitrogen flush, this polyethylene macromonomer product was cannulated into septum sealed vials using a slight nitrogen gas overpressure. The charged vials were transferred into the purged Vacuum Atmospheres dry box. PE_{mac}-2 and PE_{mac}-3 were produced following the same polymerization process, unless noted otherwise. Table A lists polymerization conditions used for preparing the macromonomers.

Table A.

Syntheses of Vinyl-PE Macromonomers with Catalyst 5/Activator B

Sample	Time, min.	Temp, (°C)	Yield, g	Productivity, g/mmol/hr
PE _{mac} -1	12	100	25	155
PE _{mac} -2	30	80	45	1395
PE _{mac} -3	60	60	100	3100

The properties of these three macromonomers are listed in Table B.

Table B: Properties of Vinyl-PE Macromonomers

PE _{mac}	¹ H NMR		GPC-DRI, PE Std			DSC
	$\overline{M}_N$	% vinyl	$\overline{M}_N$	$\overline{M}_w$	$\overline{M}_z$	T _m , °C (ΔH, J/g)
PE _{mac} -1	536	93	240	434	751	76.6, (184)
PE _{mac} -2	1129	93	1019	4100	87,175	77.9, (128.8)
PE _{mac} -3	688	94	489 (862) ^a	3793 (3793) ^a	235,395 (241,617) ^a	120.5, (199.5)

^a Light scattering values from GPC-3D; g' = 1.00 (versus PE std), data in this table from second melt.

Example 2

Polymerizations with PE_{mac}'s were done inside a purged Vacuum Atmospheres dry box. The basic polymerization procedure follows: 2.0 g. of PE_{mac} was placed into an oven dried 10 mL glass vial along with a Teflon coated stir bar. The vial was then heated to 85°C (above the melting point of this PE_{mac}) on a hot plate. Once the PE_{mac} was molten, catalyst and activator were added. In several examples no further solvent was added. The contents of the vial are stirred for 1 hour on the hot plate and then cooled to ambient temperature. A summary of polymerizations carried out using the three PE_{mac}'s is provided in Table C.

Table C: Summary of PE_{brush} Syntheses Using PE_{mac}

Example	PE _{mac}	Catalyst	Act	Cat/Activator (mg) ^a	T _p , (C)	Time (min)	Condition
1	1	1	A	2 / 3	85	60	Neat
2	1	4/MAO	A	2 / 0.2 / 1.6	85	120	Neat
3		4MAO	A	2 / 1 / 2	110	60	Toluene
4	3 repeat	4/MAO	A	20 / 0.2 / 16.1	120	30	Neat
5	3	2	A	2 / 3.4	165	60	Neat
6	3	1	A	2 / 3.0	195	60	Neat
7	3	1	A	2 / 3.0	195	30	Neat
8	3	3	B	2 / 1	195	60	Toluene
9	3	3	B	2 / 1	115	60	Neat

^a Value in italics is volume of MAO in mL added in addition to Activator A.

Table D: ¹H NMR Unsaturation Analysis

	PE _{mac} -1	Example 2t
	<u>Olefinic Groups per 1000 Carbons</u>	
Vinyl	30.8	Not Detected
Vinylene	0.9	1.0
Vinylidene	Not Detected	Not Detected
Trisubstituted	Not Detected	Not Detected

A summary is provided in Table E of the ¹H NMR results recorded for the eight polymerizations with PE_{mac}'s. The percentage of total unsaturations that are vinyls has decreased from the ~95% range to between 0 (not detected) and 25%. Accounting for the impacts of residual vinyls as well as unreacted vinylenes, we can calculate number average molecular weights for the brush structures, and these are also tabulated below.

Table E: Summary ¹H NMR Results for Polymacromonomers (PE_{brush})

Example	(Unsat / 1000C)				% vinyls	DP*	M _N
	vinylenes	olefins	vinyls	vinylidenes			¹ H NMR*
1	0.91	0.20	0.04	0.36	2.7	340	9,524
2	1.03	0.07	0.00	0.00	0.00	456	12,727
3	0.60	0.17	0.26	0.01	25	641	17,949
53	1.48	1.15	0.03	0.09	1	184	5147
6	1.32	0.57	0.47	0.62	16	199	5577
7	1.49	0.65	0.64	0.80	18	170	4762
9	0.63	0.25	0.09	0.45	6	376	10526
8	1.48	1.15	0.03	0.09	1	184	5147

* Degree of Polymerization corrected for residual vinyl and vinylene contributions from unconsumed PE_{mac}

The ¹³C NMR spectrum recorded for Example 1 is shown, along with major peak assignments, in Figure 1. The peak resonance positions and assignments for Example 1 are organized in Table F. These assignments and intensities, within reasonable limitations, are consistent with the material being a product that has a branch on alternating carbons. Assignment nomenclature is described in Figure 3.

Table F

ppm *	Carbon Type**	Assignment	Integral Area***
41.04	CH ₂	αα	65
35.57	CH ₂	αδ ⁺	60
33.20	CH	Branch Point	60
32.22	CH ₂	3S	73
30.72	CH ₂	γδ ⁺	
29.98	CH ₂	δ ⁺ δ ⁺	1620
29.59	CH ₂	4S	
26.99	CH ₂	βδ ⁺	58
22.91	CH ₂	2S	81
14.24	CH ₃	1S	82

¹³C NMR Spectral Assignments for Example 2

* Shifts relative to backbone methylene signal set to 29.98 ppm in tetrachloroethane-d₂ at 120 C

** From DEPT experiment

*** Intensity from gated decoupling experiment (suppressed NOE)

Assignment Nomenclature:

Methylene carbons are identified by a pair of Greek letters or a number preceding a S. The Greek symbols are used to indicate the number of carbons a methylene is from a methine in either direction. A + sign is used when the closest methine is 4 more carbons away from the methylene of interest. The 'S' terminology identifies carbons at or near the end of saturated n-alkyl chains. The number specifies how many carbons a methylene is from the terminal -CH₃ with the 1S carbon defined as the terminal carbon. Figure 3 illustrates this particular naming convention.

Table G: GPC-3D Results for (PE_{mac})_x Brushes Made with PE_{mac}'s 1 and 3
¹H NMR brush Mol Wt Moments, DRI (Viscometry)

Example	M _N ^a	% vinyl	M _N	M _W	M _Z	g' _{vis}
1	9,524	~5	2,766 (29,525)	18,771 (55,732)	35,649 (101,875)	0.131
2	12,727	~0	4,802 (84,641)	56,259 (207,202)	139,819 (462,453)	0.122
11		40	1,371	12,624	24,466	----
3	17,949	25	6,715 (52,631)	41,019 (111,907)	86,999 (198,094)	0.187
10		50	3,325	18,227	80,842	----
5	5,147	1	3,177 (4420)	8,356 (10,600)	35,673 (46,288)	0.50
6	5,577	16	3,660 (6,149)	13,038 (13,689)	838,876 (103,392)	0.49
7	4,762	18	2,896 (6,691)	9,183 (11,491)	135,219 (63,784)	0.494
9	10,526	6	1,595 (7,937)	10,640 (13,762)	28,794 (26,460)	0.370

In Table G, (g')_{vis} is defined as $g' = [\eta_{\text{polymacromonomer}} / \eta_{\text{linear HDPE}}]$ (1). Values span the range from 0.122 to 0.50. These values reflect the relative chain mass per unit volume. Due to their topology, the brushes are much more compact than polyethylene, and the smallest value of (g')_{vis} is comparable to those measured for poly(decene-1) and poly(dodecene-1).

Further Macromonomers were synthesized in a continuous polymerizations in a 0.5 liter stainless steel continuous autoclave reactor equipped with a stirrer, steam heating/water cooling element and a pressure controller. Solvent, macromonomer and comonomer (if any) are typically first chilled to -15°C prior to entering a manifold, and then pumped into the reactor. The preactivated catalyst solution ((CpMe₅)((1,3-dimethyl Ind)Hf Me₂ and N, N- dimethylanilinium tetra (perfluorophenyl)borate, where Cp = cyclopentadienyl, Me = methyl, Ind = indenyl) is fed into the reactor from a dry box through metering pumps in a separate line. Solvent (such as hexanes) are pumped into the reactor at a desired rate to control the residence time. The reactor was first fed with solvent, and heated to the desired temperature and controlled at a set pressure. The monomers and catalyst were then pumped into the reactor. Catalyst feed rate was constant at 2.23×10^{-7} mol/min for all runs. The speed of the stirrer was high enough so the reactor was operated under continuous stirred tank reactor conditions. Polymer samples were collected for 20 minutes each in a collection box when the system reached steady state. Products were dried in a vacuum oven. Reactions were carried out at a pressure of 350 psig and in the temperature range of 70 to 90°C. A summary of the polymerizations and characterization data are provided in Tables H to L.

TABLE H: E-co-P Macromonomer Synthesis Conditions

Example Number	Reaction temp (°C)	Propylene feed rate (g/min)	Ethylene feed rate (SLPM)	Productivity (g poly/g catalyst)	Conversion (%)
H-1	60	5.09	3	1773	57.9
H-2	60	5.09	6	3887	93.8
H-3	60	5.09	9	4971	93.3
H-4	80	5.09	3	1639	55.4
H-5	80	5.09	6	2890	69.7
H-6	80	5.09	9	4802	90.1

Table I: Summary of Unsaturation in E-co-P Macromonomers Measured by ¹H NMR

Sample	Unsat/ 1000C				% vinyls	DP ^a	MN ^a
	vinylenes	olefins	vinyls	vinylidenes			
H-1	0.06	0.13	16.36	0.35	96.8	19.7	828
H-4	0.28	0.7	19.88	0.54	92.9	15.6	654

^a Calculated assuming one unsaturation per chainTable J: Ethylene Content in E-P Macromonomer Products by ¹H NMR

¹ H NMR		
Sample	Mol fraction C ₂ ⁼	Wt Fraction C ₂ ⁼
H-1	0.72	0.63
H-4	0.73	0.64

Table K: Molecular Weight Moments from GPC-DRI (LS) E-P Macromers

	Wt% C ₂ ^{=a}	MN	MW	MZ	MWD	g' _{vis}
H-1	63	465	1229	5069	2.65	0.678
H-4	64	374	1035	4227	2.77	0.516

^a calculated from ¹H NMR, g'_{vis} relative to HDPE standard.

Table L: Differential Scanning Calorimetry Data

Sample	Wt% C ₂ ⁼	Crystallinity, melting endotherm
H-1	63	Broad, sub-ambient peak
H-2	74	Weak peak 110C, broad peak ~50C
H-3	80	Weak peaks 110, 120C; broad peak ~ 68C
H-4	64	Broad, weak peak around 25C
H-5	78	Weak peak 112C; Broad peak ~58C
H-6	83	Weak peak ~111C; broad peak ~68C

E-co-P Macromonomer Polymerization Reactions

Macromonomer was added to a solution of catalyst and activator in toluene (1,1'diphenylmethylenecyclopentadienyl)(fluorenyl)hafnium dimethyl and N, N- dimethylanilinium tetra (perfluorophenyl)borate) All catalysts dissolved in toluene and simply added to the macromonomer at the designated polymerization temperature.

Table M: Polymerization with Macromers from Table H

Macromer	Catalyst		E-co-P Macromonomer		Temperature, C	Time, min
	prep	μM	wt, g	mM vinyls		
H-4		3.32	2.18 g	3.32	85	100
H-4		3.32	3.28 g	5.01	85	100
H-4		3.32	4.36 g	6.67	85	100

Table N: E-co-P Polymacromonomer Polymerization

NB#	Wt% C ₂ =	GPC		GPC	
	¹ H NMR	Mn	Mw	Mz	g'(vis)
H-4	64	70101	132006	216733	0.125
H-4	64	43164	83147	136449	0.132
H-4	64	85470	157365	253983	0.125

g'vis relative to linear standard EP copolymer having 64 wt% ethylene.

- 5 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 forms of the invention have been illustrated and described, various modifications can be made without departing from the spirit and scope of the invention. Accordingly, it is not intended that the invention be limited thereby. Likewise,
- 10 the term "comprising" is considered synonymous with the term "including" for purposes of Australian law.

CLAIMS

What is Claimed is:

1. A polymacromonomer comprising at least one macromonomer and from 0 to 20wt% of a C₂ to C₁₈ comonomer, wherein the macromonomer has:
 - 1) from 20 to 800 carbon atoms,
 - 2) an Mn of 280 g/mol or more,
 - 3) an Mw of 400 g/mol or more,
 - 4) an Mz of 600 g/mol or more,
 - 5) an Mw/Mn of 1.5 or more,
 - 6) vinyl termination of at least 70% (as determined by ¹H NMR) relative to total unsaturations,
 - 7) a melting point (Tm) of 60°C or more or an Hm of 20 J/g or less, and
 - 8) less than 10wt% aromatic containing monomer, based upon the weight of the macromonomer;
 and
- wherein the polymacromonomer has:
 - a) a g value of less than 0.6,
 - b) an Mw of greater than 30,000 g/mol,
 - c) an Mn of greater than 20,000 g/mol,
 - d) a branching index (g')_{vis} of less than 0.5,
 - e) a melting point of 50°C or more or an Hm of 20 J/g or less,
 - f) less than 25% vinyl terminations (as measured by ¹H NMR) relative to total unsaturations,
 - g) at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and
 - h) from 0 to 20wt% aromatic containing monomer, based upon the weight of the polymacromonomer.
2. The polymacromonomer of claim 1 wherein the polymacromonomer contains 0wt% aromatic containing monomer.
3. The polymacromonomer of claim 1 or 2 wherein the polymacromonomer contains 0wt% styrenic monomer.
4. The polymacromonomer of claim 1, 2 or 3 wherein the macromonomer is isotactic.
5. The polymacromonomer of claim 1, 2, 3, or 4 wherein the polymacromonomer comprises at least 70wt% macromonomer comprising at least 50wt% propylene.
6. The polymacromonomer of claim 1, 2, 3, 4, or 5 wherein the polymacromonomer comprises at least 70wt% macromonomer comprising at least 50wt% ethylene.
7. The polymacromonomer of any of claims 1 to 6 wherein the polymacromonomer comprises two or more different macromonomers.
8. The polymacromonomer of claim 7 wherein the macromonomers differ in molecular weight (Mw) by at least 200 g/mol.

9. The polymacromonomer of claim 7 or 8 wherein the first macromonomer has a melting point of 60°C or more and the second macromonomer has an Hm of 20 J/g or less.

10. The polymacromonomer of any of claims 1 to 10 wherein the macromonomer comprises a propylene polymer having a g'_{vis} of 0.95 or less.

5 11. The polymacromonomer of any of claims 1 to 11 wherein the macromonomer comprises a copolymer of 65 to 80wt% ethylene and 20 to 35wt% propylene (based upon the weight of the copolymer) and has a Hm of 15 J/g or less.

12. A polymacromonomer comprising at least one macromonomer and from 0 to 20wt% of a C₂ to C₁₈ comonomer, wherein the polymacromonomer has:

- 10 a) a g value of less than 0.6,
b) an Mw of greater than 30,000 g/mol,
c) an Mn of greater than 20,000 g/mol,
d) a branching index (g'_{vis}) of less than 0.5,
e) less than 25% vinyl terminations (as measured by ¹H NMR) relative to total unsaturations,
15 f) at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and
g) from 0 to 20wt% aromatic containing monomer, based upon the weight of the

polymacromonomer; and the macromonomer comprises one or more of:

i) propylene co-oligomer having an Mn of 300 to 30,000 g/mol comprising 10 to 90 mol% propylene and 10 to 90 mol% of ethylene, wherein the oligomer has at least X% allyl chain ends (relative
20 to total unsaturations), where: 1) $X = (-0.94 (\text{mol\% ethylene incorporated}) + 100)$, when 10 to 60 mol% ethylene is present in the co-oligomer, and 2) $X = 45$, when greater than 60 and less than 70 mol% ethylene is present in the co-oligomer, and 3) $X = (1.83 * (\text{mol\% ethylene incorporated}) - 83)$, when 70 to 90 mol% ethylene is present in the co-oligomer; and/or

ii) propylene oligomer, comprising more than 90 mol% propylene and less than 10 mol%
25 ethylene, wherein the oligomer has: at least 93% allyl chain ends, an Mn of about 500 to about 20,000 g/mol, an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.35:1.0, and less than 1400 ppm aluminum; and/or

iii) propylene oligomer, comprising at least 50 mol% propylene and from 10 to 50 mol% ethylene, wherein the oligomer has: at least 90% allyl chain ends, Mn of about 150 to about 10,000
30 g/mol, and an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.3:1.0, wherein monomers having four or more carbon atoms are present at from 0 to 3 mol%; and/or

iv) propylene oligomer, comprising at least 50 mol% propylene, from 0.1 to 45 mol% ethylene, and from 0.1 to 5 mol% C₄ to C₁₂ olefin, wherein the oligomer has: at least 87% allyl chain ends (alternately at least 90%), an Mn of about 150 to about 10,000 g/mol, and an isobutyl chain end to allylic
35 vinyl group ratio of 0.8:1 to 1.35:1.0; and/or

v) propylene oligomer, comprising at least 50 mol% propylene, from 0.1 to 45wt% ethylene, and from 0.1 to 5 mol% diene, wherein the oligomer has: at least 90% allyl chain ends, an Mn of about 150 to about 10,000 g/mol, and an isobutyl chain end to allylic vinyl group ratio of 0.7:1 to 1.35:1.0; and/or

vi) a homooligomer, comprising propylene, wherein the oligomer has: at least 93% allyl chain ends, an Mn of about 500 to about 20,000 g/mol, an isobutyl chain end to allylic vinyl group ratio of 0.8:1 to 1.2:1.0, and less than 1400 ppm aluminum.

13. The polymacromonomer of claim 12 wherein the macromonomer is a propylene co-oligomer having an Mn of 300 to 30,000 g/mol comprising 10 to 90 mol% propylene and 10 to 90 mol% of ethylene, wherein the oligomer has at least X% allyl chain ends (relative to total unsaturations), where: 1) $X = (-0.94 (\text{mol\% ethylene incorporated}) + 100)$, when 10 to 60 mol% ethylene is present in the co-oligomer, and 2) $X = 45$, when greater than 60 and less than 70 mol% ethylene is present in the co-oligomer, and 3) $X = (1.83 * (\text{mol\% ethylene incorporated}) - 83)$, when 70 to 90 mol% ethylene is present in the co-oligomer.

14. The polymacromonomer of any of claims 1 to 13 wherein the macromonomers are liquid at 25°C.

15. A process to produce the polymacromonomers of claims 1 to 14 comprising contacting macromonomer and up to 40wt% of C₂ to C₁₈ comonomer with a catalyst system capable of polymerizing vinyl terminated macromonomer, wherein the macromonomer has:

- 1) from 20 to 800 carbon atoms,
- 2) an Mn of 280 g/mol or more,
- 3) an Mw of 400 g/mol or more,
- 4) an Mz of 600 g/mol or more,
- 5) an Mw/Mn of 1.5 or more,
- 6) at least 70% vinyl termination (as measured by ¹H NMR) relative to total unsaturations,
- 7) a melting point T_m of 60°C or more or an H_m of 20 J/g or less, and
- 8) less than 20wt% aromatic containing monomer;

under polymerization conditions of a temperature of 60 to 130°C and a reaction time of 1 to 90 minutes, wherein the molar ratio of all comonomer present in the reactor to all macromonomer present in the reactor is 3:1 or less and where conversion of macromonomer to polymacromonomer is 70wt% or more; and

obtaining a polymacromonomer having:

- a) a g value of less than 0.6,
- b) an Mw of greater than 30,000 g/mol,
- c) an Mn of greater than 20,000 g/mol,
- d) a branching index (g')_{vis} of less than 0.5,
- e) a melting point of 50°C or more or an H_m of 20 J/g or less,

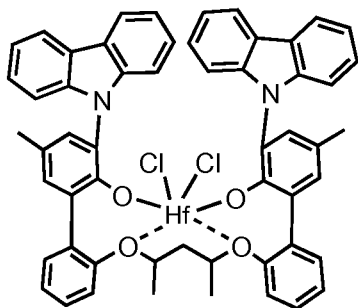
- f) less than 25% vinyl termination (as measured by ^1H NMR) relative to total unsaturations,
 g) at least 70wt% macromonomer, based upon the weight of the polymacromonomer, and
 h) from 0 to 20wt% aromatic containing monomer, based upon the weight of the

polymacromonomer.

5 16. The process of claim 15 wherein the degree of polymerization of the polymacromonomer is 6 or more.

17. The process of claim 15 wherein the degree of polymerization of the polymacromonomer is 100 or more.

18. The process of claim 15, 16, or 17 wherein the catalyst system capable of polymerizing vinyl
 10 terminated macromonomer comprises the compound represented by the formula:

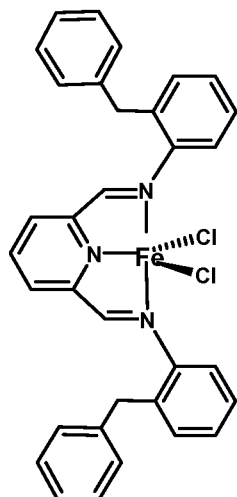


19. The process of claim 15, 16, 17, or 18 wherein the catalyst system capable of polymerizing vinyl terminated macromonomer comprise one or more of:

- dimethylsilyl (cyclopentadienyl) (cyclododecylamido) titanium dimethyl,
 15 dibenzylmethyl(cyclopentadienyl)(fluorenyl)hafnium dimethyl,
 diphenylmethyl(cyclopentadienyl)(fluorenyl)hafnium dimethyl, dimethylgermanium bisindenyl hafnium dimethyl, rac-dimethylsilyl (2-methyl-4-phenylindenyl) zirconium dichloride, rac-dimethylsilyl (2-methyl-4-phenylindenyl) zirconium dimethyl, rac-dimethylsilyl (2-methyl-4-phenylindenyl) hafnium dichloride, rac-dimethylsilyl (2-methyl-4-phenylindenyl) hafnium dimethyl, rac-dimethylsilyl
 20 bis(indenyl)hafnium dimethyl, rac-dimethylsilyl bis(indenyl)hafnium dichloride, rac-dimethylsilyl bis(indenyl)zirconium dimethyl, rac-dimethylsilyl bis(indenyl)zirconium dichloride, ac-dimethylsilanediylbis(2-methylindenyl)metal dichloride; rac-dimethylsilanediylbis(indenyl)metal dichloride; rac-dimethylsilanediylbis(indenyl)metal dimethyl; rac-dimethylsilanediylbis(tetrahydroindenyl)metal dichloride; rac-
 25 dimethylsilanediylbis(tetrahydroindenyl)metal dimethyl; rac-dimethylsilanediylbis(indenyl)metal diethyl; and rac-dibenzylsilanediylbis(indenyl)metal dimethyl; wherein the metal is chosen from Zr, Hf, or Ti.
 20. The process of any of claims 15 to 19 wherein the catalyst system capable of polymerizing vinyl terminated macromonomer comprises one or more of: dimethylaniliniumtetrakis(pentafluorophenyl) borate, N,N-dimethylanilinium tetra(perfluorophenyl)borate, triphenylcarbonium
 30 perfluorotetraphenylborate, dimethylanilinium perfluorotetranaphthylborate, 4-tert-butylnilinium bis(pentafluorophenyl)bis(perfluoro-2-naphthyl)borate, 4-tert-butylnilinium

(pentafluorophenyl)tris(perfluoro-2-naphthyl)borate, dimethylanilinium tetrakis(perfluoro-2-naphthyl)borate, dimethylanilinium tetrakis(3,5 (pentafluorophenyl)perfluorophenyl)borate); and tris-perfluorophenyl boron.

21. The process of any of claims 15 to 20 further comprising preparing the macromonomer by contacting monomer with a catalyst system comprising activator and catalyst represented by the formula:

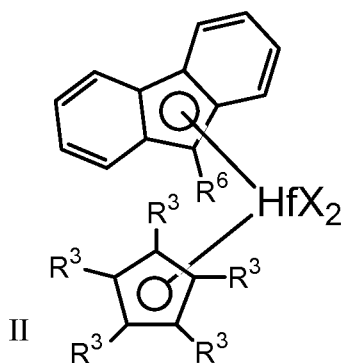
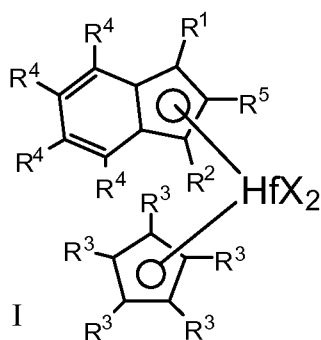


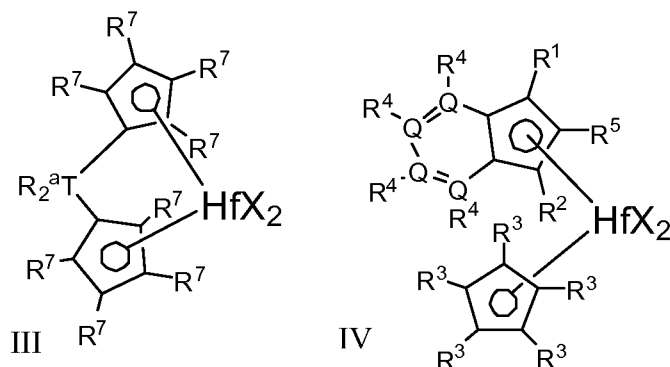
or $\text{rac-Me}_2\text{Si-bis(2-R-indenyl)MX}_2$ or $\text{rac-Me}_2\text{Si-bis(2-R,4-Ph-indenyl)MX}_2$,

where R is an alkyl group, Ph is phenyl or substituted phenyl, M is Hf, Zr or Ti, and X is a halogen or alkyl group.

22. A homogenous process for making the propylene co-oligomer of claim 12 or 13, said process having productivity of at least 4.5×10^3 g/gmol/hr, wherein the process comprises:

contacting, at a temperature of from 35°C to 150°C, propylene, 0.1 to 70 mol% ethylene and from 0 to about 5wt% hydrogen in the presence of a catalyst system comprising an activator and at least one metallocene compound represented by the formulae:





where

Hf is hafnium;

each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system);

each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's

are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms);

each R¹ is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R¹ may the same or different as R²;

each R² is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, preferably R¹ and/or R² are not branched;

each R³ is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that at least three R³ groups are not hydrogen (alternately four R³ groups are not hydrogen, alternately five R³ groups are not hydrogen);

each R⁴ is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH₂SiR', where R' is a C₁ to C₁₂ hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl);

R⁵ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

R⁶ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;

each R^7 is, independently, hydrogen, or a C_1 to C_8 alkyl group, preferably a C_1 to C_8 linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven R^7 groups are not hydrogen, alternately at least eight R^7 groups are not hydrogen, alternately all R^7 groups are not hydrogen, (preferably the R^7 groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen);

N is nitrogen;

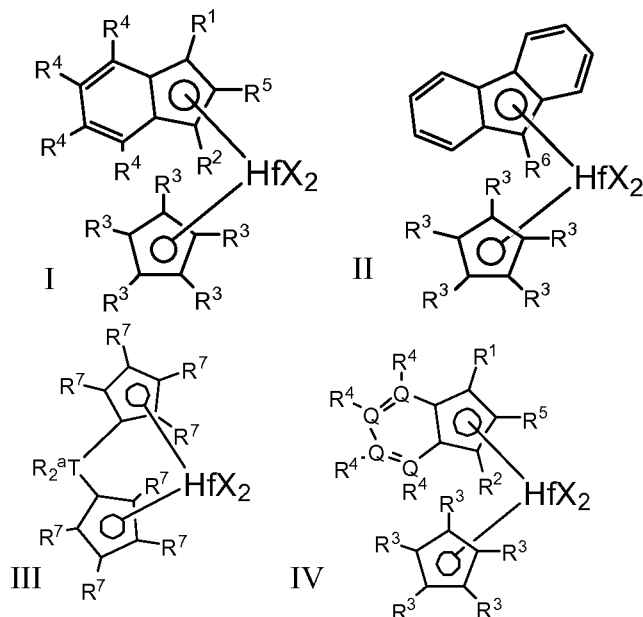
T is a bridge, preferably, Si or Ge, preferably Si;

each R^a , is independently, hydrogen, halogen or a C_1 to C_{20} hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system;

and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.

23. A homogenous process for making the propylene homo-oligomer of claim 12 or 13, said process having a productivity of at least 4.5×10^6 g/mol/min, wherein the process comprises:

contacting, at a temperature of from 30°C to 120°C , propylene, 0 mol% comonomer and from 0 to about 5wt% hydrogen in the presence of a catalyst system comprising an activator and at least one metallocene compound represented by the formulae:



where

Hf is hafnium;

each X is, independently, selected from the group consisting of hydrocarbyl radicals having from 1 to 20 carbon atoms, hydrides, amides, alkoxides, sulfides, phosphides, halogens, dienes, amines, phosphines, ethers, or a combination thereof, preferably methyl, ethyl, propyl, butyl, phenyl, benzyl, chloride, bromide, iodide, (alternately two X's may form a part of a fused ring or a ring system);

- each Q is, independently carbon or a heteroatom, preferably C, N, P, S (preferably at least one Q is a heteroatom, alternately at least two Q's are the same or different heteroatoms, alternately at least three Q's are the same or different heteroatoms, alternately at least four Q's are the same or different heteroatoms);
- each R¹ is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, R¹ may be the same or different as R²;
- each R² is, independently, a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, preferably R¹ and/or R² are not branched;
- each R³ is, independently, hydrogen, or a substituted or unsubstituted hydrocarbyl group having from 1 to 8 carbon atoms, preferably 1 to 6 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, provided however that: 1) all five R³ groups are methyl, or 2) four R³ groups are not hydrogen and at least one R³ group is a C₂ to C₈ substituted or unsubstituted hydrocarbyl (preferably at least two, three, four or five R³ groups are a C₂ to C₈ substituted or unsubstituted hydrocarbyl);
- each R⁴ is, independently, hydrogen or a substituted or unsubstituted hydrocarbyl group, a heteroatom or heteroatom containing group, preferably a substituted or unsubstituted hydrocarbyl group having from 1 to 20 carbon atoms, preferably 1 to 8 carbon atoms, preferably a substituted or unsubstituted C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, substituted phenyl (such as propyl phenyl), phenyl, silyl, substituted silyl, (such as CH₂SiR', where R' is a C₁ to C₁₂ hydrocarbyl, such as methyl, ethyl, propyl, butyl, phenyl);
- R⁵ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;
- R⁶ is hydrogen or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl;
- each R⁷ is, independently, hydrogen, or a C₁ to C₈ alkyl group, preferably a C₁ to C₈ linear alkyl group, preferably methyl ethyl, propyl, butyl, pentyl, hexyl, heptyl or octyl, provided however that at least seven R⁷ groups are not hydrogen, alternately at least eight R⁷ groups are not hydrogen, alternately all R⁷ groups are not hydrogen, (preferably the R⁷ groups at the 3 and 4 positions on each Cp ring of Formula IV are not hydrogen);
- N is nitrogen;
- T is a bridge, preferably, Si or Ge, preferably Si;
- each R^a, is independently, hydrogen, halogen or a C₁ to C₂₀ hydrocarbyl, such as methyl, ethyl, propyl, butyl, pentyl, hexyl, heptyl, octyl, phenyl, benzyl, substituted phenyl, and two R^a can form a cyclic structure including aromatic, partially saturated, or saturated cyclic or fused ring system;
- and further provided that any two adjacent R groups may form a fused ring or multicenter fused ring system where the rings may be aromatic, partially saturated or saturated.