

BUTYL IONOMER BLENDS

Field

This application relates to polymers, particularly to butyl rubber ionomers blended with other polymers.

5 Background

Poly(isobutylene-co-isoprene) or IIR, is a synthetic elastomer commonly known as butyl rubber (or Butyl polymer) which has been prepared since the 1940's through the random cationic copolymerization of isobutylene with small amounts of isoprene (usually not more than 2.5 mol %). As a result of its molecular structure, IIR possesses superior
10 air impermeability, a high loss modulus, oxidative stability and extended fatigue resistance.

Halogenation of butyl rubber produces reactive allylic halide functionality within the elastomer. Conventional butyl rubber halogenation processes are described in, for example, Ullmann's Encyclopedia of Industrial Chemistry (Fifth, Completely Revised
15 Edition, Volume A231 Editors Elvers, et al.) and/or "Rubber Technology" (Third Edition) by Maurice Morton, Chapter 10 (Van Nostrand Reinhold Company © 1987), particularly pp. 297-300.

The development of halogenated butyl rubber (halobutyl) has greatly extended the usefulness of butyl by providing much higher curing rates and enabling co-vulcanization
20 with general purpose rubbers such as natural rubber and styrene-butadiene rubber (SBR). Butyl rubber and halobutyl rubber are high value polymers, as their unique combination of properties (excellent impermeability, good flex, broad damping characteristics, good weatherability, heat resistance, chemical resistance, biocompatibility, co-vulcanization with high unsaturation rubbers, in the case of halobutyl)
25 make them preferred materials for various applications, such as their use in making tire inner tubes and tire inner liners.

The presence of allylic halide functionalities allows for nucleophilic alkylation reactions. It has been shown that treatment of brominated butyl rubber (BIIR) with nitrogen and/or phosphorus based nucleophiles, in the solid state, leads to the generation
30 of IIR-based ionomers with interesting physical and chemical properties (see: Parent, J. S.; Liskova, A.; Whitney, R. A.; Resendes, R. Journal of Polymer Science, Part A: Polymer Chemistry 43, 5671-5679, 2005; Parent, J. S.; Liskova, A.; Resendes, R. Polymer 45,

8091-8096, 2004 ; Parent, J. S. ; Penciu, A. ; Guillen- Castellanos, S . A.; Liskova, A.; Whitney, R. A. *Macromolecules* 37, 7477-7483, 2004). The ionomer functionality is generated from the reaction of a nitrogen or phosphorus based nucleophile and the allylic halide sites in the halogenated butyl rubber to produce an ammonium or phosphonium ionic group respectively. In addition to benefits derived from the butyl rubber, butyl rubber ionomers are also more easily formed into pellets and have enhanced green strength.

Thermoplastics are materials which contain physical, thermoreversible networks imparting excellent physical properties and are widely used in a variety of applications.. For example, polyethylenes have good impact resistance, light weight, high tensile strength, good resistance to chemicals, low moisture absorption, ease of processing (e.g. injection moldable) and are FDA approved for direct contact. Polyethylenes are used in detergent, milk and juice bottles, cutting boards, water pipes, molded plastic cases and garden furniture, among others. Polyamides have good durability, high elongation, excellent abrasion resistance, good impact resistance, antimicrobial properties, and good resistance to chemicals. Polyamides are used in rope, fibers, carpets, sports equipment, bristles, low strength machine parts, seat belts and tire cords, among others. Polypropylene has light weight, high tensile strength, excellent abrasion resistance, good impact resistance, good resistance to chemicals and is sterilized using autoclaves. Polypropylene is used in plastic pressure pipe systems, storage containers, bottle caps, appliances (e.g. kettles), car fenders (bumpers) and diapers, among others.

However, despite the success of thermoplastics, there remains a need for improving one or more of the properties of thermoplastics.

Summary

There is provided a polymeric compound comprising a blend of 50 wt% or greater of a thermoplastic having an average melting point (T_m) of less than 300 °C and less than 50 wt% of a butyl rubber ionomer dispersed in a matrix of the thermoplastic, percentage weight is based on total weight of the thermoplastic and butyl rubber ionomer.

There is also provided a process for producing a polymeric compound comprising blending 50 wt% or greater of a thermoplastic having an average melting point (T_m) of less than 300 °C with less than 50 wt% of a butyl rubber ionomer at a temperature of less than 300 °C to disperse the butyl rubber ionomer in a matrix of the thermoplastic, weights based on total weight of the thermoplastic and butyl rubber ionomer.

There is also provided an article of manufacture comprising the polymeric compound.

Polymeric compounds comprising a blend of 50 wt% or greater of a thermoplastic having an average melting point (T_m) of less than 300 °C and less than 50 wt% of a butyl rubber ionomer may exhibit improved physical properties compared to unblended thermoplastic, particularly ultimate elongation and/or damping.

Further features will be described or will become apparent in the course of the following detailed description. It should be understood that each feature described herein may be utilized in any combination with any one or more of the other described features, and that each feature does not necessarily rely on the presence of another feature except where evident to one of skill in the art.

Brief Description of the Drawings

For clearer understanding, preferred embodiments will now be described in detail by way of example, with reference to the accompanying drawings, in which:

Fig. 1A is an atomic force microscope (AFM) image of a blend of high density polyethylene (LDPE) and butyl rubber ionomer mixed at 130 °C showing domains of butyl ionomer (dark regions) dispersed in a LDPE matrix (light regions).

Fig. 1B is an atomic force microscope (AFM) image of a blend of low density polyethylene (LDPE) and butyl rubber ionomer mixed at 160 °C showing domains of butyl ionomer (dark regions) dispersed in a LDPE matrix (light regions).

Fig. 1C is an atomic force microscope (AFM) image of a blend of low density polyethylene (LDPE) and butyl rubber ionomer with oil mixed at 130 °C showing domains of butyl ionomer (dark regions) dispersed in a LDPE matrix (light regions).

Fig. 1D is an atomic force microscope (AFM) image of a blend of low density polyethylene (LDPE) and butyl rubber ionomer with oil showing domains of butyl ionomer (dark regions) dispersed in a LDPE matrix (light regions).

Fig. 1E is an atomic force microscope (AFM) image of a blend of high density polyethylene (HDPE) and butyl rubber ionomer with oil showing domains of butyl ionomer (dark regions) dispersed in a HDPE matrix (light regions).

Fig. 1F is an atomic force microscope (AFM) image of a blend of nylon and butyl rubber ionomer with oil showing domains of butyl ionomer (dark regions) dispersed in a nylon matrix (light regions).

Fig. 1G is an atomic force microscope (AFM) image of a blend of polypropylene (PP) and butyl rubber ionomer with oil showing domains of butyl ionomer (dark regions) dispersed in a PP matrix (light regions).

Detailed Description

The polymeric compound comprises a blend of 50 wt% or greater of a thermoplastic and less than 50 wt% of a butyl rubber ionomer dispersed in a matrix of the thermoplastic, based on total weight of the thermoplastic and butyl rubber ionomer. Preferably, the blend comprises 51-99 wt% of the thermoplastic and 1-49 wt% of the butyl rubber ionomer. More preferably, the blend comprises 75-99 wt% of the thermoplastic and 1-25 wt% of the butyl rubber ionomer. Even more preferably, the blend comprises 80-95 wt% of the thermoplastic and 5-20 wt% of the butyl rubber ionomer. For example, the blend may comprise 85-90 wt% of the thermoplastic and 10-15 wt% of the butyl rubber ionomer.

The butyl rubber ionomer is preferably dispersed in the matrix of thermoplastic as domains of butyl rubber ionomer having an average diameter of about 5 μm or less, preferably about 2 μm or less. The average diameter may be as low as 0.1 μm or lower. The average diameter may be in a range of 0.1-5 μm or 0.1-2 μm . The butyl rubber ionomer may be sufficiently dispersed in the thermoplastic that a compatibilizer for compatibilizing the butyl rubber ionomer and thermoplastic may not be required.

Ultimate elongation of the polymeric compounds, as measured by ASTM D412, may be over 1.25 times greater, over 1.5 times greater, over 1.75 times greater, over 2 times greater, or even over 5 times greater, than ultimate elongation of unblended thermoplastic. Damping ability of polymeric compounds of the present invention, as measured by GABO Eplexor® 150N, may be over 1.25 times greater, over 1.5 times greater, over 1.75 times greater, over 2 times greater, over 2.5 times greater, or even over 3 times greater, than damping ability of unblended thermoplastic.

Thermoplastic

A thermoplastic is a polymer which becomes pliable or moldable above a specific temperature and returns to a solid state upon cooling. Thermoplastics for blending with

butyl rubber ionomers have average melting points (T_m) of less than 300°C, preferably 250°C or less, more preferably 200°C or less and even more preferably 185°C or less. Examples of thermoplastics include polyolefins, polyvinyls, polystyrenics, polyacrylonitrils, polyacrylics, polyamides, polyurethanes, polyesters, polysiloxane, polyvinylchlorines, polystyrene and the like. Polyolefins, polyamides and polyvinylidene fluoride are preferred. Polyvinylidene fluoride has a T_m of 155-185°C. Some examples of polyolefins include polyethylenes, polypropylenes (PP, T_m of 165-175°C), polybutylenes (PBI). Some examples of polyethylenes include low density polyethylene (LDPE, T_m of 85-125°C), high density polyethylene (HDPE, T_m of 130-140°C), linear low density polyethylene (LLDPE) and ultra high molecular weight polyethylene (UHMWPE). Some examples of polyamides are nylon 6,12 (T_m of 130-140°C) and nylon 12 (T_m of 160-210°C)

Butyl Rubber Ionomer

The butyl rubber ionomer may be prepared from a halogenated butyl rubber polymer. The halogenated butyl rubber polymer may be prepared from a butyl rubber polymer. The butyl rubber polymer may be a copolymer derived from at least one isoolefin monomer and at least one multiolefin monomer and/or β -pinene, and optionally one or more further copolymerizable monomers.

Suitable isoolefin monomers include hydrocarbon monomers having 4 to 16 carbon atoms. In one embodiment, isoolefins have from 4-7 carbon atoms. Examples of suitable isoolefins include isobutene (isobutylene), 2-methyl-1-butene, 3-methyl-1-butene, 2-methyl-2-butene, 4-methyl-1-pentene, 4-methyl-1-pentene and mixtures thereof. A preferred isoolefin monomer is isobutene (isobutylene).

Multiolefin monomers copolymerizable with the isoolefin monomers may include dienes, for example conjugated dienes. Particular examples of multiolefin monomers include those having in the range of from 4-14 carbon atoms. Examples of suitable multiolefin monomers include isoprene, butadiene, 2-methylbutadiene, 2,4-dimethylbutadiene, piperylene, 3-methyl-1,3-pentadiene, 2,4-hexadiene, 2-neopentylbutadiene, 2-methyl-1,5-hexadiene, 2,5-dimethyl-2,4-hexadiene, 2-methyl-1,4-pentadiene, 4-butyl-1,3-pentadiene, 2,3-dimethyl-1,3-pentadiene, 2,3-dibutyl-1,3-pentadiene, 2-ethyl-1,3-pentadiene, 2-ethyl-1,3-butadiene, 2-methyl-1,6-heptadiene, cyclopentadiene, methylcyclopentadiene, cyclohexadiene, 1-vinyl-cyclohexadiene and mixtures thereof. A particularly preferred conjugated diene is isoprene. β -pinene may also be used instead of or in addition to the multiolefin monomer. Herein multiolefin/ β -

pinene monomers refer to the presence or use of one or more multiolefin monomers and/or β -pinene monomer.

The butyl rubber polymer may optionally include one or more additional copolymerizable monomers along with the isoolefin and multiolefin/ β -pinene monomers.

5 Additional copolymerizable monomers include monomers copolymerizable with the isoolefin and/or multiolefin/ β -pinene monomers. Suitable copolymerizable monomers include, for example, styrenic monomers, such as alkyl-substituted vinyl aromatic co-

10 monomers, including but not limited to a C_1 - C_4 alkyl substituted styrene. Specific examples of copolymerizable monomers include, for example, α -methyl styrene, *p*-methyl styrene, chlorostyrene, cyclopentadiene and methylcyclopentadiene. In one embodiment, the butyl rubber polymer may comprise random copolymers of isobutylene, isoprene and *p*-methyl styrene.

The butyl rubber polymers are formed from a mixture of monomers described herein. In one embodiment, the monomer mixture comprises from about 80% to about

15 99% by weight of an isoolefin monomer and from about 1% to 20% by weight of a multiolefin/ β -pinene monomer. In another embodiment, the monomer mixture comprises from about 85% to about 99% by weight of an isoolefin monomer and from about 1% to 15% by weight of a multiolefin/ β -pinene monomer. In certain embodiments, three monomers may be employed. In these embodiments, the monomer mixture may

20 comprise about 80% to about 99% by weight of isoolefin monomer, from about 0.5% to about 5% by weight of a multiolefin/ β -pinene monomer, and from about 0.5% to about 15% by weight a third monomer copolymerizable with the isoolefin and/or multiolefin/ β -pinene monomers. In one embodiment, the monomer mixture comprises from about 68% to about 99% by weight of an isoolefin monomer, from about 0.5% to about 7% by weight

25 of a multiolefin/ β -pinene monomer and from about 0.5% to about 25% by weight of a third monomer copolymerizable with the isoolefin and/or multiolefin/ β -pinene monomers.

The butyl rubber polymer may be prepared by any suitable method, of which several are known in the art. For example, the polymerization of monomers may be performed in the presence of $AlCl_3$ and a proton source and/or cationogen capable of

30 initiating the polymerization process. A proton source includes any compound that will produce a proton when added to $AlCl_3$ or a composition containing $AlCl_3$. Protons may be generated from the reaction of $AlCl_3$ with proton sources such as water, alcohol or phenol to produce the proton and the corresponding by-product. Such reaction may be preferred in the event that the reaction of the proton source is faster with the protonated additive as

35 compared with its reaction with the monomers. Other proton generating reactants include

thiols, carboxylic acids, and the like. The most preferred proton source is water. The preferred ratio of AlCl_3 to water is between 5:1 to 100:1 by weight. It may be advantageous to further introduce AlCl_3 derivable catalyst systems, diethylaluminium chloride, ethylaluminium chloride, titanium tetrachloride, stannous tetrachloride, boron trifluoride, boron trichloride, or methylalumoxane. Inert solvents or diluents known to the person skilled in the art for butyl polymerization may be considered as the solvents or diluents (reaction medium). These include alkanes, chloroalkanes, cycloalkanes or aromatics, which are frequently also mono- or polysubstituted with halogens. Hexane/chloroalkane mixtures, methyl chloride, dichloromethane or the mixtures thereof may be preferred. Chloroalkanes are preferably used. The monomers are generally polymerized cationically, preferably at temperatures in the range from -120°C to $+20^\circ\text{C}$, preferably in the range from -100°C to -20°C , and pressures in the range from 0.1 to 4 bar.

The butyl polymer may also be produced via a solution process as outlined in WO2011089083 A1 and references therein. A C6 solvent is a particularly preferred choice for use in a solution process. C6 solvents suitable for use in the present invention preferably have a boiling point of between 50°C and 69°C . Examples of preferred C6 solvents include n-hexane or hexane isomers, such as 2-methyl pentane or 3-methyl pentane, or mixtures of n-hexane and such isomers as well as cyclohexane.

The butyl rubber polymer may comprise at least 0.5 mol% repeating units derived from the multiolefin/ β -pinene monomers. In some embodiments, the repeating units derived from the multiolefin/ β -pinene monomers may be present in the butyl rubber polymer in an amount of at least 0.75 mol%, or at least 1.0 mol%, or at least 1.5 mol%, or at least 2.0 mol%, or at least 2.5 mol%, or at least 3.0 mol%, or at least 3.5 mol%, or at least 4.0 mol%, or at least 5.0 mol%, or at least 8.0 mol%, or at least 10.0 mol%. In one embodiment, the butyl rubber polymer may comprise from 0.5 to 2.2 mol% of the multiolefin/ β -pinene monomers. In another embodiment, the butyl rubber polymer may comprise higher multiolefin/ β -pinene monomer content, e.g. 3.0 mol% or greater. The preparation of suitable high multiolefin/ β -pinene butyl rubber polymers is described in Canadian Patent Application 2,418,884, which is incorporated herein by reference.

In one embodiment, the halogenated butyl rubber polymer may be obtained by first preparing a butyl rubber polymer from a monomer mixture comprising one or more isoolefins, and one or more multiolefins and/or β -pinene, followed by subjecting the resulting copolymer to a halogenation process to form the halogenated butyl rubber polymer. Halogenation can be performed according to the process known by those skilled

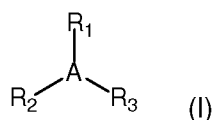
in the art, for example, the procedures described in Rubber Technology, 3rd Ed., Edited by Maurice Morton, Kluwer Academic Publishers, pp. 297-300 and further documents cited therein. Halogenation may involve bromination and/or chlorination. Brominated butyl rubber polymers may be of particular note. For example, a brominated butyl rubber comprising isobutylene and less than 2.2 mole percent isoprene is commercially available from LANXESS Deutschland GmbH and sold under the name BB2030™.

In the halogenated butyl rubber polymers one or more of the repeating units derived from the multiolefin monomers comprise an allylic halogen moiety. During halogenation, some or all of the multiolefin and/or β -pinene content of the copolymer is converted to units comprising allylic halides. These allylic halide sites in the halobutyl rubber polymer result in repeating units derived from the multiolefin monomers and/or β -pinene originally present in the butyl rubber polymer. The total allylic halide content of the halogenated butyl rubber polymer cannot exceed the starting multiolefin and/or β -pinene content of the parent butyl rubber polymer, however residual allylic halides and/or residual multiolefins may be present. The allylic halide sites allow for reacting with and attaching one or more nucleophiles to the halobutyl rubber polymer. The halogenated butyl rubber polymer may have a total allylic halide content from 0.05 to 2.0 mol%. The halogenated butyl rubber polymer may also contain residual multiolefin levels ranging from 0.2 to 10 mol %.

The butyl rubber ionomers may be obtained by reacting a halogenated butyl rubber polymer with a nucleophile having no pendant vinyl group, a nucleophile comprising a pendant vinyl group or a mixture thereof. The halogenated rubber polymer may be reacted first with a nucleophile having no pendant vinyl group and then with a nucleophile having a pendant vinyl group.

Nucleophiles suitable for the preparation of the butyl rubber ionomers may contain at least one neutral phosphorus or nitrogen center, which possess a lone pair of electrons, the lone pair being both electronically and sterically accessible for participation in nucleophilic substitution reactions. The butyl rubber ionomers obtained from such nucleophiles would comprise phosphorus-based or nitrogen-based ionic moieties.

In one embodiment, the allylic halide sites of the halogenated butyl rubber polymers are reacted with nucleophiles (with or without a pendant vinyl group) having of formula (I):



wherein,

A is a nitrogen or phosphorus; and,

5 R_1 , R_2 and R_3 are independently: a vinyl group, a linear or branched C_1 - C_{18} alkyl group; a linear or branched C_1 - C_{18} alkyl group comprising one or more hetero atoms selected from the group consisting of O, N, S, B, Si and P; C_6 - C_{10} aryl group; C_3 - C_6 heteroaryl group; C_3 - C_6 cycloalkyl group; C_3 - C_6 heterocycloalkyl group; or combinations thereof. If the nucleophile has a pendant vinyl group, the vinyl group may be one of R_1 , R_2 or R_3 or could be pendant from one or more of the R_1 , R_2 or R_3 groups. Two or all three of
10 the R_1 , R_2 and R_3 moieties may be fused together.

Suitable nucleophiles include, but are not limited to trimethylamine, triethylamine, triisopropylamine, tri-n-butylamine, trimethylphosphine, triethylphosphine, triisopropylphosphine, tri-n-butylphosphine, triphenylphosphine, diphenylphosphinostyrene, allyldiphenylphosphine, diallylphenylphosphine,
15 diphenylvinylphosphine, triallylphosphine, 2-dimethylaminoethanol, 1-dimethylamino-2-propanol, 2-(isopropylamino)ethanol, 3-dimethylamino-1-propanol, N-methyldiethanolamine, 2-(diethylamino)ethanol, 2-dimethylamino-2-methyl-1-propanol, 2-[2-(dimethylamino)ethoxy]ethanol, 4-(dimethylamino)-1-butanol, N-ethyldiethanolamine, triethanolamine, 3-diethylamino-1-propanol, 3-(diethylamino)-1,2-propanediol, 2-[[2-
20 (dimethylamino)ethyl]methylamino]ethanol, 4-diethylamino-2-butyne-1-ol, 2-(diisopropylamino)ethanol, N-butyldiethanolamine, N-tert-butyldiethanolamine, 2-(methylphenylamino)ethanol, 3-(dimethylamino)benzyl alcohol, 2-[4-(dimethylamino)phenyl]ethanol, 2-(N-ethylanilino)ethanol, N-benzyl-N-methylethanolamine, N-phenyldiethanolamine, 2-(dibutylamino)ethanol, 2-(N-ethyl-N-m-
25 toluidino)ethanol, 2,2'-(4-methylphenylimino)-diethanol, tris[2-(2-methoxyethoxy)ethyl]amine, 3-(dibenzylamino)-1-propanol, N-vinyl caprolactam, N-vinyl phthalimide, 9-vinyl carbazole, N-[3-(dimethylamino)propyl]methacrylamide or mixtures thereof.

The reaction between the nucleophile and the halogenated butyl rubber polymer
30 may be carried out at a temperature in a range of from about 60 °C to about 250 °C. In one embodiment, the reaction between the nucleophile and the halogenated butyl rubber polymer may be carried out at a temperature about 80 °C to about 200 °C. In another

embodiment, the reaction between the nucleophile and the halogenated butyl rubber polymer may be carried out at a temperature about 100°C to about 160°C. The reaction may be carried out for a time in a range of from about 0.5 to 90 minutes, preferably from 1 to 60 minutes, more preferably from 5 to 30 minutes. The amount of nucleophile reacted
5 with the halogenated butyl rubber polymer may be in the range of from 0.01 to 5 molar equivalents, more preferably about 0.1 to 2 molar equivalents, even more preferably about 0.5 to 1 molar equivalents, based on the total molar amount of allylic halide present in the halogenated butyl rubber polymer. The resulting butyl rubber ionomer preferably possesses from about 0.01 to 10 mol%, more preferably from about 0.1 to 5.0 mol%,
10 even more preferably from about 0.5 to 0.8 mol% of ionomeric moieties. The resulting butyl rubber ionomer may be a mixture of the polymer-bound ionomeric moiety and allylic halide such that the total molar amount of ionomeric moiety and allylic halide functionality are present in an amount not exceeding the original allylic halide content.

Compounding and Shaping

15 In an embodiment, the thermoplastic is blended with the butyl rubber ionomer at a temperature of 300°C or less to disperse the butyl rubber ionomer in a matrix of the thermoplastic. Blending is preferably performed at a temperature above the melting temperature of the thermoplastic.

Ingredients may be blended together using conventional mixing techniques.
20 Suitable techniques include, for example, mixing the ingredients using a batch mixer, a two roll mill, an internal mixer or various types of a continuous mixers. Either a single or twin screw extruder may also be employed which provide effective mixing with shorter mixing times. Twin screw extruders may include modular co-rotating twin screw extruders, or modular counter-rotating twin screw extruders. The mixing may be carried
25 out for a time in a range of from about 0.25 to 30 minutes, preferably from 0.5 to 20 minutes, more preferably from 1 to 10 minutes. The ingredients may be dosed into the extruder using various feeders/stuffers which may include single and twin screw feeders, rotary feeders, belts feeders, vibratory feeders which can be controlled by either volume or weight. Liquids may be introduced directly into the mixing chamber where needed.
30 Extruders are preferred. It is possible to carry out the mixing in two or more stages, and the mixing can be done using different types of mixing equipment in series for example mixing can be performed using an internal mixer followed by an extruder.

The blended material may be finished in a variety of ways including pelletizing (die-face, dry-cut or underwater), dicing, granulation, in sheets strips, lumps, and slabs

which can be achieved via cast film extrusion, blown film extrusion, sheet extrusion, coextrusion, wire coating, or pipe and tubing extrusion. Additionally, the blended material may be injection molded via, for example, a two-plate or three-plate or stacked mold or the material may be compression molded using a hand, semiautomatic or fully automatic
5 mold or the material may be transfer molded via, for example, transfer-in compression molding, plunger molding, or screw transfer molding. Additionally, the blended material may be blow molded by, for example, injection, stretch, dip blow multiblock, or coextrusion, sequential extrusion blow molding or the material may be molded by rotational molding using, for example, a batch system, carousel machine, shuttle
10 machine, or clamshell machine. Additionally, the blended material may be finished as a foam material or calendered or welded. For further information on compounding techniques, see Encyclopedia of Polymer Science and Engineering, Vol. 4, p. 66 et seq. (Compounding) as well as Handbook of Thermoplastic Elastomers, 2007. Other techniques, as known to those of skill in the art, are further suitable for compounding.

15 It is preferable that the viscosities of the thermoplastic and butyl rubber ionomer are closely matched at the mixing temperature and the shear rate of the mixer or extruder. In an embodiment, the thermoplastic and butyl ionomer have viscosities within about 15% of each other, or more preferably within about 10% of each other (i.e. a viscosity ratio of about 0.9), in which case, the blending may be performed without the
20 addition of plasticizer. In another embodiment, a plasticizer may be added to the butyl rubber ionomer prior to mixing to more closely match the viscosities, for example to change the viscosity of the butyl rubber ionomer to within 10% of the viscosity of the thermoplastic. In a preferred embodiment, no plasticizer is added to viscosity match the thermoplastic and butyl rubber ionomer. Sufficient dispersion of the butyl rubber ionomer
25 in the thermoplastic may be obtained and the blend maintains good physical properties, particularly elongation and damping, despite the absence of a plasticizer.

Stabilizers, anti-oxidants, tackifiers, and/or other additives known to those of skill in the art may also be added to the blend in the usual way and in the normal amounts. Antioxidants may be either primary antioxidants (such as hindered phenolics or
30 secondary aromatic amines) or secondary antioxidants (such as phosphites and thioesters). Additionally, other additives may be added to the ionomer prior to blending with the thermoplastic and include light stabilizers nucleating agents, flame retardants, colorants, antistatic agents, slip agents, antiblocking agents, processing aids, fillers and reinforcements. Light stabilizers may include UV absorbers, UV quenchers, or free
35 radical scavengers. Nucleating agents may include inorganic additives (such as talc,

silica and clay), organic compounds (such as salts of mono- or polycarboxylic acids and certain pigments), or polymers (such as ethylene/acrylic ester co-polymers). Flame retardants may include intumescent systems or those that act in the condensed phase or the gas phase. Colorants may include dyes (organic compounds that are soluble in the plastic) or pigments (insoluble in the plastic and may be inorganic or organic) Antistatic agents, commonly known as antistats, may be ionic or non-ionic and may be internal or external antistats. Slip agents may include modified fatty acids. Antiblocking agents may include natural and manufacturing waxes, metallic salts of fatty acids, silica compounds or polymers. Process aides may include lubricants or fluoro-polymer-based additives.

10 Fillers and reinforcements may include inactive or active fillers and may include cubic or spheroidal fillers such as carbon black, calcium carbonate barium sulfate, glass beads, ceramic beads, synthetic silica, as well as platy fillers such as talc, mica, kaolin and clay or fibrous fillers such as glass fillers, carbon fibers, or aramid fibres as well as nanofillers. Plasticizers may include phthalic esters, phosphoric esters, adipic esters, azelaic esters,

15 sebacic esters, citric esters, trimellitic esters, halogenated hydrocarbons, hydrocarbons (aliphatic, naphthenic, and aromatic), benzoic esters, fatty acid esters (oleates, stearates, ricinoleates), fatty esters, polyesters and polymers and polycondensates. Other additives may include antimicrobials, fluorescent whitening agents, and heat stabilizers.

Any article of manufacture amenable to be formed from a thermoplastic material

20 may be made using the blend of the present invention. Applications may include adhesives, sealants, coatings, modified asphalt, automotive applications, hoses, tubes, sheets, mechanical rubber goods, consumer goods, architectural good, construction goods, electrical goods, electronic goods, medical and food contact goods, seals, gaskets, valve seats, bushings, grommets, appliance feet, caster wheels, torque

25 couplings, vibration isolators, suction cups, caps, rollers, extruded profiles, bumpers, housings, bellows, shields, toys, ski pole grips, foamed profiles, sheets, wire and cable, mechanical goods. Some articles of manufacture include detergent, bottles (e.g. milk and juice bottles), cutting boards, water pipes, molded plastic cases, garden furniture, rope, fibers, carpets, sports equipment, bristles, low strength machine parts, seat belts, tire

30 cords, pipes (e.g. for plastic pressure pipe systems), storage containers, bottle caps, appliances (e.g. kettles), car fenders (e.g. bumpers), door handle seals, floor mats, seals, handles, stamps, power cords, plugs, knobs, toothbrush handles, soft shoe inserts, phone cases, coolers, cases, pen cases, grips, sporting equipment, wires, expansions joints, roofing, flooring, weather seals, electrical connectors, plugs and insulators for electrical

35 and electronic assemblies, computer hardware, telephones, electronic appliances, office equipment, drug vial stoppers, syringe plunger tips, aerosol valve seals, medical tubing,

liquid dispenser pump diaphragms, nursing bed sheets, bumper covers, bumper caps, bumper side cladding, body molding, air dams, airing pieces, fender liners, rocker panel covers, rub strips, scuff plates, sight shields, stone deflectors, wheel well moldings, grills, valence panels, heating air ducts, conduits, hoods seals, firewall pads, air bag covers, instrument panels, knee bolsters, glove box doors, door panels, door inserts, flexible cords, battery booster cables, appliance wires, low voltage wire, control cables, hook-up wire, submersible pump cable, cable jackets, transmission belts, timing belts, shock absorbers, membranes, conveyor belts, housewares, recreational goods, luggage handles, shoe soles, musical instruments, garden hose, spatulas, tapes, hot melt adhesives, coated fabrics, steering wheels, boots, bellows, dust covers, grips of tools, grips of sporting equipment, belts, valves, diapers, surgical garments, push buttons, parts of instruments, parts of hand-held devices, irrigation systems, agricultural equipment, keypads, seismographic cable, audio wire, camera cable, computer cable, head-set cable, marine cable, welder cable, air gun cable, communication wire, towing leader, wheels and castors for shipping carts, food service carts, wheels for inline skates, wheels for skateboards, coatings for inflatable boats, coatings for collapsible canoes, coatings for life rafts, life jackets, shoe lacquers, inks, leather coatings, magnetic tape, gel seats, catheters, medical tubing, switches, connectors, and fibre optic coatings.. Articles may be formed from the polymeric compound by any suitable shaping method, for example molding, die cutting, stamping, etc. as described above.

Examples:

Materials and Methods

The butyl rubber ionomer used in these examples is X Butyl™ I4565P available from LANXESS Corporation. The high density polyethylene (ET326320) was obtained from Goodfellow, having a T_m of 130°C. The low density polyethylene (A-C® 617) was obtained from Honeywell, having a T_m of 110°C. The nylon 12 (Nylon 12) was provided by EMS-GRIVORY, having a T_m of 180°C. The polypropylene (PP) was provided by Safipol, having a T_m of 180°C.

Tensile properties were prepared using DIN 53504 S2 samples size and a pull rate of 500 mm/min extension rate according to ASTM D 412.

Elastic modulus is determined by using a GABO Eplexor® 150N using 12 x 4 x 2 mm samples and testing at 1% static strain, 0.1% dynamic strain at a heating rate of 2 °C/min.

Atomic Force Microscopy (AFM) imaging was performed on by analysing the surface of samples created by freeze-fracturing the sample immersed in liquid nitrogen for ~ 5 minutes. The surface was imaged using the dynamic force mode of a Park Systems XE-100 AFM. A silicon cantilever with a nominal spring constant of 40 N/m, resonant frequency of 300 kHz and tip radius of 10 nm was used. The phase shift angle (phase difference between the piezo driver signal and the oscillation of the cantilever as detected by the photodetector) of the dynamic force mode AFM is sensitive to tip-sample interaction. A smaller phase shift angle (i.e., darker contrast in the phase image) suggests a softer component and a larger phase shift angle (brighter contrast) suggests a more rigid component.

Compounding of thermoplastic and Butyl ionomer to form blends was performed using a DSM Micro Compounder at a shear rate of 2000 sec⁻¹.

Examples 1-5

LDPE (100 or 90 phr) was mixed with X_Butyl™ I4565P (0 or 10 phr) in a twin screw extruder at either 130 °C or 160 °C for 1 min and 3 min. The viscosity ratio at 2000 s⁻¹ was 1.5 at 130 °C and 1.2 at 160 °C. The resulting tensile properties and dynamic properties are summarized in Table 1. Addition of X_Butyl™ I4565P led to compounds with higher elongation. Figure 1 demonstrates butyl ionomer domains (dark areas) in a plastic matrix (light area) where the domain sizes for Example 2 are <5 µm (Figure 1A) and those for Example 4 are <3 µm (Figure 1B).

Table 1

Example	1	2	3	4	5
X_Butyl™ I4565P (wt%)	0	10	10	10	10
LDPE (wt%)	100	90	90	90	90
Mixing Temperature (°C)	130	130	130	160	160
Mixing Time (min)	1	1	3	1	3
Ultimate Tensile (MPa)	16	11.7	11.8	11.4	10.9
Ultimate Elongation (%)	59	77	89	97	92

Examples 6-7

LDPE (90 phr) was mixed with 10 phr of X_Butyl™ I4565P that contained 10 phr Sunpar 2280 in a twin screw extruder at either 130 °C or 160 °C for 1 min and 3 min in order to better match the viscosity of the LDPE. The resulting viscosity ratio at 2000 s⁻¹ was 1.0 at 130 °C and 0.9 at 160 °C. The resulting tensile properties and dynamic properties are summarized in Table 2. Addition of X_Butyl™ I4565P led to compounds with comparable elongation to Examples 2 and 5 above which contained no oil. Figure 1

demonstrates butyl ionomer domains (dark areas) in a plastic matrix (light areas) where the domain sizes for Example 6 are <2 μm (Figure 1C) and those for Example 7 are <3 μm (Figure 1D).

Table 2

Example	1	6	7
X_Butyl™ I4565P (wt%)	0	9.9	9.9
Sunpar 2280 (wt%)	0	0.1	0.1
LDPE (wt%)	100	90	90
Mixing Temperature (°C)	130	130	160
Mixing Time (min)	1	1	1
Ultimate Tensile (MPa)	16	11.8	10.9
Ultimate Elongation (%)	59	80	100

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Example 8 and 9

Example 9 was formed by mixing HDPE (85 phr) with 15 phr of X_Butyl™ I4565P in a twin screw extruder at 130 °C. The resulting viscosity ratio at 2000 s^{-1} was 0.97 s^{-1} when compared to Example 8 (100 phr HDPE). The resulting tensile properties and dynamic properties are summarized in Table 3. Addition of X_Butyl™ I4565P led to compounds with longer elongation and lower tensile. As seen in Figure 1E, the butyl ionomer forms discrete ionomer domains (dark areas, <2 μm in diameter) dispersed in an HDPE matrix (light area). As seen in Figure 2A, the blend shows significant improvement in damping across a wide temperature range.

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Table 3

Example	8	9
X_Butyl™ I4565P (wt%)		15
HDPE (wt%)	100	85
Ultimate Tensile (MPa)	6	11
Ultimate Elongation (%)	63	54

Example 10 -12

Example 11 was formed by mixing Nylon 12 (85 phr) with 15 phr of X_Butyl™ I4565P in a twin screw extruder at 180 °C. The resulting viscosity ratio at 2000 s^{-1} was 1.24 s^{-1} when compared to Example 10 (100 phr Nylon 12). Example 12 was formed by the addition of oil to the butyl ionomer which served to improve the viscosity ratio to 1.0.

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The resulting tensile properties and dynamic properties are summarized in Table 4. Addition of the butyl ionomer led to compounds with longer elongation and comparable tensile strength. As seen in Figure 1F, forms discrete ionomer domains (dark area, <2 μm in diameter) dispersed in a Nylon 12 matrix (light area). As seen in Figure 2B the blend (Example 12) shows significant improvement in damping across a wide temperature range.

Table 4

Example	10	11	12
X_Butyl™ I4565P (wt%)		15	14.25
Nylon 12 (wt%)	100	85	85
Sunpar 2280			0.75
Ultimate Tensile (MPa)	43	-	46
Ultimate Elongation (%)	122	-	229

Example 13-15

Example 14 was formed by mixing polypropylene (85 phr) with 15 phr of X_Butyl™ I4565P in a twin screw extruder at 180 °C. The resulting viscosity ratio at 2000 s^{-1} was 1.54 s^{-1} when compared to Example 13 (100 phr polypropylene). Example 15 was formed by the addition of oil to the butyl ionomer which served to improve the viscosity ratio to 1.0. The resulting tensile properties and dynamic properties are summarized in Table 5. Addition of the butyl ionomer led to compounds with longer elongation and comparable tensile strength. As seen in Figure 1G, forms discrete ionomer domains (dark areas, <2 μm in diameter) dispersed in a polypropylene matrix (light area). As seen in Figure 2C the blend (Example 12) shows improvement in damping across a wide temperature range.

Table 5.

Example	13	14	15
X_Butyl™ I4565P (wt%)		15	13.5
Nylon 12 (wt%)	100	85	85
Sunpar 2280			1.5
Ultimate Tensile (MPa)	45	-	36
Ultimate Elongation (%)	23	-	193

The novel features will become apparent to those of skill in the art upon examination of the description. It should be understood, however, that the scope of the

claims should not be limited by the embodiments, but should be given the broadest interpretation consistent with the wording of the claims and the specification as a whole.

Claims:

1. A polymeric compound comprising a blend comprising 50 wt% or greater of a thermoplastic having an average melting point (T_m) of less than 300°C and less than 50 wt% of a butyl rubber ionomer dispersed in a matrix of the thermoplastic, based on total weight of the blend. .
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2. The polymeric compound according to claim 1, wherein the thermoplastic has a T_m of 250°C or less.
3. The polymeric compound according to claim 1, wherein the thermoplastic has a T_m of 185°C or less.
- 10 4. The polymeric compound according to any one of claims 1 to 3, wherein the blend comprises 75-99 wt% of the thermoplastic and 25-1 wt% of the butyl rubber ionomer.
5. The polymeric compound according to any one of claims 1 to 3, wherein the blend comprises 85-90 wt% of the thermoplastic and 10-15 wt% of the butyl rubber ionomer.
6. The polymeric compound according to any one of claims 1 to 5, wherein the blend
15 does not comprise a compatibilizer for compatibilizing the thermoplastic and butyl rubber ionomer.
7. The polymeric compound according to any one of claims 1 to 6, wherein the butyl rubber ionomer is dispersed as domains having an average diameter of about 5 μm or less in the matrix of thermoplastic.
- 20 8. The polymeric compound according to any one of claims 1 to 7, further comprising a plasticizer.
9. The polymeric compound according to any one of claims 1 to 8, wherein the thermoplastic comprises a polyolefin or a polyamide.
10. The polymeric compound according to any one of claims 1 to 8, wherein the
25 thermoplastic comprises polyethylene, polypropylene, polystyrene or nylon 12.
11. The polymeric compound according to any one of claims 1 to 11, wherein the thermoplastic elastomer comprises stabilizers, anti-oxidants, tackifiers, nucleating agents, flame retardants, colorants, antistatic agents, slip agents, antiblocking agents, processing aids, fillers, reinforcements and/or curatives.

12. A process for producing a polymeric compound comprising blending 50 wt% or greater of a thermoplastic having an average melting point (T_m) of less than 300°C with less than 50 wt% of a butyl rubber ionomer at a temperature of 300°C or less to disperse the butyl rubber ionomer in a matrix of the thermoplastic, weights based on total weight of the thermoplastic and butyl rubber ionomer.
13. The process according to claim 12, wherein the blending is performed in an mixer, a roll mill, an internal mixer, a continuous mixer or a single or twin screw extruder.
14. The process according to any one of claims 12 to 13, wherein the thermoplastic and butyl ionomer have viscosities within about 10% of each other during blending.
15. The process according to claim 16, wherein a plasticizer is added to match the viscosity of the butyl rubber ionomer to within about 10% of the viscosity of the thermoplastic.
16. The process according to any one of claims 12 to 15, wherein 85-90 wt% of the thermoplastic is blended with 10-15 wt% of the butyl rubber ionomer.
17. The process according to any one of claims 12 to 16, wherein the thermoplastic comprises a polyolefin or a polyamide.
18. The process according to any one of claims 12 to 16, wherein the thermoplastic comprises polyethylene, polypropylene, polystyrene or nylon 12.
19. An article of manufacture comprising the polymeric compound as defined in any one of claims 1 to 11.
20. The article according to claim 19, which is an adhesive, sealant, coating, automotive application, hose, tubes, sheet, mechanical rubber good, consumer good, architectural good, construction good, electrical good, electronic good, medical and food contact good, seal, gasket, valve, bushing, grommet, appliance good, coupling, vibration isolator, cap, roller, extruded profile, bumper, housing, bellow, shield, toy, sporting good, foamed good, wire, cable, or mechanical goods.