

DESCRIPTION

ETHYLENE/ALPHA-OLEFIN COPOLYMER WITH EXCELLENT ELECTRICAL INSULATION

5

TECHNICAL FIELD

Cross-reference to Related Applications

[0001] This application claims the benefit of Korean Patent
Application No. 2020-0046026, filed on April 16, 2020, in the
10 Korean Intellectual Property Office, the contents of which
are incorporated herein by reference.

Technical Field

[0002] The present invention relates to an ethylene/alpha-
15 olefin copolymer having high volume resistance and light
transmittance, and a method for preparing the same.

BACKGROUND ART

[0003] As global environmental problems, energy problems,
20 etc. get worse and worse, solar cells receive attention as a
clean energy generating means without fear of exhaustion. If
solar cells are used outside such as the roof of a building,
generally, a module type is used. In order to obtain a
crystalline solar cell module when manufacturing a solar cell
25 module, protection sheet for solar cell module (surface side

protection member)/solar cell sealant/crystalline solar cell device/solar cell sealant/protection sheet for solar cell module (back side protection member) are stacked in order. Meanwhile, in order to manufacture a thin film-based solar cell module, thin film-type solar cell device/solar cell sealant/protection sheet for solar cell module (back side protection member) are stacked in order.

[0004] As the solar cell sealant, generally, an ethylene/vinyl acetate copolymer or ethylene/alpha-olefin copolymer, etc. is used. In addition, in the solar cell sealant, a light stabilizer is generally included as an additive considering the requirement on climate-resistance for a long time. In addition, considering the adhesiveness of a transparent surface side protection member or a back side protection member represented by glass, a silane coupling agent is commonly included in the solar cell sealant.

[0005] Particularly, an ethylene/vinyl acetate copolymer (EVA) sheet has been widely used because transparency, flexibility and adhesiveness are excellent. An ethylene·vinyl acetate copolymer (EVA) film has been widely used because transparency, flexibility and adhesiveness are excellent. However, if an EVA composition is used as the constituent material of a solar cell sealant, components such as an acetic acid gas generated by the decomposition of EVA might influence a solar cell device.

[0006] In addition, the increase of the scale of a power generation system such as a mega solar is conducted along with the recent dissemination of the power generation of the sunlight, and for the purpose of reducing transmission loss, there are moves to increase a voltage of a system voltage. As the system voltage increases, a potential difference between a frame and cells increases in a solar cell module. That is, the frame of a solar cell module is generally grounded, and if the system voltage of a solar cell array is from 600 V to 1000 V, the potential difference between the frame and the cells becomes from 600 V to 1000 V just the same in a module with the highest voltage, and the power generation is maintained during the day in a high-voltage applied state. In addition, glass has lower electric resistance when compared with a sealant, and due to the interposition of the frame, a high voltage is generated between the glass and the cells. That is, under the circumstance of generating power during the day, in a module with series connection, a potential difference between the cells and the module, and the cells and glass side increases in succession from a grounded side, and at the greatest point, almost the same potential difference of the system voltage is maintained. In a solar cell module used in such a state, output is largely reduced, and an example of a module using a crystalline power generation device in which potential

induced degradation (abbreviated as PID) phenomenon arising degradation is generated, has been reported. Accordingly, in order to solve the problems, a solar cell sealant which comes into direct contact with the solar cell device, having even
5 higher volume intrinsic resistance is required.

[0007] Volume resistance or specific resistance (ρ) known as electric resistance is defined as electric resistance between facing surfaces of 1 m^3 of a material, and it is importance to obtain a molded article in which this volume resistance
10 may be reproduced in a predetermined range in all application divisions and permanent. In an electric insulation material field for a high-voltage power cable, low-density polyethylene processed at a high pressure, crosslinked polyethylene, etc. are widely used due to excellent electric
15 properties. One of the difficulties of the high-voltage power cable is the power loss shown during power transmission. The reduction of the power loss is the most important conditions to be satisfied. The reduction of the power loss could be attained by increasing the high-voltage properties,
20 particularly, volume resistance of an insulating material. However, in the insulating material for a power cable, the inner part of a conductor is heated to a high temperature (about 90°C) by heat generated by the passing of current, but the outer part of the conductor maintains room temperature.
25 The conventional polyethylene shows marked drop of volume

resistance according to the increase of the temperature. Accordingly, polyethylene shows marked drop of volume resistance near the inner conductor through the passing of current.

5 [0008] As described above, the development of an ethylene/alpha-olefin copolymer usefully utilized as a material having excellent volume resistance and requiring high insulation such as a solar cell encapsulant is still required.

10

[0009] [Prior Art Document]

[0010] [Patent Document]

[0011] Korean Laid-open Patent No. 2018-0063669

15 **DISCLOSURE OF THE INVENTION**

TECHNICAL PROBLEM

[0012] An object of the present invention is to provide an ethylene/alpha-olefin copolymer showing wide crystallinity distribution while maintaining a narrow level of molecular weight distribution, and thus, having high volume resistance, and may be usefully utilized as an insulating material, and a method for preparing the same.

20

TECHNICAL SOLUTION

25 [0013] To solve the above tasks, the present invention

provides an ethylene/alpha-olefin copolymer satisfying the following conditions (a) to (d):

[0014] (a) a density is 0.85 to 0.89 g/cc;

[0015] (b) molecular weight distribution is 1.5 to 2.3;

5 [0016] (c) a melting temperature is 85°C or less; and

[0017] (d) a free volume proportional constant (C_2) derived from the following Equations 1 and 2 is 600 or less:

[0018] [Equation 1]

$$\log \frac{\eta_0(T)}{\eta_0(T_r)} = \log(a_T)$$

10 [0019] in Formula 1,

[0020] $\eta_0(T)$ is a viscosity (Pa·s) of a copolymer measured at an arbitrary temperature of T (K) using ARES-G2 (Advanced Rheometric Expansion System),

[0021] $\eta_0(T_r)$ is a viscosity (Pa·s) of a copolymer measured
15 at a reference temperature of T_r (K) using the ARES-G2, and

[0022] a_T is a shift factor of the arbitrary temperature of T (K) with respect to the reference temperature of T_r (K), and obtained from Equation 1 above,

[0023] [Equation 2]

$$\log(a_T) = \frac{-C_1(T - T_r)}{C_2 + (T - T_r)}$$

20

[0024] in Formula 2,

[0025] C_1 is a free volume inverse proportional constant,

[0026] C_2 is the free volume proportional constant (K), and

[0027] C_1 and C_2 are intrinsic constants of the ethylene/alpha-olefin copolymer, and obtained from Equation 2 above.

5 **ADVANTAGEOUS EFFECTS**

[0028] The ethylene/alpha-olefin copolymer of the present invention has high crystallinity distribution and a small free volume, and shows good volume resistance and light transmittance and excellent electrical insulation and
10 accordingly, may be widely used for various uses in electric and electronic industrial fields.

BEST MODE FOR CARRYING OUT THE INVENTION

[0029] Hereinafter, the present invention will be described
15 in more detail to assist the understanding of the present invention.

[0030] It will be understood that words or terms used in the present disclosure and claims shall not be interpreted as the
20 meaning defined in commonly used dictionaries. It will be further understood that the words or terms should be interpreted as having a meaning that is consistent with their meaning in the context of the relevant art and the technical idea of the invention, based on the principle that an
25 inventor may properly define the meaning of the words or

terms to best explain the invention.

[0031] [Ethylene/alpha-olefin copolymer]

[0032] The ethylene/alpha-olefin copolymer of the present
5 invention is characterized in satisfying the following
conditions (a) to (d):

[0033] (a) a density is 0.85 to 0.89 g/cc;

[0034] (b) molecular weight distribution is 1.5 to 2.3;

[0035] (c) a melting temperature is 85°C or less; and

10 **[0036]** (d) a free volume proportional constant (C_2) derived
from the following Equations 1 and 2 is 600 or less:

[0037] [Equation 1]

$$\log \frac{\eta_0(T)}{\eta_0(T_r)} = \log(a_T)$$

[0038] in Formula 1,

15 **[0039]** $\eta_0(T)$ is a viscosity (Pa·s) of a copolymer measured
at an arbitrary temperature of T (K) using ARES-G2 (Advanced
Rheometric Expansion System),

[0040] $\eta_0(T_r)$ is a viscosity (Pa·s) of a copolymer measured
at a reference temperature of T_r (K) using the ARES-G2, and

20 **[0041]** a_T is a shift factor of the arbitrary temperature of
 T (K) with respect to the reference temperature of T_r (K),
and obtained from Equation 1 above,

[0042] [Equation 2]

$$\log(a_T) = \frac{-C_1(T - T_r)}{C_2 + (T - T_r)}$$

[0043] in Formula 2,

[0044] C_1 is a free volume inverse proportional constant,

[0045] C_2 is the free volume proportional constant (K), and

5 [0046] C_1 and C_2 are intrinsic constants of the ethylene/alpha-olefin copolymer, and obtained from Equation 2 above.

[0047] The present invention relates to an ethylene/alpha-olefin copolymer having high volume resistance and showing excellent electrical insulation. Particularly, for preparing the ethylene/alpha-olefin copolymer of the present invention, transition metal compounds represented by Formula 1 and Formula 2 are mixed and used as a catalyst. The introduction of an alpha-olefin-based monomer into the transition metal compound represented by Formula 1 is difficult due to the structural characteristics of the catalyst, and a copolymer of a high-density region tends to be prepared, and a large amount of alpha-olefin may be introduced into the transition metal compound represented by Formula 2, a polymer (elastomer) in a very low-density region may be prepared. Accordingly, if each of the two transition metal compounds is used solely, copolymerization properties of mixing and introducing an alpha-olefin-based monomer are different.

[0048] The ethylene/alpha-olefin copolymer of the present invention, prepared by using the mixture composition as a catalyst is a copolymer in which both a low-density region in which a large amount of an alpha-olefin-based monomer is mixed and introduced and a high-density region in which a small amount of an alpha-olefin-based monomer is mixed and introduced are present, and has wide crystallinity distribution, and contains a small free volume. Accordingly, charge mobility is low, and excellent electric insulation is shown.

[0049] The ethylene/alpha-olefin copolymer of the present invention is a polymer having a low density in a range of 0.85 to 0.89 g/cc, and in this case, the density may mean a density measured according to ASTM D-792. More particularly, the density may be 0.850 g/cc or more, 0.860 g/cc or more, 0.870 g/cc or more, 0.875 g/cc or more, and 0.890 g/cc or less, or 0.880 g/cc or less.

[0050] If the density deviates from the range, problems of degrading the volume resistance or light transmittance of the ethylene/alpha-olefin copolymer may arise.

[0051] Generally, the density of the ethylene/alpha-olefin copolymer is influenced by the type and amount of a monomer used for polymerization, a polymerization degree, etc., and is largely influenced by the amount of a comonomer in case of

a copolymer. In this case, if the amount of the comonomer increases, an ethylene/alpha-olefin copolymer of a low density may be prepared, and the amount of the comonomer introduced into the copolymer may be dependent on the
5 intrinsic copolymerization properties of a catalyst.

[0052] The ethylene/alpha-olefin copolymer of the present invention is a copolymer prepared using the compounds represented by Formula 1 and Formula 2 as catalysts, and shows a low density as described above, and as a result,
10 excellent processability may be shown.

[0053] The ethylene/alpha-olefin copolymer of the present invention has narrow molecular weight distribution (MWD) in a range of 1.5 to 2.3. More particularly, the molecular weight
15 distribution may be 1.50 or more, 1.80 or more, or 1.90 or more, and 2.30 or less, 2.20 or less, 2.15 or less, or 2.00 or less.

[0054] Generally, if two or more types of monomers are polymerized, molecular weight distribution increases, and as
20 a result, impact strength and mechanical properties are reduced, and there is possibility of generating blocking phenomenon, etc. Particularly, since the polymerization properties of a monomer are different according to the catalyst, the molecular weight of a polymer finally prepared
25 may be influenced by the type of the catalyst. If two or

more types of catalysts are mixed and used in polymerization reaction, and if the difference of the polymerization properties of the catalysts is large, there are problems of increasing the molecular weight distribution of a polymer.

5 **[0055]** In order to reduce the molecular weight distribution to prevent the degradation of the crosslinking properties, impact strength, mechanical properties, etc. of a copolymer, a suitable amount of hydrogen may be injected during polymerization reaction to prevent the generation of
10 arbitrary β -hydride elimination reaction in a polymer chain and induce uniform termination reaction, and in this case, the weight average molecular weight and melt index of the copolymer tend to decrease according to the injection of hydrogen. Accordingly, appropriate catalyst type and
15 hydrogen injection amount are determined in ranges for achieving both the intrinsic properties of a catalyst structure influencing the weight average molecular weight and the melt index and the reducing effects of molecular weight distribution according to the injection of hydrogen.

20 **[0056]** Considering the above-described points, in the present invention, since a transition metal compound represented by Formula 1 and a transition metal compound represented by Formula 2 are mixed and used as a catalyst, an excellent ethylene/ α -olefin copolymer having the above-
25 described range of narrow molecular weight distribution and

satisfying other physical properties may be prepared.

[0057] In addition, the ethylene/alpha-olefin copolymer of the present invention may have a weight average molecular weight (Mw) of 40,000 g/mol to 150,000 g/mol. Particularly,
5 the weight average molecular weight may be 45,000 g/mol or more, 49,000 g/mol or more, or 52,000 g/mol or more, and 130,000 g/mol or less, 90,000 g/mol or less, or 65,000 g/mol or less.

[0058] The weight average molecular weight (Mw) and the
10 number average molecular weight (Mn) are polystyrene conversion molecular weights analyzed by gel permeation chromatography (GPC), and the molecular weight distribution may be calculated from the ratio of Mw/Mn.

[0059] The ethylene/alpha-olefin copolymer of the present invention has a melting temperature (Tm) of 85°C or less. Particularly, the melting temperature may be 50°C or more, 55°C or more, or 60°C or more, and 85°C or less, 70°C or less, 68°C or less, or 65°C or less.

[0060] Generally, if the crystallinity distribution of a
20 copolymer is high, the high crystal content increases, and the degradation of light transmittance and crosslinking physical properties may be induced. On the contrary, the copolymer of the present invention has wide crystallinity
25 distribution, high volume resistance and a low melting

temperature as described above, and accordingly, there are advantages in that light transmittance and crosslinking physical properties are not deteriorated.

[0061] At the same time, the ethylene/alpha-olefin copolymer of the present invention may have a crystallization temperature (T_c) of 70°C or less, 60°C or less, 50°C or less, or 49°C or less, and 30°C or more, 35°C or more, 40°C or more, 45°C or more.

[0062] The melting temperature and crystallization temperature may be measured using differential scanning calorimeter (DSC). Particularly, a copolymer is heated to 150°C and maintained for 5 minutes, and the temperature is reduced to -100°C again and elevated again. In this case, the elevating rate and decreasing rate of the temperature are controlled to 10°C/min, respectively. Measured results in the second temperature elevating section is the melting temperature, and the measured results in a range shown while reducing the temperature is the crystallization temperature.

[0063] The ethylene/alpha-olefin copolymer of the present invention has a free volume proportional constant of C_2 derived from Equations 1 to 3 of 600 or less, and in this case, the unit of C_2 is absolute temperature (K). More particularly, the free volume proportional constant (C_2) may be 600 or less, 550 or less, or 500 or less, and 300 or more.

[0064] The physical/chemical properties of a polymer such as an ethylene/alpha-olefin copolymer are considered to be fixed, but in practice, have properties dependent on time and temperature. If viscoelastic functional curves in accordance with time at various temperatures are derived and moved horizontally in parallel based on an arbitrary temperature, time-temperature superposition is shown by which all curves are superposed into one curve.

[0065] In this case, the relation of Equation 1 below is established for data of physical properties on arbitrary temperature T (kelvin, K) and reference temperature T_r (Kelvin, K) with respect to data of linear viscoelasticity of a copolymer measured at various temperatures. In equation 1, $\eta_0(T)$ is a viscosity (Pa·s) of a copolymer measured at an arbitrary temperature of T (K) using ARES-G2, and $\eta_0(T_r)$ is a viscosity (Pa·s) of a copolymer measured at a reference temperature of $T_r(K)$ using ARES-G2. From the above, a shift factor (a_T , a factor of shifting the phase of a graph for anticipating data of physical properties measured at the temperature of T as data of physical properties at another temperature) of the arbitrary temperature of T (K) with respect to the reference temperature of $T_r(K)$ may be obtained, and this represents temperature dependency.

[0066] [Equation 1]

$$\log \frac{\eta_0(T)}{\eta_0(T_r)} = \log(a_T)$$

[0067] In addition, it has been found that the shift factor (a_T) making data of physical properties at all temperatures superposed into one curve has a mathematical form below, and
5 this is called Williams-Landel-Ferry equation (WLF equation).

[0068] [Equation 2]

$$\log(a_T) = \frac{-C_1(T - T_r)}{C_2 + (T - T_r)}$$

[0069] In Formula 2, C_1 is a free volume inverse proportional constant, C_2 is the free volume proportional
10 constant (K), and C_1 and C_2 are intrinsic constants of the ethylene/alpha-olefin copolymer, and obtained from Equation 2 above.

[0070] In the present invention, C_1 may be a value of 2 or more, 3 or more, and 7 or less, 5 or less, but is not limited
15 thereto.

[0071] More particularly, in the present invention, a process of obtaining the C_2 value may be as follows using a measurement apparatus of ARES-G2 (Advanced Rheometric Expansion System) of TA Co. Particularly, a disk type disk
20 specimen of an ethylene/alpha-olefin copolymer having a diameter of 25 mm and a thickness of 1 mm was prepared as a sample. The geometry of a parallel plate (flat shape) was used, and Equation 1 was calculated by the methods 1) and 2)

below.

[0072] 1) Frequency sweep at five specific temperatures

[0073] In a temperature range lower than $T_g + 200^\circ\text{C}$ of an ethylene/alpha-olefin copolymer, frequency sweep was measured
5 at five specific temperatures selected with an interval of 10°C . In the present invention, measurement was conducted at a temperature of $110\text{--}150^\circ\text{C}$ with an interval of 10°C (strain $0.5\text{--}3\%$, frequency $0.1\text{--}500\text{ rad/s}$).

[0074] 2) Deduction of master curve

10 **[0075]** The reference temperature T_r was set to 130°C , and the measurement results of step 1) was shifted to 130°C to deduce a master curve.

[0076] 3) Deduction of C_2 value

[0077] The shift factor (aT) of a WLF equation was obtained,
15 and this value was substituted in Equation 2 to deduce a C_2 value.

[0078] [Equation 3]

$$C_2 = \frac{f_0}{\alpha_f}$$

[0079] As in Equation 3, the C_2 value is a value
20 proportional to a free volume (f_0), and a small C_2 means a small free volume in a copolymer, and in this case, α_f means a coefficient of thermal expansion of an ethylene/alpha-olefin copolymer.

[0080] In addition, the ethylene/alpha-olefin copolymer has a melt index (MI, 190°C, 2.16 kg load conditions) of 0.1 to 50 dg/min. More particularly, the melt index may be 1 dg/min

5 or more, 1.5 dg/min or more, 3 dg/min or more, or 4 dg/min or more, and 50 dg/min or less, 30 dg/min or less, 20 dg/min or less, or 10 dg/min or less.

[0081] In addition, the ethylene/alpha-olefin copolymer may have a melt flow rate ratio (MFRR, $MI_{10}/MI_{2.16}$) which is a

10 value of melt index (MI_{10} , 190°C, 10 kg load conditions) with respect to the melt index ($MI_{2.16}$, 190°C, 2.16 kg load conditions), of 8.0 or less, 7.0 or less, or 6.5 or less, or 6.3 or less and 5.0 or more, or 5.5 or more, or 6.0 or more.

[0082] The melt flow rate ratio is an index of the degree of

15 long chain branching of a copolymer, and the ethylene/alpha-olefin copolymer of the present invention satisfies the melt flow rate ratio together with the above-described physical properties and has excellent physical properties, and thus, may be suitably applied to an encapsulant composition for a

20 solar cell.

[0083] The ethylene/alpha-olefin copolymer of the present invention is prepared by copolymerizing ethylene and an alpha-olefin-based monomer, and in this case, the alpha-

25 olefin which means a moiety derived from an alpha-olefin-

based monomer in the copolymer may be C4 to C20 alpha-olefin, particularly, propylene, 1-butene, 1-pentene, 4-methyl-1-pentene, 1-hexene, 1-heptene, 1-octene, 1-decene, 1-undecene, 1-dodecene, 1-tetradecene, 1-hexadecene, 1-eicosene, etc.,
5 and any one among them or mixtures of two or more thereof may be used.

[0084] Among them, the alpha-olefin may be 1-butene, 1-hexene or 1-octene, preferably, 1-butene, 1-hexene, or a combination thereof.

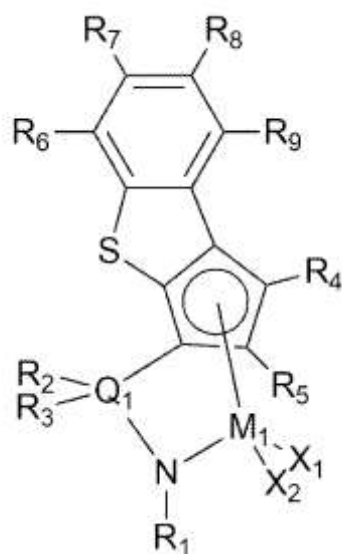
10 **[0085]** In addition, in the ethylene/alpha-olefin copolymer, the alpha-olefin content may be suitably selected in the range satisfying the physical conditions, particularly, greater than 0 to 99 mol%, or 10 to 50 mol%, without limitation.

15

[0086] [Method for preparing ethylene/alpha-olefin copolymer]

[0087] The method for preparing an ethylene/alpha-olefin copolymer of the present invention is characterized in
20 including: a step of polymerizing ethylene and an alpha-olefin-based monomer in the presence of a catalyst composition including transition metal compounds represented by Formula 1 and Formula 2 below.

[0088] [Formula 1]



[0089] In Formula 1,

[0090] R₁ is hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; alkoxy of 1 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; arylalkoxy of 7 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; or arylalkyl of 7 to 20 carbon atoms,

[0091] R₂ and R₃ are each independently hydrogen; halogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamido of 1 to 20 carbon atoms; or arylamido of 6 to 20 carbon atoms,

[0092] R₄ and R₅ are each independently hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; or alkenyl of 2 to 20 carbon atoms,

[0093] R₆ to R₉ are each independently hydrogen; alkyl of 1

to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; or alkenyl of 2 to 20 carbon atoms,

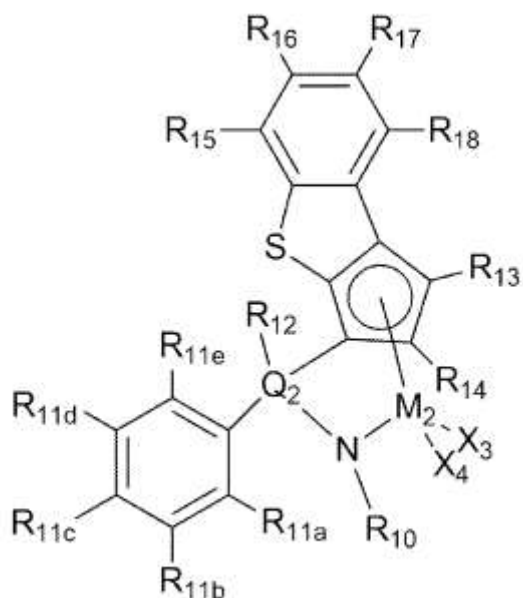
[0094] two or more adjacent groups among R_2 to R_9 may be connected with each other to form a ring,

5 **[0095]** Q_1 is Si, C, N, P or S,

[0096] M_1 is Ti, Hf or Zr, and

[0097] X_1 and X_2 are each independently hydrogen; halogen; alkyl of 1 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamino of 1 to 20 carbon atoms; or arylamino of 6 to 20 carbon atoms.

[0098] [Formula 2]



[0099] In Formula 2,

15 **[00100]** R_{10} is hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon

atoms; alkoxy of 1 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; arylalkoxy of 7 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; or arylalkyl of 7 to 20 carbon atoms,

[00101] R_{11a} to R_{11e} are each independently hydrogen; halogen;
5 alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; alkoxy of 1 to 20 carbon atoms; or aryl of 6 to 20 carbon atoms,

[00102] R₁₂ is hydrogen; halogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20
10 carbon atoms; aryl of 6 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamido of 1 to 20 carbon atoms; or arylamido of 6 to 20 carbon atoms,

[00103] R₁₃ and R₁₄ are each independently hydrogen; alkyl of
15 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; or alkenyl of 2 to 20 carbon atoms,

[00104] R₁₅ to R₁₈ are each independently hydrogen; alkyl of 1
20 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; or alkenyl of 2 to 20 carbon atoms,

[00105] two or more adjacent groups among R₁₅ to R₁₈ may be connected with each other to form a ring,

[00106] Q₂ is Si, C, N, P or S,

[00107] M₂ is Ti, Hf or Zr, and

25 **[00108]** X₃ and X₄ are each independently hydrogen; halogen;

alkyl of 1 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamino of 1 to 20 carbon atoms; or arylamino of 6 to 20 carbon atoms.

5

[00109] Particularly, in Formula 1, R_1 is hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; alkoxy of 1 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; arylalkoxy of 7 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; or arylalkyl of 7 to 20 carbon atoms, and more particularly, R_1 may be methyl, ethyl, propyl, butyl, isobutyl, tert-butyl, isopropyl, cyclohexyl, benzyl, phenyl, methoxyphenyl, ethoxyphenyl, fluorophenyl, bromophenyl, chlorophenyl, dimethylphenyl or diethylphenyl.

[00110] Particularly, in Formula 1, R_2 and R_3 are each independently hydrogen; halogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamido of 1 to 20 carbon atoms; or arylamido of 6 to 20 carbon atoms, and more particularly, R_2 and R_3 may be each independently hydrogen; alkyl of 1 to 20 carbon atoms; or arylalkyl of 7 to 20 carbon atoms.

[00111] Particularly, in Formula 1, R_4 and R_5 may be the same or different, and may be each independently hydrogen; alkyl

of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; or alkenyl of 2 to 20 carbon atoms, more particularly, alkyl of 1 to 6 carbon atoms. More particularly, R₄ and R₅ may be methyl, ethyl or propyl.

5 **[00112]** Particularly, in Formula 1, R₆ to R₉ may be the same or different and may be each independently hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; or alkenyl of 2 to 20 carbon atoms. More particularly, R₆ to R₉ may be the same or
10 different and may be each independently hydrogen or methyl.

[00113] Two or more adjacent groups among R₆ to R₉ may be connected with each other to form an aliphatic ring of 5 to 20 carbon atoms or an aromatic ring of 6 to 20 carbon atoms, and the aliphatic ring or aromatic ring may be substituted
15 with halogen, alkyl of 1 to 20 carbon atoms, alkenyl of 2 to 20 carbon atoms or aryl of 6 to 20 carbon atoms.

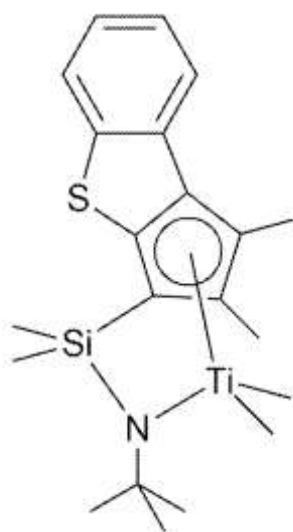
[00114] Particularly, in Formula 1, Q₁ is Si, C, N, P or S, and more particularly, Q₁ may be Si.

[00115] Particularly, in Formula 1, M₁ may be Ti, Hf or Zr.

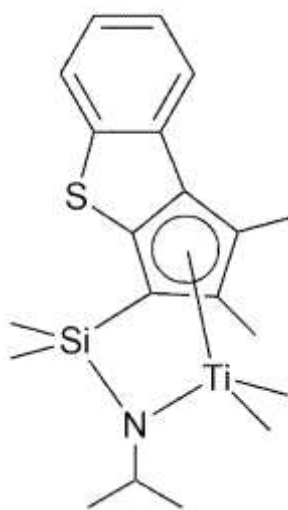
20 **[00116]** Particularly, in Formula 1, X₁ and X₂ may be the same or different and may be each independently hydrogen; halogen; alkyl of 1 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamino
25 of 1 to 20 carbon atoms; or arylamino of 6 to 20 carbon atoms.

[00117] In addition, the compound represented by Formula 1 may be a compound represented by any one among the compounds below.

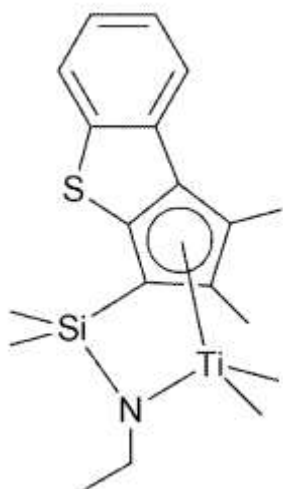
5 **[00118]** [Formula 1-1]



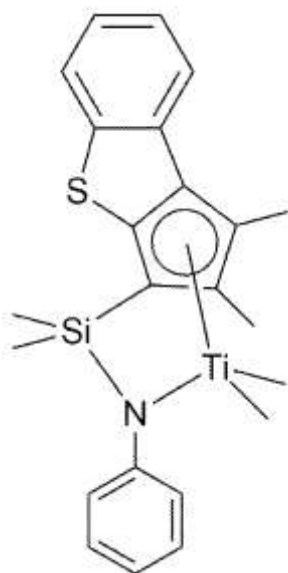
[00119] [Formula 1-2]



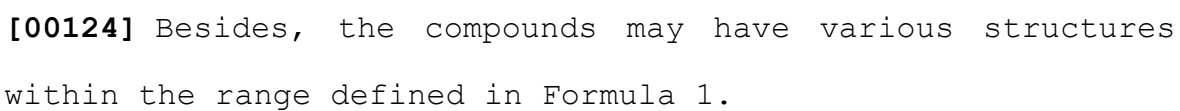
[00120] [Formula 1-3]



[00121] [Formula 1-4]



[00122] [Formula 1-5]



[00125] In addition, in Formula 2, R₁₀ is hydrogen; alkyl of

1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; alkoxy of 1 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; arylalkoxy of 7 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; or arylalkyl of 7 to 20 carbon atoms, and more particularly, R₁₀ may be hydrogen; alkyl of 1 to 20 carbon atoms or 1 to 12 carbon atoms; alkoxy of 1 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; arylalkoxy of 7 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; or arylalkyl of 7 to 20 carbon atoms.

[00126] Particularly, in Formula 2, R_{11a} to R_{11e} are each independently hydrogen; halogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; alkoxy of 1 to 20 carbon atoms; or aryl of 6 to 20 carbon atoms, more particularly, hydrogen; halogen; alkyl of 1 to 12 carbon atoms; cycloalkyl of 3 to 12 carbon atoms; alkenyl of 2 to 12 carbon atoms; alkoxy of 1 to 12 carbon atoms; or phenyl.

[00127] Particularly, in Formula 2, R₁₂ is hydrogen; halogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; alkenyl of 2 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamido of 1 to 20 carbon atoms; or arylamido of 6 to 20 carbon atoms, more particularly, hydrogen; halogen; alkyl of 1 to 12 carbon atoms; cycloalkyl of 3 to 12 carbon atoms; alkenyl of 2 to 12 carbon atoms; or

phenyl.

[00128] Particularly, in Formula 2, R_{13} and R_{14} are each independently hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon
5 atoms; or alkenyl of 2 to 20 carbon atoms, more particularly, hydrogen; or alkyl of 1 to 12 carbon atoms.

[00129] Particularly, in Formula 2, R_{15} to R_{18} are each independently hydrogen; alkyl of 1 to 20 carbon atoms; cycloalkyl of 3 to 20 carbon atoms; aryl of 6 to 20 carbon
10 atoms; or alkenyl of 2 to 20 carbon atoms, more particularly, hydrogen; alkyl of 1 to 12 carbon atoms; or cycloalkyl of 3 to 12 carbon atoms, or hydrogen; or methyl.

[00130] Particularly, in Formula 2, two or more adjacent groups among R_{15} to R_{18} may be connected with each other to
15 form a ring.

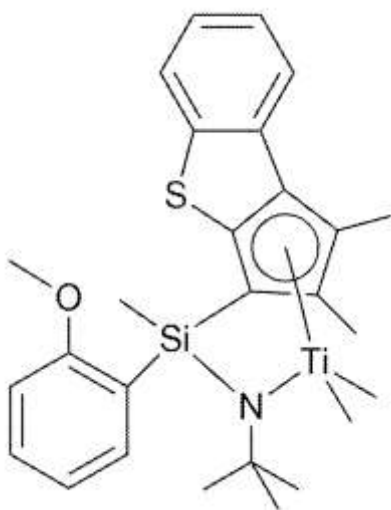
[00131] Particularly, in Formula 2, Q_2 is Si, C, N, P or S, more particularly, Q may be Si.

[00132] Particularly, in Formula 2, X_3 and X_4 are each independently hydrogen; halogen; alkyl of 1 to 20 carbon
20 atoms; alkenyl of 2 to 20 carbon atoms; aryl of 6 to 20 carbon atoms; alkylaryl of 7 to 20 carbon atoms; arylalkyl of 7 to 20 carbon atoms; alkylamino of 1 to 20 carbon atoms; or arylamino of 6 to 20 carbon atoms, particularly, hydrogen; halogen; alkyl of 1 to 12 carbon atoms; cycloalkyl of 3 to 12
25 carbon atoms; or alkenyl of 2 to 12 carbon atoms, more

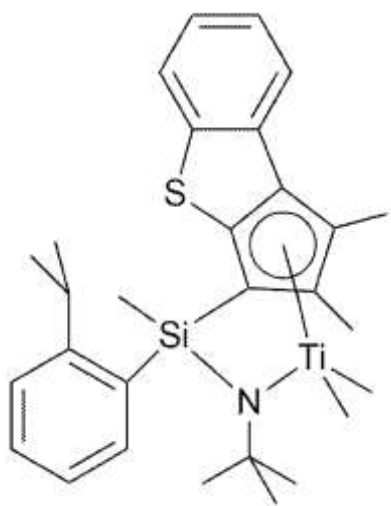
particularly, hydrogen; or alkyl of 1 to 12 carbon atoms.

[00133] In addition, the compound represented by Formula 2 may be any one among the compounds represented by Formula 2-1 to Formula 2-10 below.

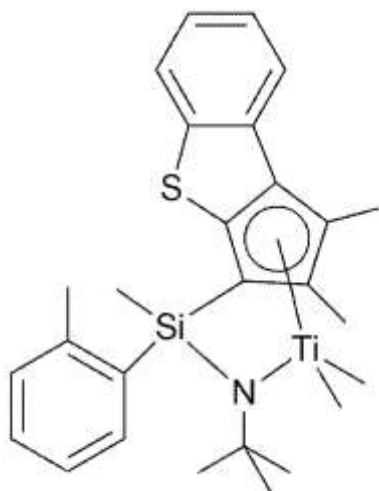
[00134] [Formula 2-1]



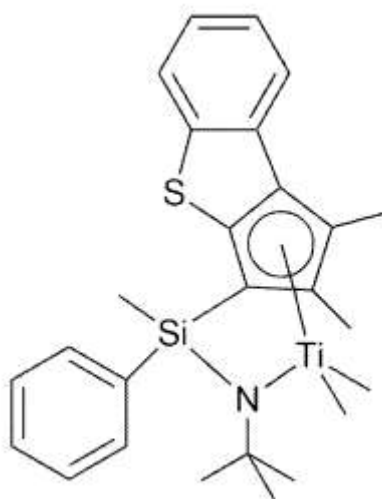
[00135] [Formula 2-2]



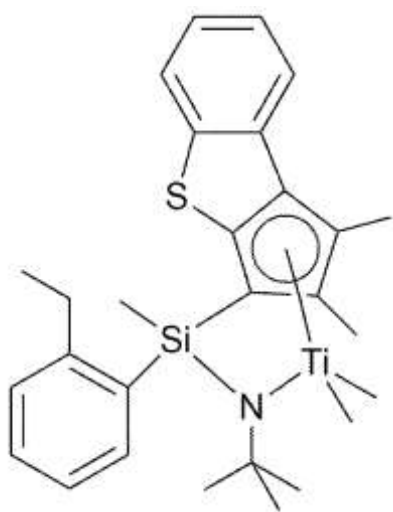
10 **[00136]** [Formula 2-3]



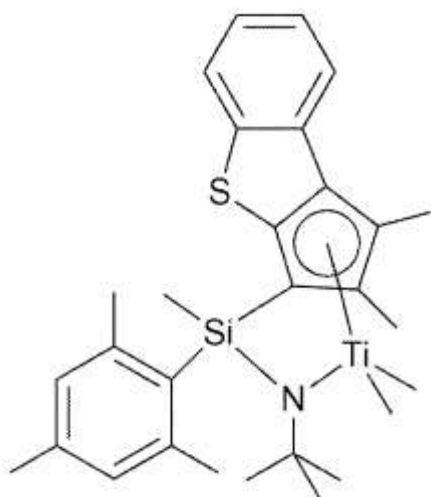
[00137] [Formula 2-4]



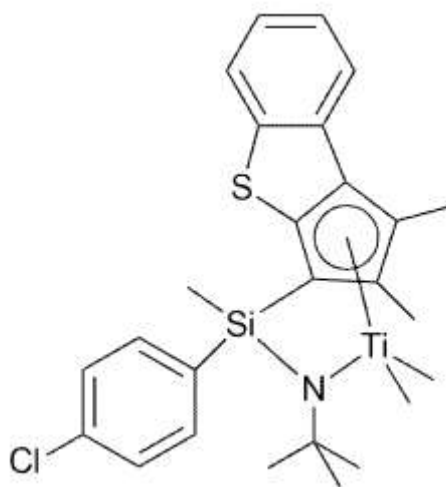
[00138] [Formula 2-5]



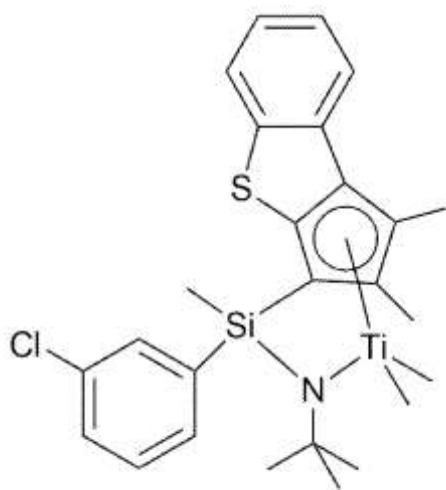
[00139] [Formula 2-6]



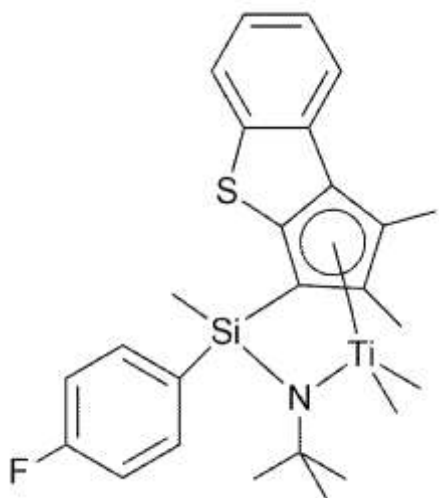
[00140] [Formula 2-7]



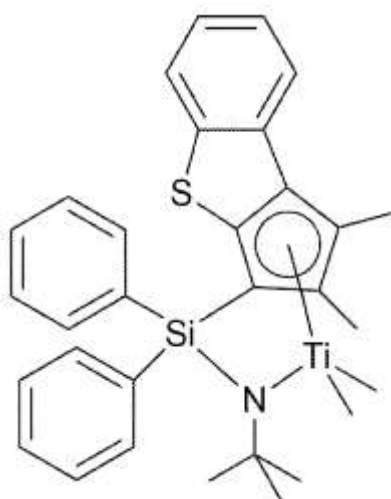
[00141] [Formula 2-8]



[00142] [Formula 2-9]



[00143] [Formula 2-10]



[00144] In the present invention, the molar ratio of the transition metal compounds represented by Formula 1 and Formula 2 may be 1:1.2 to 1:10, or 1:1.5 to 1:9, 1:2 to 1:5, or 1:2 to 1:4, without limitation.

[00145] As described above, the transition metal compounds represented by Formula 1 and Formula 2 used in the present invention have different mixing and introducing capacity of a

comonomer, and by mixing and using them, a copolymer having both a low-density region and a high-density region and high crystallinity distribution may be prepared, and the copolymer of the present invention thus prepared may show high
5 crystallinity distribution, a small free volume, and excellent electrical insulation.

[00146] In the present invention, the polymerization reaction may be performed by continuously polymerizing ethylene and an
10 alpha-olefin-based monomer by continuously injecting hydrogen in the presence of the catalyst composition, particularly, may be performed by injecting hydrogen in 5 to 100 cc/min.

[00147] The hydrogen gas plays the role of restraining vigorous reaction of the transition metal compounds at the
15 initiation point of polymerization and terminating polymerization reaction. Accordingly, by the use of the hydrogen gas and the control of the amount used, an ethylene/alpha-olefin copolymer having narrow molecular weight distribution may be effectively prepared.

20 **[00148]** For example, the hydrogen may be injected in 5 cc/min or more, 7 cc/min or more, or 10 cc/min or more, or 15 cc/min or more, or 19 cc/min or more, and 100 cc/min or less, or 50 cc/min or less, or 45 cc/min or less, or 35 cc/min or less, or 29 cc/min or less. If injected in the above-described
25 conditions, the ethylene/alpha-olefin copolymer thus prepared

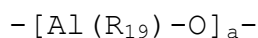
may achieve the physical properties of the present invention.

[00149] If the hydrogen gas is injected in less than 5 cc/min, the termination of polymerization reaction is not uniformly carried out, and the preparation of an ethylene/alpha-olefin copolymer having desired physical properties may become difficult, and if injected in greater than 100 cc/min, termination reaction may occur too fast, and it is apprehended that an ethylene/alpha-olefin copolymer having a very low molecular weight may be prepared.

[00150] In addition, the polymerization reaction may be performed at 100 to 200°C, and by controlling the polymerization temperature together with the injection amount of hydrogen, the crystallinity distribution and the molecular weight distribution in the ethylene/alpha-olefin copolymer may be controlled more advantageously. Particularly, the polymerization reaction may be performed at 100 to 200°C, 120 to 180°C, 130 to 170°C, or 140 to 160°C, without limitation.

[00151] In the present invention, a co-catalyst may be additionally used in the catalyst composition for activating the transition metal compounds represented by Formula 1 and/or Formula 2. The co-catalyst is an organometallic compound including a metal in group 13, and may particularly include one or more selected from Formula 3 to Formula 5 below.

[00152] [Formula 3]



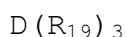
[00153] In Formula 3,

[00154] each R_{19} is independently halogen radical;

5 hydrocarbyl radical of 1 to 20 carbon atoms; or halogen-substituted hydrocarbyl radical of 1 to 20 carbon atoms, and

[00155] a is an integer of 2 or more.

[00156] [Formula 4]



10 **[00157]** In Formula 4,

[00158] D is aluminum or boron, and

[00159] each R_{19} is independently halogen radical;

hydrocarbyl radical of 1 to 20 carbon atoms; or halogen-substituted hydrocarbyl radical of 1 to 20 carbon atoms.

15 **[00160]** [Formula 5]



[00161] In Formula 5,

[00162] H is a hydrogen atom,

[00163] Z is an element in group 13,

20 **[00164]** each A is independently aryl of 6 to 20 carbon atoms, in which one or more hydrogen atoms may be substituted as substituents; or alkyl of 1 to 20 carbon atoms,

[00165] the substituent is halogen; hydrocarbyl of 1 to 20 carbon atoms; alkoxy of 1 to 20 carbon atoms; or aryloxy of 6
25 to 20 carbon atoms,

[00166] $[L-H]^+$ is trimethylammonium; triethylammonium; tripropylammonium; tributylammonium; diethylammonium; trimethylphosphonium; or triphenylphosphonium, and

[00167] $[L]^+$ is N,N-diethylanilinium; or triphenylcarbonium.

5

[00168] More particularly, the compound of Formula 3 may be an alkylaluminumoxane-based compound in which repeating units are combined in a linear, circular or network shape, and particular example may include methylaluminumoxane (MAO),
10 ethylaluminumoxane, isobutylaluminumoxane or tert-butylaluminumoxane.

[00169] In addition, the compound of Formula 4 may include trimethylaluminum, triethylaluminum, triisobutylaluminum, tripropylaluminum, tributylaluminum, dimethylchloroaluminum,
15 triisopropylaluminum, tri-s-butylaluminum, tricyclopentylaluminum, tripentylaluminum, triisopentylaluminum, trihexylaluminum, trioctylaluminum, ethyldimethylaluminum, methyldiethylaluminum, triphenylaluminum, tri-p-tolylaluminum,
20 dimethylaluminummethoxide, dimethylaluminummethoxide, trimethylboron, triethylboron, triisobutylboron, tripropylboron, tributylboron, etc., particularly, trimethylaluminum, triethylaluminum or triisobutylaluminum, without limitation.

25 **[00170]** In addition, the compound of Formula 5 may include a

borate-based compound of a trisubstituted ammonium salt, a
 dialkyl ammonium salt or a trisubstituted phosphonium salt
 type. More particular examples include a borate-based
 compound of a trisubstituted ammonium salt type such as
 5 trimethylammonium tetraphenylborate,
 methyldioctadecylammonium tetraphenylborate, triethylammonium
 tetraphenylborate, tripropylammonium tetraphenylborate,
 tri(n-butyl) ammonium tetraphenylborate,
 methyltetradecylcyclooctadecylammonium tetraphenylborate,
 10 N,N-dimethylanilinium tetraphenylborate, N,N-diethylanilinium
 tetraphenylborate, N,N-dimethyl(2,4,6-
 trimethylanilinium) tetraphenylborate, trimethylammonium
 tetrakis(pentafluorophenyl) borate, methylditetradecylammonium
 tetrakis(pentaphenyl) borate, methyldioctadecylammonium
 15 tetrakis(pentafluorophenyl) borate, triethylammonium,
 tetrakis(pentafluorophenyl) borate,
 tripropylammoniumtetrakis(pentafluorophenyl) borate, tri(n-
 butyl) ammonium tetrakis(pentafluorophenyl) borate, tri(sec-
 butyl) ammoniumtetrakis(pentafluorophenyl) borate, N,N-
 20 dimethylanilinium tetrakis(pentafluorophenyl) borate, N,N-
 diethylaniliniumtetrakis(pentafluorophenyl) borate, N,N-
 dimethyl(2,4,6-
 trimethylanilinium) tetrakis(pentafluorophenyl) borate,
 trimethylammoniumtetrakis(2,3,4,6-tetrafluorophenyl) borate,
 25 triethylammonium tetrakis(2,3,4,6-tetrafluorophenyl) borate,

tripropylammonium tetrakis(2,3,4,6-tetrafluorophenyl)borate,
tri(n-butyl) ammonium tetrakis(2,3,4,6-
,tetrafluorophenyl)borate, dimethyl(t-butyl) ammonium
tetrakis(2,3,4,6-tetrafluorophenyl)borate, N,N-
5 dimethylanilinium tetrakis(2,3,4,6-tetrafluorophenyl)borate,
N,N-diethylanilinium tetrakis(2,3,4,6-
tetrafluorophenyl)borate and N,N-dimethyl-(2,4,6-
trimethylanilinium)tetrakis-(2,3,4,6-
tetrafluorophenyl)borate; a borate-based compound of a
10 dialkyl ammonium salt type such as dioctadecylammonium
tetrakis(pentafluorophenyl)borate, ditetradecylammonium
tetrakis(pentafluorophenyl)borate and dicyclohexylammonium
tetrakis(pentafluorophenyl)borate; or a borate-based compound
of a trisubstituted phosphonium salt type such as
15 triphenylphosphonium tetrakis(pentafluorophenyl)borate,
methyldioctadecylphosphonium
tetrakis(pentafluorophenyl)borate and tri(2,6-,
dimethylphenyl)phosphoniumtetrakis(pentafluorophenyl)borate,
without limitation.

20 **[00171]** By using such a co-catalyst, the molecular weight
distribution of the ethylene/alpha-olefin copolymer finally
prepared may become more uniform, and polymerization activity
may be improved.

[00172] The co-catalyst may be used in a suitable amount so
25 that the activation of the transition metal compounds of

Formula 1 and/or Formula 2 may be sufficiently achieved.

[00173] In the present invention, the transition metal compounds of Formula 1 and/or Formula 2 may be used in a supported type on a support.

[00174] In case where the transition metal compounds of Formula 1 and/or Formula 2 are supported by the support, the weight ratio of the transition metals and the support may be 1:10 to 1:1,000, more particularly, 1:10 to 1:500. If the support and the transition metal compounds are included in a weight ratio in the above range, optimized type may be shown. In addition, if the co-catalyst is supported together by the support, the weight ratio of the co-catalyst and the support may be 1:1 to 1:100, more particularly, 1:1 to 1:50. If the co-catalyst and the support are included in the weight ratio, catalyst activity may be improved, and the microstructure of a polymer prepared may be optimized.

[00175] Meanwhile, silica, alumina, magnesia or mixtures thereof may be used as the support, or these materials may be used after drying at a high temperature to remove moisture at the surface and in a state including a hydroxyl group or siloxane group which has high reactivity at the surface. Also, the dried support at a high temperature may further include an oxide, a carbonate, a sulfate or a nitrate component such as Na_2O , K_2CO_3 , BaSO_4 and $\text{Mg}(\text{NO}_3)_2$.

[00176] The drying temperature of the support is preferably, from 200 to 800°C, more preferably, from 300 to 600°C, most preferably, from 300 to 400°C. If the drying temperature of the support is less than 200°C, humidity is too high and moisture at the surface may react with the co-catalyst, and if the temperature is greater than 800°C, the pores at the surface of the support may be combined to decrease the surface area, and a large amount of the hydroxyl groups at the surface may be removed to remain only siloxane groups to decrease reaction sites with the co-catalyst, undesirably.

[00177] In addition, the amount of the hydroxyl group at the surface of the support may preferably be 0.1 to 10 mmol/g, more preferably, 0.5 to 5 mmol/g. The amount of the hydroxyl group at the surface of the support may be controlled by the preparation method and conditions of the support, or drying conditions, for example, temperature, time, vacuum or spray drying.

[00178] In addition, an organoaluminum compound may be further injected for removing moisture in a reactor during polymerization reaction, and the polymerization reaction may be performed in the presence thereof. Particular examples of such organoaluminum compound may include trialkylaluminum, dialkylaluminum halide, alkyl aluminum dihalide, aluminum dialkyl hydride or alkyl aluminum sesqui halide, and more

particular examples may include $\text{Al}(\text{C}_2\text{H}_5)_3$, $\text{Al}(\text{C}_2\text{H}_5)_2\text{H}$, $\text{Al}(\text{C}_3\text{H}_7)_3$, $\text{Al}(\text{C}_3\text{H}_7)_2\text{H}$, $\text{Al}(\text{i-C}_4\text{H}_9)_2\text{H}$, $\text{Al}(\text{C}_8\text{H}_{17})_3$, $\text{Al}(\text{C}_{12}\text{H}_{25})_3$, $\text{Al}(\text{C}_2\text{H}_5)(\text{C}_{12}\text{H}_{25})_2$, $\text{Al}(\text{i-C}_4\text{H}_9)(\text{C}_{12}\text{H}_{25})_2$, $\text{Al}(\text{i-C}_4\text{H}_9)_2\text{H}$, $\text{Al}(\text{i-C}_4\text{H}_9)_3$, $(\text{C}_2\text{H}_5)_2\text{AlCl}$, $(\text{i-C}_3\text{H}_9)_2\text{AlCl}$, $(\text{C}_2\text{H}_5)_3\text{Al}_2\text{Cl}_3$, etc. Such organoaluminum compound
5 may be continuously injected into a reactor, or may be injected in a ratio of about 0.1 to 10 mol per 1 kg of a reaction medium injected into the reactor for suitable removal of moisture.

[00179] In addition, a polymerization pressure may be about 1
10 to about 100 Kgf/cm², preferably, about 1 to about 50 Kgf/cm², more preferably, about 5 to about 30 Kgf/cm².

[00180] Also, if the transition metal compound is used in a supported type by a support, the transition metal compound may be injected after being dissolved or diluted in an
15 aliphatic hydrocarbon solvent of 5 to 12 carbon atoms, for example, pentane, hexane, heptane, nonane, decane, and isomers thereof, an aromatic hydrocarbon solvent such as toluene and benzene, or a hydrocarbon solvent substituted with a chlorine atom such as dichloromethane and
20 chlorobenzene. The solvent used is preferably used after treating with a small amount of alkyl aluminum to remove a small amount of water or air, which acts as a catalyst poison, and may be used by using a co-catalyst further.

25 **[00181]** The ethylene/alpha-olefin copolymer of the present

invention may be processed into a resin composition by including a crosslinking agent, a crosslinking auxiliary agent, a silane coupling agent, a light stabilizer, a UV absorbent, a thermal stabilizer, etc., and various additives known in this corresponding field may be suitably additionally included according to the use of a resin component applied in addition to the components.

[00182] In addition, the ethylene/alpha-olefin copolymer may be utilized in various molded articles by molding by extrusion, etc. Particularly, the ethylene/alpha-olefin copolymer may be used in various optoelectronic devices, for example, as an encapsulant for the encapsulation of a device in a solar cell, for example, may be used as an industrial material applied in a lamination process with heating, etc., without limitation.

[00183] Examples

[00184] Hereinafter, the present invention will be explained in more detail referring to embodiments. However, the embodiments are provided only for illustration of the present invention, and the scope of the present invention is not limited thereto.

[00185] [Preparation of transition metal compound]

[00186] Preparation Example 1

[00187] (1) Preparation of ligand compound

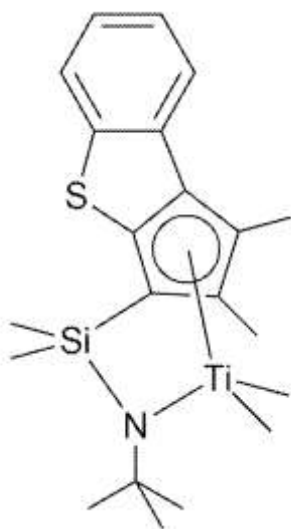
[00188] <Synthesis of N-tert-butyl-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophen-3-yl)-1,1-dimethylsilanamine>

[00189] To a 100 ml schlenk flask, 4.65 g (15.88 mmol) of the
5 compound of Formula 3 was weighed and added, and 80 ml of THF
was injected thereto. At room temperature, tBuNH₂ (4 eq,
6.68 ml) was injected thereto and reacted at room temperature
for 3 days. After finishing the reaction, THF was removed,
and the resultant reaction product was filtered with hexane.
10 After drying solvents, 4.50 g (86%) of a yellow liquid was
obtained.

[00190] ¹H-NMR (in CDCl₃, 500 MHz): 7.99 (d, 1H), 7.83 (d,
1H), 7.35 (dd, 1H), 7.24 (dd, 1H), 3.49 (s, 1H), 2.37 (s, 3H),
2.17 (s, 3H), 1.27 (s, 9H), 0.19 (s, 3H), -0.17 (s, 3H).

15 **[00191]** (2) Preparation of transition metal compound

[00192] [Formula 1-1]



[00193] To a 50 ml schlenk flask, the ligand compound (1.06 g, 3.22 mmol/1.0 eq) and 16.0 ml (0.2 M) of MTBE were put and stirred first. n-BuLi (2.64 ml, 6.60 mmol/2.05 eq, 2.5 M in THF) was added thereto at -40°C and reacted at room temperature overnight. After that, MeMgBr (2.68 ml, 8.05 mmol/2.5 eq, 3.0 M in diethyl ether) was slowly added thereto dropwisely at -40°C, and TiCl₄ (2.68 ml, 3.22 mmol/1.0 eq, 1.0 M in toluene) was put in order, followed by reacting at room temperature overnight. After that, the reaction mixture was passed through celite using hexane for filtration. After drying the solvents, 1.07 g (82%) of a brown solid was obtained.

[00194] ¹H-NMR (in CDCl₃, 500 MHz): 7.99 (d, 1H), 7.68 (d, 1H), 7.40 (dd, 1H), 7.30 (dd, 1H), 3.22 (s, 1H), 2.67 (s, 3H), 2.05 (s, 3H), 1.54 (s, 9H), 0.58 (s, 3H), 0.57 (s, 3H), 0.40 (s, 3H), -0.45 (s, 3H).

[00195] Preparation Example 2

[00196] (1) Preparation of ligand compound

[00197] <Synthesis of N-tert-butyl-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(2-ethylphenyl) (methyl)silanamine>

[00198] (i) Preparation of chloro-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(2-ethylphenyl) (methyl)silane

[00199] To a 100 ml schlenk flask, 2 g (1 eq, 9.99 mmol) of 1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene and 50 ml of THF were put, and 4 ml (1 eq, 9.99 mmol, 2.5 M in hexane) of n-BuLi was added thereto dropwisely at -30°C, followed by stirring at room temperature overnight. A stirred Li-complex THF solution was cannulated into a schlenk flask containing 2.19 ml (1.0 eq, 9.99 mmol) of dichloro(2-ethylphenyl)(methyl)silane and 50 ml of THF at -78°C, followed by stirring at room temperature overnight. After stirring, drying in vacuum was carried out and extraction with 60 ml of hexane was carried out. After drying again in vacuum and washing with hexane, 3.83 g (99%, dr = 1:1) of an ivory solid was obtained.

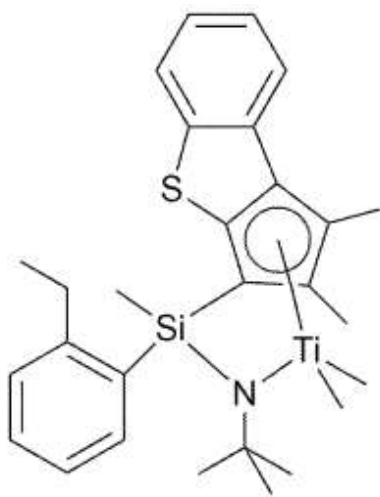
[00200] (ii) Preparation of N-tert-butyl-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(2-ethylphenyl)(methyl)silanamine

[00201] To 100 ml round flask, 3.87 g (10.1 mmol) of chloro-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(2-ethylphenyl)(methyl)silane was weighed and added, and 40 ml of hexane was injected thereto. At room temperature, t-BuNH₂ (10 eq, 10.5 mL) was injected and reacted at room temperature for 2 days. After the reaction, hexane was removed, and filtering with hexane was carried out. After drying the solvents, 3.58 g (84.4%, dr = 1:0.8) of a yellow solid was obtained.

[00202] $^1\text{H-NMR}$ (CDCl_3 , 500 MHz): δ 7.98 (t, 2H), 7.71 (d, 1H), 7.55 (d, 1H), 7.52 (d, 1H), 7.48 (d, 1H), 7.30 (t, 1H), 7.26-7.22 (m, 3H), 7.19 (dd, 2H), 7.12-7.06 (m, 3H), 7.00 (t, 1H), 3.08-2.84 (m, 4H) 3.05-2.84 (m, 2H), 2.28 (s, 3H), 2.20 (s, 3H), 2.08 (s, 3H), 1.62 (s, 3H), 1.26-1.22 (m, 6H), 1.06 (s, 9H), 0.99 (s, 9H), 0.05 (s, 3H), -0.02 (s, 3H).

[00203] (2) Preparation of transition metal compound

[00204] [Formula 2-5]



[00205] To a 50 ml vial, the ligand compound (1.74 g, 4.14 mmol/1.0 eq) and 20.7 ml (0.2 M) of toluene were put and stirred. $n\text{-BuLi}$ (3.48 ml, 8.7 mmol/2.1 eq, 2.5 M in hexane) was added thereto at -40°C and stirred at room temperature overnight. Then, MeMgBr (4.14 ml, 12.42 mmol/3.0 eq, 3.0 M in diethyl ether) was slowly added thereto dropwisely at -40°C , and TiCl_4DME (1.1 g, 4.14 mmol/1.0 eq) was put in order, followed by stirring at room temperature overnight. After drying the solvents, the reaction mixture was filtered using

hexane. Then, DME (1.29 ml, 12.42 mmol/3 eq) was added to the filtrate and stirred at room temperature overnight. After drying the solvents, the resultant product was filtered using hexane to obtain 335 mg (16.3%, dr = 1:0.8) of a yellow solid.

[00206] ^1H NMR(CDCl_3 , 500 MHz): δ 7.90(d, 1H), 7.85(d, 1H), 7.74(d, 1H), 7.71(d, 1H), 7.40(d, 1H), 7.37(d, 1H), 7.27(d, 1H), 7.23(t, 2H), 7.17(t, 2H), 7.13(t, 2H), 7.06(t, 1H), 7.01(t, 1H), 6.86(t, 1H), 2.97-2.91(m, 2H), 2.90-2.82(m, 2H), 2.33(s, 3H), 2.22(s, 3H), 1.96(s, 3H), 1.68(s, 9H), 1.66(s, 9H), 1.38(s, 3H), 1.32(t, 3H), 1.24(t, 3H), 1.07(s, 3H), 0.88(s, 3H), 0.85(s, 3H), 0.72(s, 3H), 0.19(s, 3H), 0.01(s, 3H).

[00207] Preparation Example 3

[00208] (1) Preparation of ligand compound

[00209] <Synthesis of N-tert-butyl-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(methyl)(phenyl)silane>

[00210] (i) Preparation of chloro-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(methyl)(phenyl)silane

[00211] To a 250 ml schlenk flask, 10 g (1.0 eq, 49.925 mmol) of 1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene and 100 ml of THF were put, and 22 ml (1.1 eq, 54.918 mmol, 2.5 M in

hexane) of n-BuLi was added thereto dropwisely at -30°C, followed by stirring at room temperature for 3 hours. A stirred Li-complex THF solution was cannulated into a schlenk flask containing 8.1 ml (1.0 eq, 49.925 mmol) of
5 dichloro(methyl)(phenyl)silane and 70 ml of THF at -78°C, followed by stirring at room temperature overnight. After stirring, drying in vacuum was carried out, and extraction with 100 ml of hexane was carried out.

[00212] (ii) Preparation of N-tert-butyl-1-(1,2-dimethyl-3H-
10 benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-
(methyl)(phenyl)silamine

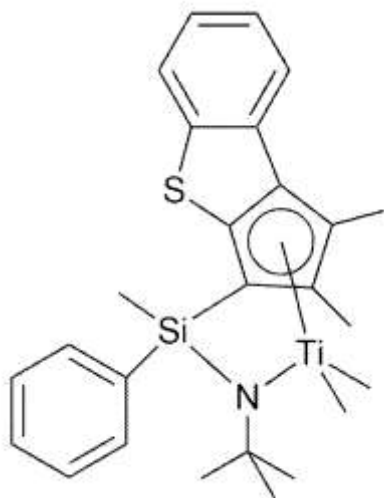
[00213] After injecting 42 ml (8 eq, 399.4 mmol) of t-BuNH₂ to 100 ml of the extracted chloro-1-(1,2-dimethyl-3H-
benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-

15 (methyl)(phenyl)silane hexane solution at room temperature, stirring was performed at room temperature overnight. After stirring, drying in vacuum was carried out, and extraction with 150 ml of hexane was carried out. After drying the solvents, 13.36 g (68%, dr = 1:1) of a yellow solid was
20 obtained.

[00214] ¹H NMR(CDCl₃, 500 MHz): δ 7.93(t, 2H), 7.79(d,1H), 7.71(d,1H), 7.60(d, 2H), 7.48(d, 2H), 7.40~7.10(m, 10H, aromatic), 3.62(s, 1H), 3.60(s, 1H), 2.28(s, 6H), 2.09(s, 3H), 1.76(s, 3H), 1.12(s, 18H), 0.23(s, 3H), 0.13(s, 3H).

25 **[00215]** (2)Preparation of transition metal compound

[00216] [Formula 2-4]



[00217] To a 100 ml schlenk flask, 4.93 g (12.575 mmol, 1.0 eq) of the ligand compound of Formula 2-4 and 50 ml (0.2 M) of toluene were put, and 10.3 ml (22.779 mmol, 2.05 eq, 2.5 M in hexane) of n-BuLi was added thereto dropwisely at -30°C, followed by stirring at room temperature overnight. After stirring, 12.6 ml (37.725 mmol, 3.0 eq, 3.0 M in diethyl ether) of MeMgBr was added thereto dropwisely, and 13.2 ml (13.204 mmol, 1.05 eq, 1.0 M in toluene) of TiCl₄ was put in order, followed by stirring at room temperature overnight. After stirring, the reaction product was dried in vacuum and extracted with 150 ml of hexane. The solvents were removed to 50 ml, and 4 ml (37.725 mmol, 3.0 eq) of DME was added dropwisely and stirred at room temperature overnight. After drying again in vacuum and extracting with 150 ml of hexane, 2.23 g (38%, dr = 1:0.5) of a brown solid was obtained.

[00218] ^1H NMR(CDCl_3 , 500 MHz): δ 7.98(d, 1H), 7.94(d, 1H), 7.71(t, 6H), 7.50~7.30(10H), 2.66(s, 3H), 2.61(s, 3H), 2.15(s, 3H), 1.62(s, 9H), 1.56(s, 9H), 1.53(s, 3H), 0.93(s, 3H), 0.31(s, 3H), 0.58(s, 3H), 0.51(s, 3H), -0.26(s, 3H), -0.39(s, 3H).

[00219] Preparation Example 4

[00220] (1) Preparation of ligand compound

[00221] <Synthesis of N-tert-butyl-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(methyl)(2-methylphenyl)silanamine>

[00222] (i) Preparation of chloro-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(methyl)(2-methylphenyl)silane

[00223] To a 250 ml schlenk flask, 2.0 g (1.0 eq, 9.985 mmol) of 1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene and 50 ml of THF were put, and 4.2 ml (1.05 eq, 10.484 mmol, 2.5 M in hexane) of n-BuLi was added thereto dropwisely at -30°C , followed by stirring at room temperature overnight. A stirred Li-complex THF solution was cannulated into a schlenk flask containing 2.46 g (1.2 eq, 11.982 mmol) of dichloro(o-tolylmethyl)silane and 30 ml of THF at -78°C , followed by stirring at room temperature overnight. After stirring, drying in vacuum was carried out, and extraction with 100 ml of hexane was carried out.

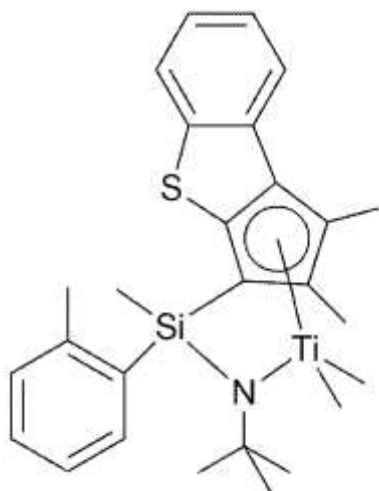
[00224] (ii) Preparation of N-tert-butyl-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(methyl)(2-methylphenyl)silanamine

[00225] After stirring 4.0 g (1.0 eq, 10.0 mmol) of the
5 extracted chloro-1-(1,2-dimethyl-3H-benzo[b]cyclopenta[d]thiophene-3-yl)-1,1-(methyl)(2-methylphenyl)silane in 10 ml of hexane, 4.2 ml (4.0 eq, 40.0 mmol) of t-BuNH₂ was injected at room temperature, followed by stirring at room temperature overnight. After stirring,
10 drying in vacuum was carried out, and extraction with 150 ml of hexane was carried out. After drying the solvents, 4.26 g (99%, dr = 1:0.83) of a sticky liquid was obtained.

[00226] ¹H-NMR(CDCl₃, 500 MHz): δ 7.95(t, 2H), 7.70(d, 1H), 7.52(d, 1H), 7.47-7.44(m, 2H), 7.24-7.02(m, 9H), 6.97(t, 1H),
15 3.59(s, 1H), 3.58(s, 1H), 2.50(s, 3H), 2.44(s, 3H), 2.25(s, 3H), 2.16(s, 3H), 2.06(s, 3H), 1.56(s, 3H), 1.02(s, 9H), 0.95(s, 9H), -0.03(s, 3H), -0.11(s, 3H).

[00227] (2)Preparation of transition metal compound

[00228] [Formula 2-3]



[00229] To a 250 ml round flask, the ligand compound of Formula 2-3 (4.26 g, 10.501 mmol) was put in 53 ml (0.2 M) of MTBE and stirred. n-BuLi (8.6 ml, 21.52 mmol, 2.05 eq, 2.5 M in hexane) was added thereto at -40°C and stirred at room temperature overnight.

[00230] Then, MeMgBr (8.8 ml, 26.25 mmol, 2.5 eq, 3.0 M in diethyl ether) was slowly added thereto dropwisely at -40°C, and TiCl₄ (10.50 ml, 10.50 mmol) was put in order, followed by stirring at room temperature overnight. After that, the reaction mixture was filtered using hexane.

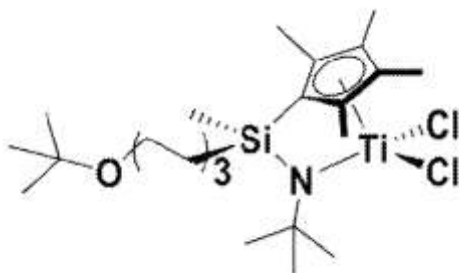
[00231] DME (3.3 ml, 31.50 mmol) was added to the filtrate, and the resultant solution was filtered using hexane and concentrated to obtain 3.42 g (68%, dr = 1:0.68) of a yellow solid.

[00232] ¹H NMR(CDCl₃, 500 MHz): δ 7.83(d, 1H), 7.80(d, 1H), 7.74(d, 1H), 7.71(d, 1H), 7.68(d, 1H), 7.37(d, 1H), 7.31-

6.90 (m, 9H), 6.84 (t, 1H), 2.54 (s, 3H), 2.47 (s, 3H), 2.31 (s, 3H), 2.20 (s, 3H), 1.65 (s, 9H), 1.63 (s, 9H), 1.34 (s, 3H), 1.00 (s, 3H), 0.98 (s, 3H), 0.81 (s, 3H), 0.79 (s, 3H), 0.68 (s, 3H), 0.14 (s, 3H), -0.03 (s, 3H).

5

[00233] Comparative Preparation Example 1



[00234]

[00235] The compound above was synthesized according to a method described in PCT Publication WO 2016-186295 A1 and then, used.

10

[00236] [Preparation of ethylene/alpha-olefin copolymer]

[00237] Example 1

[00238] While injecting a hexane solvent in 5 kg/h and 1-butene in 1.15 kg/h, a 1.5 L continuous process reactor was pre-heated at 120°C. Triisobutylaluminum (Tibal, 0.045 mmol/min), a mixture (0.120 μmol/min) of the transition metal compounds obtained in Preparation Examples 1 and 2 in a molar ratio of 3:7, and a dimethylanilinium tetrakis(pentafluorophenyl)borate co-catalyst (0.144 μmol/min) were put in the reactor at the same time. Then,

15

20

into the reactor, ethylene (0.87 kg/h) and a hydrogen gas (20 cc/min) were injected and copolymerization reaction was continuously carried out while maintaining a pressure of 89 bar and 130.1°C for 60 minutes or more to prepare a copolymer.

5 After drying for 12 hours or more in a vacuum oven, yield was measured, and the results are shown in Table 1.

[00239] Examples 2 to 4, and Comparative Examples 1 to 5

[00240] Ethylene/alpha-olefin copolymers were prepared by the same method as in Example 1 except for changing
10 polymerization conditions as shown in Table 1 below.

[00241] [Table 1]

	Catalyst type	Molar ratio	Cat.	Co-cat.	Tibal	C2	C6	Alpha olefin		Hydrogen	Polymerization temp.	Yield
			μmol/min		mmol/min	kg/h	kg/h	type	kg/h			
Example 1	Preparation Example 1 + Preparation Example 2	3:7	0.120	0.144	0.045	0.87	5.0	1-C4	1.15	20	130.1	10.8
Example 2	Preparation Example 1 + Preparation Example 3	3:7	0.120	0.144	0.045	0.87	5.0	1-C4	1.00	20	130.5	9.9
Example 3	Preparation Example 1 + Preparation Example 3	3:7	0.135	0.162	0.045	0.87	5.0	1-C4	0.70	20	130.2	9.5
Example 4	Preparation Example 1 + Preparation Example 4	3:7	0.120	0.144	0.058	0.87	5.0	1-C4	0.84	22	130.9	10.8
Comparative Example 1	Comparative Preparation Example 1	-	0.120	0.188	0.035	0.87	5.0	1-C4	1.15	2	130.8	12.5
Comparative Example 2	Preparation Example 3 + Comparative Preparation Example 1	8:2	0.200	0.400	0.035	0.87	5.0	1-C4	0.70	7	132.1	13.4
Comparat	Preparation	-	0.1	0.1	0.040	0.8	5.0	1-	0.	23	130.1	9.8

ive Example 3	Example 2		20	44		7		C4	70			
Comparat ive Example 4	Preparation Example 3	-	0.1 70	0.2 04	0.045	0.8 7	5.0	1- C4	0. 84	23	136.8	9.6
Comparat ive Example 5	Preparation Example 1	-	0.6 00	2.6 00	0.045	0.8 7	5.0	1- C8	0. 31	-	160.0	15. 4

[00242] [Analysis of ethylene/alpha-olefin copolymer]

[00243] Experimental Example 1

[00244] With respect to the ethylene/alpha-olefin copolymers
5 prepared in the Examples and Comparative Examples, physical
properties were measured by the methods below and are shown
in Table 2.

[00245] (1) Density (g/cm³)

[00246] Measurement was conducted according to ASTM D-792.

10 **[00247]** (2) Melt index (MI_{2.16}, dg/min)

[00248] Measurement was conducted according to ASTM D-1238
(condition E, 190°C, 2.16 kg load).

[00249] (3) Melt flow rate ratio (MFRR, MI₁₀/MI_{2.16})

[00250] MI₁₀ (condition E, 190°C, 10 kg load) and MI_{2.16}
15 (condition E, 190°C, 2.16 kg load) were measured according to
ASTM D-1238 and MI₁₀/MI_{2.16} was calculated.

[00251] (4) Melting temperature (T_m) and Crystallization
temperature (T_c)

[00252] Melting temperature (T_m) and crystallization
20 temperature (T_c) could be obtained using differential

scanning calorimeter (DSC 6000) manufactured by PerkinElmer, and particularly, using DSC under a nitrogen atmosphere, the temperature of the copolymer was elevated to 150°C, maintained for 5 minutes, decreased to -100°C, and elevated again, and a DSC curve was observed. In this case, the temperature elevating rate and decreasing rate were 10°C/min, respectively.

[00253] In the measured DSC curve, the melting temperature was the maximum point of an endothermic peak during the second temperature elevation, and the crystallization temperature was determined as the maximum point of an exothermal peak during decreasing the temperature.

[00254] (5) Molecular weight distribution (MWD)

[00255] A weight average molecular weight (Mw) and a number average molecular weight (Mn) of the copolymer thus produced were measured under analysis conditions of gel permeation chromatography (GPC) below, and molecular weight distribution (MWD) was calculated from the ratio of Mw/Mn.

[00256] - Column: Agilent Olexis

[00257] - Solvent: Trichlorobenzene

[00258] - Flow rate: 1.0 ml/min

[00259] - Specimen concentration: 1.0 mg/ml

[00260] - Injection amount: 200 µl

[00261] - column temperature: 160°C

[00262] - Detector: Agilent High Temperature RI detector

[00263] - Standard: Polystyrene (calibrated by cubic function)

[00264] - Data processing: Cirrus

[00265] (6) C_2 value

5 **[00266]** Measurement was conducted using a measurement apparatus of ARES-G2 of TA Co. Particularly, a disk type disk specimen having a diameter of 25 mm and a thickness of 1 mm was prepared as the sample of an ethylene/alpha-olefin copolymer. The geometry of a parallel plate (flat shape) was
10 used, and Equation 1 was calculated by the methods 1) and 2) below.

[00267] 1) Frequency sweep at five specific temperatures

[00268] In a temperature range lower than $T_g + 200^\circ\text{C}$ of an ethylene/alpha-olefin copolymer, frequency sweep was measured
15 at five specific temperatures selected with an interval of 10°C . In the present invention, measurement was conducted at a temperature of $110\text{--}150^\circ\text{C}$ with an interval of 10°C (strain $0.5\text{--}3\%$, frequency $0.1\text{--}500\text{ rad/s}$).

[00269] 2) Deduction of master curve

20 **[00270]** The reference temperature T_r was set to 130°C , and the measurement results of step 1) at 130°C was shifted to deduce a master curve.

[00271] 3) Deduction of C_2 value

[00272] The shift factor (aT) of a WLF equation was obtained,
25 and this value was substituted in Equation 2 to deduce a C_2

value.

[00273] [Table 2]

	Density	MI	MFRR	Tm	Tc	MWD	C2
	g/cm ³	dg/min	-	°C	°C	-	-
Example 1	0.878	5.8	6.2	64.1	47.0	1.98	403
Example 2	0.878	4.3	6.1	64.2	48.3	2.00	498
Example 3	0.878	4.8	6.0	62.1	46.9	1.97	488
Example 4	0.877	6.1	6.1	62.2	47.5	2.00	449
Comparative Example 1	0.878	5.0	7.3	62.8	47.7	2.23	625
Comparative Example 2	0.875	4.0	6.7	90.4	67.0	2.35	423
Comparative Example 3	0.878	5.6	5.9	62.0	47.5	1.96	646
Comparative Example 4	0.879	4.5	6.1	63.4	49.3	2.01	610
Comparative Example 5	0.902	4.2	7.4	103.0	78.1	2.24	470

[00274] As summarized in Table 2, it was confirmed that Examples 1 to 4 corresponding to the ethylene/alpha-olefin copolymers according to the present invention showed small C2 values of 500 or less and narrow molecular weight distribution and also satisfied the ranges of the density and the melting temperature defined in the present invention. On the contrary, the ethylene/alpha-olefin copolymers of Comparative Examples 1, 3 and 4 showed high C2 values greater than 600, and this indicates that the crystallinity distribution of the copolymers was narrow, and free volume ratios were high.

[00275] In addition, it was confirmed that the molecular weight distribution and melting temperature of the copolymer of Comparative Example 2 were high and deviated from the ranges of the present invention, and the density and melting temperature of the copolymer of Comparative Example 5

deviated from the ranges of the present invention.

[00276] Experimental Example 2

[00277] 6 g of the ethylene/alpha-olefin copolymer was put in
5 a 0.5 T square frame, the front and back sides were covered
with 3T steel sheets, and this was injected into a high
temperature press. After continuously treating at 190°C with
25 N/cm² (240 seconds), decompression/compression degassing
six times, and at 190°C with 151 N/cm² for 240 seconds, the
10 temperature was decreased to 30°C by 15°C per minute. In
this case, the pressure was kept to 151 N/cm². By keeping
30°C at 151 N/cm² for 300 seconds, the manufacture of a
specimen was completed.

[00278] With respect to the specimen thus manufactured,
15 volume resistance and light transmittance were measured
according to the methods below and are shown in Table 3.

[00279] (1) Volume resistance

[00280] Measurement was conducted while applying a voltage of
1000 V for 600 seconds using Agilent 4339B High-resistance
20 meter (product of Agilent Technologies K.K.) under
temperature conditions of 23±1°C and humidity conditions of
50±3%.

[00281] (2) Light transmittance

[00282] Light transmittance at 550 nm was measured using a
25 UV-3600 spectrophotometer of Shimadzu.

[00283] - Measurement mode: transmittance

[00284] - Wavelength interval: 1 nm

[00285] - Measurement rate: medium

[00286] [Table 3]

	Volume resistance ($\Omega \cdot \text{cm}$)	Light transmittance (%)
Example 1	1.4×10^{16}	91.1
Example 2	1.3×10^{16}	91.4
Example 3	1.2×10^{16}	91.2
Example 4	2.2×10^{16}	91.6
Comparative Example 1	5.0×10^{15}	91.1
Comparative Example 2	9.2×10^{15}	88.5
Comparative Example 3	7.0×10^{15}	91.2
Comparative Example 4	7.5×10^{15}	91.4
Comparative Example 5	9.8×10^{15}	88.2

5 [00287] As shown in Table 3, it was confirmed that, different from the ethylene/alpha-olefin copolymers of the Comparative Examples, the ethylene/alpha-olefin copolymers of the present invention could achieve both high volume resistance and high light transmittance. Particularly, the ethylene/alpha-olefin copolymers of Comparative Examples 1, 3 and 4 showed C2
10 values greater than 600, and volume resistance was markedly degraded, and the copolymers of Comparative Examples 2 and 5 showed particularly low light transmittance. As described above, the ethylene/alpha-olefin copolymers satisfying all of
15 the density, molecular weight distribution, melting temperature and C2 value defined in the present invention may achieve excellent degrees of volume resistance and light transmittance without using a separate additive.

CLAIMS

1. An ethylene/alpha-olefin copolymer satisfying the following conditions (a) to (d):
 - (a) a density is 0.85 to 0.89 g/cc;
 - (b) molecular weight distribution is 1.5 to 2.3;
 - (c) a melting temperature is 85°C or less; and
 - (d) a free volume proportional constant (C_2) is 300 to 550, determined with an ARES-G2 as set out in the specification,
 - wherein the alpha-olefin is comprised in 10 to 50 mol% with respect to the copolymer;
 - wherein a melt index ($MI_{2.16}$, 190°C, 2.16 kg load conditions) of the alpha-olefin is 3 dg/min to 10 dg/min, and
 - wherein an alpha-olefin of the copolymer comprises one or more selected from the group consisting of propylene, 1-butene, 1-pentene, 4-methyl-1-pentene, 1-hexene, 1-heptene, 1-octene, 1-decene, 1-undecene, 1-dodecene, 1-tetradecene, 1-hexadecene and 1-eicosene.
2. The ethylene/alpha-olefin copolymer according to claim 1, wherein the molecular weight distribution is 1.8 to 2.2.
3. The ethylene/alpha-olefin copolymer according to claim 1, wherein a melt flow rate ratio (MFRR, $MI_{10}/MI_{2.16}$) which is a value of a melt index (MI_{10} , 190°C, 10 kg load conditions) with respect to a melt index ($MI_{2.16}$, 190°C, 2.16 kg load conditions) is 8.0 or less.
4. The ethylene/alpha-olefin copolymer according to claim 1, wherein the copolymer has a crystallization temperature of 70°C or less.
5. The ethylene/alpha-olefin copolymer according to claim 1, wherein the copolymer has a melt index ($MI_{2.16}$, 190°C, 2.16 kg load conditions) of 0.1 to 50 dg/min.
6. The ethylene/alpha-olefin copolymer according to claim 1, wherein the copolymer has a weight average molecular weight (M_w) of 40,000 to 150,000 g/mol.