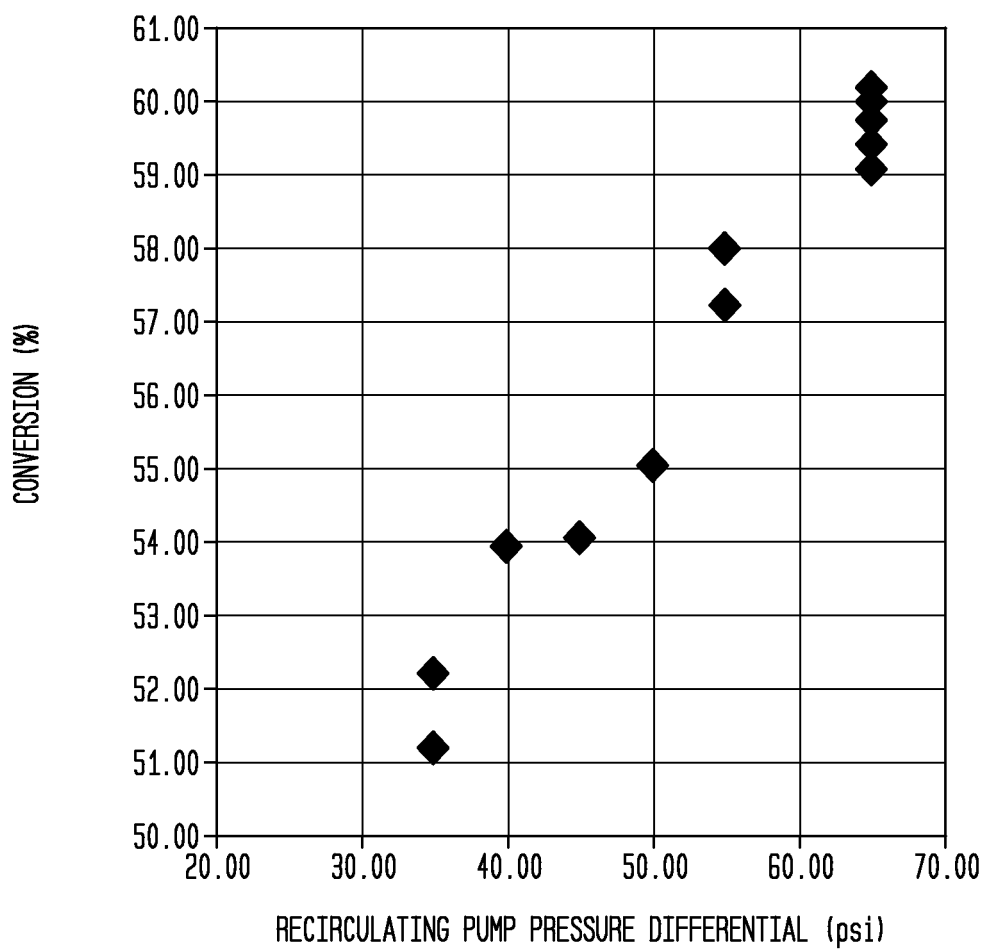


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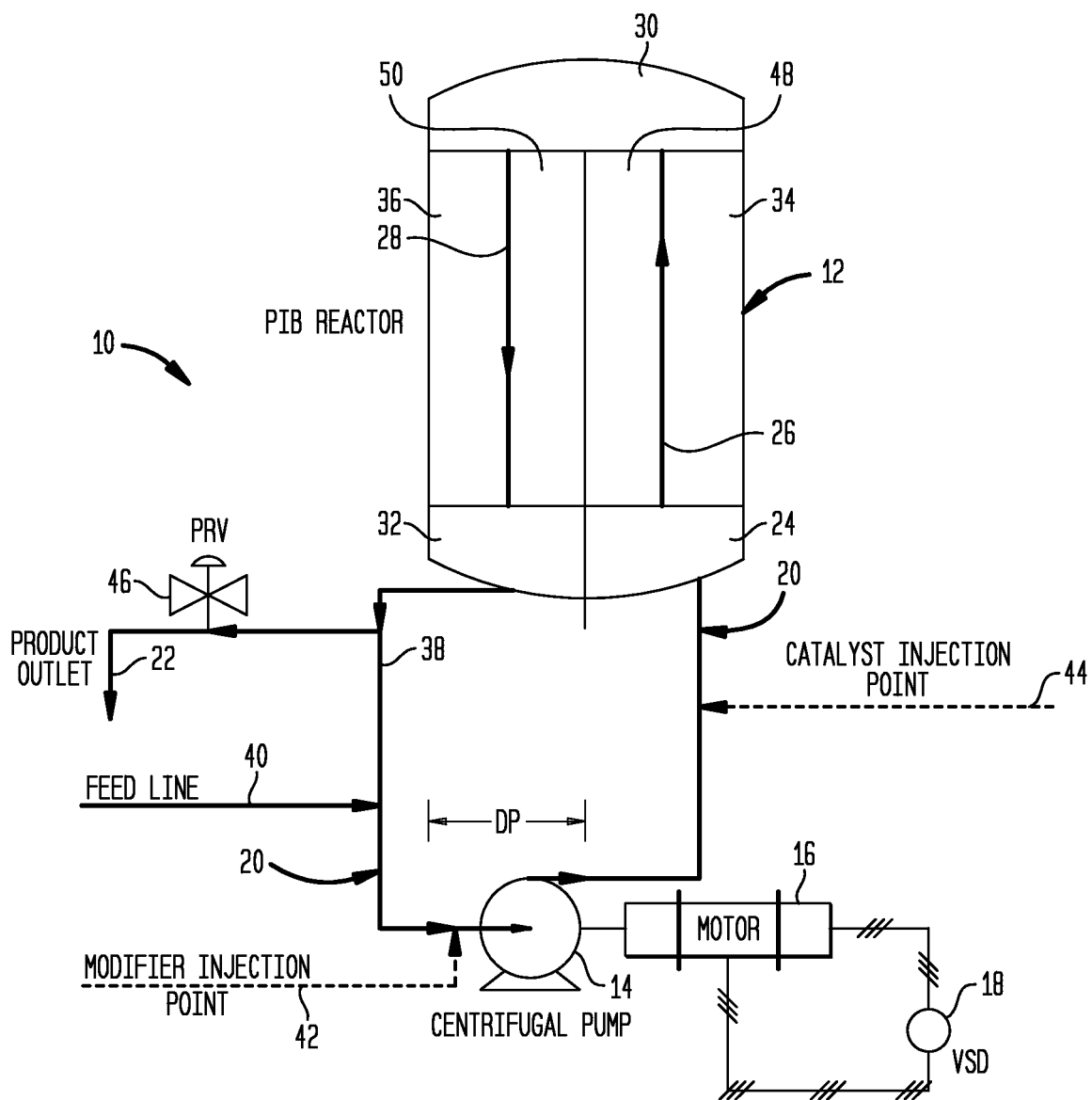
FIG. 1

CONVERSION AS A FUNCTION OF DELTA P (CIRCULATION RATE);
MID RANGE VINYLIDENE PIB; NOMINAL Mn of 3000



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FIG. 2



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FIG. 3

$$Q = \dot{m} c_p (t_1 - t_2) = \dot{M} C_p (T_1 - T_2) \quad (1)$$

$$Q = U A F_t \Delta t \quad (2)$$

$$\Delta t = \frac{(T_1 - t_2) - (T_2 - t_1)}{\ln \left\{ \frac{(T_1 - t_2)}{(T_2 - t_1)} \right\}} \quad (3)$$

$$F_t = \frac{\sqrt{R^2 + 1}}{R - 1} \frac{\ln \frac{(1 - S)}{(1 - RS)}}{\ln \frac{2 - S(R + 1 - \sqrt{R^2 + 1})}{2 - S(R + 1 + \sqrt{R^2 + 1})}} \quad (4)$$

$$R = \frac{(T_1 - T_2)}{(t_2 - t_1)} ; S = \frac{(t_2 - t_1)}{(T_1 - t_1)} \quad (5)$$

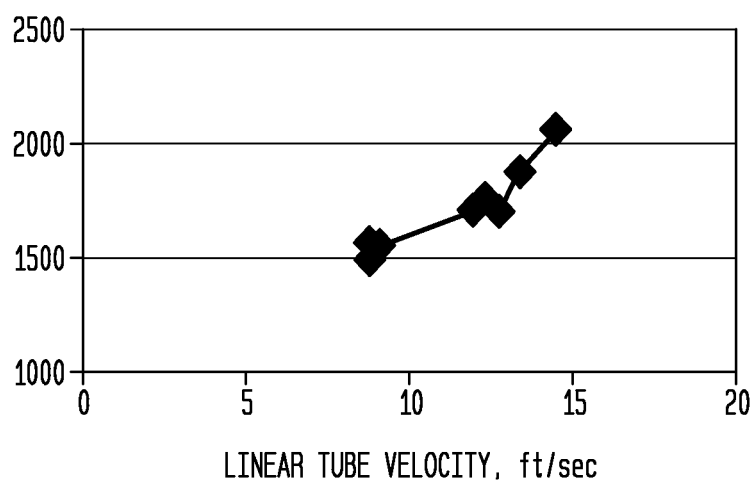
$$U = Q / (A F_t \Delta t) \quad (6)$$

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FIG. 4

CATALYST TURNOVER VS. VELOCITY, MID RANGE VINYLIDENE PIB, NOMINAL Mn 3300

CATALYST TURNOVER, Lbs POLYMER/ lb CATALYST COMPLEX



—◆— CATALYST TURNOVER
VS. VELOCITY

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FIG. 5

CONVERSION AS A FUNCTION OF DELTA P (CIRCULATION RATE);
MID RANGE VINYLIDENE PIB; NOMINAL M_n of 3300

