

## **CROSSLINKED POLYOLEFIN POLYMER BLENDS**

### **CROSS REFERENCE TO RELATED APPLICATIONS**

[0001] This application claims priority to U.S. Provisional Patent Application No. 61/248,190, filed October 2, 2009, the disclosure of which is incorporated herein by reference in its entirety. This application is related to U.S. Patent Application No. 12/130,745, filed May 30, 2008, which is herein incorporated by reference in its entirety.

### **BACKGROUND OF THE INVENTION**

[0002] Polyolefin polymers and polymer blends are known for their versatility and applicability in a wide variety of uses. In particular, many polyolefin polymers, including copolymers of propylene with other  $\alpha$ -olefins such as ethylene, are well suited for use in applications requiring good stretchability, elasticity, and strength. Materials with good stretchability and elasticity are used to manufacture a variety of disposable articles in addition to durable articles including but not limited to incontinence pads, disposable diapers, training pants, clothing, undergarments, sports apparel, automotive trim, weather-stripping, gaskets, and furniture upholstery. For clothing, stretchability and elasticity are performance attributes that allow the materials to provide a closely conforming fit to the body of the wearer.

[0003] While numerous materials are known to exhibit excellent stress-strain properties and elasticity at room temperatures, it is often desirable for elastic materials to provide a conforming or secure fit during repeated use, during extensions and retractions at elevated or depressed temperatures, or in automobile interiors during summer months. Elasticity at elevated temperatures is also important for maintaining tight tolerances throughout temperature cycles. In particular, elastic materials used for repeated wear clothing or garments must maintain their integrity and elastic performance after laundering.

[0004] Spandex, a segmented polyurethane urea elastic material, is currently used in various durable fabrics. For example, fibers made from Spandex have been used in launderable apparels, fabrics, durable and disposable furnishing, beddings, etc. Similar to conventional uncrosslinked polyolefin-based elastic materials, articles made from Spandex can lose integrity, shape, and elastic properties when subjected to elevated temperatures. Thus, Spandex is not suitable for many co-knitting applications with high temperature fibers, such as polyester fibers.

[0005] Propylene-based polymers having good elastic properties are known and have been used for stretchable clothing. See, for example, U.S. Patent No. 6,525,157 and U.S.

Patent No. 6,342,565. U.S. 6,342,565, in particular, discloses a soft, set-resistant, annealed fiber comprising a blend of polyolefins. The blend has a flexural modulus less than or equal to 12,000 psi and includes from 75 to 98 wt% of a first polymer component and from 2 to 25 wt% of a second polymer component. The first polymer component is a propylene-ethylene polymer having at least 80 wt% propylene and up to 20 wt% ethylene, a melting point (T<sub>m</sub>) by DSC in the range of from 25 to 70°C, and a heat of fusion less than 25 J/g. The second polymer component is a stereoregular isotactic polypropylene having a melting point by DSC of greater than 130°C, and a heat of fusion greater than 120 J/g. The fiber exhibits a resistance to set equal to or less than 80% from a 400% tensile deformation. The polyolefin blend is said to be substantially non-crosslinked.

[0006] U.S. Patent No. 6,500,563 discloses blends of two different types of polypropylene, including blends made from a polypropylene having a T<sub>m</sub> of less than 110°C and propylene-ethylene copolymer that has isotactically arranged propylene derived sequences and T<sub>m</sub> less than 105°C.

[0007] U.S. Patent Application Publication No. 2006/0183861 discloses cross-linked elastomeric compositions, including blends made from a propylene-based polymer blended with at least one component selected from the group consisting of multifunctional acrylates, multifunctional methacrylates, functionalized polybutadiene resins, functionalized cyanurate, and allyl isocyanurate, and at least one component selected from the group consisting of hindered phenols, phosphites, and hindered amines. The blends are cross-linked by exposure to electron beam radiation.

[0008] Three component blends of isotactic polypropylene, impact modifying amounts of an ethylene-propylene based rubber or low density ethylene copolymer and a propylene-based elastomer as compatibilizer are described in EP946640, EP964641, EP969043 and EP1098934.

[0009] WO04/014988 describes blends of isotactic polypropylene with non-functionalized plasticizers such as poly-alpha-olefins. WO03/040233 also discloses two component blends with the isotactic polypropylene as the predominant, matrix phase and the propylene-based copolymer serving as an impact modifier.

[0010] EP1003814 and U.S. 6,642,316 disclose two-component blends of small amounts of isotactic polypropylene and predominant amounts of an ethylene based elastomer. EP0374695 discloses visually homogeneous two component blends however using 40 wt% or less of the propylene-based copolymer. WO 00/69963 describes films made of two-

component blends with from 75 to 98 wt% of a propylene ethylene based elastomer having a heat of fusion of less than 25 J/g.

[0011] Other related references include U.S. Publication Numbers 2006/102149 2005/0107529; 2005/0107530; 2005/0131142; and 2005/0107534.

5 [0012] Many polyolefin blends such as those disclosed in the prior art are formed into pellets for intermediate storage purposes before being shaped into articles such as fibers, films, nonwovens, extruded coatings, and molded articles. Some of these compositions, however, are known to exhibit poor pellet stability over extended periods of time, leading to agglomeration of pellets and resulting in poor pourability and flowability of the pellets.

10 [0013] There is therefore still a need for new and improved propylene-based materials which exhibit good pellet stability while also displaying good stretchability and elasticity for use in a wide variety of applications.

#### **SUMMARY OF THE INVENTION**

[0014] The present invention is directed to polymer blends formed from two or more  
15 polymers produced in two or more reactors and to processes for manufacturing such polymer blends. In some embodiments, the polymer blends are at least partially cross-linked by exposure to energetic photons, and may be further formed into articles including fibers, films, and nonwovens, among others. The polymer blends described herein exhibit improved mechanical and elastic properties and improved pellet stability when compared to similar  
20 materials known in the art.

#### **BRIEF DESCRIPTION OF THE FIGURES**

[0015] Figure 1 depicts stress (in MPa) as a function of elongation (in %) for uncrosslinked inventive and comparative materials.

[0016] Figure 2 depicts stress (in MPa) as a function of elongation (in %) for crosslinked  
25 inventive and comparative materials.

[0017] Figure 3 depicts stress (in MPa) as a function of elongation (in %) for materials with and without coagents, and for a comparative uncrosslinked material.

#### **DETAILED DESCRIPTION OF THE INVENTION**

[0018] The present invention is directed to polyolefin polymer blends and processes for  
30 their production. More particularly, embodiments of the invention include blends of a first propylene-based polymer formed in a first reactor with a second propylene-based polymer produced in a second reactor. These polymer blends may be compounded with a variety of additional components including coagents, antioxidants, secondary elastomers,

polypropylene, additives, fillers, and additive oils, among others. The blends may further be at least partially cross-linked by exposure to energetic photons from sources including ultraviolet (UV) light, x-rays, and gamma rays. In some embodiments, cross-linking of the polymer blends is accomplished via electron beam radiation. The polymer blends described  
5 herein exhibit improved pellet stability when compared to similar blends prepared in a single reactor, and have exceptional mechanical and elastic properties. In particular, when the polymer blends described herein are compounded with a coagent, an antioxidant, or both and subsequently crosslinked, they have improved properties such as peak stress, peak elongation, and tension set when compared to crosslinked polymer blends prepared in the same manner  
10 and having similar compositions but lacking a coagent and an antioxidant. The polymer blends and methods for their production are described in greater detail below.

#### Polymers Comprising the Blend

[0019] The present invention comprises a first polymer prepared in a first reactor and a second polymer prepared in a second reactor. The first and second polymers are typically  
15 olefin-based polymers, and in some embodiments each is a propylene-based homopolymer or copolymer. As used herein, the term "copolymer" is intended to mean a material which is prepared by copolymerizing at least two different co-monomer types, including co-monomers derived from  $\alpha$ -olefins and dienes. One or more other different co-monomer types may also be included in the copolymer such that the copolymer definition includes terpolymers as well  
20 as copolymers comprising four or more different comonomer types. The term "monomer" or "comonomer" as used herein can refer to the monomer used to form the polymer, i.e., the unreacted chemical compound in the form prior to polymerization, and can also refer to the monomer after it has been incorporated into the polymer, also referred to herein as a "[monomer]-derived unit", which by virtue of the polymerization reaction typically has fewer  
25 hydrogen atoms than it does prior to the polymerization reaction. Different monomers are discussed herein, including propylene monomers, ethylene monomers, and diene monomers.

[0020] In some embodiments of the present invention, the first and second polymers are each a copolymer of propylene and one or more comonomers. The comonomers may be linear or branched. In one or more embodiments, linear comonomers may include ethylene  
30 or  $C_4$  to  $C_8$   $\alpha$ -olefins, including but not limited to 1-butene, 1-hexene, and 1-octene. Branched comonomers may include 4-methyl-1-pentene, 3-methyl-1-pentene, and 3,5,5-trimethyl-1-hexene. In one or more embodiments, the comonomer can include styrene.

[0021] In some embodiments, the first and second polymers are each a copolymer of propylene and ethylene (and may comprise other comonomers as well). For example, the first and second polymers may be the same or different, and may each comprise from about 75 to about 99 wt% units derived from propylene and from about 1 to about 25 wt% units derived from ethylene. In some embodiments, the first polymer may comprise from about 12 to about 20 wt% ethylene-derived units, or from about 14 to about 18 wt% ethylene-derived units. In the same or other embodiments, the second polymer may comprise from about 3 to about 10 wt% ethylene-derived units, or from about 5 to about 8 wt% ethylene-derived units. In one embodiment of the present invention, the first polymer has a greater ethylene content than the second polymer. For example, the first polymer may comprise at least 3 wt%, or at least 5 wt%, or at least 7 wt%, or at least 9 wt% more ethylene-derived units than the second polymer.

[0022] In one or more embodiments herein, the second polymer may alternately comprise lower amounts of ethylene, or no ethylene at all, such that the second polymer may be homopolypropylene or a random copolymer of polypropylene (RCP). Exemplary RCPs typically comprise from about 1 to about 8 wt% comonomer, or from about 2 to about 5 wt% comonomer. In one or more embodiments, the RCP comonomer is ethylene.

[0023] Optionally, the first and second polymers may also include one or more dienes. The term "diene" is defined as a hydrocarbon compound that has two unsaturation sites, i.e., a compound having two double bonds connecting carbon atoms. Depending on the context, the term "diene" in this patent refers broadly to either a diene monomer prior to polymerization, e.g., forming part of the polymerization medium, or a diene monomer after polymerization has begun (also referred to as a diene monomer unit or a diene-derived unit). Exemplary dienes suitable for use in the present invention include, but are not limited to, butadiene, pentadiene, hexadiene (e.g., 1,4-hexadiene), heptadiene (e.g., 1,6-heptadiene), octadiene (e.g., 1,7-octadiene), nonadiene (e.g., 1,8-nonadiene), decadiene (e.g., 1,9-decadiene), undecadiene (e.g., 1,10-undecadiene), dodecadiene (e.g., 1,11-dodecadiene), tridecadiene (e.g., 1,12-tridecadiene), tetradecadiene (e.g., 1,13-tetradecadiene), pentadecadiene, hexadecadiene, heptadecadiene, octadecadiene, nonadecadiene, icosadiene, heneicosadiene, docosadiene, tricosadiene, tetracosadiene, pentacosadiene, hexacosadiene, heptacosadiene, octacosadiene, nonacosadiene, triacontadiene, and polybutadienes having a molecular weight (Mw) of less than 1000 g/mol. Examples of straight chain acyclic dienes include, but are not limited to 1,4-hexadiene and 1,6-octadiene. Examples of branched chain acyclic dienes include, but are

not limited to 5-methyl-1,4-hexadiene, 3,7-dimethyl-1,6-octadiene, and 3,7-dimethyl-1,7-octadiene. Examples of single ring alicyclic dienes include, but are not limited to 1,4-cyclohexadiene, 1,5-cyclooctadiene, and 1,7-cyclododecadiene. Examples of multi-ring alicyclic fused and bridged ring dienes include, but are not limited to tetrahydroindene; norbornadiene; methyltetrahydroindene; dicyclopentadiene; bicyclo(2.2.1)hepta-2,5-diene; and alkenyl-, alkylidene-, cycloalkenyl-, and cycloalkylidene norbornenes [including, e.g., 5-methylene-2-norbornene, 5-ethylidene-2-norbornene, 5-propenyl-2-norbornene, 5-isopropylidene-2-norbornene, 5-(4-cyclopentenyl)-2-norbornene, 5-cyclohexylidene-2-norbornene, and 5-vinyl-2-norbornene]. Examples of cycloalkenyl-substituted alkenes include, but are not limited to vinyl cyclohexene, allyl cyclohexene, vinylcyclooctene, 4-vinylcyclohexene, allyl cyclodecene, vinylcyclododecene, and tetracyclododecadiene. In some embodiments of the present invention, the diene is selected from 5-ethylidene-2-norbornene (ENB); 1,4-hexadiene; 5-methylene-2-norbornene (MNB); 1,6-octadiene; 5-methyl-1,4-hexadiene; 3,7-dimethyl-1,6-octadiene; 1,3-cyclopentadiene; 1,4-cyclohexadiene; vinyl norbornene (VNB); dicyclopentadiene (DCPD), and combinations thereof. In one or more embodiments, the diene is ENB.

**[0024]** The first and second polymers may comprise the same or different amounts of diene-derived units. In some embodiments, the first and second polymers each comprise from 0.05 to about 6 wt% diene-derived units. In further embodiments, the first polymer comprises from about 0.5 to about 5.0 wt% diene-derived units, or from about 1.0 to about 3.0 wt% diene-derived units. In the same or different embodiments, the second polymer comprises from about 0.1 to about 1.0 wt% diene-derived units.

**[0025]** The first and second polymers may have a weight average molecular weight (Mw) of 5,000,000 g/mole or less, a number average molecular weight (Mn) of about 3,000,000 g/mole or less, a z-average molecular weight (Mz) of about 10,000,000 g/mole or less, and a g' index of 0.95 or greater measured at the weight average molecular weight (Mw) of the polymer using isotactic polypropylene as the baseline, all of which can be determined by size exclusion chromatography, e.g., 3D SEC, also referred to as GPC-3D.

**[0026]** In one or more embodiments, the first and second polymers have the same or different Mw, and each have an Mw of about 5,000 to about 5,000,000 g/mole, or an Mw of about 10,000 to about 1,000,000, or an Mw of about 20,000 to about 500,000, or an Mw of about 50,000 to about 400,000, where Mw is determined as described herein.

[0027] In one or more embodiments, the first and second polymers may have the same or different Mn, and each have an Mn of about 2,500 to about 2,500,000 g/mole, or an Mn of about 5,000 to about 500,000, or an Mn of about 10,000 to about 250,000, or an Mn of about 25,000 to about 200,000, where Mn is determined as described herein.

5 [0028] In one or more embodiments, the first and second polymers have the same or different Mz, and each have an Mz of about 10,000 to about 7,000,000 g/mole, or an Mz of about 50,000 to about 1,000,000, or an Mz of about 80,000 to about 700,000, or an Mz of about 100,000 to about 500,000, where Mz is determined as described herein.

[0029] The molecular weight distribution (MWD = (Mw/Mn)), sometimes referred to as a  
10 "polydispersity index" (PDI), of the first and second polymers may be the same or different, and may be from about 1.5 to 40. In some embodiments the MWD can have an upper limit of 40, or 20, or 10, or 5, or 4.5, and a lower limit of 1.5, or 1.8, or 2.0. In one or more embodiments, the MWD of the first polymer or the second polymer or both is about 1.8 to 5. Techniques for determining the molecular weight (Mn, Mw, and Mz) and molecular weight  
15 distribution (MWD) can be found in U.S. Patent No. 4,540,753 (Cozewith, Ju and Verstrate) (which is incorporated by reference herein for purposes of U.S. practices) and references cited therein, in Macromolecules, 1988, volume 21, p 3360 (Verstrate et al.), which is herein incorporated by reference for purposes of U.S. practice, and references cited therein, and in accordance with the procedures disclosed in U.S. Patent No. 6,525,157, column 5, lines 1-44,  
20 which patent is hereby incorporated by reference in its entirety.

[0030] In one or more embodiments, the first and second polymers may have a g' index value of 0.95 or greater, or at least 0.97, or at least 0.99, wherein g' is measured at the Mw of the polymer using the intrinsic viscosity of isotactic polypropylene as the baseline. For use herein, the g' index is defined as:

25 
$$g' = \frac{\eta_b}{\eta_l}$$

where  $\eta_b$  is the intrinsic viscosity of the polymer and  $\eta_l$  is the intrinsic viscosity of a linear polymer of the same viscosity-averaged molecular weight ( $M_v$ ) as the polymer.  $\eta_l = KM_v^\alpha$ , K and  $\alpha$  are measured values for linear polymers and should be obtained on the same instrument as the one used for the g' index measurement.

30 [0031] In one or more embodiments, the first and second polymers may have the same or different density, which may be from about 0.85 g/cm<sup>3</sup> to about 0.92 g/cm<sup>3</sup>, or from about

0.87 g/cm<sup>3</sup> to 0.90 g/cm<sup>3</sup>, or from about 0.88 g/cm<sup>3</sup> to about 0.89 g/cm<sup>3</sup> at room temperature as measured per the ASTM D-1505 test method.

[0032] In one or more embodiments, the first and second polymer can have a melt flow rate (MFR, 2.16 kg weight @ 230°C) greater than or equal to 0.2 g/10 min as measured according to the ASTM D-1238(A) test method. The MFR of the first and second polymers can be the same or different. In some embodiments, the MFR (2.16 kg @ 230°C) of the first polymer or the second polymer or both is from about 0.5 g/10 min to about 200 g/10 min, or from about 1 g/10 min to about 100 g/10 min. In some embodiments, the first and/or second polymers have an MFR of from about 0.5 g/10 min to about 200 g/10 min, or from about 2 g/10 min to about 30 g/10 min, or from about 5 g/10 min to about 30 g/10 min, or from about 10 g/10 min to about 30 g/10 min, or from about 10 g/10 min to about 25 g/10 min, or from about 2 g/10 min to about 10 g/10 min.

[0033] The first and/or second polymers may have a Mooney viscosity, ML (1+4)@125°C, as determined according to ASTM D1646, of less than 100, or less than 75, or less than 60, or less than 30. The Mooney viscosity of the first and second polymers may be the same or different.

[0034] In one or more embodiments, the first polymer or second polymer or both may have a heat of fusion (Hf) determined according to the DSC procedure described later, which is greater than or equal to about 0.5 Joules per gram (J/g), and is less than or equal to about 80 J/g, or less than or equal to about 75 J/g, or less than or equal to about 70 J/g, or less than or equal to about 60 J/g, or less than or equal to about 50 J/g. The first polymer or second polymer or both may also have a heat of fusion that is greater than or equal to about 1 J/g, or greater than or equal to about 5 J/g. In another embodiment, the first polymer or second polymer or both may have a heat of fusion (Hf) which is from about 0.5 J/g to about 75 J/g, or from about 1 J/g to about 75 J/g, or from about 3 J/g to about 35 J/g. In some embodiments, the polymers and compositions can be characterized in terms of both their melting points (Tm) and heats of fusion, which properties can be influenced by the presence of comonomers or steric irregularities that hinder the formation of crystallites by the polymer chains. In one or more embodiments, the heat of fusion of the first polymer or the second polymer or both ranges from a lower limit of 1.0 J/g, or 1.5 J/g, or 3.0 J/g, or 4.0 J/g, or 6.0 J/g, or 7.0 J/g, to an upper limit of 30 J/g, or 35 J/g, or 40 J/g, or 50 J/g, or 60 J/g or 70 J/g, or 75 J/g, or 80 J/g. The heat of fusion of the first and second polymers may be the same or different.

[0035] The crystallinity of the first and second polymers can also be expressed in terms of percentage of crystallinity (i.e., % crystallinity). In one or more embodiments, the first polymer and second polymers have the same or different crystallinity, and the % crystallinity of one or both of the polymers may be from 0.5% to 40%, or from 1% to 30%, or from 5% to 25%, where % crystallinity is determined according to the DSC procedure described below. For reference purposes, the thermal energy for the highest order of polypropylene is estimated at 189 J/g (i.e., 100% crystallinity is equal to 209 J/g).

[0036] In addition to this level of crystallinity, the first and second polymers may have a single broad melting transition. However, the polymers can show secondary melting peaks adjacent to the principal peak, but for purposes herein, such secondary melting peaks are considered together as a single melting point, with the highest of these peaks (relative to baseline as described herein) being considered the melting point of the polymer.

[0037] The first and second polymers may have the same or different melting point, and, in some embodiments, one or both of the first and second polymers has a melting point (measured by DSC) of equal to or less than 110°C, or less than 100°C, or less than 90°C, or less than or equal to 80, or less than or equal to 75°C, or from about 25°C to about 80°C, or from about 25°C to about 75°C, or from about 30°C to about 65°C. In these or other embodiments, the melting point of the second polymer is greater than the melting point of the first polymer, and may be greater than about 105°C, or greater than about 110°C, or greater than about 115°C.

[0038] The Differential Scanning Calorimetry (DSC) procedure can be used to determine heat of fusion and melting temperature of the first and second polymers, as well as that of a blend of the first and second polymers. The method is as follows: about 0.5 grams of polymer is weighed out and pressed to a thickness of about 15-20 mils (about 381-508 microns) at about 140°C -150°C, using a "DSC mold" and Mylar as a backing sheet. The pressed pad is allowed to cool to ambient temperature by hanging in air (the Mylar is not removed). The pressed pad is annealed at room temperature (23-25°C) for about 8 days. At the end of this period, an about 15-20 mg disc is removed from the pressed pad using a punch die and is placed in a 10 microliter aluminum sample pan. The sample is placed in a Differential Scanning Calorimeter (Perkin Elmer Pyris 1 Thermal Analysis System) and is cooled to about -100°C. The sample is heated at 10°C/min to attain a final temperature of about 165°C. The thermal output, recorded as the area under the melting peak of the sample, is a measure of the heat of fusion and can be expressed in Joules per gram of polymer and is automatically

calculated by the Perkin Elmer System. The melting point is recorded as the temperature of the greatest heat absorption within the range of melting of the sample relative to a baseline measurement for the increasing heat capacity of the polymer as a function of temperature.

[0039] The first and/or second polymers may further have a triad tacticity of three  
5 propylene units, as measured by  $^{13}\text{C}$  NMR, of 75% or greater, 80% or greater, 82% or greater, 85% or greater, or 90% or greater. In some embodiments, the triad tacticity of the first polymer, the second polymer, or both ranges from about 50 to about 99%, or from about 60 to about 99%, or from about 75 to about 99%, or from about 80 to about 99%, or from about 60 to about 97%. Triad tacticity is determined by the methods described in U.S. Patent  
10 Application Publication 2004/0236042, which is incorporated herein by reference.

#### Preparation of the Polymer Blend

[0040] Particles made from polymers of the type described herein are generally soft to the touch and may be tacky. While these properties are desirable for many end-use applications, the polymers may present storage and handling problems. For example, polymer particles,  
15 commonly referred to in the industry as pellets, made from these polymers have a tendency to agglomerate (or exhibit restricted flow), particularly after long-term warehouse storage at ambient temperatures.

[0041] It has been discovered that agglomeration of these pellets results from deformation of the polymer pellets during storage and handling of the pellets during the first  
20 few hours or days following production of the pellets. Specifically, upon production, polymer pellets generally have shapes that are spherical, cylindrical, disk-like, or other shapes in which the outer surface of the pellets are curved as opposed to flat surfaces. Generally, polymer pellets are free-flowing, as the curved surfaces of the pellets have minimal contact surface and thus slide freely past each other. However, it has been  
25 discovered that under certain circumstances, the curved pellet surfaces may become flattened during storage as a result of the pellets pressing against each other, especially when stored in containers with significant vertical dimensions. When this flattening of the surfaces of the polymer pellets occurs, contact area increases significantly, reducing the ability of the pellet surfaces to slide past each other, leading to agglomeration or restricted flow of the particles in  
30 subsequent processing steps.

[0042] By increasing the rate of crystallization, flattening of the surfaces of the pellets is less likely to occur and the pellets can become hard in the course of conventional polymer

finishing steps to provide free-flowing pellets, even after the pellets are stored for long periods of time at high ambient temperatures.

[0043] The resistance of a pellet to flattening of its surfaces is related to the level of crystallization of the polymers and may be determined by measuring the hardness of the polymer pellets. Generally, it has been determined, in one embodiment, that a Shore A Hardness (ASTM 2240) of at least 50 provides pellets with a reduced tendency to agglomerate. In another embodiment, a Shore A Hardness of at least 55 provides pellets with a reduced tendency to agglomerate. In a further embodiment, a shore A Hardness of at least 60 provides pellets with a reduced tendency to agglomerate. While pellets made from many low crystallinity polymers may achieve this level of hardness following production, it may take days before this level of hardness is attained as the pellets crystallize slowly over time, particularly for propylene-based polymers and copolymers where crystallization kinetics are known to be slower than ethylene-based polymers and copolymers. The processes described herein speed the rate of crystallization of the polymer pellets to provide a hardness, in a short period of time after production, which enables the pellets to flow freely, even after long storage periods.

[0044] In certain embodiments of the processes and blends described herein, a first polymer is blended with a second polymer to produce a polymer blend that, when processed into pellet forms, will achieve a state of crystallization sufficient to provide a Shore A hardness of at least 50, or at least 52, or at least 55, or at least 57, or at least 60, in a relatively short period time (i.e., within 40 minutes after initial cooling of the pellets, or within 30 minutes, or within 20 minutes, or within 15 minutes), as compared to pellets produced from the first polymer alone.

[0045] For purposes of this disclosure, the first polymer, as described above, may generally be considered a low crystallinity polymer, while the second polymer, as described above, may generally be considered a high crystallinity polymer. It has been discovered that the agglomeration tendencies of pellets made from low crystallinity polymers may be reduced or eliminated by blending the low crystallinity polymer with at least one high crystallinity polymer incorporating propylene-derived units having high crystallinity. For purposes of this disclosure, a high crystallinity polymer incorporating propylene-derived units means a polymer incorporating at least 90 wt% of propylene derived units and having a melt temperature of at least 100°C.

[0046] In certain embodiments of the processes and blends described herein, solutions of a first low crystallinity polymer and a second high crystallinity polymer are blended via a process which produces the polymers in separate series or parallel polymerization stages. For example, the first low crystallinity polymer may be produced in a first reactor. An effluent  
5 from the first reactor, containing a solution of the first polymer, is transferred to a second reactor where a catalyst and monomers necessary to produce the second high crystallinity polymer are contacted, so that a solution of the second polymer is produced in the second reactor and in the presence of the first polymer. This is referred to as a series reactor process.

[0047] Both the first polymer and the second polymer may be produced in solution  
10 polymerization reactors. Combining the solutions of the polymeric components resulting from these processes provides an intimate blending of the first and second polymers during polymerization of the second copolymer. The blended polymers are then withdrawn from the second reactor and processed into polymer particles, fibers, films, nonwovens, or other finished articles using conventional processing equipment and techniques.

[0048] Alternatively, the first low crystallinity polymer may be produced in the first  
15 reactor in parallel with the second high crystallinity polymer produced in the second reactor. In parallel polymerization processes, the first and second polymers are produced in parallel reactors with effluents from each reactor, containing solutions of the respective polymer, directed to a device for blending the effluents to produce a solution of blended polymer  
20 components. The blended polymers are then recovered from the solution and processed into polymer particles, fibers, films, nonwovens, or other finished articles in accordance with conventional process equipment and techniques.

[0049] More detailed descriptions of both series and parallel processes suitable for production of the polymer blends described herein, including polymerization conditions and  
25 suitable catalysts for use therein, are found in U.S. Application Publication No. 2004/0024146 and U.S. Application Publication No. 2006/0183861, both of which are incorporated by reference herein in their entireties.

[0050] In alternate embodiments of the present invention, the first and second polymers may be produced in high pressure solution processes. Such processes, including  
30 polymerization conditions and suitable catalysts for use therein, are described in more detail in U.S. Application Publication No. 2009/0163642, which is incorporated by reference herein in its entirety.

[0051] In some embodiments of the present invention, polymer blends of the invention are produced by polymerizing a polymer solution comprising a first polymer in a first reactor, polymerizing a polymer solution comprising a second polymer in a second reactor, combining the first polymer solution with the second polymer solution to produce a polymer blend solution, and processing the polymer blend solution to produce a polymer blend.

#### Properties of the Polymer Blend

[0052] In certain embodiments of the present invention, the polymer blends produced by the dual reactor process described above may incorporate, in neat form, from about 45 wt% to about 98 wt%, or from about 50 wt% to about 98 wt%, or from about 60 wt% to about 98 wt%, or from about 70 wt% to about 98 wt% of the first polymer and from about 2 wt% to about 55 wt%, or from about 2 wt% to about 50 wt%, or from about 2 wt% to about 40 wt%, or from about 2 wt% to about 30 wt% of the second polymer. In another embodiment, in neat form, the polymer blends described herein incorporate from about 80 wt% to about 95 wt% of the first polymer and from about 5 wt% to about 20 wt% of the second polymer. In other embodiments, in neat form, the polymer blends described herein incorporate from about 90 wt% to about 95 wt% of the first polymer and from about 5 wt% to about 10 wt% of the second polymer.

[0053] In further embodiments of the invention, the polymer blends may comprise an overall ethylene content of from about 10 to about 18 wt%, or from about 12 to about 16 wt% ethylene. In the same or other embodiments, the blends may comprise from about 0.1 to about 5.0 wt% diene-derived units, or from about 0.5 to about 3.0 wt% diene-derived units, or from about 1.0 to about 2.0 wt% diene-derived units.

[0054] In some embodiments, the polymer blends described herein may have a melt flow rate (MFR, 2.16 kg weight @ 230°C) of from about 1 to about 10 g/10 min, as measured according to the ASTM D-1238(A) test method. In further embodiments, the MFR of the blend is from about 3 to about 7 g/10 min.

[0055] In some embodiments, the polymer blends may have an Mn of from about 10,000 to about 200,000 g/mole, or from about 20,000 to about 150,000, or from about 30,000 to about 100,000. In the same or other embodiments, the polymer blends may have an Mw of from about 100,000 to about 400,000 g/mole, or from about 150,000 to about 300,000, or from about 200,000 to about 250,000. The polymer blends may also have an MWD of from about 1.5 to about 10, or from about 2.0 to about 4.0. In addition, the polymer blends may have a g' of from about 0.94 to about 0.99, or from about 0.95 to about 0.98.

[0056] The polymer blends described herein may, in some embodiments, have a melting point greater than about 100°C, or greater than about 110°C, or greater than about 115°C. In addition, the heat of fusion of the polymer blends may be less than about 30 J/g, or less than about 25 J/g, or less than about 20 J/g. In some embodiments of the present invention, the polymer blends prepared in dual reactors as described above have a melting point that is at least about 5°C greater, or at least about 10°C greater, than the melting point of a polymer blend having the same overall composition but prepared by physically blending the first and second polymers rather than by reactor blending.

#### Compounding of the Polymer Blend

[0057] In some embodiments of the present invention, the polymer blends described herein may be compounded with one or more additional components. Additional components suitable for compounding with the polymer blend are well known to persons of skill in the art and may include, but are not limited to, coagents, antioxidants, secondary elastomers, polypropylene, additives, fillers, and additive oils. In further embodiments, the polymer blends are compounded with at least one or more coagents or one or more antioxidants, with or without other additional components. In certain embodiments, the polymer blends are compounded with both a coagent and an antioxidant.

[0058] In one or more embodiments, the individual materials and components, such as the polymer blends described herein and optionally the one or more coagents, antioxidants, secondary elastomers, polypropylene, additives, fillers, and/or additive oils may be blended by melt-mixing to form a compounded blend. Examples of machinery capable of generating the required shear and mixing for compounding include extruders with kneaders or mixing elements with one or more mixing tips or flights, extruders with one or more screws, extruders of co or counter rotating type, Banbury mixers, Farrell Continuous mixers, and Buss Kneaders. The type and intensity of mixing, temperature, and residence time required can be achieved by the choice of one of the above machines in combination with the selection of kneading or mixing elements, screw design, and screw speed (<3000 RPM).

[0059] In one or more embodiments, the coagents, antioxidants, and/or other additives can be introduced at the same time as the other polymer components or later downstream, in the case of using an extruder or Buss kneader, or only later in time. In further embodiments, the coagents, antioxidants, and/or other additives may be incorporated into the polymer product by in-line compounding, in which the additives are introduced into the second reactor at the time the second polymer is formed. This eliminates the need for additional

compounding steps and equipment. In addition to the coagents and antioxidants described, other additives can include, but are not limited to, antiblocking agents, antistatic agents, ultraviolet stabilizers, pigments, coloring agents, nucleating agents, fire or flame retardants, plasticizers, vulcanizing or curative agents, vulcanizing or curative accelerators, tackifiers, flow improvers, lubricants, mold release agents, foaming agents, reinforcing agents, and processing aids. The additives can be added to the blend in pure form or in master batches. Fillers suitable for use in the compounded polymer blends of the present invention are well known in the art and may include granular, fibrous, and powder-like fillers. Particular fillers which may be suitable for use in the present invention include natural and synthetic clays, carbon black, and diatomaceous earth, among others.

[0060] Illustrative ingredients with which the polymer blends may be compounded are set forth in greater detail below, but persons of skill in the art will recognize that the following description is not inclusive, and that any material suitable for compounding with the polymer blends described herein may be employed.

#### Coagents

[0061] The polymer blends described herein can optionally include one or more coagents. Suitable coagents may include liquid and metallic multifunctional acrylates and methacrylates, functionalized polybutadiene resins, functionalized cyanurate, and allyl isocyanurate. More particularly, suitable coagents can include, but are not limited to polyfunctional vinyl or allyl compounds such as, for example, triallyl cyanurate, triallyl isocyanurate, pentaerythritol tetramethacrylate, ethylene glycol dimethacrylate, diallyl maleate, dipropargyl maleate, dipropargyl monoallyl cyanurate, azobisisobutyronitrile and the like, and combinations thereof. In one or more embodiments, suitable coagents include triacrylates, and in a particular embodiment the coagent is trimethylolpropane trimethacrylate. Commercially available coagents may be purchased from, for example, Sartomer. An exemplary coagent is Sartomer 350.

[0062] In one or more embodiments, the polymer blends contain at least 0.1 wt% of coagent based on the total weight of blend. In one or more embodiments, the amount of coagent(s) can range from about 0.1 wt% to about 15 wt%, based on the total weight of blend. In one or more embodiments, the amount of coagent(s) can range from a low of about 0.1 wt%, 1.5 wt% or 2.0 wt% to a high of about 4.0 wt%, 7.0 wt%, or 15 wt%, based on the total weight of blend. In further embodiments, the amount of coagent(s) is about 3 wt%, based on the total weight of blend.

*Antioxidants*

[0063] The polymer blends described herein may optionally include one or more antioxidants. Examples of antioxidants include, but are not limited to quinolein, e.g., trimethylhydroxyquinolein (TMQ); imidazole, e.g., zincmercapto toluyil imidazole (ZMTI);  
5 and conventional antioxidants, such as hindered phenols, lactones, phosphates, and hindered amines. Further suitable anti-oxidants are commercially available from, for example, Ciba Geigy Corp. under the tradenames Irgafos 168, Irganox 1010, Irganox 3790, Irganox B225, Irganox 1035, Irgafos 126, Irgastab 410, and Chimassorb 944. In one or more embodiments, the antioxidant comprises a phosphite ester, and may particularly be tris-(2,4-di-tert-  
10 butylphenyl)phosphite. The one or more antioxidants may be added to the polymer blends to protect against degradation during shaping or fabrication operations and/or to better control the extent of chain degradation.

[0064] In one or more embodiments, the polymer blends contain at least 0.1 wt% of antioxidant, based on the total weight of blend. In one or more embodiments, the amount of  
15 antioxidant(s) can range from about 0.1 wt% to about 5 wt%, based on the total weight of blend. In other embodiments, the amount of antioxidant(s) can range from a low of about 0.1 wt%, 0.15 wt% or 0.2 wt% to a high of about 1 wt%, 2.5 wt%, or 5 wt%, based on the total weight of blend. In further embodiments, the amount of antioxidant(s) is about 0.2 wt%, based on the total weight of blend.

*20 Secondary Elastomers*

[0065] The polymer blends of the present invention can optionally include one or more secondary elastomeric components. In at least one specific embodiment, the secondary elastomeric component can be or include one or more ethylene-propylene copolymers (EP). Preferably, the ethylene-propylene polymer (EP) is non-crystalline, e.g., atactic or  
25 amorphous, but in certain embodiments the EP may be crystalline (including "semi-crystalline"). The crystallinity of the EP is preferably derived from the ethylene, and a number of published methods, procedures and techniques are available for evaluating whether the crystallinity of a particular material is derived from ethylene. The crystallinity of the EP can be distinguished from the crystallinity of the propylene-based polymer by  
30 removing the EP from the composition and then measuring the crystallinity of the residual propylene-based polymer. Such crystallinity measured is usually calibrated using the crystallinity of polyethylene and related to the comonomer content. The percent crystallinity

in such cases is measured as a percentage of polyethylene crystallinity and thus the origin of the crystallinity from ethylene is established.

[0066] In one or more embodiments, the EP can include one or more optional polyenes, including particularly a diene; thus, the EP can be an ethylene-propylene-diene terpolymer (commonly called "EPDM"). The optional polyene is considered to be any hydrocarbon structure having at least two unsaturated bonds wherein at least one of the unsaturated bonds is readily incorporated into a polymer. The second bond may partially take part in polymerization to form long chain branches but preferably provides at least some unsaturated bonds suitable for subsequent curing or vulcanization in post polymerization processes. Examples of EP or EPDM copolymers include those that are available under the trade name Vistalon from ExxonMobil Chemicals. Several commercial EPDMs are available from DOW under the tradenames Nordel IP and MG. Certain rubber components (e.g., EPDMs, such as Vistalon 3666) include additive oil that is preblended before the rubber component is combined with the thermoplastic. The type of additive oil utilized will be that customarily used in conjunction with a particular rubber component.

[0067] Examples of the optional polyenes include, but are not limited to, butadiene; pentadiene; hexadiene (e.g., 1,4-hexadiene); heptadiene (e.g., 1,6-heptadiene); octadiene (e.g., 1,7-octadiene); nonadiene (e.g., 1,8-nonadiene); decadiene (e.g., 1,9-decadiene); undecadiene (e.g., 1,10-undecadiene); dodecadiene (e.g., 1,11-dodecadiene); tridecadiene (e.g., 1,12-tridecadiene); tetradecadiene (e.g., 1,13-tetradecadiene); pentadecadiene; hexadecadiene; heptadecadiene; octadecadiene; nonadecadiene; icosadiene; heneicosadiene; docosadiene; tricosadiene; tetracosadiene; pentacosadiene; hexacosadiene; heptacosadiene; octacosadiene; nonacosadiene; triacontadiene; and polybutadienes having a molecular weight (Mw) of less than 1000 g/mol. Examples of straight chain acyclic dienes include, but are not limited to 1,4-hexadiene and 1,6-octadiene. Examples of branched chain acyclic dienes include, but are not limited to 5-methyl-1,4-hexadiene, 3,7-dimethyl-1,6-octadiene, and 3,7-dimethyl-1,7-octadiene. Examples of single ring alicyclic dienes include, but are not limited to 1,4-cyclohexadiene, 1,5-cyclooctadiene, and 1,7-cyclododecadiene. Examples of multi-ring alicyclic fused and bridged ring dienes include, but are not limited to tetrahydroindene; norbornadiene; methyltetrahydroindene; dicyclopentadiene; bicyclo(2.2.1)hepta-2,5-diene; and alkenyl-, alkylidene-, cycloalkenyl-, and cycloalkylidene norbornenes [including, e.g., 5-methylene-2-norbornene; 5-ethylidene-2-norbornene; 5-propenyl-2-norbornene; 5-isopropylidene-2-norbornene; 5-(4-cyclopentenyl)-2-norbornene; 5-cyclohexylidene-2-

norbornene; and 5-vinyl-2-norbornene]. Examples of cycloalkenyl-substituted alkenes include, but are not limited to vinyl cyclohexene; allyl cyclohexene; vinylcyclooctene; 4-vinylcyclohexene; allyl cyclodecene; vinylcyclododecene; and tetracyclododecadiene.

[0068] In another embodiment, the secondary elastomeric component can include, but is not limited to, styrene/butadiene rubber (SBR); styrene/isoprene rubber (SIR); styrene/isoprene/butadiene rubber (SIBR); styrene-butadiene-styrene block copolymer (SBS); hydrogenated styrene-ethylene/butylene-styrene block copolymer (SEBS); hydrogenated styrene-ethylene block copolymer (SEB); styrene-isoprene-styrene block copolymer (SIS); styrene-isoprene block copolymer (SI); hydrogenated styrene-isoprene block copolymer (SEP); hydrogenated styrene-isoprene-styrene block copolymer (SEPS); styrene-ethylene/butylene-ethylene block copolymer (SEBE); styrene-ethylene-styrene block copolymer (SES); ethylene-ethylene/butylene block copolymer (EEB); ethylene-ethylene/butylene/styrene block copolymer (hydrogenated BR-SBR block copolymer); ethylene-ethylene/butylene-ethylene block copolymer (EEBE); ethylene-ethylene/alpha-olefin block copolymers; polyisoprene rubber; polybutadiene rubber; isoprene butadiene rubber (IBR); polysulfide; nitrile rubber; propylene oxide polymers; star-branched butyl rubber and halogenated star-branched butyl rubber; brominated butyl rubber; chlorinated butyl rubber; star-branched polyisobutylene rubber; star-branched brominated butyl (polyisobutylene/isoprene copolymer) rubber; poly(isobutylene-co-alkylstyrene); preferably isobutylene/methylstyrene copolymers such as isobutylene/meta-bromomethylstyrene; isobutylene/bromomethylstyrene; isobutylene/chloromethylstyrene; halogenated isobutylene cyclopentadiene; and isobutylene/chloromethylstyrene, and mixtures thereof. Preferred secondary elastomeric components include hydrogenated styrene-ethylene/butylene-styrene block copolymer (SEBS), and hydrogenated styrene-isoprene-styrene block copolymer (SEPS).

[0069] The secondary elastomeric component can also be or include natural rubber. Natural rubbers are described in detail by *Subramaniam* in RUBBER TECHNOLOGY, pp. 179-208 (1995). Suitable natural rubbers may be Malaysian rubbers such as SMR CV, SMR 5, SMR 10, SMR 20, and SMR 50 and mixtures thereof, wherein the natural rubbers have a Mooney viscosity at 100°C (ML 1+4) of from 30 to 120, more preferably from 40 to 65. The Mooney viscosity test referred to herein is in accordance with ASTM D-1646.

[0070] The secondary elastomeric component can also be or include one or more synthetic rubbers. Suitable commercially available synthetic rubbers include NATSYN™

(Goodyear Chemical Company), and BUDENE™ 1207 or BR 1207 (Goodyear Chemical Company). A desirable rubber is high cis-polybutadiene (cis-BR). By "cis-polybutadiene" or "high cis-polybutadiene", it is meant that 1,4-cis polybutadiene is used, wherein the amount of cis component is at least 95%. An example of a high cis-polybutadiene commercial product is BUDENE™ 1207.

[0071] The secondary elastomeric component can be present in an amount of up to 50 phr in one embodiment, or up to 40 phr in another embodiment, or up to 30 phr in yet another embodiment. In one or more embodiments, the amount of the secondary rubber component can range from a low of about 1, 7, or 20 phr to a high of about 25, 35, or 50 phr.

#### 10 *Polypropylene*

[0072] In one or more embodiments, the compounded polymer blends described herein may contain additional amounts of polypropylene. The term "polypropylene" as used herein broadly means any polymer that is considered a "polypropylene" by persons skilled in the art (as reflected in at least one patent or publication), and includes homo, impact, and random polymers of propylene. Preferably, the polypropylene used in the compositions described herein has a melting point above 110°C, includes at least 90 wt% propylene units, and contains isotactic sequences of those units. The polypropylene can also include atactic sequences or syndiotactic sequences, or both. The polypropylene can also include essentially syndiotactic sequences such that the melting point of the polypropylene is above 110°C. The polypropylene can either derive exclusively from propylene monomers (i.e., having only propylene units) or derive from mainly propylene (more than 80% propylene) with the remainder derived from olefins, particularly ethylene, and/or C<sub>4</sub>-C<sub>10</sub> alpha-olefins. As noted elsewhere herein, certain polypropylenes have a high MFR (e.g., from a low of 10, or 15, or 20 g/10 min to a high of 25 to 30 g/10 min). Others have a lower MFR, e.g., "fractional" polypropylenes which have an MFR less than 1.0. Those with high MFR may be preferred for ease of processing or compounding.

#### *Additive Oil*

[0073] The polymer blends described herein can also optionally include one or more additive oils. The term "additive oil" includes both "process oils" and "extender oils." For example, "additive oil" may include hydrocarbon oils and plasticizers, such as organic esters and synthetic plasticizers. Many additive oils are derived from petroleum fractions, and have particular ASTM designations depending on whether they fall into the class of paraffinic, naphthenic, or aromatic oils. Other types of additive oils include mineral oil, alpha olefinic

synthetic oils, such as liquid polybutylene, e.g., products sold under the trademark Parapol®. Additive oils other than petroleum based oils can also be used, such as oils derived from coal tar and pine tar, as well as synthetic oils, e.g., polyolefin materials (e.g., SpectraSyn™ and Elevast™, both supplied by ExxonMobil Chemical Company).

5    **[0074]**    The ordinarily skilled chemist will recognize which type of oil should be used with a particular composition, and will also be able to determine the suitable amount (quantity) of oil to be added. The additive oil can be present in amounts from about 5 to about 300 parts by weight per 100 parts by weight of the blend.

10   **[0075]**    In some embodiments, the additive oil comprises a polybutene oil. Preferable polybutene oils have an Mn of less than 15,000, and include homopolymers or copolymers of olefin-derived units having from 3 to 8 carbon atoms and more preferably from 4 to 6 carbon atoms. In one or more embodiments, the polybutene is a homopolymer or copolymer of a C<sub>4</sub> raffinate. An embodiment of preferred low molecular weight polymers termed "polybutene" polymers is described in, for example, SYNTHETIC LUBRICANTS AND HIGH-PERFORMANCE  
15   FUNCTIONAL FLUIDS 357-392 (Leslie R. Rudnick & Ronald L. Shubkin, ed., Marcel Dekker 1999) (hereinafter "polybutene processing oil" or "polybutene").

20   **[0076]**    In one or more embodiments, the polybutene processing oil is a copolymer having at least isobutylene derived units, and optionally 1-butene derived units, and/or 2-butene derived units. In one embodiment, the polybutene is a homopolymer if isobutylene, or a copolymer of isobutylene and 1-butene or 2-butene, or a terpolymer of isobutylene and 1-butene and 2-butene, wherein the isobutylene derived units are from 40 to 100 wt% of the copolymer, the 1-butene derived units are from 0 to 40 wt% of the copolymer, and the 2-butene derived units are from 0 to 40 wt% of the copolymer. In another embodiment, the polybutene is a copolymer or terpolymer wherein the isobutylene derived units are from 40 to  
25   99 wt% of the copolymer, the 1-butene derived units are from 2 to 40 wt% of the copolymer, and the 2-butene derived units are from 0 to 30 wt% of the copolymer. In yet another embodiment, the polybutene is a terpolymer of the three units, wherein the isobutylene derived units are from 40 to 96 wt% of the copolymer, the 1-butene derived units are from 2 to 40 wt% of the copolymer, and the 2-butene derived units are from 2 to 20 wt% of the  
30   copolymer. In yet another embodiment, the polybutene is a homopolymer or copolymer of isobutylene and 1-butene, wherein the isobutylene derived units are from 65 to 100 wt% of the homopolymer or copolymer, and the 1-butene derived units are from 0 to 35 wt% of the copolymer. Commercial examples of a suitable processing oil include the PARAPOL™

series of processing oils or polybutene grades or Indopol™ oils, from Soltex Synthetic Oils and Lubricants or from BP/Innovene.

5 [0077] In certain embodiments, the processing oil or oils can be present at from 1 to 60, or from 2 to 40, or from 4 to 35, or from 5 to 30 parts by weight per 100 parts by weight of the blend.

#### Applications

10 [0078] The polymer blends of the present invention, whether compounded or not, may be formed or shaped into a wide variety of finished articles by finishing methods well known to those of skill in the art. Such articles may include, but are not limited to, films, fibers, nonwovens, coatings, molded articles, and the like. Finished articles may be formed by any suitable process, such as for example extrusion, blow molding, injection molding, meltblowing, spunbonding, compression molding, fiber spinning, and other processes known to those familiar with the art. The blends of the present invention are particularly useful in applications requiring stretchable elastic materials, such as in disposable diapers, training pants, incontinence pads, clothing, undergarments, sports apparel, automotive trim, weather-stripping, gaskets, and furniture upholstery, among others.

#### Crosslinking

20 [0079] The polymer blends of the present invention, whether compounded as described above or not and whether formed into finished articles or not, may be at least partially crosslinked by a variety of methods known in the art. One such method for at least partially crosslinking the polymer blends is by exposing the blend to energetic photons. In particular, crosslinking of the blend may be accomplished by exposing the blend to electromagnetic radiation having a frequency greater than that of visible light, such as for example near ultraviolet radiation, extreme ultraviolet radiation, soft x-rays, hard x-rays, gamma rays, and high-energy gamma rays. In certain embodiments of the present invention, crosslinking is accomplished by electron beam radiation, or “e-beam” radiation.

25 [0080] E-beam radiation is a form of ionizing energy that is generally characterized by its low penetration and high dose rates. The electrons are generated by equipment referred to as accelerators which are capable of producing beams that are either pulsed or continuous. The term “beam” is meant to include any area exposed to electrons, which may range from a focused point to a broader area, such as a line or field. The electrons are produced by a series of cathodes (electrically heated tungsten filaments) that generate a high concentration of electrons. These electrons are then accelerated across a potential. The accelerating potential

is typically in the keV to MeV range (where eV denotes electron volts), depending on the depth of penetration required. The irradiation dose is usually measured in Gray (unit) but also in rads, where 1Gy is equivalent to 100 rad, or, more typically, 10 kGy equals 1 Mrad. Commercial e-beam units generally range in energies from 50 keV to greater than 10 MeV (million electron volts).

[0081] In one or more embodiments herein, the polymer blends or articles formed from the polymer blends are at least partially crosslinked or cured so that they become heat-resistant. As used herein, the term "heat-resistant" refers to the ability of a polymer composition or an article formed from a polymer composition to pass the high temperature heat-setting tests described herein. As used herein, the terms "cured," "crosslinked," "at least partially cured," and "at least partially crosslinked" refer to a composition having at least 2 wt% insolubles based on the total weight of the composition. In one or more embodiments, the compositions described herein can be cured to a degree so as to provide at least 3 wt%, or at least 5 wt%, or at least 10 wt%, or at least 20 wt%, or at least 35 wt%, or at least 45 wt%, or at least 65 wt%, or at least 75 wt%, or at least 85 wt%, or less than 95 wt% insolubles using Xylene as the solvent by Soxhlet extraction.

[0082] In a particular embodiment, the crosslinking is accomplished by subjecting the polymers described herein to e-beam radiation. Suitable e-beam equipment is available from E-BEAM Services, Inc., or from PCT Engineered Systems, LLC. In a particular embodiment, electrons are employed at a dose of about 100 kGy or less in multiple exposures. The source can be any electron beam unit operating in a range of about 50 KeV to greater than 10 MeV with a power output capable of supplying the desired dosage. The electron voltage can be adjusted to appropriate levels, which may be, for example, 100,000 eV; 300,000 eV; 1,000,000 eV; 2,000,000 eV; 3,000,000 eV; or 6,000,000 eV. A wide range of apparatuses for irradiating polymers and polymeric articles is available.

[0083] Effective irradiation is generally carried out at a dosage from about 10 kGy to about 100 kGy, or from about 20 to about 90 kGy, or from about 30 to about 80 kGy, or from about 50 to about 60 kGy. In a particular aspect of this embodiment, the irradiation is carried out at room temperature.

[0084] Without wishing to be bound by theory, it is believed that two competing processes occur upon irradiation of polymers comprising propylene and ethylene, such as the inventive polymers described herein. In portions of the polymer chains containing pendant methyl groups (such as those polymer units derived from propylene), the carbon atoms in the

polymer backbone are susceptible to chain scission upon irradiation, which results in lowered molecular weight. The irradiation process also breaks the bonds between carbon and hydrogen atoms comprising the backbones of the polymer chains, creating free radicals that are available to cross-link with free radicals on adjacent polymer chains. Thus, irradiation  
5 leads to cross-linking, which builds a polymer network, as well as scission, which disrupts formation of a broad polymer network. To provide polymers with good tensile and elastic properties, it is desired to reduce chain scission while encouraging crosslinking of adjacent polymer chains.

**[0085]** In polymers containing predominantly propylene, the dominant mechanism which  
10 takes place upon irradiation is scissioning. In polyethylene polymers, on the other hand, the dominant mechanism is crosslinking. The inclusion of ethylene-derived units in the propylene-rich polymer blends described herein therefore enhances crosslinking and reduces chain scission, leading to improved crosslinking. In addition, the inclusion of a non-conjugated diene in the polymer blends, such as ENB, also creates a greater preference for  
15 crosslinking in the overall polymer blend.

**[0086]** To further optimize the polymer blends herein and enhance cross-linking, both a coagent and an antioxidant may be added to the polymer blend formulation in a compounding step prior to irradiation. Again without wishing to be bound by theory, it is believed that coagents enhance crosslinking behavior, while antioxidants suppress chain scission. The sum  
20 total, therefore, is improved crosslinking when compared to polymers lacking a coagent, an antioxidant, or both. In other words, the polymer chains of the inventive polymer blends described herein stay longer in length due to reduced scissioning, thus forming a crosslinked network that extends over a greater distance within the polymer blend. This enhanced crosslinking in turn leads to improved tension set, elongation, stress, and other mechanical  
25 properties of the polymers.

**[0087]** In another embodiment, crosslinking can be accomplished by exposure to one or more chemical agents in addition to the e-beam cure. Illustrative chemical agents include but are not limited to peroxides and other free radical generating agents, sulfur compounds, phenolic resins, and silicon hydrides. In a particular aspect of this embodiment, the  
30 crosslinking agent is either a fluid or is converted to a fluid such that it can be applied uniformly to the article. Fluid crosslinking agents include those compounds which are gases (e.g., sulfur dichloride), liquids (e.g., Trigonox C, available from Akzo Nobel), solutions

(e.g., dicumyl peroxide in acetone), or suspensions thereof (e.g., a suspension or emulsion of dicumyl peroxide in water, or redox systems based on peroxides).

[0088] Illustrative peroxides include, but are not limited to dicumyl peroxide; di-tert-butyl peroxide; t-butyl perbenzoate; benzoyl peroxide; cumene hydroperoxide; t-butyl peroctoate; methyl ethyl ketone peroxide; 2,5-dimethyl-2,5-di(t-butyl peroxy)hexane; lauryl peroxide; and tert-butyl peracetate. When used, peroxide curatives are generally selected from organic peroxides. Examples of organic peroxides include, but are not limited to, di-tert-butyl peroxide; dicumyl peroxide; t-butylcumyl peroxide;  $\alpha$ ,  $\alpha$ -bis(tert-butylperoxy) diisopropyl benzene; 2,5 dimethyl 2,5-di(t-butylperoxy)hexane; 1,1-di(t-butylperoxy)-3,3,5-trimethyl cyclohexane; butyl-4,4-bis(tert-butylperoxy) valerate; benzoyl peroxide; lauroyl peroxide; dilauroyl peroxide; 2,5-dimethyl-2,5-di(tert-butylperoxy) hexene-3; and mixtures thereof. Also, diaryl peroxides; ketone peroxides; peroxydicarbonates; peroxyesters; dialkyl peroxides; hydroperoxides; peroxyketals; and mixtures thereof may be used.

[0089] In one or more embodiments, the crosslinking can be carried out using hydrosilylation techniques.

[0090] In one or more embodiments, the crosslinking can be carried out under an inert or oxygen-limited atmosphere. Suitable atmospheres can be provided by the use of helium, argon, nitrogen, carbon dioxide, xenon and/or a vacuum.

[0091] Crosslinking either by chemical agents or by irradiation can be promoted with a crosslinking catalyst, such as organic bases, carboxylic acids, and organometallic compounds including organic titanates and complexes or carboxylates of lead, cobalt, iron, nickel, zinc, and tin (such as dibutyltindilaurate, dioctyltinmaleate, dibutyltindiacetate, dibutyltindioctoate, stannous acetate, stannous octoate, lead naphthenate, zinc caprylate, cobalt naphthenate, and the like). In the case where irradiation is accomplished via ultraviolet radiation, one or more UV sensitizers, which generate free radicals in the presence of UV radiation, may be employed to promote crosslinking. Such UV sensitizers are known in the art, and include halogenated polynuclear ketones, organic carbonyl compounds selected from alkyl phenones, benzophenones, and tricyclic fused ring compounds, and carbonylated phenol nuclear sulfonyl chlorides.

#### 30 Properties of the Crosslinked Polymer Blends

[0092] The at least partially crosslinked blends described herein combine good mechanical and elastic properties with improved pellet stability to provide optimized materials well suited for a variety of uses. In particular, the blends of the present invention

exhibit better pellet stability than blends having similar compositions but prepared in a single reactor. The crosslinked compounded blends described herein which contain at least one coagent and at least one antioxidant also exhibit better mechanical and elastic properties when compared to similar crosslinked compositions prepared in the same manner but lacking a coagent and an antioxidant.

[0093] Surprisingly, it has further been found that inclusion of both a coagent and an antioxidant in the crosslinked blends described herein has a synergistic effect, as described in more detail above, leading to improved properties in comparison to similar compositions comprising a coagent or an antioxidant, but not both.

[0094] As a result of the processes and formulations set forth in this invention, in one or more embodiments, the polymer blends of the invention have a melt temperature at least about 5°C higher than a polymer blend having the same composition but formed by physically blending the polymer rather than by reactor blending.

[0095] In the same or other embodiments, the polymer blend compositions herein which comprise a coagent exhibit greater peak stress and/or peak elongation than polymers prepared the same way and having the same composition but lacking a coagent. In some embodiments, the polymer blend compositions herein which comprise a coagent exhibit greater improvements in tension set upon crosslinking than polymers prepared the same way and having the same composition but lacking a coagent.

[0096] In the same or other embodiments, the polymer blend compositions herein which comprise an antioxidant exhibit greater peak stress and/or peak elongation than polymers prepared the same way and having the same composition but lacking an antioxidant. In some embodiments, the polymer blend compositions herein which comprise an antioxidant exhibit greater improvements in tension set upon crosslinking than polymers prepared the same way and having the same composition but lacking an antioxidant.

[0097] In further embodiments, the polymer blend compositions herein which comprise both a coagent and an antioxidant exhibit greater peak stress and/or peak elongation than polymers prepared the same way and having the same composition but lacking a coagent and/or an antioxidant. In some embodiments, the polymer blend compositions herein which comprise both a coagent and an antioxidant exhibit greater improvements in tension set upon crosslinking than polymers prepared the same way and having the same composition but lacking a coagent and/or an antioxidant.

**Examples**

[0098] The foregoing discussion can be further described with reference to the following non-limiting examples.

5 [0099] Five polymer blends, designated A through E, were prepared by a dual reactor method as described above using a parallel reactor configuration and a bis(cyclopentadienyl) metallocene catalyst system. Properties of the blends, including properties of the first polymer and second polymer comprising the blend, are reported in Table 1, below.

**Table 1**

| <b>Blend ID</b>                    | <b>A</b> | <b>B</b> | <b>C</b> | <b>D</b> | <b>E</b> |
|------------------------------------|----------|----------|----------|----------|----------|
| <b>Reaction Temp (°C)</b>          | 64.00    | 58.40    | 56.28    | 57.57    | 56.20    |
| <b>Polymerization Rate (kg/hr)</b> | 7.71     | 8.35     | 8.19     | 8.22     | 7.69     |
| <b>First Polymer Properties</b>    |          |          |          |          |          |
| Wt% C <sub>2</sub>                 | 15.69    | 16.12    | 15.98    | 16.34    | 16.83    |
| Wt% ENB                            | 0.19     | 1.62     | 1.63     | 2.03     | 2.18     |
| Wt% Irganox 1076                   | 0.04     | 0.08     | 0.36     | 0.07     | 0.17     |
| MFR (g/10 min)                     | 3.81     | 5.97     | 5.95     | 5.38     | 4.82     |
| <b>Second Polymer Properties</b>   |          |          |          |          |          |
| Wt% C <sub>2</sub>                 | 6.25     | 7.10     | 6.30     | 5.84     | 6.09     |
| Wt% ENB                            | 0.23     | 0.73     | 0.72     | 0.87     | 0.95     |
| Wt% Irganox 1076                   | 0.04     | 0.04     | 0.27     | 0.13     | 0.32     |
| MFR (g/10 min)                     | 7.40     | 7.24     | 5.62     | 6.75     | 5.43     |
| <b>Overall Blend Properties</b>    |          |          |          |          |          |
| Wt% C <sub>2</sub>                 | 13.87    | 14.54    | 14.55    | 14.08    | 15.59    |
| Wt% ENB                            | 0.19     | 1.41     | 1.40     | 1.78     | 1.87     |
| Wt% Irganox 1076                   | 0.08     | 0.04     | 0.06     | 0.04     | 0.04     |
| MFR (g/10 min)                     | 4.35     | 7.15     | 4.62     | 7.49     | 6.21     |

10 [00100] Molecular weight characteristics and thermal characteristics of polymer blends A through E are shown in Table 2, below. Also shown are the same characteristics for a comparative polymer having a similar composition but prepared in a single reactor. Specifically, the comparative polymer is available commercially from ExxonMobil Chemical Co. as Vistamaxx<sup>TM</sup> 6102, which comprises approximately 16 wt% ethylene and has an MFR of approximately 2 g/10 min.

Table 2

| Blend ID | A      | B      | C      | D      | E      | Comp.  |
|----------|--------|--------|--------|--------|--------|--------|
| Mn       | 98700  | 90800  | 96500  | 55900  | 22200  | 110000 |
| Mw       | 235000 | 210000 | 230000 | 205600 | 204500 | 235000 |
| MWD      | 2.4    | 2.3    | 2.4    | 3.7    | 9.2    | 2.1    |
| g'       | 0.95   | 0.96   | 0.96   | 0.97   | 0.98   | 0.98   |
| Tm (°C)  | 114    | 119    | 117    | 119    | 119    | 106    |
| Hf (J/g) | 3.7    | 4.8    | 4.8    | 4.4    | 4.5    | 1.9    |

**Examples 1-11**

[00101] Polymer blends A through E were then compounded with polypropylene, a coagent, an antioxidant, or combinations thereof. Each composition was prepared in a Brabender thermoplastic compounder. The pellets of blends A through E were charged into the Brabender in the presence of a nitrogen blanket along with the antioxidants at a melt temperature of 150°C for 3 minutes. The temperature was then lowered to 140°C and the coagent, antioxidant, and/or polypropylene were added and mixed for about 2 minutes to obtain a homogenous blend. The compounded blends were then molded into plaques having a thickness of 75 mils and films having a thickness of 10 mils on a compression molding press.

[00102] The resulting compounded formulations, identified herein as Examples 1 through 6, were crosslinked using e-beam radiation, first at 50 kGy and then at 60 kGy. The compositions, process conditions, and mechanical properties of Examples 1-6 are reported in Table 3, below.

[00103] Comparative examples were also prepared from polymer blends A through E by the same procedure, except that the blends do not contain a coagent, an antioxidant, or polypropylene. The compositions, process conditions, and mechanical properties of Comparative Examples 7-11 are reported in Table 4, below.

[00104] PP 9122 is a random copolymer of polypropylene (RCP) containing 2-3 wt% ethylene-derived units, and the balance polypropylene. PP 9122 has an MFR (2.16 kg at 230°C) of 2.1 g/10min and a density of 0.9 g/cm<sup>3</sup>. The 1% secant flexural modulus is 140 kPsi, as measured by ASTM D790A. PP 9122 is commercially available from ExxonMobil Chemical Company.

[00105] Sartomer 350 is a trimethylolpropane trimethacrylate coagent that is commercially available from Sartomer Company, Inc.

[00106] Irgafos 168 is an antioxidant that is commercially available from Ciba Specialty Chemicals.

[00107] Physical properties of the compositions were evaluated before and after curing. Hardness was tested according to ASTM 2240, and the tension set of the blends was tested according to ASTM D412 at room temperature and 70°C. For room temperature and 70°C testing for tension set, the sample was aged at the test temperature for 30 minutes under 50% tension on Jig and annealed at room temperature for 30 minute after removing from the Jig. A xylene Soxhlet solvent extraction test was conducted according to ASTM D5492 on the cured samples using a Soxhlet extractor (extraction time = 12 hrs) to understand the level of crosslinked material after e-beam curing. Results are expressed as: percent Xylene insoluble = weight after extraction/weight before extraction\*100.

**Table 3**

| Example No.                  | 1    | 2    | 3    | 4    | 5    | 6    |
|------------------------------|------|------|------|------|------|------|
| <b>Composition (wt%)</b>     |      |      |      |      |      |      |
| Blend A                      | 96.8 |      |      |      |      |      |
| Blend B                      |      | 96.8 |      |      |      |      |
| Blend C                      |      |      | 96.8 |      |      | 91.8 |
| Blend D                      |      |      |      | 96.8 |      |      |
| Blend E                      |      |      |      |      | 96.8 |      |
| PP9122                       | 0    | 0    | 0    | 0    | 0    | 5.0  |
| Sartomer 350                 | 3.0  | 3.0  | 3.0  | 3.0  | 3.0  | 3.0  |
| Irgafos 168                  | 0.2  | 0.2  | 0.2  | 0.2  | 0.2  | 0.2  |
| <b>Mixing Conditions</b>     |      |      |      |      |      |      |
| RPM                          | 40   | 40   | 40   | 40   | 40   | 40   |
| Mixing Temp (°C)             | 150  | 150  | 150  | 150  | 150  | 150  |
| Mixing Time (min)            | 3    | 3    | 3    | 3    | 3    | 3    |
| Cooling Temp (°C)            | 140  | 140  | 140  | 140  | 140  | 140  |
| Cooling Time (min)           | 2    | 2    | 2    | 2    | 2    | 2    |
| <b>Mechanical Properties</b> |      |      |      |      |      |      |
| <b>Before E-Beaming</b>      |      |      |      |      |      |      |
| Stress at Break (MPa)        | 15.3 | N/A  | N/A  | N/A  | N/A  | N/A  |
| Elongation at Break (%)      | 787  | N/A  | N/A  | N/A  | N/A  | N/A  |
| Peak Stress (Mpa)            | 15.3 | 11.5 | 13.9 | 12.8 | 10.6 | 15.3 |
| Peak Elongation (%)          | 787  | 902  | 855  | 890  | 902  | 865  |
| 100% Modulus (Mpa)           | 2.7  | 1.9  | 2.0  | 2.1  | 1.6  | 2.2  |

Table 3 Cont.

| Example No.                      | 1    | 2    | 3    | 4    | 5    | 6    |
|----------------------------------|------|------|------|------|------|------|
| Mechanical Properties            |      |      |      |      |      |      |
| <b>Before E-Beaming</b>          |      |      |      |      |      |      |
| Tension Set, 23°C (%)            | 5.0  | 4.0  | 4.0  | 4.0  | 4.0  | 4.0  |
| Tension Set, 70°C (%)            | 39.0 | 42.0 | 41.0 | 39.0 | 43.0 | 45.0 |
| MFR (230°C, 2.16 kg)             | 4.5  | 7.6  | 5.4  | 8.5  | 6.1  | 5.0  |
| <b>E-beamed at 50 kGy</b>        |      |      |      |      |      |      |
| Hardness, Shore A, 15s.          | 70   | 63   | 63   | 66   | 61   | 67   |
| Stress at Break (Mpa)            | N/A  | N/A  | 15.3 | 14.4 | 12.4 | 15.4 |
| Elongation at Break (%)          | N/A  | N/A  | 784  | 816  | 800  | 766  |
| Peak Stress (Mpa)                | 16.9 | 15.3 | 15.3 | 14.4 | 12.4 | 15.4 |
| Peak Elongation (%)              | 860  | 820  | 784  | 816  | 800  | 766  |
| 100% Modulus (Mpa)               | 2.8  | 2.0  | 2.2  | 2.2  | 1.8  | 2.3  |
| Tension Set, 23°C (%)            | 6.0  | 4.0  | 3.0  | 4.0  | 3.0  | 4.0  |
| Tension Set, 70°C (%)            | 34.0 | 25.0 | 24.0 | 29.0 | 24.0 | 26.0 |
| Xylene Extraction (% insolubles) | 76   | 81   | 81   | 81   | --   | 82   |
| <b>E-beamed at 60 kGy</b>        |      |      |      |      |      |      |
| Stress at Break (Mpa)            | N/A  | 13.5 | 13.7 | 13.9 | 11.7 | 13.7 |
| Elongation at Break (%)          | N/A  | 777  | 750  | 797  | 768  | 746  |
| Peak Stress (Mpa)                | 17.0 | 13.5 | 13.7 | 13.9 | 11.7 | 13.7 |
| Peak Elongation (%)              | 820  | 777  | 750  | 797  | 768  | 746  |
| 100% Modulus (Mpa)               | 3.0  | 2.0  | 2.2  | 2.2  | 1.9  | 2.4  |
| Tension Set, 23°C (%)            | 6.0  | 4.0  | 3.0  | 4.0  | 3.0  | 4.0  |
| Tension Set, 70°C (%)            | 34.0 | 24.0 | 24.0 | 27.0 | 28.0 | 26.0 |

Table 4 (Comparative Examples)

| Example No.              | 7   | 8   | 9   | 10  | 11  |
|--------------------------|-----|-----|-----|-----|-----|
| <b>Composition (wt%)</b> |     |     |     |     |     |
| Blend A                  | 100 |     |     |     |     |
| Blend B                  |     | 100 |     |     |     |
| Blend C                  |     |     | 100 |     |     |
| Blend D                  |     |     |     | 100 |     |
| Blend E                  |     |     |     |     | 100 |
| PP9122                   | 0   | 0   | 0   | 0   | 0   |
| Sartomer 350             | 0   | 0   | 0   | 0   | 0   |

Table 4 (Comparative Examples) Cont.

| Example No.                      | 7    | 8    | 9    | 10   | 11   |
|----------------------------------|------|------|------|------|------|
| <b>Composition (wt%)</b>         |      |      |      |      |      |
| Irgafos 168                      | 0    | 0    | 0    | 0    | 0    |
| <b>Mixing Conditions</b>         |      |      |      |      |      |
| RPM                              | 40   | 40   | 40   | 40   | 40   |
| Mixing Temp (°C)                 | 150  | 150  | 150  | 150  | 150  |
| Mixing Time (min)                | 3    | 3    | 3    | 3    | 3    |
| Cooling Temp (°C)                | 140  | 140  | 140  | 140  | 140  |
| Cooling Time (min)               | 2    | 2    | 2    | 2    | 2    |
| <b>Before E-Beaming</b>          |      |      |      |      |      |
| Hardness, Shore A, 15s.          | 70   | 61   | 63   | 63   | 57   |
| Stress at Break (Mpa)            | N/A  | N/A  | N/A  | N/A  | N/A  |
| Elongation at Break (%)          | N/A  | N/A  | N/A  | N/A  | N/A  |
| Peak Stress (Mpa)                | 18.9 | 11.9 | 14.7 | 13.8 | 11.7 |
| Peak Elongation (%)              | 805  | 871  | 834  | 857  | 848  |
| 100% Modulus (Mpa)               | 3.0  | 2.0  | 2.2  | 2.2  | 1.8  |
| Tension Set, 23°C (%)            | 5.0  | 4.0  | 4.0  | 5.0  | 4.0  |
| Tension Set, 70°C (%)            | 36.0 | 42.0 | 42.0 | 41.0 | 43.0 |
| MFR (230°C, 2.16 kg)             | 4.3  | 6.9  | 4.6  | 7.6  | 5.5  |
| <b>E-beamed at 50 kGy</b>        |      |      |      |      |      |
| Hardness, Shore A, 15s.          | 67   | 62   | 66   | 66   | 57   |
| Stress at Break (Mpa)            | N/A  | N/A  | 11.8 | N/A  | N/A  |
| Elongation at Break (%)          | N/A  | N/A  | 842  | N/A  | N/A  |
| Peak Stress (Mpa)                | 14.0 | 11.5 | 11.8 | 12.6 | 11.1 |
| Peak Elongation (%)              | 880  | 860  | 842  | 880  | 860  |
| 100% Modulus (Mpa)               | 2.9  | 1.9  | 2.1  | 2.2  | 1.8  |
| Tension Set, 23°C (%)            | 5.0  | 4.0  | 4.0  | 4.0  | 4.0  |
| Tension Set, 70°C (%)            | 36.0 | 30.0 | 31.0 | 33.0 | 32.0 |
| Xylene Extraction (% insolubles) | 0    | 79   | 86   | 66   | 75   |
| <b>E-beamed at 60 kGy</b>        |      |      |      |      |      |
| Stress at Break (Mpa)            | N/A  | 10.2 | N/A  | 12.1 | N/A  |
| Elongation at Break (%)          | N/A  | 861  | N/A  | 864  | N/A  |
| Peak Stress (Mpa)                | 13.8 | 10.2 | 13.4 | 12.1 | 10.8 |
| Peak Elongation (%)              | 940  | 861  | 860  | 864  | 880  |
| 100% Modulus (Mpa)               | 2.8  | 2.0  | 2.2  | 2.2  | 1.7  |

**Table 4 (Comparative Examples) Cont.**

| Example No.               | 7    | 8    | 9    | 10   | 11   |
|---------------------------|------|------|------|------|------|
| <b>E-beamed at 60 kGy</b> |      |      |      |      |      |
| Tension Set, 23°C (%)     | 6.0  | 4.0  | 4.0  | 4.0  | 5.0  |
| Tension Set, 70°C (%)     | 34.0 | 28.0 | 30.0 | 32.0 | 30.0 |

**[00108]** As is evident from a comparison of the mechanical properties of Examples 1-6 with those of Comparative Examples 7-11, the addition of at least one coagent and at least one antioxidant to the polymer blends of the invention results in greatly improved mechanical properties. For example, a comparison of the difference in peak stress before and after e-beaming for all of the examples shows that the peak stress measurements increase (i.e., improve) for Examples 1-6, which contain a coagent and an antioxidant, while the peak stress measurements for Comparative Examples 7-11 decrease (i.e., worsen) upon crosslinking. A similar comparison of tension set values at 70°C for all examples shows that, while an improvement in tension set (indicated by a decrease in the tension set %) is exhibited by all of the samples, the improvement is much greater for those samples containing both a coagent and an antioxidant.

**[00109]** The examples above further illustrate that the elastic properties of the crosslinked blends are improved by addition of a non-conjugated diene. This is reflected by a comparison of Examples 1 and 7, which are prepared from Blend A and comprise a very low level of diene (0.19 wt% ENB), to the remaining examples prepared from Blends B, C, D, and E, which vary in diene content from 1.41 to 1.87 wt%. For example, the tension set at 70°C of Examples 1 and 7 remains essentially the same upon crosslinking with e-beam radiation, while the tension set of the remaining examples is greatly improved following irradiation.

**[00110]** Figure 1 illustrates the improved tensile properties which result from production of polymer blends by a dual reactor process, even before crosslinking. In particular, Fig. 1 shows stress as a function of elongation for the uncrosslinked blends of Examples 1, 3, and 4, and for two comparative polymer blends prepared in a single reactor.

**[00111]** Figure 2 illustrates the improved tensile properties which result from crosslinking polymer blends formed in a dual reactor process. In particular, Fig. 2 shows stress as a function of elongation for Examples 1, 3, and 4, and for a comparable crosslinked polymer blend prepared in a single reactor.

[00112] Figure 3 illustrates the improved tensile properties which result from addition of a coagent in the polymer blends of the invention. In particular, Fig. 3 shows stress as a function of elongation for Example 2, which contains coagent, both before and after crosslinking, and for Example 8, which does not contain coagent, after crosslinking.

5 [00113] For purposes of convenience, various specific test procedures are identified above for determining certain properties such as tension set, percent elongation at break, Shore A Hardness, etc. However, when a person of ordinary skill reads this patent and wishes to determine whether a composition or polymer has a particular property identified in a claim, then any published or well-recognized method or test procedure can be followed to determine  
10 that property, although the specifically identified procedure is preferred. Each claim should be construed to cover the results of any of such procedures, even to the extent different procedures can yield different results or measurements. Thus, a person of ordinary skill in the art is to expect experimental variations in measured properties that are reflected in the claims. All numerical values can be considered to be "about" or "approximately" the stated  
15 value, in view of the nature of testing in general.

[00114] Having described the various aspects of the compositions herein, further specific embodiments of the invention include those set forth in the following lettered paragraphs:

AA. A process for the production of cross-linked polymer blends comprising:

- a) polymerizing a polymer solution comprising a first polymer in a first reactor;
- 20 b) polymerizing a polymer solution comprising a second polymer in a second reactor;
- c) combining the first polymer solution with the second polymer solution to produce a polymer blend solution;
- d) processing the polymer blend solution to produce a polymer blend; and
- 25 e) at least partially cross-linking the polymer blend by subjecting the blend to energetic photons;

where the first and second polymers each comprise from about 75 to about 99 wt% propylene-derived units, from about 1 to about 25 wt% ethylene-derived units, and from about 0.05 to about 6 wt% diene-derived units.

AB. The process of paragraph AA, wherein the first polymer comprises from about 12 to  
30 about 20 wt% ethylene-derived units.

AC. The process of any of the preceding lettered paragraphs, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units.

- AD. The process of any of the preceding lettered paragraphs, wherein the second polymer comprises from about 3 to about 10 wt% ethylene-derived units.
- AE. The process of any of the preceding lettered paragraphs, wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units.
- 5 AF. The process of any of the preceding lettered paragraphs, wherein the first polymer comprises from about 0.5 to about 5 wt% diene-derived units.
- AG. The process of any of the preceding lettered paragraphs, wherein the first polymer comprises from about 1 to about 3 wt% diene-derived units.
- AH. The process of any of the preceding lettered paragraphs, wherein the second polymer  
10 comprises from about 0.1 to about 1.0 wt% diene-derived units.
- AI. The process of any of the preceding lettered paragraphs, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units and from about 1 to about 3 wt% diene-derived units, and wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units and from about 0.1 to about 1.0 wt% diene-derived units.
- 15 AJ. The process of any of the preceding lettered paragraphs, wherein the polymer blend comprises from about 10 to about 18 wt% ethylene-derived units.
- AK. The process of any of the preceding lettered paragraphs, wherein the polymer blend comprises from about 12 to about 16 wt% ethylene-derived units.
- AL. The process of any of the preceding lettered paragraphs, wherein the polymer blend  
20 comprises from about 0.1 to about 5.0 wt% diene-derived units.
- AM. The process of any of the preceding lettered paragraphs, wherein the polymer blend comprises from about 0.5 to about 3.0 wt% diene-derived units.
- AN. The process of any of the preceding lettered paragraphs, wherein the polymer blend comprises from about 1.0 to about 2.0 wt% diene-derived units.
- 25 AO. The process of any of the preceding lettered paragraphs, wherein the energetic photons are in the form of ultraviolet light, electrons, x-rays, or gamma rays.
- AP. The process of any of the preceding lettered paragraphs, wherein the polymer blend is subjected to electron beam radiation in an amount of from about 30 to about 100 kGy.
- AQ. The process of any of the preceding lettered paragraphs, wherein the polymer blend is  
30 subjected to electron beam radiation in an amount of from about 50 to about 60 kGy.
- AR. The process of any of the preceding lettered paragraphs, wherein the polymer blend is formed into one or more fibers, films, nonwovens, or other articles prior to crosslinking.

AS. The process of any of the preceding lettered paragraphs, wherein the polymer blend is compounded with one or more coagents, antioxidants, secondary elastomers, polypropylene, additives, or any combination thereof prior to crosslinking.

AT. The process of paragraph AS, wherein the coagent is a triacrylate.

5 AU. The process of any of paragraphs AS through AT, wherein the antioxidant is a phosphate ester.

AV. The process of any of paragraphs AS through AU, wherein the polymer blend is compounded with at least one coagent and at least one antioxidant.

10 AW. The process of any of paragraphs AS through AV, wherein the coagent is a triacrylate and the antioxidant is a phosphate ester.

AX. The process of any of paragraphs AS through AW, wherein the compounded polymer blend is further formed into one or more fibers, films, nonwovens, or other articles before being subjected to energetic photons.

15 AY. A polymer composition comprising a polymer blend formed by creating and processing a reactor blend of a first polymer formed in a first reactor with a second polymer formed in a second reactor, wherein the first and second polymers each comprise from about 75 to about 99 wt% propylene-derived units, from about 1 to about 25 wt% ethylene-derived units, and from about 0.05 to about 6 wt% diene-derived units.

20 AZ. The polymer composition of paragraph AY, wherein the first polymer comprises from about 12 to about 20 wt% ethylene-derived units.

BA. The polymer composition of any of paragraphs AY through AZ, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units.

BB. The polymer composition of any of paragraphs AY through BA, wherein the second polymer comprises from about 3 to about 10 wt% ethylene-derived units.

25 BC. The polymer composition of any of paragraphs AY through BB, wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units.

BD. The polymer composition of any of paragraphs AY through BC, wherein the first polymer comprises from about 0.5 to about 5 wt% diene-derived units.

30 BE. The polymer composition of any of paragraphs AY through BD, wherein the first polymer comprises from about 1.0 to about 3.0 wt% diene-derived units.

BF. The polymer composition of any of paragraphs AY through BE, wherein the second polymer comprises from about 0.1 to about 1.0 wt% diene-derived units.

BG. The polymer composition of any of paragraphs AY through BF, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units and from about 1 to about 3 wt% diene-derived units, and wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units and from about 0.1 to about 1.0 wt% diene-derived units.

BH. The polymer composition of any of paragraphs AY through BG, wherein the polymer blend comprises from about 10 to about 18 wt% ethylene-derived units.

BI. The polymer composition of any of paragraphs AY through BH, wherein the polymer blend comprises from about 12 to about 16 wt% ethylene-derived units.

BJ. The polymer composition of any of paragraphs AY through BI, wherein the polymer blend comprises from about 0.1 to about 5.0 wt% diene-derived units.

BK. The polymer composition of any of paragraphs AY through BJ, wherein the polymer blend comprises from about 0.5 to about 3.0 wt% diene-derived units.

BL. The polymer composition of any of paragraphs AY through BK, wherein the polymer blend comprises from about 1.0 to about 2.0 wt% diene-derived units.

BM. The polymer composition of any of paragraphs AY through BL, wherein the polymer blend is at least partially crosslinked by subjecting it to energetic photons.

BN. The polymer composition of paragraph BM, wherein the energetic photons are in the form of ultraviolet light, electrons, x-rays, or gamma rays.

BO. The polymer composition of any of paragraphs BM through BN, wherein the polymer blend is subjected to electron beam radiation in an amount of from about 30 to about 100 kGy.

BP. The polymer composition of any of paragraphs BM through BO, wherein the polymer blend is subjected to electron beam radiation in an amount of from about 50 to about 60 kGy.

BQ. The polymer composition any of paragraphs BM through BP, wherein the polymer blend is formed into one or more fibers, films, nonwovens, or other articles prior to crosslinking.

BR. The polymer composition of paragraph BQ, wherein the fibers, films, nonwovens, or other articles are at least partially cross-linked via electron beam radiation.

BS. The polymer composition of any of paragraphs AY through BR, wherein the polymer blend is further compounded with one or more coagents, antioxidants, secondary elastomers, polypropylene, additives, or any combination thereof.

BT. The process of paragraph BS, wherein the coagent is a triacrylate.

- BU. The process of any of paragraphs BS through BT, wherein the antioxidant is a phosphate ester.
- BV. The process of any of paragraphs BS through BU, wherein the polymer blend is compounded with at least one coagent and at least one antioxidant.
- 5 BW. The process of any of paragraphs BS through BV, wherein the coagent is a triacrylate and the antioxidant is a phosphate ester.
- BX. An at least partially cross-linked polymer composition formed by cross-linking the polymer composition of any of paragraphs AY through BW by subjecting it to electron beam radiation.
- 10 BY. The polymer composition of any of paragraphs AY through BX, wherein the polymer blend has a melt flow rate of from about 0.1 to about 10.0 g/10 min.
- BZ. The polymer composition of any of paragraphs AY through BY, wherein the polymer blend has a melt flow rate of from about 3.0 to about 7.0 g/10 min.
- CA. The polymer composition of any of paragraphs AY through BZ, wherein the polymer  
15 blend has a molecular weight distribution of from about 1.5 to about 10.0.
- CB. The polymer composition of any of paragraphs AY through CA, wherein the polymer blend has a molecular weight distribution of from about 2.0 to about 4.0.
- CC. The polymer composition of any of paragraphs AY through CB, wherein the polymer blend has a melt temperature greater than about 110°C.
- 20 CD. The polymer composition of any of paragraphs AY through CC, wherein the polymer blend has a melt temperature greater than about 115°C.
- CE. The polymer composition of any of paragraphs AY through CD, wherein the polymer blend has a melt temperature at least about 5°C higher than a polymer blend having the same composition and formed by physically blending the polymer rather than by reactor blending.
- 25 CF. The cross-linked polymer composition of any of paragraphs BX through CE, wherein the polymer composition comprises a coagent and wherein the peak stress of the polymer composition is greater than that of a polymer prepared the same way and having the same composition but lacking a coagent.
- CG. The cross-linked polymer composition of any of paragraphs BX through CF, wherein  
30 the polymer composition comprises a coagent and wherein the peak elongation of the polymer composition is greater than that of a polymer prepared the same way and having the same composition but lacking a coagent.

CH. The cross-linked polymer composition of any of paragraphs BX through CG, wherein the polymer composition comprises a coagent and wherein the polymer composition exhibits a greater improvement in tension set upon crosslinking than that of a polymer prepared the same way and having the same composition but lacking a coagent.

- 5 CI. The cross-linked polymer composition of any of paragraphs BX through CH, wherein the polymer composition comprises an antioxidant and wherein the peak stress of the polymer composition is greater than that of a polymer prepared the same way and having the same composition but lacking an antioxidant.

10 CJ. The cross-linked polymer composition of any of paragraphs BX through CI, wherein the polymer composition comprises an antioxidant and wherein the peak elongation of the polymer composition is greater than that of a polymer prepared the same way and having the same composition but lacking an antioxidant.

15 CK. The cross-linked polymer composition of any of paragraphs BX through CJ, wherein the polymer composition comprises an antioxidant and wherein the polymer composition exhibits a greater improvement in tension set upon crosslinking than that of a polymer prepared the same way and having the same composition but lacking an antioxidant.

20 CL. The cross-linked polymer composition of any of paragraphs BX through CK, wherein the polymer composition comprises a coagent and an antioxidant and wherein at least one of the peak stress, peak elongation, or tension set of the composition is improved compared to that of a polymer prepared the same way and having the same composition but lacking a coagent and an antioxidant.

CM. An at least partially cross-linked polymer composition comprising a polymer blend formed by creating and processing a reactor blend of a first polymer formed in a first reactor and a second polymer formed in a second reactor, wherein:

- 25 a) the first polymer comprises from about 14 to about 18 wt% ethylene-derived units and from about 1.0 to about 3.0 wt% diene-derived units;
- b) the second polymer comprises from about 5 to about 8 wt% ethylene-derived units and from about 0.1 to about 1.0 wt% diene-derived units;
- 30 c) the polymer blend is compounded with at least one coagent and at least one antioxidant; and
- d) the compounded polymer composition is at least partially cross-linked by subjecting it to electron beam radiation;

wherein at least one of the peak stress, peak elongation, or tension set of the composition is greater than that of a polymer prepared the same way and having the same composition but lacking a coagent and an antioxidant.

5 [00115] Certain embodiments and features have been described using a set of numerical upper limits and a set of numerical lower limits. It should be appreciated that ranges from any lower limit to any upper limit are contemplated unless otherwise indicated. Certain lower limits, upper limits and ranges appear in one or more claims below. All numerical values are “about” or “approximately” the indicated value, and take into account experimental error and variations that would be expected by a person having ordinary skill in  
10 the art.

[00116] To the extent a term used in a claim is not defined above, it should be given the broadest definition persons in the pertinent art have given that term as reflected in at least one printed publication or issued patent. Furthermore, all patents, test procedures, and other documents cited in this application are fully incorporated by reference to the extent such  
15 disclosure is not inconsistent with this application and for all jurisdictions in which such incorporation is permitted.

[00117] While the foregoing is directed to embodiments of the present invention, other and further embodiments of the invention may be devised without departing from the basic scope thereof, and the scope thereof is determined by the claims that follow.

20 [00118] Each of the appended claims defines a separate invention, which for infringement purposes is recognized as including equivalents of the various elements or limitations specified in the claims. Depending on the context, all references herein to the “invention” may in some cases refer to certain specific embodiments only. In other cases it will be recognized that references to the “invention” will refer to subject matter recited in one or  
25 more, but not necessarily all, of the claims. Each of the inventions is described herein, including specific embodiments, versions and examples, but the inventions are not limited to these embodiments, versions or examples, which are included to enable a person having ordinary skill in the art to make and use the inventions, when the information in this patent is combined with available information and technology.

## **CLAIMS**

*We claim:*

1. A process for the production of cross-linked polymer blends comprising:
  - a) polymerizing propylene, ethylene, and diene in the presence of a metallocene catalyst to form a polymer solution comprising a first polymer in a first reactor;
  - b) polymerizing propylene, ethylene, and diene in the presence of a metallocene catalyst to form a polymer solution comprising a second polymer in a second reactor;
  - c) combining the first polymer solution with the second polymer solution to produce a polymer blend solution;
  - d) processing the polymer blend solution to produce a polymer blend; and
  - e) at least partially cross-linking the polymer blend by subjecting the blend to energetic photons;where the first and second polymers each comprise from about 75 to about 99 wt% propylene-derived units, from about 1 to about 25 wt% ethylene-derived units, and from about 0.05 to about 6 wt% diene-derived units.
2. The process of claim 1, wherein the first polymer comprises from about 12 to about 20 wt% ethylene-derived units.
3. The process of claim 1, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units.
4. The process of claim 1, wherein the second polymer comprises from about 3 to about 10 wt% ethylene-derived units.
5. The process of claim 1, wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units.
6. The process of claim 1, wherein the first polymer comprises from about 0.5 to about 5 wt% diene-derived units.
7. The process of claim 1, wherein the first polymer comprises from about 1 to about 3 wt% diene-derived units.

8. The process of claim 1, wherein the second polymer comprises from about 0.1 to about 1.0 wt% diene-derived units.
9. The process of claim 1, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units and from about 1 to about 3 wt% diene-derived units, and wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units and from about 0.1 to about 1.0 wt% diene-derived units.
10. The process of claim 1, wherein the polymer blend comprises from about 10 to about 18 wt% ethylene-derived units.
11. The process of claim 1, wherein the polymer blend comprises from about 12 to about 16 wt% ethylene-derived units.
12. The process of claim 1, wherein the polymer blend comprises from about 0.1 to about 5.0 wt% diene-derived units.
13. The process of claim 1, wherein the energetic photons are in the form of ultraviolet light, electrons, x-rays, or gamma rays.
14. The process of claim 1, wherein the polymer blend is subjected to electron beam radiation in an amount of from about 30 to about 100 kGy.
15. The process of claim 1, wherein the polymer blend is formed into one or more fibers, films, nonwovens, or other articles prior to crosslinking.
16. The process of claim 1, wherein the coagent is a triacrylate.
17. The process of claim 1, wherein the antioxidant is a phosphate ester.
18. The process of claim 1, wherein the compounded polymer blend is further formed into one or more fibers, films, nonwovens, or other articles before being subjected to energetic photons.

19. A polymer composition comprising a polymer blend formed by creating and processing a reactor blend of a first polymer formed in the presence of a metallocene catalyst in a first reactor with a second polymer formed in the presence of a metallocene catalyst in a second reactor, wherein the first and second polymers each comprise from about 75 to about 99 wt% propylene-derived units, from about 1 to about 25 wt% ethylene-derived units, and from about 0.05 to about 6 wt% diene-derived units.
20. The polymer composition of claim 19, wherein the first polymer comprises from about 14 to about 18 wt% ethylene-derived units and from about 1 to about 3 wt% diene-derived units, and wherein the second polymer comprises from about 5 to about 8 wt% ethylene-derived units and from about 0.1 to about 1.0 wt% diene-derived units.
21. The polymer composition of claim 19, wherein the energetic photons are in the form of ultraviolet light, electrons, x-rays, or gamma rays.
22. The polymer composition of claim 19, wherein the polymer blend is subjected to electron beam radiation in an amount of from about 30 to about 100 kGy.
23. The polymer composition of claim 19, wherein the fibers, films, nonwovens, or other articles, are at least partially cross-linked via electron beam radiation.
24. An at least partially cross-linked polymer composition formed by cross-linking the polymer composition of claim 19, by subjecting it to electron beam radiation.
25. An at least partially cross-linked polymer composition comprising a polymer blend formed by creating and processing a reactor blend of a first polymer formed in the presence of a metallocene catalyst in a first reactor and a second polymer formed in the presence of a metallocene catalyst in a second reactor, wherein:
- a) the first polymer comprises from about 14 to about 18 wt% ethylene-derived units and from about 1.0 to about 3.0 wt% diene-derived units;
  - b) the second polymer comprises from about 5 to about 8 wt% ethylene-derived units and from about 0.1 to about 1.0 wt% diene-derived units;
  - c) the polymer blend is compounded with at least one coagent and at least one

antioxidant; and

d) the compounded polymer composition is at least partially cross-linked by subjecting it to electron beam radiation;

wherein at least one of the peak stress, peak elongation, or tension set of the composition is greater than that of a polymer prepared the same way and having the same composition but lacking a coagent and an antioxidant.