

ETHYLENE/ α -OLEFINS BLOCK INTERPOLYMERSFIELD OF THE INVENTION

[1] This invention relates to ethylene/ α -olefin block interpolymers and products made from the block interpolymers.

BACKGROUND OF THE INVENTION

[2] Block copolymers comprise sequences ("blocks") of the same monomer unit, covalently bound to sequences of unlike type. The blocks can be connected in a variety of ways, such as A—B in diblock and A—B—A triblock structures, where A represents one block and B represents a different block. In a multi-block copolymer, A and B can be connected in a number of different ways and be repeated multiply. It may further comprise additional blocks of different type. Multi-block copolymers can be either linear multi-block or multi-block star polymers (in which all blocks bond to the same atom or chemical moiety).

[3] A block copolymer is created when two or more polymer molecules of different chemical composition are covalently bonded in an end-to-end fashion. While a wide variety of block copolymer architectures are possible, most block copolymers involve the covalent bonding of hard plastic blocks, which are substantially crystalline or glassy, to elastomeric blocks forming thermoplastic elastomers. Other block copolymers, such as rubber-rubber (elastomer-elastomer), glass-glass, and glass-crystalline block copolymers, are also possible and may have commercial importance.

[4] One method to make block copolymers is to produce a "living polymer". Unlike typical Ziegler-Natta polymerization processes, living polymerization processes involve only initiation and propagation steps and essentially lack chain terminating side reactions. This permits the synthesis of predetermined and well-controlled structures desired in a block copolymer. A polymer created in a "living" system can have a narrow or extremely narrow distribution of molecular weight and be essentially monodisperse (i.e., the molecular weight distribution is essentially one). Living catalyst systems are characterized by an initiation rate which is on the order of or exceeds the propagation rate, and the absence of termination or transfer reactions. In addition, these catalyst systems are characterized by

the presence of a single type of active site. To produce a high yield of block copolymer in a polymerization process, the catalyst must exhibit living characteristics to a substantial extent.

[5] Butadiene-isoprene block copolymers have been synthesized via anionic polymerization using the sequential monomer addition technique. In sequential addition, a certain amount of one of the monomers is contacted with the catalyst. Once a first such monomer has reacted to substantial extinction forming the first block, a certain amount of the second monomer or monomer species is introduced and allowed to react to form the second block. The process may be repeated using the same or other anionically polymerizable monomers. However, ethylene and other α -olefins, such as propylene, butene, 1-octene, etc., are not directly block polymerizable by anionic techniques.

[6] Therefore, there is an unfulfilled need for block copolymers which are based on ethylene and α -olefins. There is also a need for a method of making such block copolymers.

SUMMARY OF THE INVENTION

[7] The aforementioned needs are met by various aspects of the invention. In one aspect, the invention relates to an ethylene/ α -olefin interpolymer comprising polymerized units of ethylene and α -olefin, wherein the interpolymer is characterized by an average block index greater than zero and up to about 1.0 and a molecular weight distribution, M_w/M_n , greater than about 1.3. In another aspect, the invention relates to an ethylene/ α -olefin interpolymer comprising polymerized units of ethylene and α -olefin, wherein the average block index is greater than 0 but less than about 0.4 and a molecular weight distribution, M_w/M_n , greater than about 1.3. Preferably, the interpolymer is a linear, multi-block copolymer with at least three blocks. Also preferably, the ethylene content in the interpolymer is at least 50 mole percent.

[8] In some embodiments, the average block index of the interpolymer is in the range from about 0.1 to about 0.3, from about 0.4 to about 1.0, from about 0.3 to about 0.7, from about 0.6 to about 0.9, or from about 0.5 to about 0.7. In other embodiments, the interpolymer has a density of less than about 0.91 g/cc, such as from about 0.86 g/cc to about 0.91 g/cc. In some embodiments, the α -olefin in the ethylene/ α -olefin interpolymer is styrene, propylene, 1-butene, 1-hexene, 1-octene, 4-methyl-1-pentene, norbornene, 1-decene,

1,5-hexadiene, or a combination thereof. In other embodiments, the molecular weight distribution, M_w/M_n , is greater than about 1.5 or greater than about 2.0. It can also range from about 2.0 to about 8 or from about 1.7 to about 3.5.

[9] In yet another aspect, the invention relates to an ethylene/ α -olefin
5 interpolymers comprising polymerized units of ethylene and α -olefin, the interpolymers characterized by having at least one fraction obtained by Temperature Rising Elution Fractionation ("TREF"), wherein the fraction has a block index greater than about 0.3 and up to about 1.0 and the ethylene/ α -olefin interpolymers has a molecular weight distribution, M_w/M_n , greater than about 1.3. In still another aspect, the invention relates to an ethylene/ α -
10 olefin interpolymers comprising polymerized units of ethylene and α -olefin, the interpolymers characterized by having at least one fraction obtained by TREF, wherein the fraction has a block index greater than about 0 and up to about 0.4 and the ethylene/ α -olefin interpolymers has a molecular weight distribution, M_w/M_n , greater than about 1.3. In some embodiments, the block index of the fraction is greater than about 0.4, greater than about 0.5, greater than
15 about 0.6, greater than about 0.7, greater than about 0.8, or greater than about 0.9.

[10] The interpolymers comprises one or more hard segments and one or more soft segments. Preferably, the hard segments comprise at least 98% of ethylene by weight, and the soft segments comprise less than 95%, preferably less than 50%, of ethylene by weight. In some embodiments, the hard segments are present in an amount from about 5% to about
20 85% by weight of the interpolymers. In other embodiments, the interpolymers comprises at least 5 or at least 10 hard and soft segments connected in a linear fashion to form a linear chain. Preferably, the hard segments and soft segments are randomly distributed along the chain. In some embodiments, neither the soft segments nor the hard segments include a tip segment (which is different by chemical composition than the rest of the segments).

25 [11] Methods of making the interpolymers are also provided herein. Additional aspects of the invention and characteristics and properties of various embodiments of the invention become apparent with the following description.

BRIEF DESCRIPTION OF THE DRAWINGS

[12] Figure 1 shows the melting point/density relationship for the inventive polymers (represented by diamonds) as compared to traditional random copolymers (represented by circles) and Ziegler-Natta copolymers (represented by triangles).

5 [13] Figure 2 shows plots of delta DSC-CRYSTAF as a function of DSC Melt Enthalpy for various polymers. The diamonds represent random ethylene/octene copolymers; the squares represent polymer examples 1-4; the triangles represent polymer examples 5-9; and the circles represent polymer examples 10-19. The "X" symbols represent polymer examples A*-F*.

10 [14] Figure 3 shows the effect of density on elastic recovery for unoriented films made from inventive interpolymers (represented by the squares and circles) and traditional copolymers (represented by the triangles which are Dow AFFINITY® polymers). The squares represent inventive ethylene/butene copolymers; and the circles represent inventive ethylene/octene copolymers.

15 [15] Figure 4 is a plot of octene content of Temperature Rising Elution Fractionation ("TREF") fractionated ethylene/ 1-octene copolymer fractions versus TREF elution temperature of the fraction for the polymer of Example 5 (represented by the circles) and comparative polymers E and F (represented by the "X" symbols). The diamonds represent traditional random ethylene/octene copolymers.

20 [16] Figure 5 is a plot of octene content of TREF fractionated ethylene/1-octene copolymer fractions versus ATREF elution temperature of the fraction for the polymer of Example 5 and for comparative F*. The squares represent Polymer Example F*; and the triangles represent Polymer Example 5. Also shown is the ATREF temperature distribution for Example 5 (curve 1) and comparative F* (curve 2).

25 [17] Figure 6 is a graph of log storage modulus as a function of temperature for comparative ethylene/1-octene copolymer (curve 2) and propylene/ethylene copolymer (curve 3) and for two ethylene/1-octene block copolymers according to embodiments of the invention made with differing quantities of chain shuttling agent (curves 1).

[18] Figure 7 shows a plot of Thermomechanical Analysis ("TMA") (1mm) versus flex modulus for some inventive polymers (represented by the diamonds), as compared to some known polymers. The triangles represent Dow VERSIFY[®] polymers; the circles represent random ethylene/styrene copolymers; and the squares represent Dow AFFINITY[®] polymers.

[19] Figure 8 is plot of natural log ethylene mole fraction for random ethylene/ α -olefin copolymers as a function of the inverse of DSC peak melting temperature or ATREF peak temperature. The filled squares represent data points obtained from random homogeneously branched ethylene/ α -olefin copolymers in ATREF; and the open squares represent data points obtained from random homogeneously branched ethylene/ α -olefin copolymers in DSC. "P" is the ethylene mole fraction; "T" is the temperature in Kelvin.

[20] Figure 9 is a plot constructed on the basis of the Flory equation for random ethylene/ α -olefin copolymers to illustrate the definition of "block index." "A" represents the whole, perfect random copolymer; "B" represents a pure "hard segment"; and "C" represents the whole, perfect block copolymer having the same comonomer content as "A". A, B, and C define a triangular area within which most TREF fractions would fall.

[21] Figure 10 is a plot of the block index calculated for each TREF fraction for four polymers. The diamond represent Polymer F* with an average block index of 0; the triangles represent Polymer 5 with an average block index of 0.53; the squares represent Polymer 8 with an average block index of 0.59; and the "X" represents Polymer 20 with an average block index of 0.20.

[22] Figure 11 is a plot of the block index calculated for each TREF fraction for two inventive polymers: the filled bars represent Polymer 18B; and the open bars represent Polymer 5.

[23] Figure 12 is a plot of the average block index calculated for nine different polymers as a function of the diethyl zinc concentration during polymerization in terms of "[Zn/C₂H₄]*1000." "x" represents an inventive ethylene/propylene block copolymer (Polymer 23); the two triangles represent two inventive ethylene/butene block copolymers (Polymer 21 and Polymer 22); and the squares represent ethylene/octene copolymers made at different levels of diethyl zinc (including one made without any diethyl zinc).

[24] Figure 13 is a plot of the square root of the second moment about the mean weight average block index as a function of $[Zn/C_2H_4]*1000$.

[25] Figure 14 is a representation of a normal DSC profile for an inventive polymer.

5 [26] Figure 15 is a weighted DSC profile obtained by converting Figure 14.

[27] Figure 16 is a ^{13}C NMR spectrum of Polymer 19A.

DESCRIPTION OF EMBODIMENTS OF THE INVENTION

General Definitions

[28] "Polymer" means a polymeric compound prepared by polymerizing
10 monomers, whether of the same or a different type. The generic term "polymer" embraces the terms "homopolymer," "copolymer," "terpolymer" as well as "interpolymer."

[29] "Interpolymer" means a polymer prepared by the polymerization of at least two different types of monomers. The generic term "interpolymer" includes the term "copolymer" (which is usually employed to refer to a polymer prepared from two different
15 monomers) as well as the term "terpolymer" (which is usually employed to refer to a polymer prepared from three different types of monomers). It also encompasses polymers made by polymerizing four or more types of monomers.

[30] The term "ethylene/ α -olefin interpolymer" generally refers to polymers comprising ethylene and an α -olefin having 3 or more carbon atoms. Preferably, ethylene
20 comprises the majority mole fraction of the whole polymer, i.e., ethylene comprises at least about 50 mole percent of the whole polymer. More preferably ethylene comprises at least about 60 mole percent, at least about 70 mole percent, or at least about 80 mole percent, with the substantial remainder of the whole polymer comprising at least one other comonomer that is preferably an α -olefin having 3 or more carbon atoms. For many ethylene/octene
25 copolymers, the preferred composition comprises an ethylene content greater than about 80 mole percent of the whole polymer and an octene content of from about 10 to about 15, preferably from about 15 to about 20 mole percent of the whole polymer. In some embodiments, the ethylene/ α -olefin interpolymers do not include those produced in low

yields or in a minor amount or as a by-product of a chemical process. While the ethylene/ α -olefin interpolymers can be blended with one or more polymers, the as-produced ethylene/ α -olefin interpolymers are substantially pure and often comprise a major component of the reaction product of a polymerization process.

5 [31] The term “crystalline” if employed, refers to a polymer or a segment that possesses a first order transition or crystalline melting point (T_m) as determined by differential scanning calorimetry (DSC) or equivalent technique. The term may be used interchangeably with the term “semicrystalline”. The term “amorphous” refers to a polymer lacking a crystalline melting point as determined by differential scanning calorimetry (DSC)
10 or equivalent technique.

 [32] The term “multi-block copolymer” or “segmented copolymer” refers to a polymer comprising two or more chemically distinct regions or segments (also referred to as “blocks”) preferably joined in a linear manner, that is, a polymer comprising chemically differentiated units which are joined end-to-end with respect to polymerized ethylenic
15 functionality, rather than in pendent or grafted fashion. In a preferred embodiment, the blocks differ in the amount or type of comonomer incorporated therein, the density, the amount of crystallinity, the crystallite size attributable to a polymer of such composition, the type or degree of tacticity (isotactic or syndiotactic), regio-regularity or regio-irregularity, the amount of branching, including long chain branching or hyper-branching, the homogeneity,
20 or any other chemical or physical property. The multi-block copolymers are characterized by unique distributions of both polydispersity index (PDI or M_w/M_n), block length distribution, and/or block number distribution due to the unique process making of the copolymers. More specifically, when produced in a continuous process, the polymers desirably possess PDI from about 1.7 to about 8, preferably from about 1.7 to about 3.5, more preferably from about
25 1.7 to about 2.5, and most preferably from about 1.8 to about 2.5 or from about 1.8 to about 2.1. When produced in a batch or semi-batch process, the polymers possess PDI from about 1.0 to about 2.9, preferably from about 1.3 to about 2.5, more preferably from about 1.4 to about 2.0, and most preferably from about 1.4 to about 1.8. It is noted that “block(s)” and “segment(s)” are used herein interchangeably.

30 [33] In the following description, all numbers disclosed herein are approximate values, regardless whether the word “about” or “approximate” is used in connection

therewith. They may vary by 1 percent, 2 percent, 5 percent, or, sometimes, 10 to 20 percent. Whenever a numerical range with a lower limit, R^L and an upper limit, R^U , is disclosed, any number falling within the range is specifically disclosed. In particular, the following numbers within the range are specifically disclosed: $R=R^L+k*(R^U-R^L)$, wherein k is a variable ranging from 1 percent to 100 percent with a 1 percent increment, i.e., k is 1 percent, 2 percent, 3 percent, 4 percent, 5 percent,..., 50 percent, 51 percent, 52 percent,..., 95 percent, 96 percent, 97 percent, 98 percent, 99 percent, or 100 percent. Moreover, any numerical range defined by two R numbers as defined in the above is also specifically disclosed.

[34] Embodiments of the invention provide a new class of ethylene/ α -olefin block interpolymers (hereinafter "inventive polymer", "ethylene/ α -olefin interpolymers", or variations thereof). The ethylene/ α -olefin interpolymers comprise ethylene and one or more copolymerizable α -olefin comonomers in polymerized form, characterized by multiple blocks or segments of two or more polymerized monomer units differing in chemical or physical properties. That is, the ethylene/ α -olefin interpolymers are block interpolymers, preferably multi-block interpolymers or copolymers. The terms "interpolymer" and copolymer" are used interchangeably herein. In some embodiments, the multi-block copolymer can be represented by the following formula:



[35] where n is at least 1, preferably an integer greater than 1, such as 2, 3, 4, 5, 10, 15, 20, 30, 40, 50, 60, 70, 80, 90, 100, or higher, "A" represents a hard block or segment and "B" represents a soft block or segment. Preferably, As and Bs are linked in a linear fashion, not in a branched or a star fashion. "Hard" segments refer to blocks of polymerized units in which ethylene is present in an amount greater than 95 weight percent, and preferably greater than 98 weight percent. In other words, the comonomer content in the hard segments is less than 5 weight percent, and preferably less than 2 weight percent. In some embodiments, the hard segments comprises all or substantially all ethylene. "Soft" segments, on the other hand, refer to blocks of polymerized units in which the comonomer content is greater than 5 weight percent, preferably greater than 8 weight percent, greater than 10 weight percent, or greater than 15 weight percent. In some embodiments, the comonomer content in the soft segments can be greater than 20 weight percent, greater than 25 weight percent, greater than 30 weight

percent, greater than 35 weight percent, greater than 40 weight percent, greater than 45 weight percent, greater than 50 weight percent, or greater than 60 weight percent.

[36] In some embodiments, A blocks and B blocks are randomly distributed along the polymer chain. In other words, the block copolymers usually do not have a structure like:



[37] In other embodiments, the block copolymers usually do not have a third type of block. In still other embodiments, each of block A and block B has monomers or comonomers randomly distributed within the block. In other words, neither block A nor block B comprises two or more segments (or sub-blocks) of distinct composition, such as a
10 tip segment, which has a different composition than the rest of the block.

[38] The ethylene/ α -olefin interpolymers are characterized by an average block index, ABI, which is greater than zero and up to about 1.0 and a molecular weight distribution, M_w/M_n , greater than about 1.3. The average block index, ABI, is the weight average of the block index ("BI") for each of the polymer fractions obtained in preparative
15 TREF (i.e., fractionation of a polymer by Temperature Rising Elution Fractionation) from 20°C and 110°C, with an increment of 5°C (although other temperature increments, such as 1°C, 2°C, 10°C, also can be used):

$$ABI = \sum (w_i BI_i)$$

where BI_i is the block index for the i th fraction of the inventive ethylene/ α -olefin
20 interpolymers obtained in preparative TREF, and w_i is the weight percentage of the i th fraction. Similarly, the square root of the second moment about the mean, hereinafter referred to as the second moment weight average block index, can be defined as follows.

$$2^{\text{nd}} \text{ moment weight average BI} = \sqrt{\frac{\sum (w_i (BI_i - ABI)^2)}{\frac{(N-1) \sum w_i}{N}}}$$

[39] where N is defined as the number of fractions with BI_i greater than zero.
25 Referring to Figure 9, for each polymer fraction, BI is defined by one of the two following equations (both of which give the same BI value):

$$BI = \frac{1/T_X - 1/T_{XO}}{1/T_A - 1/T_{AB}} \text{ or } BI = -\frac{\ln P_X - \ln P_{XO}}{\ln P_A - \ln P_{AB}}$$

where T_X is the ATREF (i.e., analytical TREF) elution temperature for the i th fraction (preferably expressed in Kelvin), P_X is the ethylene mole fraction for the i th fraction, which can be measured by NMR or IR as described below. P_{AB} is the ethylene mole fraction of the whole ethylene/ α -olefin interpolymer (before fractionation), which also can be measured by NMR or IR. T_A and P_A are the ATREF elution temperature and the ethylene mole fraction for pure "hard segments" (which refer to the crystalline segments of the interpolymer). As an approximation or for polymers where the "hard segment" composition is unknown, the T_A and P_A values are set to those for high density polyethylene homopolymer.

[40] T_{AB} is the ATREF elution temperature for a random copolymer of the same composition (having an ethylene mole fraction of P_{AB}) and molecular weight as the inventive copolymer. T_{AB} can be calculated from the mole fraction of ethylene (measured by NMR) using the following equation:

$$\ln P_{AB} = \alpha/T_{AB} + \beta$$

where α and β are two constants which can be determined by a calibration using a number of well characterized preparative TREF fractions of a broad composition random copolymer and/or well characterized random ethylene copolymers with narrow composition. It should be noted that α and β may vary from instrument to instrument. Moreover, one would need to create an appropriate calibration curve with the polymer composition of interest, using appropriate molecular weight ranges and comonomer type for the preparative TREF fractions and/or random copolymers used to create the calibration. There is a slight molecular weight effect. If the calibration curve is obtained from similar molecular weight ranges, such effect would be essentially negligible. In some embodiments as illustrated in Figure 8, random ethylene copolymers and/or preparative TREF fractions of random copolymers satisfy the following relationship:

$$\ln P = -237.83/T_{ATREF} + 0.639$$

The above calibration equation relates the mole fraction of ethylene, P , to the analytical TREF elution temperature, T_{ATREF} , for narrow composition random copolymers

and/or preparative TREF fractions of broad composition random copolymers. T_{XO} is the ATREF temperature for a random copolymer of the same composition (i.e., the same comonomer type and content) and the same molecular weight and having an ethylene mole fraction of P_X . T_{XO} can be calculated from $\ln P_X = \alpha/T_{XO} + \beta$ from a measured P_X mole fraction. Conversely, P_{XO} is the ethylene mole fraction for a random copolymer of the same composition (i.e., the same comonomer type and content) and the same molecular weight and having an ATREF temperature of T_X , which can be calculated from $\ln P_{XO} = \alpha/T_X + \beta$ using a measured value of T_X .

[41] Once the block index (BI) for each preparative TREF fraction is obtained, the weight average block index, ABI, for the whole polymer can be calculated. In some embodiments, ABI is greater than zero but less than about 0.4 or from about 0.1 to about 0.3. In other embodiments, ABI is greater than about 0.4 and up to about 1.0. Preferably, ABI should be in the range of from about 0.4 to about 0.7, from about 0.5 to about 0.7, or from about 0.6 to about 0.9. In some embodiments, ABI is in the range of from about 0.3 to about 0.9, from about 0.3 to about 0.8, or from about 0.3 to about 0.7, from about 0.3 to about 0.6, from about 0.3 to about 0.5, or from about 0.3 to about 0.4. In other embodiments, ABI is in the range of from about 0.4 to about 1.0, from about 0.5 to about 1.0, or from about 0.6 to about 1.0, from about 0.7 to about 1.0, from about 0.8 to about 1.0, or from about 0.9 to about 1.0.

[42] Another characteristic of the inventive ethylene/ α -olefin interpolymer is that the inventive ethylene/ α -olefin interpolymer comprises at least one polymer fraction which can be obtained by preparative TREF, wherein the fraction has a block index greater than about 0.1 and up to about 1.0 and the polymer having a molecular weight distribution, M_w/M_n , greater than about 1.3. In some embodiments, the polymer fraction has a block index greater than about 0.6 and up to about 1.0, greater than about 0.7 and up to about 1.0, greater than about 0.8 and up to about 1.0, or greater than about 0.9 and up to about 1.0. In other embodiments, the polymer fraction has a block index greater than about 0.1 and up to about 1.0, greater than about 0.2 and up to about 1.0, greater than about 0.3 and up to about 1.0, greater than about 0.4 and up to about 1.0, or greater than about 0.4 and up to about 1.0. In still other embodiments, the polymer fraction has a block index greater than about 0.1 and up to about 0.5, greater than about 0.2 and up to about 0.5, greater than about 0.3 and up to about

0.5, or greater than about 0.4 and up to about 0.5. In yet other embodiments, the polymer fraction has a block index greater than about 0.2 and up to about 0.9, greater than about 0.3 and up to about 0.8, greater than about 0.4 and up to about 0.7, or greater than about 0.5 and up to about 0.6.

5 [43] In addition to an average block index and individual fraction block indices, the ethylene/ α -olefin interpolymers are characterized by one or more of the properties described as follows.

10 [44] In one aspect, the ethylene/ α -olefin interpolymers used in embodiments of the invention have a M_w/M_n from about 1.7 to about 3.5 and at least one melting point, T_m , in degrees Celsius and density, d , in grams/cubic centimeter, wherein the numerical values of the variables correspond to the relationship:

$$T_m > -2002.9 + 4538.5(d) - 2422.2(d)^2, \text{ and preferably}$$

$$T_m \geq -6288.1 + 13141(d) - 6720.3(d)^2, \text{ and more preferably}$$

$$T_m \geq 858.91 - 1825.3(d) + 1112.8(d)^2.$$

15 [45] Such melting point/density relationship is illustrated in Figure 1. Unlike the traditional random copolymers of ethylene/ α -olefins whose melting points decrease with decreasing densities, the inventive interpolymers (represented by diamonds) exhibit melting points substantially independent of the density, particularly when density is between about 0.87 g/cc to about 0.95 g/cc. For example, the melting point of such polymers are in the
20 range of about 110 °C to about 130 °C when density ranges from 0.875 g/cc to about 0.945 g/cc. In some embodiments, the melting point of such polymers are in the range of about 115 °C to about 125 °C when density ranges from 0.875 g/cc to about 0.945 g/cc.

25 [46] In another aspect, the ethylene/ α -olefin interpolymers comprise, in polymerized form, ethylene and one or more α -olefins and are characterized by a ΔT , in degree Celsius, defined as the temperature for the tallest Differential Scanning Calorimetry ("DSC") peak minus the temperature for the tallest Crystallization Analysis Fractionation ("CRYSTAF") peak and a heat of fusion in J/g, ΔH , and ΔT and ΔH satisfy the following relationships:

$\Delta T > -0.1299(\Delta H) + 62.81$, and preferably

$\Delta T \geq -0.1299(\Delta H) + 64.38$, and more preferably

$\Delta T \geq -0.1299(\Delta H) + 65.95$,

for ΔH up to 130 J/g. Moreover, ΔT is equal to or greater than 48 °C for ΔH greater than 130 J/g. The CRYSTAF peak is determined using at least 5 percent of the cumulative polymer (that is, the peak must represent at least 5 percent of the cumulative polymer), and if less than 5 percent of the polymer has an identifiable CRYSTAF peak, then the CRYSTAF temperature is 30°C, and ΔH is the numerical value of the heat of fusion in J/g. More preferably, the highest CRYSTAF peak contains at least 10 percent of the cumulative polymer. Figure 2 shows plotted data for inventive polymers as well as comparative examples. Integrated peak areas and peak temperatures are calculated by the computerized drawing program supplied by the instrument maker. The diagonal line shown for the random ethylene octene comparative polymers corresponds to the equation $\Delta T = -0.1299 (\Delta H) + 62.81$.

[47] In yet another aspect, the ethylene/ α -olefin interpolymers have a molecular fraction which elutes between 40°C and 130°C when fractionated using Temperature Rising Elution Fractionation ("TREF"), characterized in that said fraction has a molar comonomer content higher, preferably at least 5 percent higher, more preferably at least 10 percent higher, than that of a comparable random ethylene interpolymers fraction eluting between the same temperatures, wherein the comparable random ethylene interpolymers contains the same comonomer(s), and has a melt index, density, and molar comonomer content (based on the whole polymer) within 10 percent of that of the block interpolymers. Preferably, the M_w/M_n of the comparable interpolymers is also within 10 percent of that of the block interpolymers and/or the comparable interpolymers has a total comonomer content within 10 weight percent of that of the block interpolymers.

[48] In still another aspect, the ethylene/ α -olefin interpolymers are characterized by an elastic recovery, Re , in percent at 300 percent strain and 1 cycle measured on a compression-molded film of an ethylene/ α -olefin interpolymers, and has a density, d , in grams/cubic centimeter, wherein the numerical values of Re and d satisfy the following relationship when ethylene/ α -olefin interpolymers is substantially free of a cross-linked phase:

Re >1481-1629(d); and preferably

Re $\geq$ 1491-1629(d); and more preferably

Re $\geq$ 1501-1629(d); and even more preferably

Re $\geq$ 1511-1629(d).

5 [49] Figure 3 shows the effect of density on elastic recovery for unoriented films made from certain inventive interpolymers and traditional random copolymers. For the same density, the inventive interpolymers have substantially higher elastic recoveries.

10 [50] In some embodiments, the ethylene/ α -olefin interpolymers have a tensile strength above 10 MPa, preferably a tensile strength $\geq$ 11 MPa, more preferably a tensile strength $\geq$ 13 MPa and/or an elongation at break of at least 600 percent, more preferably at least 700 percent, highly preferably at least 800 percent, and most highly preferably at least 900 percent at a crosshead separation rate of 11 cm/minute.

15 [51] In other embodiments, the ethylene/ α -olefin interpolymers have (1) a storage modulus ratio, $G'(25^\circ\text{C})/G'(100^\circ\text{C})$, of from 1 to 50, preferably from 1 to 20, more preferably from 1 to 10; and/or (2) a 70°C compression set of less than 80 percent, preferably less than 70 percent, especially less than 60 percent, less than 50 percent, or less than 40 percent, down to a compression set of 0 percent.

20 [52] In still other embodiments, the ethylene/ α -olefin interpolymers have a 70°C compression set of less than 80 percent, less than 70 percent, less than 60 percent, or less than 50 percent. Preferably, the 70°C compression set of the interpolymers is less than 40 percent, less than 30 percent, less than 20 percent, and may go down to about 0 percent.

25 [53] In some embodiments, the ethylene/ α -olefin interpolymers have a heat of fusion of less than 85 J/g and/or a pellet blocking strength of equal to or less than 100 pounds/foot² (4800 Pa), preferably equal to or less than 50 lbs/ft² (2400 Pa), especially equal to or less than 5 lbs/ft² (240 Pa), and as low as 0 lbs/ft² (0 Pa).

 [54] In other embodiments, the ethylene/ α -olefin interpolymers comprise, in polymerized form, at least 50 mole percent ethylene and have a 70°C compression set of less

than 80 percent, preferably less than 70 percent or less than 60 percent, most preferably less than 40 to 50 percent and down to close to zero percent.

[55] In some embodiments, the multi-block copolymers possess a PDI fitting a Schultz-Flory distribution rather than a Poisson distribution. The copolymers are further characterized as having both a polydisperse block distribution and a polydisperse distribution of block sizes and possessing a most probable distribution of block lengths. Preferred multi-block copolymers are those containing 4 or more blocks or segments including terminal blocks. More preferably, the copolymers include at least 5, 10 or 20 blocks or segments including terminal blocks .

[56] In addition, the inventive block interpolymers have additional characteristics or properties. In one aspect, the interpolymers, preferably comprising ethylene and one or more copolymerizable comonomers in polymerized form, are characterized by multiple blocks or segments of two or more polymerized monomer units differing in chemical or physical properties (blocked interpolymers), most preferably a multi-block copolymer, said block interpolymers having a molecular fraction which elutes between 40°C and 130°C when fractionated using TREF, characterized in that said fraction has a molar comonomer content higher, preferably at least 5 percent higher, more preferably at least 10 percent higher, than that of a comparable random ethylene interpolymers fraction eluting between the same temperatures, wherein said comparable random ethylene interpolymers comprises the same comonomer(s), and has a melt index, density, and molar comonomer content (based on the whole polymer) within 10 percent of that of the blocked interpolymers. Preferably, the Mw/Mn of the comparable interpolymers is also within 10 percent of that of the blocked interpolymers and/or the comparable interpolymers has a total comonomer content within 10 weight percent of that of the blocked interpolymers.

[57] Comonomer content may be measured using any suitable technique, with techniques based on nuclear magnetic resonance ("NMR") spectroscopy preferred. Moreover, for polymers or blends of polymers having relatively broad TREF curves, the polymer is first fractionated using TREF into fractions each having an eluted temperature range of 10°C or less. That is, each eluted fraction has a collection temperature window of 10°C or less. Using this technique, said block interpolymers have at least one such fraction

having a higher molar comonomer content than a corresponding fraction of the comparable interpolpolymer.

[58] In another aspect, the inventive polymer is an olefin interpolpolymer, preferably comprising ethylene and one or more copolymerizable comonomers in polymerized form, characterized by multiple blocks (i.e., at least two blocks) or segments of two or more polymerized monomer units differing in chemical or physical properties (blocked interpolpolymer), most preferably a multi-block copolymer, said block interpolpolymer having a peak (but not just a molecular fraction) which elutes between 40°C and 130°C (but without collecting and/or isolating individual fractions), characterized in that said peak, has a comonomer content estimated by infra-red spectroscopy when expanded using a full width/half maximum (FWHM) area calculation, has an average molar comonomer content higher, preferably at least 5 percent higher, more preferably at least 10 percent higher, than that of a comparable random ethylene interpolpolymer peak at the same elution temperature and expanded using a full width/half maximum (FWHM) area calculation, wherein said comparable random ethylene interpolpolymer has the same comonomer(s) and has a melt index, density, and molar comonomer content (based on the whole polymer) within 10 percent of that of the blocked interpolpolymer. Preferably, the Mw/Mn of the comparable interpolpolymer is also within 10 percent of that of the blocked interpolpolymer and/or the comparable interpolpolymer has a total comonomer content within 10 weight percent of that of the blocked interpolpolymer. The full width/half maximum (FWHM) calculation is based on the ratio of methyl to methylene response area $[CH_3/CH_2]$ from the ATREF infra-red detector, wherein the tallest (highest) peak is identified from the base line, and then the FWHM area is determined. For a distribution measured using an ATREF peak, the FWHM area is defined as the area under the curve between T_1 and T_2 , where T_1 and T_2 are points determined, to the left and right of the ATREF peak, by dividing the peak height by two, and then drawing a line horizontal to the base line, that intersects the left and right portions of the ATREF curve. A calibration curve for comonomer content is made using random ethylene/ α -olefin copolymers, plotting comonomer content from NMR versus FWHM area ratio of the TREF peak. For this infra-red method, the calibration curve is generated for the same comonomer type of interest. The comonomer content of TREF peak of the inventive polymer can be determined by referencing this calibration curve using its FWHM methyl : methylene area ratio $[CH_3/CH_2]$ of the TREF peak.

[59] Comonomer content may be measured using any suitable technique, with techniques based on nuclear magnetic resonance (NMR) spectroscopy preferred. Using this technique, said blocked interpolymer has higher molar comonomer content than a corresponding comparable interpolymer.

5 [60] Preferably, for interpolymers of ethylene and 1-octene, the block interpolymer has a comonomer content of the TREF fraction eluting between 40 and 130°C greater than or equal to the quantity $(-0.2013) T + 20.07$, more preferably greater than or equal to the quantity $(-0.2013) T + 21.07$, where T is the numerical value of the peak elution temperature of the TREF fraction being compared, measured in °C.

10 [61] Figure 4 graphically depicts an embodiment of the block interpolymers of ethylene and 1-octene where a plot of the comonomer content versus TREF elution temperature for several comparable ethylene/1-octene interpolymers (random copolymers) are fit to a line representing $(-0.2013) T + 20.07$ (solid line). The line for the equation $(-0.2013) T + 21.07$ is depicted by a dotted line. Also depicted are the comonomer contents for
15 fractions of a block ethylene/1-octene interpolymers according to embodiments of the invention (multi-block copolymers). All of the block interpolymer fractions have significantly higher 1-octene content than either line at equivalent elution temperatures. This result is characteristic of the inventive interpolymer and is believed to be due to the presence of differentiated blocks within the polymer chains, having both crystalline and amorphous
20 nature.

[62] Figure 5 graphically displays the TREF curve and comonomer contents of polymer fractions for Example 5 and comparative F to be discussed below. The peak eluting from 40°C to 130°C, preferably from 60°C to 95°C for both polymers is fractionated in 5°C increments. Actual data for three of the fractions for Example 5 are represented by triangles.
25 The skilled artisan can appreciate that an appropriate calibration curve may be constructed for interpolymers with differing comonomer content fitted to the ATREF temperature values. Preferably, such calibration curve is obtained using comparative interpolymers of the same monomers, preferably random copolymers made using a metallocene or other homogeneous catalyst composition. The inventive interpolymers are characterized by a molar comonomer
30 content greater than the value determined from the calibration curve at the same ATREF

elution temperature, preferably at least 5 percent greater, more preferably at least 10 percent greater.

[63] In addition to the above aspects and properties described herein, the inventive polymers can be characterized by one or more additional characteristics. In one aspect, the inventive polymer is an olefin interpolymers, preferably comprising ethylene and one or more copolymerizable comonomers in polymerized form, characterized by multiple blocks or segments of two or more polymerized monomer units differing in chemical or physical properties (blocked interpolymers), most preferably a multi-block copolymer, said block interpolymers having a molecular fraction which elutes between 40°C and 130°C, when fractionated using TREF increments, characterized in that said fraction has a molar comonomer content higher, preferably at least 5 percent higher, more preferably at least 10, 15, 20 or 25 percent higher, than that of a comparable random ethylene interpolymers fraction eluting between the same temperatures, wherein said comparable random ethylene interpolymers comprises the same comonomer(s), preferably it is the same comonomer(s), and a melt index, density, and molar comonomer content (based on the whole polymer) within 10 percent of that of the blocked interpolymers. Preferably, the Mw/Mn of the comparable interpolymers is also within 10 percent of that of the blocked interpolymers and/or the comparable interpolymers has a total comonomer content within 10 weight percent of that of the blocked interpolymers.

[64] Preferably, the above interpolymers are interpolymers of ethylene and at least one α -olefin, especially those interpolymers having a whole polymer density from about 0.855 to about 0.935 g/cm³, and more especially for polymers having more than about 1 mole percent comonomer, the blocked interpolymers has a comonomer content of the TREF fraction eluting between 40 and 130°C greater than or equal to the quantity $(-0.1356)T + 13.89$, more preferably greater than or equal to the quantity $(-0.1356)T + 14.93$, and most preferably greater than or equal to the quantity $(-0.2013)T + 21.07$, where T is the numerical value of the peak ATREF elution temperature of the TREF fraction being compared, measured in °C.

[65] In still another aspect, the inventive polymer is an olefin interpolymers, preferably comprising ethylene and one or more copolymerizable comonomers in polymerized form, characterized by multiple blocks or segments of two or more polymerized

monomer units differing in chemical or physical properties (blocked interpolymers), most preferably a multi-block copolymer, said block interpolymers having a molecular fraction which elutes between 40°C and 130°C, when fractionated using TREF increments, characterized in that every fraction having a comonomer content of at least about 6 mole percent, has a melting point greater than about 100°C. For those fractions having a comonomer content from about 3 mole percent to about 6 mole percent, every fraction has a DSC melting point of about 110°C or higher. More preferably, said polymer fractions, having at least 1 mol percent comonomer, has a DSC melting point that corresponds to the equation:

$$T_m \geq (-5.5926)(\text{mol percent comonomer in the fraction}) + 135.90.$$

[66] In yet another aspect, the inventive polymer is an olefin interpolymers, preferably comprising ethylene and one or more copolymerizable comonomers in polymerized form, characterized by multiple blocks or segments of two or more polymerized monomer units differing in chemical or physical properties (blocked interpolymers), most preferably a multi-block copolymer, said block interpolymers having a molecular fraction which elutes between 40°C and 130°C, when fractionated using TREF increments, characterized in that every fraction that has an ATREF elution temperature greater than or equal to about 76°C, has a melt enthalpy (heat of fusion) as measured by DSC, corresponding to the equation:

$$\text{Heat of fusion (J/gm)} \leq (3.1718)(\text{ATREF elution temperature in Celsius}) - 136.58,$$

[67] The inventive block interpolymers have a molecular fraction which elutes between 40°C and 130°C, when fractionated using TREF increments, characterized in that every fraction that has an ATREF elution temperature between 40°C and less than about 76°C, has a melt enthalpy (heat of fusion) as measured by DSC, corresponding to the equation:

$$\text{Heat of fusion (J/gm)} \leq (1.1312)(\text{ATREF elution temperature in Celsius}) + 22.97.$$

ATREF Peak Comonomer Composition Measurement by Infra-Red Detector

[68] The comonomer composition of the TREF peak can be measured using an IR4 infra-red detector available from Polymer Char, Valencia, Spain (<http://www.polymerchar.com/>).

5 [69] The “composition mode” of the detector is equipped with a measurement sensor (CH_2) and composition sensor (CH_3) that are fixed narrow band infra-red filters in the region of $2800\text{--}3000\text{ cm}^{-1}$. The measurement sensor detects the methylene (CH_2) carbons on the polymer (which directly relates to the polymer concentration in solution) while the composition sensor detects the methyl (CH_3) groups of the polymer. The mathematical ratio
10 of the composition signal (CH_3) divided by the measurement signal (CH_2) is sensitive to the comonomer content of the measured polymer in solution and its response is calibrated with known ethylene alpha-olefin copolymer standards.

[70] The detector when used with an ATREF instrument provides both a concentration (CH_2) and composition (CH_3) signal response of the eluted polymer during the
15 TREF process. A polymer specific calibration can be created by measuring the area ratio of the CH_3 to CH_2 for polymers with known comonomer content (preferably measured by NMR). The comonomer content of an ATREF peak of a polymer can be estimated by applying the reference calibration of the ratio of the areas for the individual CH_3 and CH_2 response (i.e. area ratio CH_3/CH_2 versus comonomer content).

20 [71] The area of the peaks can be calculated using a full width/half maximum (FWHM) calculation after applying the appropriate baselines to integrate the individual signal responses from the TREF chromatogram. The full width/half maximum calculation is based on the ratio of methyl to methylene response area [CH_3/CH_2] from the ATREF infra-red detector, wherein the tallest (highest) peak is identified from the base line, and then the
25 FWHM area is determined. For a distribution measured using an ATREF peak, the FWHM area is defined as the area under the curve between T1 and T2, where T1 and T2 are points determined, to the left and right of the ATREF peak, by dividing the peak height by two, and then drawing a line horizontal to the base line, that intersects the left and right portions of the ATREF curve.

[72] The application of infra-red spectroscopy to measure the comonomer content of polymers in this ATREF-infra-red method is, in principle, similar to that of GPC/FTIR systems as described in the following references: Markovich, Ronald P.; Hazlitt, Lonnie G.; Smith, Linley; "Development of gel-permeation chromatography-Fourier transform infrared spectroscopy for characterization of ethylene-based polyolefin copolymers". Polymeric Materials Science and Engineering (1991), 65, 98-100.; and Deslauriers, P.J.; Rohlfing, D.C.; Shieh, E.T.; "Quantifying short chain branching microstructures in ethylene-1-olefin copolymers using size exclusion chromatography and Fourier transform infrared spectroscopy (SEC-FTIR)", Polymer (2002), 43, 59-170., both of which are incorporated by reference herein in their entirety.

[73] It should be noted that while the TREF fractions in the above description are obtained in a 5 °C increment, other temperature increments are possible. For instance, a TREF fraction could be in a 4 °C increment, a 3 °C increment, a 2 °C increment, or 1 °C increment.

[74] For copolymers of ethylene and an α -olefin, the inventive polymers preferably possess (1) a PDI of at least 1.3, more preferably at least 1.5, at least 1.7, or at least 2.0, and most preferably at least 2.6, up to a maximum value of 5.0, more preferably up to a maximum of 3.5, and especially up to a maximum of 2.7; (2) a heat of fusion of 80 J/g or less; (3) an ethylene content of at least 50 weight percent; (4) a glass transition temperature, T_g , of less than -25°C, more preferably less than -30°C, and/or (5) one and only one T_m .

[75] Further, the inventive polymers can have, alone or in combination with any other properties disclosed herein, a storage modulus, G' , such that $\log(G')$ is greater than or equal to 400 kPa, preferably greater than or equal to 1.0 MPa, at a temperature of 100°C. Moreover, the inventive polymers possess a relatively flat storage modulus as a function of temperature in the range from 0 to 100°C (illustrated in Figure 6) that is characteristic of block copolymers, and heretofore unknown for an olefin copolymer, especially a copolymer of ethylene and one or more C_{3-8} aliphatic α -olefins. (By the term "relatively flat" in this context is meant that $\log G'$ (in Pascals) decreases by less than one order of magnitude between 50 and 100°C, preferably between 0 and 100°C).

[76] The inventive interpolymers may be further characterized by a thermomechanical analysis penetration depth of 1 mm at a temperature of at least 90°C as well as a flexural modulus of from 3 kpsi (20 MPa) to 13 kpsi (90 MPa). Alternatively, the inventive interpolymers can have a thermomechanical analysis penetration depth of 1 mm at a temperature of at least 104°C as well as a flexural modulus of at least 3 kpsi (20 MPa). They may be characterized as having an abrasion resistance (or volume loss) of less than 90 mm³. Figure 7 shows the TMA (1 mm) versus flex modulus for the inventive polymers, as compared to other known polymers. The inventive polymers have significantly better flexibility-heat resistance balance than the other polymers.

[77] Additionally, the ethylene/ α -olefin interpolymers can have a melt index, I₂, from 0.01 to 2000 g/10 minutes, preferably from 0.01 to 1000 g/10 minutes, more preferably from 0.01 to 500 g/10 minutes, and especially from 0.01 to 100 g/10 minutes. In certain embodiments, the ethylene/ α -olefin interpolymers have a melt index, I₂, from 0.01 to 10 g/10 minutes, from 0.5 to 50 g/10 minutes, from 1 to 30 g/10 minutes, from 1 to 6 g/10 minutes or from 0.3 to 10 g/10 minutes. In certain embodiments, the melt index for the ethylene/ α -olefin polymers is 1g/10 minutes, 3 g/10 minutes or 5 g/10 minutes.

[78] The polymers can have molecular weights, M_w, from 1,000 g/mole to 5,000,000 g/mole, preferably from 1000 g/mole to 1,000,000, more preferably from 10,000 g/mole to 500,000 g/mole, and especially from 10,000 g/mole to 300,000 g/mole. The density of the inventive polymers can be from 0.80 to 0.99 g/cm³ and preferably for ethylene containing polymers from 0.85 g/cm³ to 0.97 g/cm³. In certain embodiments, the density of the ethylene/ α -olefin polymers ranges from 0.860 to 0.925 g/cm³ or 0.867 to 0.910 g/cm³.

[79] The process of making the polymers has been disclosed in the following patent applications: U.S. Provisional Application No. 60/553,906, filed March 17, 2004; U.S. Provisional Application No. 60/662,937, filed March 17, 2005; U.S. Provisional Application No. 60/662,939, filed March 17, 2005; U.S. Provisional Application No. 60/5662938, filed March 17, 2005; PCT Application No. PCT/US2005/008916, filed March 17, 2005; PCT Application No. PCT/US2005/008915, filed March 17, 2005; and PCT Application No. PCT/US2005/008917, filed March 17, 2005, all of which are incorporated by reference herein in their entirety. For example, one such method comprises contacting ethylene and

optionally one or more addition polymerizable monomers other than ethylene under addition polymerization conditions with a catalyst composition comprising:

the admixture or reaction product resulting from combining:

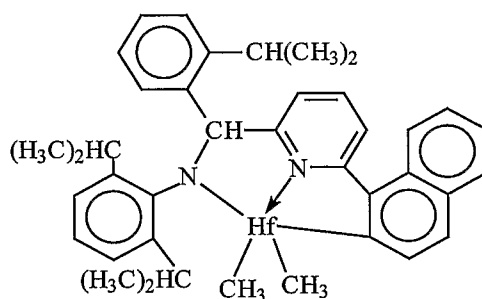
(A) a first olefin polymerization catalyst having a high comonomer incorporation index,
5 index,

(B) a second olefin polymerization catalyst having a comonomer incorporation index less than 90 percent, preferably less than 50 percent, most preferably less than 5 percent of the comonomer incorporation index of catalyst (A), and

(C) a chain shuttling agent.

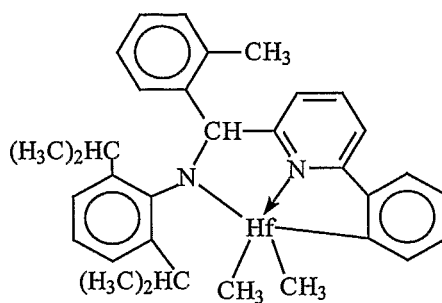
10 [80] Representative catalysts and chain shuttling agent are as follows.

[81] **Catalyst (A1)** is [N-(2,6-di(1-methylethyl)phenyl)amido](2-isopropylphenyl)(α -naphthalen-2-diyl(6-pyridin-2-diyl)methane)]hafnium dimethyl, prepared according to the teachings of WO 03/40195, U.S. Patents No. 6,953,764 and No. 6,960,635, and WO 04/24740.

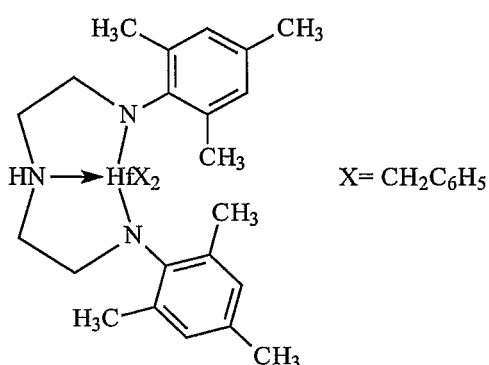


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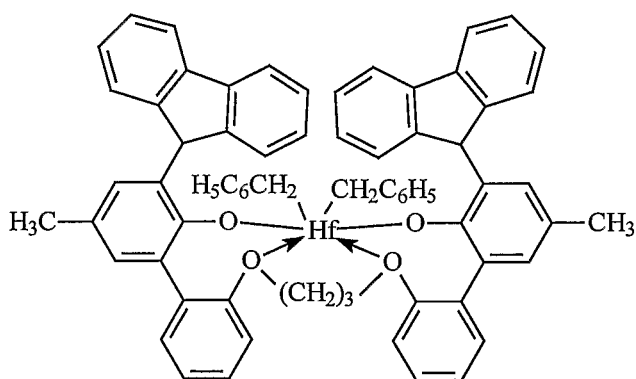
[82] **Catalyst (A2)** is [N-(2,6-di(1-methylethyl)phenyl)amido](2-methylphenyl)(1,2-phenylene-(6-pyridin-2-diyl)methane)]hafnium dimethyl, prepared according to the teachings of WO 03/40195, U.S. Patents No. 6,953,764 and No. 6,960,635, and WO 04/24740.



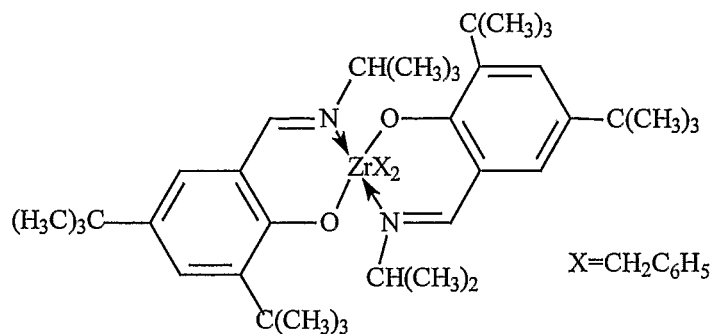
[83] **Catalyst (A3)** is bis[N,N''-(2,4,6-tri(methylphenyl)amido)ethylenediamine]hafnium dibenzyl.



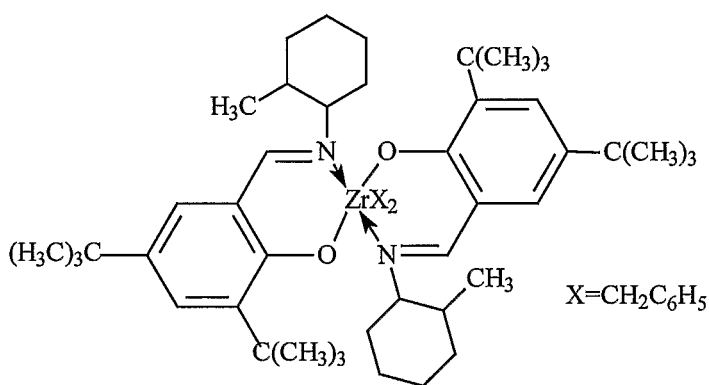
5 [84] **Catalyst (A4)** is bis((2-oxoyl-3-(dibenzo-1H-pyrrole-1-yl)-5-(methyl)phenyl)-2-phenoxyethyl)cyclohexane-1,2-diyl zirconium (IV) dibenzyl, prepared substantially according to the teachings of U.S. Patent No. 6,897,276.



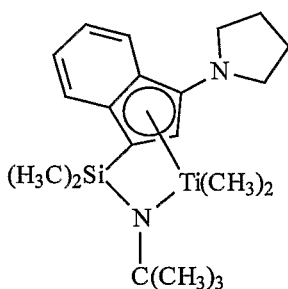
10 [85] **Catalyst (B1)** is 1,2-bis-(3,5-di-*t*-butylphenylene)(1-(N-(1-methylethyl)immino)methyl)(2-oxoyl) zirconium dibenzyl



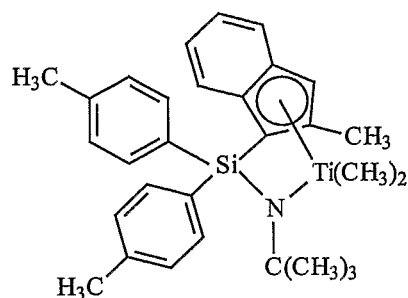
[86] **Catalyst (B2)** is 1,2-bis-(3,5-di-*t*-butylphenylene)(1-(N-(2-methylcyclohexyl)-imino)methyl)(2-oxoyl) zirconium dibenzyl



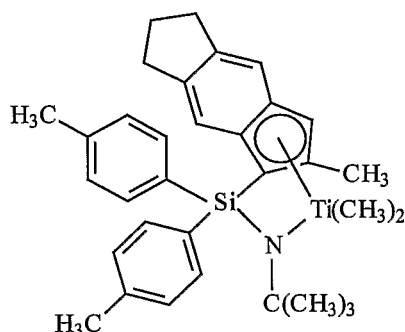
5 [87] **Catalyst (C1)** is (t-butylamido)dimethyl(3-N-pyrrolyl-1,2,3,3a,7a- η -inden-1-yl)silane titanium dimethyl prepared substantially according to the techniques of U.S. Patent No. 6,268,444:



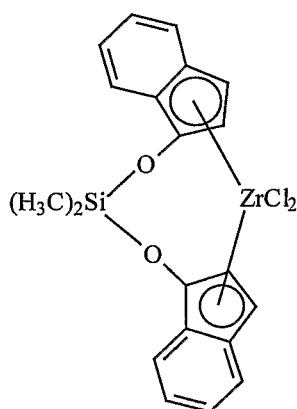
10 [88] **Catalyst (C2)** is (t-butylamido)di(4-methylphenyl)(2-methyl-1,2,3,3a,7a- η -inden-1-yl)silane titanium dimethyl prepared substantially according to the teachings of U.S. Patent No. 6,825,295:



[89] **Catalyst (C3)** is (t-butylamido)di(4-methylphenyl)(2-methyl-1,2,3,3a,8a-η-s-indacen-1-yl)silanetitanium dimethyl prepared substantially according to the teachings of U.S. Patent No. 6,825,295:



[90] **Catalyst (D1)** is bis(dimethyldisiloxane)(indene-1-yl)zirconium dichloride available from Sigma-Aldrich:



[91] **Shuttling Agents** The shuttling agents employed include diethylzinc, di(i-butyl)zinc, di(n-hexyl)zinc, triethylaluminum, trioctylaluminum, triethylgallium, i-butylaluminum bis(dimethyl(t-butyl)siloxane), i-butylaluminum bis(di(trimethylsilyl)amide), n-octylaluminum di(pyridine-2-methoxide), bis(n-octadecyl)i-butylaluminum, i-

butylaluminum bis(di(n-pentyl)amide), n-octylaluminum bis(2,6-di-t-butylphenoxide, n-octylaluminum di(ethyl(1-naphthyl)amide), ethylaluminum bis(t-butyl dimethylsiloxide), ethylaluminum di(bis(trimethylsilyl)amide), ethylaluminum bis(2,3,6,7-dibenzo-1-azacycloheptaneamide), n-octylaluminum bis(2,3,6,7-dibenzo-1-azacycloheptaneamide), n-octylaluminum bis(dimethyl(t-butyl)siloxide, ethylzinc (2,6-diphenylphenoxide), and ethylzinc (t-butoxide).

[92] Preferably, the foregoing process takes the form of a continuous solution process for forming block copolymers, especially multi-block copolymers, preferably linear multi-block copolymers of two or more monomers, more especially ethylene and a C₃₋₂₀ olefin or cycloolefin, and most especially ethylene and a C₄₋₂₀ α -olefin, using multiple catalysts that are incapable of interconversion. That is, the catalysts are chemically distinct. Under continuous solution polymerization conditions, the process is ideally suited for polymerization of mixtures of monomers at high monomer conversions. Under these polymerization conditions, shuttling from the chain shuttling agent to the catalyst becomes advantaged compared to chain growth, and multi-block copolymers, especially linear multi-block copolymers are formed in high efficiency.

[93] The inventive interpolymers may be differentiated from conventional, random copolymers, physical blends of polymers, and block copolymers prepared via sequential monomer addition, fluxional catalysts, anionic or cationic living polymerization techniques. In particular, compared to a random copolymer of the same monomers and monomer content at equivalent crystallinity or modulus, the inventive interpolymers have better (higher) heat resistance as measured by melting point, higher TMA penetration temperature, higher high-temperature tensile strength, and/or higher high-temperature torsion storage modulus as determined by dynamic mechanical analysis. Compared to a random copolymer containing the same monomers and monomer content, the inventive interpolymers have lower compression set, particularly at elevated temperatures, lower stress relaxation, higher creep resistance, higher tear strength, higher blocking resistance, faster setup due to higher crystallization (solidification) temperature, higher recovery (particularly at elevated temperatures), better abrasion resistance, higher retractive force, and better oil and filler acceptance.

[94] The inventive interpolymers also exhibit a unique crystallization and branching distribution relationship. That is, the inventive interpolymers have a relatively large difference between the tallest peak temperature measured using CRYSTAF and DSC as a function of heat of fusion, especially as compared to random copolymers containing the same monomers and monomer level or physical blends of polymers, such as a blend of a high density polymer and a lower density copolymer, at equivalent overall density. It is believed that this unique feature of the inventive interpolymers is due to the unique distribution of the comonomer in blocks within the polymer backbone. In particular, the inventive interpolymers may comprise alternating blocks of differing comonomer content (including homopolymer blocks). The inventive interpolymers may also comprise a distribution in number and/or block size of polymer blocks of differing density or comonomer content, which is a Schultz-Flory type of distribution. In addition, the inventive interpolymers also have a unique peak melting point and crystallization temperature profile that is substantially independent of polymer density, modulus, and morphology. In a preferred embodiment, the microcrystalline order of the polymers demonstrates characteristic spherulites and lamellae that are distinguishable from random or block copolymers, even at PDI values that are less than 1.7, or even less than 1.5, down to less than 1.3.

[95] Moreover, the inventive interpolymers may be prepared using techniques to influence the degree or level of blockiness. That is, the amount of comonomer and length of each polymer block or segment can be altered by controlling the ratio and type of catalysts and shuttling agent as well as the temperature of the polymerization, and other polymerization variables. A surprising benefit of this phenomenon is the discovery that as the degree of blockiness is increased, the optical properties, tear strength, and high temperature recovery properties of the resulting polymer are improved. In particular, haze decreases while clarity, tear strength, and high temperature recovery properties increase as the average number of blocks in the polymer increases. By selecting shuttling agents and catalyst combinations having the desired chain transferring ability (high rates of shuttling with low levels of chain termination) other forms of polymer termination are effectively suppressed. Accordingly, little if any β -hydride elimination is observed in the polymerization of ethylene/ α -olefin comonomer mixtures according to embodiments of the invention, and the resulting crystalline blocks are highly, or substantially completely, linear, possessing little or no long chain branching.

[96] Polymers with highly crystalline chain ends can be selectively prepared in accordance with embodiments of the invention. In elastomer applications, reducing the relative quantity of polymer that terminates with an amorphous block reduces the intermolecular dilutive effect on crystalline regions. This result can be obtained by choosing chain shuttling agents and catalysts having an appropriate response to hydrogen or other chain terminating agents. Specifically, if the catalyst which produces highly crystalline polymer is more susceptible to chain termination (such as by use of hydrogen) than the catalyst responsible for producing the less crystalline polymer segment (such as through higher comonomer incorporation, regio-error, or atactic polymer formation), then the highly crystalline polymer segments will preferentially populate the terminal portions of the polymer. Not only are the resulting terminated groups crystalline, but upon termination, the highly crystalline polymer forming catalyst site is once again available for reinitiation of polymer formation. The initially formed polymer is therefore another highly crystalline polymer segment. Accordingly, both ends of the resulting multi-block copolymer are preferentially highly crystalline.

[97] The ethylene α -olefin interpolymers used in the embodiments of the invention are preferably interpolymers of ethylene with at least one C₃-C₂₀ α -olefin. Copolymers of ethylene and a C₃-C₂₀ α -olefin are especially preferred. The interpolymers may further comprise C₄-C₁₈ diolefin and/or alkenylbenzene. Suitable unsaturated comonomers useful for polymerizing with ethylene include, for example, ethylenically unsaturated monomers, conjugated or nonconjugated dienes, polyenes, alkenylbenzenes, etc. Examples of such comonomers include C₃-C₂₀ α -olefins such as propylene, isobutylene, 1-butene, 1-hexene, 1-pentene, 4-methyl-1-pentene, 1-heptene, 1-octene, 1-nonene, 1-decene, and the like. 1-Butene and 1-octene are especially preferred. Other suitable monomers include styrene, halo- or alkyl-substituted styrenes, vinylbenzocyclobutane, 1,4-hexadiene, 1,7-octadiene, and naphthenics (e.g., cyclopentene, cyclohexene and cyclooctene).

[98] While ethylene/ α -olefin interpolymers are preferred polymers, other ethylene/olefin polymers may also be used. Olefins as used herein refer to a family of unsaturated hydrocarbon-based compounds with at least one carbon-carbon double bond. Depending on the selection of catalysts, any olefin may be used in embodiments of the invention. Preferably, suitable olefins are C₃-C₂₀ aliphatic and aromatic compounds

containing vinylic unsaturation, as well as cyclic compounds, such as cyclobutene, cyclopentene, dicyclopentadiene, and norbornene, including but not limited to, norbornene substituted in the 5 and 6 position with C₁-C₂₀ hydrocarbyl or cyclohydrocarbyl groups.

Also included are mixtures of such olefins as well as mixtures of such olefins with C₄-C₄₀ diolefin compounds.

[99] Examples of olefin monomers include, but are not limited to propylene, isobutylene, 1-butene, 1-pentene, 1-hexene, 1-heptene, 1-octene, 1-nonene, 1-decene, and 1-dodecene, 1-tetradecene, 1-hexadecene, 1-octadecene, 1-eicosene, 3-methyl-1-butene, 3-methyl-1-pentene, 4-methyl-1-pentene, 4,6-dimethyl-1-heptene, 4-vinylcyclohexene, vinylcyclohexane, norbornadiene, ethylidene norbornene, cyclopentene, cyclohexene, dicyclopentadiene, cyclooctene, C₄-C₄₀ dienes, including but not limited to 1,3-butadiene, 1,3-pentadiene, 1,4-hexadiene, 1,5-hexadiene, 1,7-octadiene, 1,9-decadiene, other C₄-C₄₀ α -olefins, and the like. In certain embodiments, the α -olefin is propylene, 1-butene, 1-pentene, 1-hexene, 1-octene or a combination thereof. Although any hydrocarbon containing a vinyl group potentially may be used in embodiments of the invention, practical issues such as monomer availability, cost, and the ability to conveniently remove unreacted monomer from the resulting polymer may become more problematic as the molecular weight of the monomer becomes too high.

[100] The polymerization processes described herein are well suited for the production of olefin polymers comprising monovinylidene aromatic monomers including styrene, o-methyl styrene, p-methyl styrene, t-butylstyrene, and the like. In particular, interpolymers comprising ethylene and styrene can be prepared by following the teachings herein. Optionally, copolymers comprising ethylene, styrene and a C₃-C₂₀ alpha olefin, optionally comprising a C₄-C₂₀ diene, having improved properties can be prepared.

[101] Suitable non-conjugated diene monomers can be a straight chain, branched chain or cyclic hydrocarbon diene having from 6 to 15 carbon atoms. Examples of suitable non-conjugated dienes include, but are not limited to, straight chain acyclic dienes, such as 1,4-hexadiene, 1,6-octadiene, 1,7-octadiene, 1,9-decadiene, branched chain acyclic dienes, such as 5-methyl-1,4-hexadiene; 3,7-dimethyl-1,6-octadiene; 3,7-dimethyl-1,7-octadiene and mixed isomers of dihydromyricene and dihydroocinene, single ring alicyclic dienes, such as

1,3-cyclopentadiene; 1,4-cyclohexadiene; 1,5-cyclooctadiene and 1,5-cyclododecadiene, and multi-ring alicyclic fused and bridged ring dienes, such as tetrahydroindene, methyl tetrahydroindene, dicyclopentadiene, bicyclo-(2,2,1)-hepta-2,5-diene; alkenyl, alkylidene, cycloalkenyl and cycloalkylidene norbornenes, such as 5-methylene-2-norbornene (MNB); 5-propenyl-2-norbornene, 5-isopropylidene-2-norbornene, 5-(4-cyclopentenyl)-2-norbornene, 5-cyclohexylidene-2-norbornene, 5-vinyl-2-norbornene, and norbornadiene. Of the dienes typically used to prepare EPDMs, the particularly preferred dienes are 1,4-hexadiene (HD), 5-ethylidene-2-norbornene (ENB), 5-vinylidene-2-norbornene (VNB), 5-methylene-2-norbornene (MNB), and dicyclopentadiene (DCPD). The especially preferred dienes are 5-ethylidene-2-norbornene (ENB) and 1,4-hexadiene (HD).

[102] One class of desirable polymers that can be made in accordance with embodiments of the invention are elastomeric interpolymers of ethylene, a C₃-C₂₀ α -olefin, especially propylene, and optionally one or more diene monomers. Preferred α -olefins for use in this embodiment of the present invention are designated by the formula CH₂=CHR*, where R* is a linear or branched alkyl group of from 1 to 12 carbon atoms. Examples of suitable α -olefins include, but are not limited to, propylene, isobutylene, 1-butene, 1-pentene, 1-hexene, 4-methyl-1-pentene, and 1-octene. A particularly preferred α -olefin is propylene. The propylene based polymers are generally referred to in the art as EP or EPDM polymers. Suitable dienes for use in preparing such polymers, especially multi-block EPDM type polymers include conjugated or non-conjugated, straight or branched chain-, cyclic- or polycyclic- dienes comprising from 4 to 20 carbons. Preferred dienes include 1,4-pentadiene, 1,4-hexadiene, 5-ethylidene-2-norbornene, dicyclopentadiene, cyclohexadiene, and 5-butylidene-2-norbornene. A particularly preferred diene is 5-ethylidene-2-norbornene.

[103] Because the diene containing polymers comprise alternating segments or blocks containing greater or lesser quantities of the diene (including none) and α -olefin (including none), the total quantity of diene and α -olefin may be reduced without loss of subsequent polymer properties. That is, because the diene and α -olefin monomers are preferentially incorporated into one type of block of the polymer rather than uniformly or randomly throughout the polymer, they are more efficiently utilized and subsequently the crosslink density of the polymer can be better controlled. Such crosslinkable elastomers and

the cured products have advantaged properties, including higher tensile strength and better elastic recovery.

[104] In some embodiments, the inventive interpolymers made with two catalysts incorporating differing quantities of comonomer have a weight ratio of blocks formed thereby from 95:5 to 5:95. The elastomeric polymers desirably have an ethylene content of from 20 to 90 percent, a diene content of from 0.1 to 10 percent, and an α -olefin content of from 10 to 80 percent, based on the total weight of the polymer. Further preferably, the multi-block elastomeric polymers have an ethylene content of from 60 to 90 percent, a diene content of from 0.1 to 10 percent, and an α -olefin content of from 10 to 40 percent, based on the total weight of the polymer. Preferred polymers are high molecular weight polymers, having a weight average molecular weight (Mw) from 10,000 to about 2,500,000, preferably from 20,000 to 500,000, more preferably from 20,000 to 350,000, and a polydispersity less than 3.5, more preferably less than 3.0, and a Mooney viscosity (ML (1+4) 125°C.) from 1 to 250. More preferably, such polymers have an ethylene content from 65 to 75 percent, a diene content from 0 to 6 percent, and an α -olefin content from 20 to 35 percent.

[105] The ethylene/ α -olefin interpolymers can be functionalized by incorporating at least one functional group in its polymer structure. Exemplary functional groups may include, for example, ethylenically unsaturated mono- and di-functional carboxylic acids, ethylenically unsaturated mono- and di-functional carboxylic acid anhydrides, salts thereof and esters thereof. Such functional groups may be grafted to an ethylene/ α -olefin interpolymers, or may be copolymerized with ethylene and an optional additional comonomer to form an interpolymers of ethylene, the functional comonomer and optionally other comonomer(s). Means for grafting functional groups onto polyethylene are described for example in U.S. Patents Nos. 4,762,890, 4,927,888, and 4,950,541, the disclosures of these patents are incorporated herein by reference in their entirety. One particularly useful functional group is maleic anhydride.

[106] The amount of the functional group present in the functional interpolymers can vary. The functional group can typically be present in a copolymer-type functionalized interpolymers in an amount of at least about 1.0 weight percent, preferably at least about 5 weight percent, and more preferably at least about 7 weight percent. The functional group will typically be present in a copolymer-type functionalized interpolymers in an amount less

than about 40 weight percent, preferably less than about 30 weight percent, and more preferably less than about 25 weight percent.

More on Block Index

[107] Random copolymers satisfy the following relationship. See P. J. Flory, *Trans. Faraday Soc.*, **51**, 848 (1955), which is incorporated by reference herein in its entirety.

$$\frac{1}{T_m} - \frac{1}{T_m^0} = -\left(\frac{R}{\Delta H_u}\right) \ln P \quad (1)$$

[108] In Equation 1, the mole fraction of crystallizable monomers, P , is related to the melting temperature, T_m , of the copolymer and the melting temperature of the pure crystallizable homopolymer, T_m^0 . The equation is similar to the relationship for the natural logarithm of the mole fraction of ethylene as a function of the reciprocal of the ATREF elution temperature ($^{\circ}\text{K}$) as shown in Figure 8 for various homogeneously branched copolymers of ethylene and olefins.

[109] As illustrated in Figure 8, the relationship of ethylene mole fraction to ATREF peak elution temperature and DSC melting temperature for various homogeneously branched copolymers is analogous to Flory's equation. Similarly, preparative TREF fractions of nearly all random copolymers and random copolymer blends likewise fall on this line, except for small molecular weight effects.

[110] According to Flory, if P , the mole fraction of ethylene, is equal to the conditional probability that one ethylene unit will precede or follow another ethylene unit, then the polymer is random. On the other hand if the conditional probability that any 2 ethylene units occur sequentially is greater than P , then the copolymer is a block copolymer. The remaining case where the conditional probability is less than P yields alternating copolymers.

[111] The mole fraction of ethylene in random copolymers primarily determines a specific distribution of ethylene segments whose crystallization behavior in turn is governed by the minimum equilibrium crystal thickness at a given temperature. Therefore, the copolymer melting and TREF crystallization temperatures of the inventive block copolymers

are related to the magnitude of the deviation from the random relationship in Figure 8, and such deviation is a useful way to quantify how “blocky” a given TREF fraction is relative to its random equivalent copolymer (or random equivalent TREF fraction). The term “blocky” refers to the extent a particular polymer fraction or polymer comprises blocks of polymerized monomers or comonomers. There are two random equivalents, one corresponding to constant temperature and one corresponding to constant mole fraction of ethylene. These form the sides of a right triangle as shown in Figure 9, which illustrates the definition of the block index.

[112] In Figure 9, the point (T_X , P_X) represents a preparative TREF fraction, where the ATREF elution temperature, T_X , and the NMR ethylene mole fraction, P_X , are measured values. The ethylene mole fraction of the whole polymer, P_{AB} , is also measured by NMR. The “hard segment” elution temperature and mole fraction, (T_A , P_A), can be estimated or else set to that of ethylene homopolymer for ethylene copolymers. The T_{AB} value corresponds to the calculated random copolymer equivalent ATREF elution temperature based on the measured P_{AB} . From the measured ATREF elution temperature, T_X , the corresponding random ethylene mole fraction, P_{XO} , can also be calculated. The square of the block index is defined to be the ratio of the area of the (P_X , T_X) triangle and the (T_A , P_{AB}) triangle. Since the right triangles are similar, the ratio of areas is also the squared ratio of the distances from (T_A , P_{AB}) and (T_X , P_X) to the random line. In addition, the similarity of the right triangles means the ratio of the lengths of either of the corresponding sides can be used instead of the areas.

$$BI = \frac{1/T_X - 1/T_{XO}}{1/T_A - 1/T_{AB}} \text{ or } BI = -\frac{\ln P_X - \ln P_{XO}}{\ln P_A - \ln P_{AB}}$$

[113] It should be noted that the most perfect block distribution would correspond to a whole polymer with a single eluting fraction at the point (T_A , P_{AB}), because such a polymer would preserve the ethylene segment distribution in the “hard segment”, yet contain all the available octene (presumably in runs that are nearly identical to those produced by the soft segment catalyst). In most cases, the “soft segment” will not crystallize in the ATREF (or preparative TREF).

Applications and End Uses

[114] The inventive ethylene/ α -olefin block interpolymers can be used in a variety of conventional thermoplastic fabrication processes to produce useful articles, including objects comprising at least one film layer, such as a monolayer film, or at least one layer in a multilayer film prepared by cast, blown, calendered, or extrusion coating processes; molded articles, such as blow molded, injection molded, or rotomolded articles; extrusions; fibers; and woven or non-woven fabrics. Thermoplastic compositions comprising the inventive polymers, include blends with other natural or synthetic polymers, additives, reinforcing agents, ignition resistant additives, antioxidants, stabilizers, colorants, extenders, crosslinkers, blowing agents, and plasticizers. Of particular utility are multi-component fibers such as core/sheath fibers, having an outer surface layer, comprising at least in part, one or more polymers according to embodiments of the invention.

[115] Fibers that may be prepared from the inventive polymers or blends include staple fibers, tow, multicomponent, sheath/core, twisted, and monofilament. Suitable fiber forming processes include spinbonded, melt blown techniques, as disclosed in U.S. Patents. No. 4,430,563, 4,663,220, 4,668,566, and 4,322,027, gel spun fibers as disclosed in U.S. Patent No. 4,413,110, woven and nonwoven fabrics, as disclosed in U.S. Patent No. 3,485,706, or structures made from such fibers, including blends with other fibers, such as polyester, nylon or cotton, thermoformed articles, extruded shapes, including profile extrusions and co-extrusions, calendared articles, and drawn, twisted, or crimped yarns or fibers. The new polymers described herein are also useful for wire and cable coating operations, as well as in sheet extrusion for vacuum forming operations, and forming molded articles, including the use of injection molding, blow molding process, or rotomolding processes. Compositions comprising the olefin polymers can also be formed into fabricated articles such as those previously mentioned using conventional polyolefin processing techniques which are well known to those skilled in the art of polyolefin processing.

[116] Dispersions, both aqueous and non-aqueous, can also be formed using the inventive polymers or formulations comprising the same. Frothed foams comprising the invented polymers can also be formed, as disclosed in PCT application No. PCT/US2004/027593, filed August 25, 2004, and published as WO2005/021622. The polymers may also be crosslinked by any known means, such as the use of peroxide, electron

beam, silane, azide, or other cross-linking technique. The polymers can also be chemically modified, such as by grafting (for example by use of maleic anhydride (MAH), silanes, or other grafting agent), halogenation, amination, sulfonation, or other chemical modification.

[117] Additives and adjuvants may be included in any formulation comprising the inventive polymers. Suitable additives include fillers, such as organic or inorganic particles, including clays, talc, titanium dioxide, zeolites, powdered metals, organic or inorganic fibers, including carbon fibers, silicon nitride fibers, steel wire or mesh, and nylon or polyester cording, nano-sized particles, clays, and so forth; tackifiers, oil extenders, including paraffinic or naphthelenic oils; and other natural and synthetic polymers, including other polymers according to embodiments of the invention.

[118] Suitable polymers for blending with the polymers according to embodiments of the invention include thermoplastic and non-thermoplastic polymers including natural and synthetic polymers. Exemplary polymers for blending include polypropylene, (both impact modifying polypropylene, isotactic polypropylene, atactic polypropylene, and random ethylene/propylene copolymers), various types of polyethylene, including high pressure, free-radical LDPE, Ziegler Natta LLDPE, metallocene PE, including multiple reactor PE ("in reactor" blends of Ziegler-Natta PE and metallocene PE, such as products disclosed in U.S. Patents No. 6,545,088, 6,538,070, 6,566,446, 5,844,045, 5,869,575, and 6,448,341), ethylene-vinyl acetate (EVA), ethylene/ vinyl alcohol copolymers, polystyrene, impact modified polystyrene, ABS, styrene/butadiene block copolymers and hydrogenated derivatives thereof (SBS and SEBS), and thermoplastic polyurethanes. Homogeneous polymers such as olefin plastomers and elastomers, ethylene and propylene-based copolymers (for example polymers available under the trade designation VERSIFY™ available from The Dow Chemical Company and VISTAMAXX™ available from ExxonMobil Chemical Company can also be useful as components in blends comprising the inventive polymers.

[119] Suitable end uses for the foregoing products include elastic films and fibers; soft touch goods, such as tooth brush handles and appliance handles; gaskets and profiles; adhesives (including hot melt adhesives and pressure sensitive adhesives); footwear (including shoe soles and shoe liners); auto interior parts and profiles; foam goods (both open and closed cell); impact modifiers for other thermoplastic polymers such as high density polyethylene, isotactic polypropylene, or other olefin polymers; coated fabrics; hoses; tubing;

weather stripping; cap liners; flooring; and viscosity index modifiers, also known as pour point modifiers, for lubricants.

[120] In some embodiments, thermoplastic compositions comprising a thermoplastic matrix polymer, especially isotactic polypropylene, and an elastomeric multi-block copolymer of ethylene and a copolymerizable comonomer according to embodiments of the invention, are uniquely capable of forming core-shell type particles having hard crystalline or semi-crystalline blocks in the form of a core surrounded by soft or elastomeric blocks forming a "shell" around the occluded domains of hard polymer. These particles are formed and dispersed within the matrix polymer by the forces incurred during melt compounding or blending. This highly desirable morphology is believed to result due to the unique physical properties of the multi-block copolymers which enable compatible polymer regions such as the matrix and higher comonomer content elastomeric regions of the multi-block copolymer to self-assemble in the melt due to thermodynamic forces. Shearing forces during compounding are believed to produce separated regions of matrix polymer encircled by elastomer. Upon solidifying, these regions become occluded elastomer particles encased in the polymer matrix.

[121] Particularly desirable blends are thermoplastic polyolefin blends (TPO), thermoplastic elastomer blends (TPE), thermoplastic vulcanizates (TPV) and styrenic polymer blends. TPE and TPV blends may be prepared by combining the invented multi-block polymers, including functionalized or unsaturated derivatives thereof with an optional rubber, including conventional block copolymers, especially an SBS block copolymer, and optionally a crosslinking or vulcanizing agent. TPO blends are generally prepared by blending the invented multi-block copolymers with a polyolefin, and optionally a crosslinking or vulcanizing agent. The foregoing blends may be used in forming a molded object, and optionally crosslinking the resulting molded article. A similar procedure using different components has been previously disclosed in U.S. Patent No. 6,797,779.

[122] Suitable conventional block copolymers for this application desirably possess a Mooney viscosity (ML 1+4 @ 100°C.) in the range from 10 to 135, more preferably from 25 to 100, and most preferably from 30 to 80. Suitable polyolefins especially include linear or low density polyethylene, polypropylene (including atactic, isotactic, syndiotactic and impact modified versions thereof) and poly(4-methyl-1-pentene). Suitable styrenic polymers

include polystyrene, rubber modified polystyrene (HIPS), styrene/acrylonitrile copolymers (SAN), rubber modified SAN (ABS or AES) and styrene maleic anhydride copolymers.

[123] The blends may be prepared by mixing or kneading the respective components at a temperature around or above the melt point temperature of one or both of the components. For most multiblock copolymers, this temperature may be above 130° C., most generally above 145° C., and most preferably above 150° C. Typical polymer mixing or kneading equipment that is capable of reaching the desired temperatures and melt plastifying the mixture may be employed. These include mills, kneaders, extruders (both single screw and twin-screw), Banbury mixers, calenders, and the like. The sequence of mixing and method may depend on the final composition. A combination of Banbury batch mixers and continuous mixers may also be employed, such as a Banbury mixer followed by a mill mixer followed by an extruder. Typically, a TPE or TPV composition will have a higher loading of cross-linkable polymer (typically the conventional block copolymer containing unsaturation) compared to TPO compositions. Generally, for TPE and TPV compositions, the weight ratio of block copolymer to multi-block copolymer may be from about 90:10 to 10:90, more preferably from 80:20 to 20:80, and most preferably from 75:25 to 25:75. For TPO applications, the weight ratio of multi-block copolymer to polyolefin may be from about 49:51 to about 5:95, more preferably from 35:65 to about 10:90. For modified styrenic polymer applications, the weight ratio of multi-block copolymer to polyolefin may also be from about 49:51 to about 5:95, more preferably from 35:65 to about 10:90. The ratios may be changed by changing the viscosity ratios of the various components. There is considerable literature illustrating techniques for changing the phase continuity by changing the viscosity ratios of the constituents of a blend that a person skilled in this art may consult if necessary.

[124] The blend compositions may contain processing oils, plasticizers, and processing aids. Rubber processing oils having a certain ASTM designation and paraffinic, naphthenic or aromatic process oils are all suitable for use. Generally from 0 to 150 parts, more preferably 0 to 100 parts, and most preferably from 0 to 50 parts of oil per 100 parts of total polymer are employed. Higher amounts of oil may tend to improve the processing of the resulting product at the expense of some physical properties. Additional processing aids include conventional waxes, fatty acid salts, such as calcium stearate or zinc stearate, (poly)alcohols including glycols, (poly)alcohol ethers, including glycol ethers, (poly)esters,

including (poly)glycol esters, and metal salt-, especially Group 1 or 2 metal or zinc-, salt derivatives thereof.

[125] It is known that non-hydrogenated rubbers such as those comprising polymerized forms of butadiene or isoprene, including block copolymers (here-in-after diene rubbers), have lower resistance to UV, ozone, and oxidation, compared to mostly or highly saturated rubbers. In applications such as tires made from compositions containing higher concentrations of diene based rubbers, it is known to incorporate carbon black to improve rubber stability, along with anti-ozone additives and anti-oxidants. Multi-block copolymers according to the present invention possessing extremely low levels of unsaturation, find particular application as a protective surface layer (coated, coextruded or laminated) or weather resistant film adhered to articles formed from conventional diene elastomer modified polymeric compositions.

[126] For conventional TPO, TPV, and TPE applications, carbon black is the additive of choice for UV absorption and stabilizing properties. Representative examples of carbon blacks include ASTM N110, N121, N220, N231, N234, N242, N293, N299, S315, N326, N330, M332, N339, N343, N347, N351, N358, N375, N539, N550, N582, N630, N642, N650, N683, N754, N762, N765, N774, N787, N907, N908, N990 and N991. These carbon blacks have iodine absorptions ranging from 9 to 145 g/kg and average pore volumes ranging from 10 to 150 cm³/100 g. Generally, smaller particle sized carbon blacks are employed, to the extent cost considerations permit. For many such applications the present multi-block copolymers and blends thereof require little or no carbon black, thereby allowing considerable design freedom to include alternative pigments or no pigments at all. Multi-hued tires or tires matching the color of the vehicle are one possibility.

[127] Compositions, including thermoplastic blends according to embodiments of the invention may also contain anti-ozonants or anti-oxidants that are known to a rubber chemist of ordinary skill. The anti-ozonants may be physical protectants such as waxy materials that come to the surface and protect the part from oxygen or ozone or they may be chemical protectors that react with oxygen or ozone. Suitable chemical protectors include styrenated phenols, butylated octylated phenol, butylated di(dimethylbenzyl) phenol, p-phenylenediamines, butylated reaction products of p-cresol and dicyclopentadiene (DCPD), polyphenolic antioxidants, hydroquinone derivatives, quinoline, diphenylene antioxidants,

thioester antioxidants, and blends thereof. Some representative trade names of such products are Wingstay™ S antioxidant, Polystay™ 100 antioxidant, Polystay™ 100 AZ antioxidant, Polystay™ 200 antioxidant, Wingstay™ L antioxidant, Wingstay™ LHLS antioxidant, Wingstay™ K antioxidant, Wingstay™ 29 antioxidant, Wingstay™ SN-1 antioxidant, and Irganox™ antioxidants. In some applications, the anti-oxidants and anti-ozonants used will preferably be non-staining and non-migratory.

[128] For providing additional stability against UV radiation, hindered amine light stabilizers (HALS) and UV absorbers may be also used. Suitable examples include Tinuvin™ 123, Tinuvin™ 144, Tinuvin™ 622, Tinuvin™ 765, Tinuvin™ 770, and Tinuvin™ 780, available from Ciba Specialty Chemicals, and Chemisorb™ T944, available from Cytex Plastics, Houston TX, USA. A Lewis acid may be additionally included with a HALS compound in order to achieve superior surface quality, as disclosed in U.S. Patent No. 6,051,681.

[129] For some compositions, additional mixing process may be employed to pre-disperse the anti-oxidants, anti-ozonants, carbon black, UV absorbers, and/or light stabilizers to form a masterbatch, and subsequently to form polymer blends there from.

[130] Suitable crosslinking agents (also referred to as curing or vulcanizing agents) for use herein include sulfur based, peroxide based, or phenolic based compounds. Examples of the foregoing materials are found in the art, including in U.S. Patents No.: 3,758,643, 3,806,558, 5,051,478, 4,104,210, 4,130,535, 4,202,801, 4,271,049, 4,340,684, 4,250,273, 4,927,882, 4,311,628 and 5,248,729.

[131] When sulfur based curing agents are employed, accelerators and cure activators may be used as well. Accelerators are used to control the time and/or temperature required for dynamic vulcanization and to improve the properties of the resulting cross-linked article. In one embodiment, a single accelerator or primary accelerator is used. The primary accelerator(s) may be used in total amounts ranging from about 0.5 to about 4, preferably about 0.8 to about 1.5, phr, based on total composition weight. In another embodiment, combinations of a primary and a secondary accelerator might be used with the secondary accelerator being used in smaller amounts, such as from about 0.05 to about 3 phr, in order to activate and to improve the properties of the cured article. Combinations of accelerators

generally produce articles having properties that are somewhat better than those produced by use of a single accelerator. In addition, delayed action accelerators may be used which are not affected by normal processing temperatures yet produce a satisfactory cure at ordinary vulcanization temperatures. Vulcanization retarders might also be used. Suitable types of accelerators that may be used in the present invention are amines, disulfides, guanidines, thioureas, thiazoles, thiurams, sulfenamides, dithiocarbamates and xanthates. Preferably, the primary accelerator is a sulfenamide. If a second accelerator is used, the secondary accelerator is preferably a guanidine, dithiocarbamate or thiuram compound. Certain processing aids and cure activators such as stearic acid and ZnO may also be used. When peroxide based curing agents are used, co-activators or coagents may be used in combination therewith. Suitable coagents include trimethylolpropane triacrylate (TMPTA), trimethylolpropane trimethacrylate (TMPTMA), triallyl cyanurate (TAC), triallyl isocyanurate (TAIC), among others. Use of peroxide crosslinkers and optional coagents used for partial or complete dynamic vulcanization are known in the art and disclosed for example in the publication, "Peroxide Vulcanization of Elastomer", Vol. 74, No 3, July-August 2001.

[132] When the multi-block copolymer containing composition is at least partially crosslinked, the degree of crosslinking may be measured by dissolving the composition in a solvent for specified duration, and calculating the percent gel or unextractable component. The percent gel normally increases with increasing crosslinking levels. For cured articles according to embodiments of the invention, the percent gel content is desirably in the range from 5 to 100 percent.

[133] The multi-block copolymers according to embodiments of the invention as well as blends thereof possess improved processability compared to prior art compositions, due, it is believed, to lower melt viscosity. Thus, the composition or blend demonstrates an improved surface appearance, especially when formed into a molded or extruded article. At the same time, the present compositions and blends thereof uniquely possess improved melt strength properties, thereby allowing the present multi-block copolymers and blends thereof, especially TPO blends, to be usefully employed in foam and thermoforming applications where melt strength is currently inadequate.

[134] Thermoplastic compositions according to embodiments of the invention may also contain organic or inorganic fillers or other additives such as starch, talc, calcium

carbonate, glass fibers, polymeric fibers (including nylon, rayon, cotton, polyester, and polyaramide), metal fibers, flakes or particles, expandable layered silicates, phosphates or carbonates, such as clays, mica, silica, alumina, aluminosilicates or aluminophosphates, carbon whiskers, carbon fibers, nanoparticles including nanotubes, wollastonite, graphite, zeolites, and ceramics, such as silicon carbide, silicon nitride or titania. Silane based or other coupling agents may also be employed for better filler bonding.

[135] The thermoplastic compositions according to embodiments of the invention, including the foregoing blends, may be processed by conventional molding techniques such as injection molding, extrusion molding, thermoforming, slush molding, over molding, insert molding, blow molding, and other techniques. Films, including multi-layer films, may be produced by cast or tentering processes, including blown film processes.

In addition to the above, the block ethylene/ α -olefin interpolymers also can be used in a manner that is described in the following U.S. provisional applications, the disclosures of which and their continuations, divisional applications and continuation-in-part applications are incorporated by reference herein in their entirety:

1) "Impact-Modification of Thermoplastics with Ethylene/ α -Olefins", U.S. Serial No. 60/717,928, filed on September 16, 2005;

2) "Three Dimensional Random Looped Structures Made from Interpolymers of Ethylene/ α -Olefins and Uses Thereof", U.S. Serial No. 60/718,130, filed on September 16, 2005;

3) "Polymer Blends from Interpolymer of Ethylene/ α -Olefin", U.S. Serial No. 60/717,825, filed on September 16, 2005;

4) "Viscosity Index Improver for Lubricant Compositions", U.S. Serial No. 60/718,129, filed on September 16, 2005;

5) "Fibers Made from Copolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/718,197, filed on September 16, 2005;

6) "Fibers Made from Copolymers of Propylene/ α -Olefins", U.S. Serial No. 60/717,863, filed on September 16, 2005;

7) "Adhesive and Marking Compositions Made from Interpolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/718,000, filed on September 16, 2005;

8) "Compositions of Ethylene/ α -Olefin Multi-Block Interpolymers Suitable For Films", U.S. Serial No. 60/718,198, filed on September 16, 2005;

5 9) "Rheology Modification of Interpolymers of Ethylene/ α -Olefins and Articles Made Therefrom", U.S. Serial No. 60/718,036, filed on September 16, 2005;

10) "Soft Foams Made From Interpolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/717,893, filed on September 16, 2005;

10 11) "Low Molecular Weight Ethylene/ α -Olefin Interpolymer as Base Lubricant Oil", U.S. Serial No. 60/717,875, filed on September 16, 2005;

12) "Foams Made From Interpolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/717,860, filed on September 16, 2005;

13) "Compositions of Ethylene/ α -Olefin Multi-Block Interpolymer For Blown Films with High Hot Tack", U.S. Serial No. 60/717,982, filed on September 16, 2005;

15 14) "Cap Liners, Closures and Gaskets From Multi-Block Polymers", U.S. Serial No. 60/717,824, filed on September 16, 2005;

15) "Polymer Blends From Interpolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/718,245, filed on September 16, 2005;

20 16) "Anti-Blocking Compositions Comprising Interpolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/717,588, filed on September 16, 2005;

17) "Interpolymers of Ethylene/ α -Olefins Blends and Profiles and Gaskets Made Therefrom", U.S. Serial No. 60/718,165, filed on September 16, 2005;

18) "Filled Polymer Compositions Made from Interpolymers of Ethylene/ α -Olefins and Uses Thereof", U.S. Serial No. 60/717,587, filed on September 16, 2005;

25 19) "Compositions Of Ethylene/ α -Olefin Multi-Block Interpolymer For Elastic Films and Laminates", U.S. Serial No. 60/718,081, filed on September 16, 2005;

20) "Thermoplastic Vulcanizate Comprising Interpolymers of Ethylene/ α -Olefins", U.S. Serial No. 60/718,186, filed on September 16, 2005;

21) "Multi-Layer, Elastic Articles", U.S. Serial No. 60/754,087, filed on December 27, 2005; and

5 22) "Functionalized Olefin Interpolymers, Compositions and Articles Prepared Therefrom, and Methods for Making the Same", U.S. Serial No. 60/718,184, filed on September 16, 2005.

EXAMPLES

[136] The following examples are provided to illustrate the synthesis of the
10 inventive polymers. Certain comparisons are made with some existing polymers. The
examples are presented to exemplify embodiments of the invention but are not intended to
limit the invention to the specific embodiments set forth. Unless indicated to the contrary, all
parts and percentages are by weight. All numerical values are approximate. When numerical
15 ranges are given, it should be understood that embodiments outside the stated ranges may still
fall within the scope of the invention. Specific details described in each example should not
be construed as necessary features of the invention.

Testing Methods

[137] In the examples that follow, the following analytical techniques are employed:

GPC Method for Samples 1-4 and A-C

20 [138] An automated liquid-handling robot equipped with a heated needle set to
160°C is used to add enough 1,2,4-trichlorobenzene stabilized with 300 ppm Ionol to each
dried polymer sample to give a final concentration of 30 mg/mL. A small glass stir rod is
placed into each tube and the samples are heated to 160°C for 2 hours on a heated, orbital-
shaker rotating at 250 rpm. The concentrated polymer solution is then diluted to 1 mg/ml
25 using the automated liquid-handling robot and the heated needle set to 160°C.

[139] A Symyx Rapid GPC system is used to determine the molecular weight data
for each sample. A Gilson 350 pump set at 2.0 ml/min flow rate is used to pump helium-

purged 1,2-dichlorobenzene stabilized with 300 ppm Ionol as the mobile phase through three Plgel 10 micrometer (μm) Mixed B 300mm x 7.5mm columns placed in series and heated to 160°C. A Polymer Labs ELS 1000 Detector is used with the Evaporator set to 250°C, the Nebulizer set to 165°C, and the nitrogen flow rate set to 1.8 SLM at a pressure of 60-80 psi (400-600 kPa) N₂. The polymer samples are heated to 160°C and each sample injected into a 250 μl loop using the liquid-handling robot and a heated needle. Serial analysis of the polymer samples using two switched loops and overlapping injections are used. The sample data is collected and analyzed using Symyx Epoch™ software. Peaks are manually integrated and the molecular weight information reported uncorrected against a polystyrene standard calibration curve.

Standard CRYSTAF Method

[140] Branching distributions are determined by crystallization analysis fractionation (CRYSTAF) using a CRYSTAF 200 unit commercially available from PolymerChar, Valencia, Spain. The samples are dissolved in 1,2,4 trichlorobenzene at 160°C (0.66 mg/mL) for 1 hr and stabilized at 95°C for 45 minutes. The sampling temperatures range from 95 to 30°C at a cooling rate of 0.2°C/min. An infrared detector is used to measure the polymer solution concentrations. The cumulative soluble concentration is measured as the polymer crystallizes while the temperature is decreased. The analytical derivative of the cumulative profile reflects the short chain branching distribution of the polymer.

[141] The CRYSTAF peak temperature and area are identified by the peak analysis module included in the CRYSTAF Software (Version 2001.b, PolymerChar, Valencia, Spain). The CRYSTAF peak finding routine identifies a peak temperature as a maximum in the dW/dT curve and the area between the largest positive inflections on either side of the identified peak in the derivative curve. To calculate the CRYSTAF curve, the preferred processing parameters are with a temperature limit of 70°C and with smoothing parameters above the temperature limit of 0.1, and below the temperature limit of 0.3.

DSC Standard Method (Excluding Samples 1-4 and A-C)

[142] Differential Scanning Calorimetry results are determined using a TAI model Q1000 DSC equipped with an RCS cooling accessory and an autosampler. A nitrogen purge gas flow of 50 ml/min is used. The sample is pressed into a thin film and melted in the press

at about 175°C and then air-cooled to room temperature (25°C). 3-10 mg of material is then cut into a 6 mm diameter disk, accurately weighed, placed in a light aluminum pan (ca 50 mg), and then crimped shut. The thermal behavior of the sample is investigated with the following temperature profile. The sample is rapidly heated to 180°C and held isothermal for 3 minutes in order to remove any previous thermal history. The sample is then cooled to -40°C at 10°C/min cooling rate and held at -40°C for 3 minutes. The sample is then heated to 150 °C at 10°C/min. heating rate. The cooling and second heating curves are recorded.

[143] The DSC melting peak is measured as the maximum in heat flow rate (W/g) with respect to the linear baseline drawn between -30°C and end of melting. The heat of fusion is measured as the area under the melting curve between -30°C and the end of melting using a linear baseline.

[144] Calibration of the DSC is done as follows. First, a baseline is obtained by running a DSC from -90 °C without any sample in the aluminum DSC pan. Then 7 milligrams of a fresh indium sample is analyzed by heating the sample to 180°C, cooling the sample to 140°C at a cooling rate of 10°C /min followed by keeping the sample isothermally at 140°C for 1 minute, followed by heating the sample from 140°C to 180°C at a heating rate of 10°C per minute. The heat of fusion and the onset of melting of the indium sample are determined and checked to be within 0.5°C from 156.6°C for the onset of melting and within 0.5 J/g from 28.71 J/g for the of fusion. Then deionized water is analyzed by cooling a small drop of fresh sample in the DSC pan from 25°C to -30°C at a cooling rate of 10°C per minute. The sample is kept isothermally at -30°C for 2 minutes and heat to 30°C at a heating rate of 10°C per minute. The onset of melting is determined and checked to be within 0.5°C from 0°C.

GPC Method (Excluding Samples 1-4 and A-C)

[145] The gel permeation chromatographic system consists of either a Polymer Laboratories Model PL-210 or a Polymer Laboratories Model PL-220 instrument. The column and carousel compartments are operated at 140 °C. Three Polymer Laboratories 10-micron Mixed-B columns are used. The solvent is 1,2,4 trichlorobenzene. The samples are prepared at a concentration of 0.1 grams of polymer in 50 milliliters of solvent containing 200 ppm of butylated hydroxytoluene (BHT). Samples are prepared by agitating lightly for 2

hours at 160°C. The injection volume used is 100 microliters and the flow rate is 1.0 ml/minute.

[146] Calibration of the GPC column set is performed with 21 narrow molecular weight distribution polystyrene standards with molecular weights ranging from 580 to 8,400,000, arranged in 6 “cocktail” mixtures with at least a decade of separation between individual molecular weights. The standards are purchased from Polymer Laboratories (Shropshire, UK). The polystyrene standards are prepared at 0.025 grams in 50 milliliters of solvent for molecular weights equal to or greater than 1,000,000, and 0.05 grams in 50 milliliters of solvent for molecular weights less than 1,000,000. The polystyrene standards are dissolved at 80°C with gentle agitation for 30 minutes. The narrow standards mixtures are run first and in order of decreasing highest molecular weight component to minimize degradation. The polystyrene standard peak molecular weights are converted to polyethylene molecular weights using the following equation (as described in Williams and Ward, J. Polym. Sci., Polym. Let., 6, 621 (1968)): $M_{\text{polyethylene}} = 0.431(M_{\text{polystyrene}})$.

[147] Polyethylene equivalent molecular weight calculations are performed using Viscotek TriSEC software Version 3.0.

Compression Set

[148] Compression set is measured according to ASTM D 395. The sample is prepared by stacking 25.4 mm diameter round discs of 3.2 mm, 2.0 mm, and 0.25 mm thickness until a total thickness of 12.7 mm is reached. The discs are cut from 12.7 cm x 12.7 cm compression molded plaques molded with a hot press under the following conditions: zero pressure for 3 min at 190°C, followed by 86 MPa for 2 min at 190°C, followed by cooling inside the press with cold running water at 86 MPa.

Density

[149] Samples for density measurement are prepared according to ASTM D 1928. Measurements are made within one hour of sample pressing using ASTM D792, Method B.

Flexural/Secant Modulus/ Storage Modulus

[150] Samples are compression molded using ASTM D 1928. Flexural and 2 percent secant moduli are measured according to ASTM D-790. Storage modulus is measured according to ASTM D 5026-01 or equivalent technique.

5 Optical properties

[151] Films of 0.4 mm thickness are compression molded using a hot press (Carver Model #4095-4PR1001R). The pellets are placed between polytetrafluoroethylene sheets, heated at 190 °C at 55 psi (380 kPa) for 3 min, followed by 1.3 MPa for 3 min, and then 2.6 MPa for 3 min. The film is then cooled in the press with running cold water at 1.3 MPa for 1
10 min. The compression molded films are used for optical measurements, tensile behavior, recovery, and stress relaxation.

[152] Clarity is measured using BYK Gardner Haze-gard as specified in ASTM D 1746.

[153] 45° gloss is measured using BYK Gardner Glossmeter Microgloss 45° as
15 specified in ASTM D-2457

[154] Internal haze is measured using BYK Gardner Haze-gard based on ASTM D 1003 Procedure A. Mineral oil is applied to the film surface to remove surface scratches.

Mechanical Properties - Tensile, Hysteresis, and Tear

[155] Stress-strain behavior in uniaxial tension is measured using ASTM D 1708
20 microtensile specimens. Samples are stretched with an Instron at 500 % min⁻¹ at 21°C. Tensile strength and elongation at break are reported from an average of 5 specimens.

[156] 100% and 300% Hysteresis is determined from cyclic loading to 100% and 300% strains using ASTM D 1708 microtensile specimens with an Instron™ instrument. The sample is loaded and unloaded at 267 % min⁻¹ for 3 cycles at 21°C. Cyclic experiments at
25 300% and 80°C are conducted using an environmental chamber. In the 80 °C experiment, the sample is allowed to equilibrate for 45 minutes at the test temperature before testing. In the 21 °C, 300% strain cyclic experiment, the retractive stress at 150% strain from the first

unloading cycle is recorded. Percent recovery for all experiments are calculated from the first unloading cycle using the strain at which the load returned to the base line. The percent recovery is defined as:

$$\% Recovery = \frac{\varepsilon_f - \varepsilon_s}{\varepsilon_f} \times 100$$

- 5 where ε_f is the strain taken for cyclic loading and ε_s is the strain where the load returns to the baseline during the 1st unloading cycle.

[157] Stress relaxation is measured at 50 percent strain and 37 °C for 12 hours using an Instron™ instrument equipped with an environmental chamber. The gauge geometry was 76 mm x 25 mm x 0.4 mm. After equilibrating at 37°C for 45 min in the environmental
 10 chamber, the sample was stretched to 50% strain at 333% min⁻¹. Stress was recorded as a function of time for 12 hours. The percent stress relaxation after 12 hours was calculated using the formula:

$$\% Stress\ Relaxation = \frac{L_0 - L_{12}}{L_0} \times 100$$

- 15 where L_0 is the load at 50% strain at 0 time and L_{12} is the load at 50 percent strain after 12 hours.

[158] Tensile notched tear experiments are carried out on samples having a density of 0.88 g/cc or less using an Instron™ instrument. The geometry consists of a gauge section of 76 mm x 13 mm x 0.4 mm with a 2 mm notch cut into the sample at half the specimen length. The sample is stretched at 508 mm min⁻¹ at 21 °C until it breaks. The tear energy is
 20 calculated as the area under the stress-elongation curve up to strain at maximum load. An average of at least 3 specimens are reported.

TMA

[159] Thermal Mechanical Analysis (Penetration Temperature) is conducted on 30mm diameter x 3.3 mm thick, compression molded discs, formed at 180°C and 10 MPa
 25 molding pressure for 5 minutes and then air quenched. The instrument used is a TMA 7, brand available from Perkin-Elmer. In the test, a probe with 1.5 mm radius tip (P/N N519-

0416) is applied to the surface of the sample disc with 1N force. The temperature is raised at 5°C/min from 25°C. The probe penetration distance is measured as a function of temperature. The experiment ends when the probe has penetrated 1 mm into the sample.

DMA

5 [160] Dynamic Mechanical Analysis (DMA) is measured on compression molded disks formed in a hot press at 180°C at 10 MPa pressure for 5 minutes and then water cooled in the press at 90°C / min. Testing is conducted using an ARES controlled strain rheometer (TA instruments) equipped with dual cantilever fixtures for torsion testing.

10 [161] A 1.5mm plaque is pressed and cut in a bar of dimensions 32x12mm. The sample is clamped at both ends between fixtures separated by 10mm (grip separation ΔL) and subjected to successive temperature steps from -100°C to 200°C (5°C per step). At each temperature the torsion modulus G' is measured at an angular frequency of 10 rad/s, the strain amplitude being maintained between 0.1 percent and 4 percent to ensure that the torque is sufficient and that the measurement remains in the linear regime.

15 [162] An initial static force of 10 g is maintained (auto-tension mode) to prevent slack in the sample when thermal expansion occurs. As a consequence, the grip separation ΔL increases with the temperature, particularly above the melting or softening point of the polymer sample. The test stops at the maximum temperature or when the gap between the fixtures reaches 65 mm.

20 Melt Index

 [163] Melt index, or I_2 , is measured in accordance with ASTM D 1238, Condition 190°C/2.16 kg. Melt index, or I_{10} is also measured in accordance with ASTM D 1238, Condition 190°C/10 kg.

ATREF

25 [164] Analytical temperature rising elution fractionation (ATREF) analysis is conducted according to the method described in U.S. Patent No. 4,798,081 and Wilde, L.; Ryle, T.R.; Knobloch, D.C.; Peat, I.R.; *Determination of Branching Distributions in Polyethylene and Ethylene Copolymers*, J. Polym. Sci., 20, 441-455 (1982), which are

incorporated by reference herein in their entirety. The composition to be analyzed is dissolved in trichlorobenzene and allowed to crystallize in a column containing an inert support (stainless steel shot) by slowly reducing the temperature to 20°C at a cooling rate of 0.1°C/min. The column is equipped with an infrared detector. An ATREF chromatogram
5 curve is then generated by eluting the crystallized polymer sample from the column by slowly increasing the temperature of the eluting solvent (trichlorobenzene) from 20 to 120°C at a rate of 1.5°C/min.

¹³C NMR Analysis

[165] The samples are prepared by adding approximately 3g of a 50/50 mixture of
10 tetrachloroethane-d²/orthodichlorobenzene to 0.4 g sample in a 10 mm NMR tube. The samples are dissolved and homogenized by heating the tube and its contents to 150°C. The data are collected using a JEOL Eclipse™ 400MHz spectrometer or a Varian Unity Plus™ 400MHz spectrometer, corresponding to a ¹³C resonance frequency of 100.5 MHz. The data are acquired using 4000 transients per data file with a 6 second pulse repetition delay. To
15 achieve minimum signal-to-noise for quantitative analysis, multiple data files are added together. The spectral width is 25,000 Hz with a minimum file size of 32K data points. The samples are analyzed at 130 °C in a 10 mm broad band probe. The comonomer incorporation is determined using Randall's triad method (Randall, J.C.; JMS-Rev. Macromol. Chem. Phys., C29, 201-317 (1989), which is incorporated by reference herein in its entirety.

20 Polymer Fractionation by TREF (also known as Preparative TREF)

[166] Large-scale TREF fractionation is carried by dissolving 15-20 g of polymer in 2 liters of 1,2,4-trichlorobenzene (TCB) by stirring for 4 hours at 160°C. The polymer solution is forced by 15 psig (100 kPa) nitrogen onto a 3 inch by 4 foot (7.6 cm x 12 cm) steel column packed with a 60:40 (v:v) mix of 30-40 mesh (600-425 µm) spherical, technical
25 quality glass beads (available from Potters Industries, HC 30 Box 20, Brownwood, TX, 76801) and stainless steel, 0.028" (0.7mm) diameter cut wire shot (available from Pellets, Inc. 63 Industrial Drive, North Tonawanda, NY, 14120). The column is immersed in a thermally controlled oil jacket, set initially to 160 °C. The column is first cooled ballistically to 125 °C, then slow cooled to 20 °C at 0.04 °C per minute and held for one hour. Fresh TCB
30 is introduced at about 65 ml/min while the temperature is increased at 0.167 °C per minute.

[167] Approximately 2000 ml portions of eluant from the preparative TREF column are collected in a 16 station, heated fraction collector. The polymer is concentrated in each fraction using a rotary evaporator until about 50 to 100 ml of the polymer solution remains. The concentrated solutions are allowed to stand overnight before adding excess methanol, filtering, and rinsing (approx. 300-500 ml of methanol including the final rinse). The filtration step is performed on a 3 position vacuum assisted filtering station using 5.0 μm polytetrafluoroethylene coated filter paper (available from Osmonics Inc., Cat# Z50WP04750). The filtrated fractions are dried overnight in a vacuum oven at 60 °C and weighed on an analytical balance before further testing. Additional information about hits method is taught in Wilde, L.; Ryle, T.R.; Knobloch, D.C.; Peat, I.R.; *Determination of Branching Distributions in Polyethylene and Ethylene Copolymers*, J. Polym. Sci., 20, 441-455 (1982),

Melt Strength

[168] Melt Strength (MS) is measured by using a capillary rheometer fitted with a 2.1 mm diameter, 20:1 die with an entrance angle of approximately 45 degrees. After equilibrating the samples at 190°C for 10 minutes, the piston is run at a speed of 1 inch/minute (2.54 cm/minute). The standard test temperature is 190°C. The sample is drawn uniaxially to a set of accelerating nips located 100 mm below the die with an acceleration of 2.4 mm/sec². The required tensile force is recorded as a function of the take-up speed of the nip rolls. The maximum tensile force attained during the test is defined as the melt strength. In the case of polymer melt exhibiting draw resonance, the tensile force before the onset of draw resonance was taken as melt strength. The melt strength is recorded in centiNewtons ("cN").

Catalysts

[169] The term "overnight", if used, refers to a time of approximately 16-18 hours, the term "room temperature", refers to a temperature of 20-25 °C, and the term "mixed alkanes" refers to a commercially obtained mixture of C₆₋₉ aliphatic hydrocarbons available under the trade designation Isopar E[®], from ExxonMobil Chemical Company. In the event the name of a compound herein does not conform to the structural representation thereof, the structural representation shall control. The synthesis of all metal complexes and the

preparation of all screening experiments were carried out in a dry nitrogen atmosphere using dry box techniques. All solvents used were HPLC grade and were dried before their use.

[170] MMAO refers to modified methylalumoxane, a triisobutylaluminum modified methylalumoxane available commercially from Akzo-Noble Corporation.

5 [171] The preparation of catalyst (B1) is conducted as follows.

a) Preparation of (1-methylethyl)(2-hydroxy-3,5-di(t-butyl)phenyl)methylimine

[172] 3,5-Di-t-butylsalicylaldehyde (3.00 g) is added to 10 mL of isopropylamine. The solution rapidly turns bright yellow. After stirring at ambient temperature for 3 hours, volatiles are removed under vacuum to yield a bright yellow, crystalline solid (97 percent
10 yield).

b) Preparation of 1,2-bis-(3,5-di-t-butylphenylene)(1-(N-(1-methylethyl)immino)methyl)(2-oxoyl) zirconium dibenzyl

[173] A solution of (1-methylethyl)(2-hydroxy-3,5-di(t-butyl)phenyl)imine (605 mg, 2.2 mmol) in 5 mL toluene is slowly added to a solution of $Zr(CH_2Ph)_4$ (500 mg, 1.1 mmol) in 50 mL toluene. The resulting dark yellow solution is stirred for 30 min. Solvent is
15 removed under reduced pressure to yield the desired product as a reddish-brown solid.

[174] The preparation of catalyst (B2) is conducted as follows.

a) Preparation of (1-(2-methylcyclohexyl)ethyl)(2-oxoyl-3,5-di(t-butyl)phenyl)imine

[175] 2-Methylcyclohexylamine (8.44 mL, 64.0 mmol) is dissolved in methanol (90
20 mL), and di-t-butylsalicylaldehyde (10.00 g, 42.67 mmol) is added. The reaction mixture is stirred for three hours and then cooled to -25°C for 12 hrs. The resulting yellow solid precipitate is collected by filtration and washed with cold methanol (2 x 15 mL), and then dried under reduced pressure. The yield is 11.17 g of a yellow solid. 1H NMR is consistent with the desired product as a mixture of isomers.

25 b) Preparation of bis-(1-(2-methylcyclohexyl)ethyl)(2-oxoyl-3,5-di(t-butyl)phenyl)immino)zirconium dibenzyl

[176] A solution of (1-(2-methylcyclohexyl)ethyl)(2-oxoyl-3,5-di(t-butyl)phenyl)imine (7.63 g, 23.2 mmol) in 200 mL toluene is slowly added to a solution of $\text{Zr}(\text{CH}_2\text{Ph})_4$ (5.28 g, 11.6 mmol) in 600 mL toluene. The resulting dark yellow solution is stirred for 1 hour at 25°C. The solution is diluted further with 680 mL toluene to give a solution having a concentration of 0.00783 M.

[177] Cocatalyst 1 A mixture of methyldi(C_{14-18} alkyl)ammonium salts of tetrakis(pentafluorophenyl)borate (here-in-after armeenium borate), prepared by reaction of a long chain trialkylamine (Armeen™ M2HT, available from Akzo-Nobel, Inc.), HCl and $\text{Li}[\text{B}(\text{C}_6\text{F}_5)_4]$, substantially as disclosed in U.S. Patent No. 5,919,9883, Ex. 2.

[178] Cocatalyst 2 Mixed C_{14-18} alkyl dimethylammonium salt of bis(tris(pentafluorophenyl)-alumane)-2-undecylimidazolide, prepared according to U.S. Patent No. 6,395,671, Ex. 16.

[179] Shuttling Agents The shuttling agents employed include diethylzinc (DEZ, SA1), di(i-butyl)zinc (SA2), di(n-hexyl)zinc (SA3), triethylaluminum (TEA, SA4), trioctylaluminum (SA5), triethylgallium (SA6), i-butylaluminum bis(dimethyl(t-butyl)siloxane) (SA7), i-butylaluminum bis(di(trimethylsilyl)amide) (SA8), n-octylaluminum di(pyridine-2-methoxide) (SA9), bis(n-octadecyl)i-butylaluminum (SA10), i-butylaluminum bis(di(n-pentyl)amide) (SA11), n-octylaluminum bis(2,6-di-t-butylphenoxide) (SA12), n-octylaluminum di(ethyl(1-naphthyl)amide) (SA13), ethylaluminum bis(t-butyl)dimethylsiloxide (SA14), ethylaluminum di(bis(trimethylsilyl)amide) (SA15), ethylaluminum bis(2,3,6,7-dibenzo-1-azacycloheptaneamide) (SA16), n-octylaluminum bis(2,3,6,7-dibenzo-1-azacycloheptaneamide) (SA17), n-octylaluminum bis(dimethyl(t-butyl)siloxide) (SA18), ethylzinc (2,6-diphenylphenoxide) (SA19), and ethylzinc (t-butoxide) (SA20).

Examples 1-4, Comparative A-C

General High Throughput Parallel Polymerization Conditions

[180] Polymerizations are conducted using a high throughput, parallel polymerization reactor (PPR) available from Symyx Technologies, Inc. and operated substantially according to U.S. Patents No. 6,248,540, 6,030,917, 6,362,309, 6,306,658, and

6,316,663. Ethylene copolymerizations are conducted at 130°C and 200 psi (1.4 MPa) with ethylene on demand using 1.2 equivalents of cocatalyst 1 based on total catalyst used (1.1 equivalents when MMAO is present). A series of polymerizations are conducted in a parallel pressure reactor (PPR) contained of 48 individual reactor cells in a 6 x 8 array that are fitted
5 with a pre-weighed glass tube. The working volume in each reactor cell is 6000 µL. Each cell is temperature and pressure controlled with stirring provided by individual stirring paddles. The monomer gas and quench gas are plumbed directly into the PPR unit and controlled by automatic valves. Liquid reagents are robotically added to each reactor cell by syringes and the reservoir solvent is mixed alkanes. The order of addition is mixed alkanes
10 solvent (4 ml), ethylene, 1-octene comonomer (1 ml), cocatalyst 1 or cocatalyst 1/MMAO mixture, shuttling agent, and catalyst or catalyst mixture. When a mixture of cocatalyst 1 and MMAO or a mixture of two catalysts is used, the reagents are premixed in a small vial immediately prior to addition to the reactor. When a reagent is omitted in an experiment, the above order of addition is otherwise maintained. Polymerizations are conducted for
15 approximately 1-2 minutes, until predetermined ethylene consumptions are reached. After quenching with CO, the reactors are cooled and the glass tubes are unloaded. The tubes are transferred to a centrifuge/vacuum drying unit, and dried for 12 hours at 60 °C. The tubes containing dried polymer are weighed and the difference between this weight and the tare weight gives the net yield of polymer. Results are contained in Table 1. In Table 1 and
20 elsewhere in the application, comparative compounds are indicated by an asterisk (*).

[181] Examples 1-4 demonstrate the synthesis of linear block copolymers by the present invention as evidenced by the formation of a very narrow MWD, essentially monomodal copolymer when DEZ is present and a bimodal, broad molecular weight distribution product (a mixture of separately produced polymers) in the absence of DEZ. Due
25 to the fact that Catalyst (A1) is known to incorporate more octene than Catalyst (B1), the different blocks or segments of the resulting copolymers according to embodiments of the invention are distinguishable based on branching or density.

Table 1

Ex.	Cat. (A1) (μmol)	Cat (B1) (μmol)	Cocat (μmol)	MMAO (μmol)	shuttling agent (μmol)	Yield (g)	Mn	Mw/Mn	hexyls ¹
A*	0.06	-	0.066	0.3	-	0.1363	300502	3.32	-
B*	-	0.1	0.110	0.5	-	0.1581	36957	1.22	2.5
C*	0.06	0.1	0.176	0.8	-	0.2038	45526	5.30 ²	5.5
1	0.06	0.1	0.192	-	DEZ (8.0)	0.1974	28715	1.19	4.8
2	0.06	0.1	0.192	-	DEZ (80.0)	0.1468	2161	1.12	14.4
3	0.06	0.1	0.192	-	TEA (8.0)	0.208	22675	1.71	4.6
4	0.06	0.1	0.192	-	TEA (80.0)	0.1879	3338	1.54	9.4

¹ C₆ or higher chain content per 1000 carbons

² Bimodal molecular weight distribution

[182] It may be seen the polymers produced according to embodiments of the invention have a relatively narrow polydispersity (Mw/Mn) and larger block-copolymer content (trimer, tetramer, or larger) than polymers prepared in the absence of the shuttling agent.

[183] Further characterizing data for the polymers of Table 1 are determined by reference to the figures. More specifically DSC and ATREF results show the following:

10 [184] The DSC curve for the polymer of example 1 shows a 115.7°C melting point (T_m) with a heat of fusion of 158.1 J/g. The corresponding CRYSTAF curve shows the tallest peak at 34.5°C with a peak area of 52.9 percent. The difference between the DSC T_m and the T_{crystaf} is 81.2°C.

15 [185] The DSC curve for the polymer of example 2 shows a peak with a 109.7°C melting point (T_m) with a heat of fusion of 214.0 J/g. The corresponding CRYSTAF curve shows the tallest peak at 46.2°C with a peak area of 57.0 percent. The difference between the DSC T_m and the T_{crystaf} is 63.5°C.

20 [186] The DSC curve for the polymer of example 3 shows a peak with a 120.7°C melting point (T_m) with a heat of fusion of 160.1 J/g. The corresponding CRYSTAF curve shows the tallest peak at 66.1°C with a peak area of 71.8 percent. The difference between the DSC T_m and the T_{crystaf} is 54.6°C.

[187] The DSC curve for the polymer of example 4 shows a peak with a 104.5°C melting point (T_m) with a heat of fusion of 170.7 J/g. The corresponding CRYSTAF curve shows the tallest peak at 30 °C with a peak area of 18.2 percent. The difference between the DSC T_m and the T_{crystaf} is 74.5°C.

5 [188] The DSC curve for comparative A shows a 90.0°C melting point (T_m) with a heat of fusion of 86.7 J/g. The corresponding CRYSTAF curve shows the tallest peak at 48.5°C with a peak area of 29.4 percent. Both of these values are consistent with a resin that is low in density. The difference between the DSC T_m and the T_{crystaf} is 41.8°C.

10 [189] The DSC curve for comparative B shows a 129.8°C melting point (T_m) with a heat of fusion of 237.0 J/g. The corresponding CRYSTAF curve shows the tallest peak at 82.4°C with a peak area of 83.7 percent. Both of these values are consistent with a resin that is high in density. The difference between the DSC T_m and the T_{crystaf} is 47.4°C.

15 [190] The DSC curve for comparative C shows a 125.3°C melting point (T_m) with a heat of fusion of 143.0 J/g. The corresponding CRYSTAF curve shows the tallest peak at 81.8 °C with a peak area of 34.7 percent as well as a lower crystalline peak at 52.4 °C. The separation between the two peaks is consistent with the presence of a high crystalline and a low crystalline polymer. The difference between the DSC T_m and the T_{crystaf} is 43.5°C.

Examples 5-19, Comparatives D-F, Continuous Solution Polymerization, Catalyst A1/B2 + DEZ

20 [191] Continuous solution polymerizations are carried out in a computer controlled autoclave reactor equipped with an internal stirrer. Purified mixed alkanes solvent (Isopar™ E available from ExxonMobil Chemical Company), ethylene at 2.70 lbs/hour (1.22 kg/hour), 1-octene, and hydrogen (where used) are supplied to a 3.8 L reactor equipped with a jacket for temperature control and an internal thermocouple. The solvent feed to the reactor is
25 measured by a mass-flow controller. A variable speed diaphragm pump controls the solvent flow rate and pressure to the reactor. At the discharge of the pump, a side stream is taken to provide flush flows for the catalyst and cocatalyst 1 injection lines and the reactor agitator. These flows are measured by Micro-Motion mass flow meters and controlled by control valves or by the manual adjustment of needle valves. The remaining solvent is combined

with 1-octene, ethylene, and hydrogen (where used) and fed to the reactor. A mass flow controller is used to deliver hydrogen to the reactor as needed. The temperature of the solvent/monomer solution is controlled by use of a heat exchanger before entering the reactor. This stream enters the bottom of the reactor. The catalyst component solutions are
5 metered using pumps and mass flow meters and are combined with the catalyst flush solvent and introduced into the bottom of the reactor. The reactor is run liquid-full at 500 psig (3.45 MPa) with vigorous stirring. Product is removed through exit lines at the top of the reactor. All exit lines from the reactor are steam traced and insulated. Polymerization is stopped by
10 additives and passing the mixture through a static mixer. The product stream is then heated by passing through a heat exchanger before devolatilization. The polymer product is recovered by extrusion using a devolatilizing extruder and water cooled pelletizer. Process details and results are contained in Table 2. Selected polymer properties are provided in Table 3.

Table 2 Process details for preparation of exemplary polymers

Ex.	C ₈ H ₁₆ kg/hr	Solv. kg/hr	H ₂ scm ¹	T °C	Cat Al ² ppm	Cat Flow kg/hr	Cat Al ¹ ppm	B2 Flow kg/hr	DEZ Conc %	DEZ Flow kg/hr	Cocat Conc. ppm	Cocat Flow kg/hr	[C ₂ H ₄]/ [DEZ] ⁴	Poly Rate ⁵ kg/hr	Conv % ⁶	Solids %	Eff. ⁷
D*	1.63	12.7	29.90	120	142.2	0.14	-	-	0.19	0.32	820	0.17	536	1.81	88.8	11.2	95.2
E*	"	9.5	5.00	"	-	-	109	0.10	0.19	"	1743	0.40	485	1.47	89.9	11.3	126.8
F*	"	11.3	251.6	"	71.7	0.06	30.8	0.06	-	-	"	0.11	-	1.55	88.5	10.3	257.7
5	"	"	-	"	"	0.14	30.8	0.13	0.17	0.43	"	0.26	419	1.64	89.6	11.1	118.3
6	"	"	4.92	"	"	0.10	30.4	0.08	0.17	0.32	"	0.18	570	1.65	89.3	11.1	172.7
7	"	"	21.70	"	"	0.07	30.8	0.06	0.17	0.25	"	0.13	718	1.60	89.2	10.6	244.1
8	"	"	36.90	"	"	0.06	"	"	"	0.10	"	0.12	1778	1.62	90.0	10.8	261.1
9	"	"	78.43	"	"	"	"	"	"	0.04	"	"	4596	1.63	90.2	10.8	267.9
10	"	"	0.00	123	71.1	0.12	30.3	0.14	0.34	0.19	1743	0.08	415	1.67	90.31	11.1	131.1
11	"	"	"	120	71.1	0.16	"	0.17	0.80	0.15	1743	0.10	249	1.68	89.56	11.1	100.6
12	"	"	"	121	71.1	0.15	"	0.07	"	0.09	1743	0.07	396	1.70	90.02	11.3	137.0
13	"	"	"	122	71.1	0.12	"	0.06	"	0.05	1743	0.05	653	1.69	89.64	11.2	161.9
14	"	"	"	120	71.1	0.05	"	0.29	"	0.10	1743	0.10	395	1.41	89.42	9.3	114.1
15	2.45	"	"	"	71.1	0.14	"	0.17	"	0.14	1743	0.09	282	1.80	89.33	11.3	121.3
16	"	"	"	122	71.1	0.10	"	0.13	"	0.07	1743	0.07	485	1.78	90.11	11.2	159.7
17	"	"	"	121	71.1	0.10	"	0.14	"	0.08	1743	"	506	1.75	89.08	11.0	155.6
18	0.69	"	"	121	71.1	"	"	0.22	"	0.11	1743	0.10	331	1.25	89.93	8.8	90.2
19	0.32	"	"	122	71.1	0.06	"	"	"	0.09	1743	0.08	367	1.16	90.74	8.4	106.0

* Comparative, not an example of the invention

¹ standard cm³/min² [N-(2,6-di(1-methyl-2-phenyl)phenyl)amido](2-isopropylphenyl)(α -naphthalen-2-yl)(6-pyridin-2-yl)methane][hafnium dimethyl³ bis-(1-(2-methylcyclohexyl)ethyl)(2-oxo-1,3,5-di(t-butyl)phenyl)imino) zirconium dibenzyl⁴ molar ratio in reactor⁵ polymer production rate⁶ percent ethylene conversion in reactor⁷ efficiency, kg polymer/g M where g M = g Hf + g Zr

Table 3 Properties of exemplary polymers

Ex.	Density (g/cm ³)	I ₂	I ₁₀	I ₁₀ /I ₂	Mw (g/mol)	Mn (g/mol)	Mw/Mn	Heat of Fusion (J/g)	T _m (°C)	T _c (°C)	T _{CRYSTAF} (°C)	T _m - T _{CRYSTAF} (°C)	CRYSTAF Peak Area (percent)
D*	0.8627	1.5	10.0	6.5	110,000	55,800	2.0	32	37	45	30	7	99
E*	0.9378	7.0	39.0	5.6	65,000	33,300	2.0	183	124	113	79	45	95
F*	0.8895	0.9	12.5	13.4	137,300	9,980	13.8	90	125	111	78	47	20
5	0.8786	1.5	9.8	6.7	104,600	53,200	2.0	55	120	101	48	72	60
6	0.8785	1.1	7.5	6.5	109,600	53,300	2.1	55	115	94	44	71	63
7	0.8825	1.0	7.2	7.1	118,500	53,100	2.2	69	121	103	49	72	29
8	0.8828	0.9	6.8	7.7	129,000	40,100	3.2	68	124	106	80	43	13
9	0.8836	1.1	9.7	9.1	129,600	28,700	4.5	74	125	109	81	44	16
10	0.8784	1.2	7.5	6.5	113,100	58,200	1.9	54	116	92	41	75	52
11	0.8818	9.1	59.2	6.5	66,200	36,500	1.8	63	114	93	40	74	25
12	0.8700	2.1	13.2	6.4	101,500	55,100	1.8	40	113	80	30	83	91
13	0.8718	0.7	4.4	6.5	132,100	63,600	2.1	42	114	80	30	81	8
14	0.9116	2.6	15.6	6.0	81,900	43,600	1.9	123	121	106	73	48	92
15	0.8719	6.0	41.6	6.9	79,900	40,100	2.0	33	114	91	32	82	10
16	0.8758	0.5	3.4	7.1	148,500	74,900	2.0	43	117	96	48	69	65
17	0.8757	1.7	11.3	6.8	107,500	54,000	2.0	43	116	96	43	73	57
18	0.9192	4.1	24.9	6.1	72,000	37,900	1.9	136	120	106	70	50	94
19	0.9344	3.4	20.3	6.0	76,800	39,400	1.9	169	125	112	80	45	88

[192] The resulting polymers are tested by DSC and ATREF as with previous examples. Results are as follows:

[193] The DSC curve for the polymer of example 5 shows a peak with a 119.6 °C melting point (T_m) with a heat of fusion of 60.0 J/g. The corresponding CRYSTAF curve shows the tallest peak at 47.6°C with a peak area of 59.5 percent. The delta between the DSC T_m and the T_{crystaf} is 72.0°C.

[194] The DSC curve for the polymer of example 6 shows a peak with a 115.2 °C melting point (T_m) with a heat of fusion of 60.4 J/g. The corresponding CRYSTAF curve shows the tallest peak at 44.2°C with a peak area of 62.7 percent. The delta between the DSC T_m and the T_{crystaf} is 71.0°C.

[195] The DSC curve for the polymer of example 7 shows a peak with a 121.3 °C melting point with a heat of fusion of 69.1 J/g. The corresponding CRYSTAF curve shows the tallest peak at 49.2°C with a peak area of 29.4 percent. The delta between the DSC T_m and the T_{crystaf} is 72.1°C.

[196] The DSC curve for the polymer of example 8 shows a peak with a 123.5 °C melting point (T_m) with a heat of fusion of 67.9 J/g. The corresponding CRYSTAF curve shows the tallest peak at 80.1°C with a peak area of 12.7 percent. The delta between the DSC T_m and the T_{crystaf} is 43.4°C.

[197] The DSC curve for the polymer of example 9 shows a peak with a 124.6 °C melting point (T_m) with a heat of fusion of 73.5 J/g. The corresponding CRYSTAF curve shows the tallest peak at 80.8°C with a peak area of 16.0 percent. The delta between the DSC T_m and the T_{crystaf} is 43.8°C.

[198] The DSC curve for the polymer of example 10 shows a peak with a 115.6 °C melting point (T_m) with a heat of fusion of 60.7 J/g. The corresponding CRYSTAF curve shows the tallest peak at 40.9°C with a peak area of 52.4 percent. The delta between the DSC T_m and the T_{crystaf} is 74.7°C.

[199] The DSC curve for the polymer of example 11 shows a peak with a 113.6 °C melting point (T_m) with a heat of fusion of 70.4 J/g. The corresponding CRYSTAF curve shows the tallest peak at 39.6°C with a peak area of 25.2 percent. The delta between the DSC T_m and the Tcrystaf is 74.1°C.

5 [200] The DSC curve for the polymer of example 12 shows a peak with a 113.2 °C melting point (T_m) with a heat of fusion of 48.9 J/g. The corresponding CRYSTAF curve shows no peak equal to or above 30 °C. (Tcrystaf for purposes of further calculation is therefore set at 30°C). The delta between the DSC T_m and the Tcrystaf is 83.2°C.

10 [201] The DSC curve for the polymer of example 13 shows a peak with a 114.4 °C melting point (T_m) with a heat of fusion of 49.4 J/g. The corresponding CRYSTAF curve shows the tallest peak at 33.8 °C with a peak area of 7.7 percent. The delta between the DSC T_m and the Tcrystaf is 84.4°C.

15 [202] The DSC for the polymer of example 14 shows a peak with a 120.8 °C melting point (T_m) with a heat of fusion of 127.9 J/g. The corresponding CRYSTAF curve shows the tallest peak at 72.9 °C with a peak area of 92.2 percent. The delta between the DSC T_m and the Tcrystaf is 47.9°C.

20 [203] The DSC curve for the polymer of example 15 shows a peak with a 114.3 °C melting point (T_m) with a heat of fusion of 36.2 J/g. The corresponding CRYSTAF curve shows the tallest peak at 32.3 °C with a peak area of 9.8 percent. The delta between the DSC T_m and the Tcrystaf is 82.0°C.

[204] The DSC curve for the polymer of example 16 shows a peak with a 116.6 °C melting point (T_m) with a heat of fusion of 44.9 J/g. The corresponding CRYSTAF curve shows the tallest peak at 48.0 °C with a peak area of 65.0 percent. The delta between the DSC T_m and the Tcrystaf is 68.6°C.

25 [205] The DSC curve for the polymer of example 17 shows a peak with a 116.0 °C melting point (T_m) with a heat of fusion of 47.0 J/g. The corresponding CRYSTAF curve shows the tallest peak at 43.1 °C with a peak area of 56.8 percent. The delta between the DSC T_m and the Tcrystaf is 72.9°C.

[206] The DSC curve for the polymer of example 18 shows a peak with a 120.5 °C melting point (T_m) with a heat of fusion of 141.8 J/g. The corresponding CRYSTAF curve shows the tallest peak at 70.0 °C with a peak area of 94.0 percent. The delta between the DSC T_m and the T_{crystaf} is 50.5 °C.

5 [207] The DSC curve for the polymer of example 19 shows a peak with a 124.8 °C melting point (T_m) with a heat of fusion of 174.8 J/g. The corresponding CRYSTAF curve shows the tallest peak at 79.9 °C with a peak area of 87.9 percent. The delta between the DSC T_m and the T_{crystaf} is 45.0 °C.

[208] The DSC curve for the polymer of comparative D shows a peak with a 37.3°C melting point (T_m) with a heat of fusion of 31.6 J/g. The corresponding CRYSTAF curve shows no peak equal to and above 30°C. Both of these values are consistent with a resin that is low in density. The delta between the DSC T_m and the T_{crystaf} is 7.3°C.

10 [209] The DSC curve for the polymer of comparative E shows a peak with a 124.0 °C melting point (T_m) with a heat of fusion of 179.3 J/g. The corresponding CRYSTAF curve shows the tallest peak at 79.3°C with a peak area of 94.6 percent. Both of these values are consistent with a resin that is high in density. The delta between the DSC T_m and the T_{crystaf} is 44.6°C.

[210] The DSC curve for the polymer of comparative F shows a peak with a 124.8 °C melting point (T_m) with a heat of fusion of 90.4 J/g. The corresponding CRYSTAF curve shows the tallest peak at 77.6°C with a peak area of 19.5 percent. The separation between the two peaks is consistent with the presence of both a high crystalline and a low crystalline polymer. The delta between the DSC T_m and the T_{crystaf} is 47.2°C.

Physical Property Testing

25 [211] Polymer samples are evaluated for physical properties such as high temperature resistance properties, as evidenced by TMA temperature testing, pellet blocking strength, high temperature recovery, high temperature compression set and storage modulus ratio, G'(25°C)/G'(100°C). Several commercially available polymers are included in the tests: Comparative G* is a substantially linear ethylene/1-octene copolymer (AFFINITY®,

available from The Dow Chemical Company), Comparative H* is an elastomeric, substantially linear ethylene/ 1-octene copolymer (AFFINITY®EG8100, available from The Dow Chemical Company), Comparative I is a substantially linear ethylene/1-octene copolymer (AFFINITY®PL1840, available from The Dow Chemical Company),

5 Comparative J is a hydrogenated styrene/butadiene/styrene triblock copolymer (KRATON™ G1652, available from KRATON Polymers), Comparative K is a thermoplastic vulcanizate (TPV, a polyolefin blend containing dispersed therein a crosslinked elastomer). Results are presented in Table 4.

Table 4 High Temperature Mechanical Properties

Ex.	TMA-1mm penetration (°C)	Pellet Blocking Strength lb/ft ² (kPa)	G'(25°C)/ G'(100°C)	300 % Strain Recovery (80°C) (percent)	Compression Set (70°C) (percent)
D*	51	-	9	Failed	-
E*	130	-	18	-	-
F*	70	141 (6.8)	9	Failed	100
5	104	0 (0)	6	81	49
6	110	-	5	-	52
7	113	-	4	84	43
8	111	-	4	Failed	41
9	97	-	4	-	66
10	108	-	5	81	55
11	100	-	8	-	68
12	88	-	8	-	79
13	95	-	6	84	71
14	125	-	7	-	-
15	96	-	5	-	58
16	113	-	4	-	42
17	108	0 (0)	4	82	47
18	125	-	10	-	-
19	133	-	9	-	-
G*	75	463 (22.2)	89	Failed	100
H*	70	213 (10.2)	29	Failed	100
I*	111	-	11	-	-
J*	107	-	5	Failed	100
K*	152	-	3	-	40

[212] In Table 4, Comparative F (which is a physical blend of the two polymers

resulting from simultaneous polymerizations using catalyst A1 and B1) has a 1 mm penetration temperature of about 70°C, while Examples 5-9 have a 1 mm penetration temperature of 100°C or greater. Further, examples 10-19 all have a 1 mm penetration temperature of greater than 85°C, with most having 1 mm TMA temperature of greater than

90°C or even greater than 100°C. This shows that the novel polymers have better

dimensional stability at higher temperatures compared to a physical blend. Comparative J (a commercial SEBS) has a good 1 mm TMA temperature of about 107°C, but it has very poor (high temperature 70°C) compression set of about 100 percent and it also failed to recover (sample broke) during a high temperature (80°C) 300 percent strain recovery. Thus the exemplified polymers have a unique combination of properties unavailable even in some commercially available, high performance thermoplastic elastomers.

[213] Similarly, Table 4 shows a low (good) storage modulus ratio, $G'(25^{\circ}\text{C})/G'(100^{\circ}\text{C})$, for the inventive polymers of 6 or less, whereas a physical blend (Comparative F) has a storage modulus ratio of 9 and a random ethylene/octene copolymer (Comparative G) of similar density has a storage modulus ratio an order of magnitude greater (89). It is desirable that the storage modulus ratio of a polymer be as close to 1 as possible. Such polymers will be relatively unaffected by temperature, and fabricated articles made from such polymers can be usefully employed over a broad temperature range. This feature of low storage modulus ratio and temperature independence is particularly useful in elastomer applications such as in pressure sensitive adhesive formulations.

[214] The data in Table 4 also demonstrate that the polymers according to embodiments of the invention possess improved pellet blocking strength. In particular, Example 5 has a pellet blocking strength of 0 MPa, meaning it is free flowing under the conditions tested, compared to Comparatives F and G which show considerable blocking. Blocking strength is important since bulk shipment of polymers having large blocking strengths can result in product clumping or sticking together upon storage or shipping, resulting in poor handling properties.

[215] High temperature (70°C) compression set for the inventive polymers is generally good, meaning generally less than about 80 percent, preferably less than about 70 percent and especially less than about 60 percent. In contrast, Comparatives F, G, H and J all have a 70°C compression set of 100 percent (the maximum possible value, indicating no recovery). Good high temperature compression set (low numerical values) is especially needed for applications such as gaskets, window profiles, o-rings, and the like.

Table 5 Ambient Temperature Mechanical Properties

Ex.	Flex Modulus (MPa)	Tensile Modulus (MPa)	Tensile Strength (MPa) ¹	Elongation at Break ¹ (%)	Tensile Strength (MPa)	Elongation at Break (%)	Abrasion: Volume Loss (mm ³)	Tensile Notched Tear Strength (mJ)	100 % Strain Recovery 21°C (percent)	300 % Strain Recovery 21°C (percent)	Retractive Stress at 150 % Strain (kPa)	Compression Set 21°C (Percent)	Stress Relaxation at 50 % Strain ²
D*	12	5	-	-	10	1074	-	-	91	83	760	-	-
E*	895	589	-	-	31	1029	-	-	-	-	-	-	-
F*	57	46	-	-	12	824	93	339	78	65	400	42	-
5	30	24	14	951	16	1116	48	-	87	74	790	14	33
6	33	29	-	-	14	938	-	-	-	75	861	13	-
7	44	37	15	846	14	854	39	-	82	73	810	20	-
8	41	35	13	785	14	810	45	461	82	74	760	22	-
9	43	38	-	-	12	823	-	-	-	-	-	25	-
10	23	23	-	-	14	902	-	-	86	75	860	12	-
11	30	26	-	-	16	1090	-	976	89	66	510	14	30
12	20	17	12	961	13	931	-	1247	91	75	700	17	-
13	16	14	-	-	13	814	-	691	91	-	-	21	-
14	212	160	-	-	29	857	-	-	-	-	-	-	-
15	18	14	12	1127	10	1573	-	2074	89	83	770	14	-
16	23	20	-	-	12	968	-	-	88	83	1040	13	-
17	20	18	-	-	13	1252	-	1274	13	83	920	4	-
18	323	239	-	-	30	808	-	-	-	-	-	-	-
19	706	483	-	-	36	871	-	-	-	-	-	-	-
G*	15	15	-	-	17	1000	-	746	86	53	110	27	50
H*	16	15	-	-	15	829	-	569	87	60	380	23	-
I*	210	147	-	-	29	697	-	-	-	-	-	-	-
J*	-	-	-	-	32	609	-	-	93	96	1900	25	-
K*	-	-	-	-	-	-	-	-	-	-	-	30	-

¹. Tested at 51 cm/minute². measured at 38°C for 12 hours

[216] Table 5 shows results for mechanical properties for the new polymers as well as for various comparison polymers at ambient temperatures. It may be seen that the inventive polymers have very good abrasion resistance when tested according to ISO 4649, generally showing a volume loss of less than about 90 mm³, preferably less than about 80 mm³, and especially less than about 50 mm³. In this test, higher numbers indicate higher volume loss and consequently lower abrasion resistance.

[217] Tear strength as measured by tensile notched tear strength of the inventive polymers is generally 1000 mJ or higher, as shown in Table 5. Tear strength for the inventive polymers can be as high as 3000 mJ, or even as high as 5000 mJ. Comparative polymers generally have tear strengths no higher than 750 mJ.

[218] Table 5 also shows that the polymers according to embodiments of the invention have better retractive stress at 150 percent strain (demonstrated by higher retractive stress values) than some of the comparative samples. Comparative Examples F, G and H have retractive stress value at 150 percent strain of 400 kPa or less, while the inventive polymers have retractive stress values at 150 percent strain of 500 kPa (Ex. 11) to as high as about 1100 kPa (Ex. 17). Polymers having higher than 150 percent retractive stress values would be quite useful for elastic applications, such as elastic fibers and fabrics, especially nonwoven fabrics. Other applications include diaper, hygiene, and medical garment waistband applications, such as tabs and elastic bands.

[219] Table 5 also shows that stress relaxation (at 50 percent strain) is also improved (less) for the inventive polymers as compared to, for example, Comparative G. Lower stress relaxation means that the polymer retains its force better in applications such as diapers and other garments where retention of elastic properties over long time periods at body temperatures is desired.

Optical Testing

Table 6 Polymer Optical Properties

Ex.	Internal Haze (percent)	Clarity (percent)	45° Gloss (percent)
F*	84	22	49
G*	5	73	56
5	13	72	60
6	33	69	53
7	28	57	59
8	20	65	62
9	61	38	49
10	15	73	67
11	13	69	67
12	8	75	72
13	7	74	69
14	59	15	62
15	11	74	66
16	39	70	65
17	29	73	66
18	61	22	60
19	74	11	52
G*	5	73	56
H*	12	76	59
I*	20	75	59

[220] The optical properties reported in Table 6 are based on compression molded films substantially lacking in orientation. Optical properties of the polymers may be varied over wide ranges, due to variation in crystallite size, resulting from variation in the quantity of chain shuttling agent employed in the polymerization.

Extractions of Multi-Block Copolymers

[221] Extraction studies of the polymers of examples 5, 7 and Comparative E are conducted. In the experiments, the polymer sample is weighed into a glass fritted extraction thimble and fitted into a Kumagawa type extractor. The extractor with sample is purged with nitrogen, and a 500mL round bottom flask is charged with 350 mL of diethyl ether. The flask is then fitted to the extractor. The ether is heated while being stirred. Time is noted when the ether begins to condense into the thimble, and the extraction is allowed to proceed under nitrogen for 24 hours. At this time, heating is stopped and the solution is allowed to cool. Any ether remaining in the extractor is returned to the flask. The ether in the flask is evaporated under vacuum at ambient temperature, and the resulting solids are

purged dry with nitrogen. Any residue is transferred to a weighed bottle using successive washes of hexane. The combined hexane washes are then evaporated with another nitrogen purge, and the residue dried under vacuum overnight at 40°C. Any remaining ether in the extractor is purged dry with nitrogen.

- 5 [222] A second clean round bottom flask charged with 350 mL of hexane is then connected to the extractor. The hexane is heated to reflux with stirring and maintained at reflux for 24 hours after hexane is first noticed condensing into the thimble. Heating is then stopped and the flask is allowed to cool. Any hexane remaining in the extractor is transferred back to the flask. The hexane is removed by evaporation under vacuum at ambient temperature, and any residue remaining in the flask is transferred to a weighed bottle using successive hexane washes. The hexane in the flask is evaporated by a nitrogen purge, and the residue is vacuum dried overnight at 40°C.

[223] The polymer sample remaining in the thimble after the extractions is transferred from the thimble to a weighed bottle and vacuum dried overnight at 40°C.

- 15 Results are contained in Table 7.

Table 7

Sample	wt. (g)	ether soluble (g)	ether soluble (percent)	C ₈ mole percent ¹	hexane soluble (g)	hexane soluble (percent)	C ₈ mole percent ¹	residue C ₈ mole percent ¹
Comp. F*	1.097	0.063	5.69	12.2	0.245	22.35	13.6	6.5
Ex. 5	1.006	0.041	4.08	-	0.040	3.98	14.2	11.6
Ex. 7	1.092	0.017	1.59	13.3	0.012	1.10	11.7	9.9

¹. Determined by ¹³C NMR

Additional Polymer Examples 19 A-J, Continuous Solution Polymerization, Catalyst A1/B2 + DEZ

- 20 [224] **Examples 19A-I:** Continuous solution polymerizations are carried out in a computer controlled well-mixed reactor. Purified mixed alkanes solvent (Isopar™ E available from Exxon Mobil Chemical Company), ethylene, 1-octene, and hydrogen (where used) are combined and fed to a 27 gallon reactor. The feeds to the reactor are measured by mass-flow controllers. The temperature of the feed stream is controlled by use of a glycol

cooled heat exchanger before entering the reactor. The catalyst component solutions are metered using pumps and mass flow meters. The reactor is run liquid-full at approximately 550 psig pressure. Upon exiting the reactor, water and additive are injected in the polymer solution. The water hydrolyzes the catalysts, and terminates the polymerization reactions.

- 5 The post reactor solution is then heated in preparation for a two-stage devolatilization. The solvent and unreacted monomers are removed during the devolatilization process. The polymer melt is pumped to a die for underwater pellet cutting.

- [225] **Example 19J:** Continuous solution polymerizations are carried out in a computer controlled autoclave reactor equipped with an internal stirrer. Purified mixed
- 10 alkanes solvent (Isopar™ E available from ExxonMobil Chemical Company), ethylene at 2.70 lbs/hour (1.22 kg/hour), 1-octene, and hydrogen (where used) are supplied to a 3.8 L reactor equipped with a jacket for temperature control and an internal thermocouple. The solvent feed to the reactor is measured by a mass-flow controller. A variable speed
- 15 diaphragm pump controls the solvent flow rate and pressure to the reactor. At the discharge of the pump, a side stream is taken to provide flush flows for the catalyst and cocatalyst injection lines and the reactor agitator. These flows are measured by Micro-Motion mass flow meters and controlled by control valves or by the manual adjustment of needle valves. The remaining solvent is combined with 1-octene, ethylene, and hydrogen (where used) and fed to the reactor. A mass flow controller is used to deliver hydrogen to the reactor as
- 20 needed. The temperature of the solvent/monomer solution is controlled by use of a heat exchanger before entering the reactor. This stream enters the bottom of the reactor. The catalyst component solutions are metered using pumps and mass flow meters and are combined with the catalyst flush solvent and introduced into the bottom of the reactor. The reactor is run liquid-full at 500 psig (3.45 MPa) with vigorous stirring. Product is removed
- 25 through exit lines at the top of the reactor. All exit lines from the reactor are steam traced and insulated. Polymerization is stopped by the addition of a small amount of water into the exit line along with any stabilizers or other additives and passing the mixture through a static mixer. The product stream is then heated by passing through a heat exchanger before devolatilization. The polymer product is recovered by extrusion using a devolatilizing
- 30 extruder and water cooled pelletizer.

[226] Polymer Examples 20-23 were made using similar procedures as described in the above. Process details and results are contained in Tables 8A- C. Selected polymer properties are provided in Tables 9A-B. Table 9C shows the block indices for various polymers measured and calculated according the methodology described above. For
5 calculations performed herein, T_A is 372°K, P_A is 1.

Table 8A Polymerization Conditions for Polymers 19A-J

Ex.	C ₂ H ₄ lb/hr	C ₆ H ₁₆ lb/hr	Solv. lb/hr	H ₂ scm ¹	T °C	Cat Al ² Conc. ppm	Cat Al ¹ Flow lb/hr	Cat B2 ³ Conc. ppm	Cat B2 Flow lb/hr	DEZ Conc wt%	DEZ Flow lb/hr	Cocat 1 Conc. ppm	Cocat 1 Flow lb/hr	Cocat 2 Conc. ppm	Cocat 2 Flow lb/hr	[Zn] ⁴ in polymer ppm
19A	55.29	32.03	323.03	101	120	600	0.25	200	0.42	3.0	0.70	4500	0.65	525	0.33	248
19B	53.95	28.96	325.3	577	120	600	0.25	200	0.55	3.0	0.24	4500	0.63	525	0.11	90
19C	55.53	30.97	324.37	550	120	600	0.216	200	0.609	3.0	0.69	4500	0.61	525	0.33	246
19D	54.83	30.58	326.33	60	120	600	0.22	200	0.63	3.0	1.39	4500	0.66	525	0.66	491
19E	54.95	31.73	326.75	251	120	600	0.21	200	0.61	3.0	1.04	4500	0.64	525	0.49	368
19F	50.43	34.80	330.33	124	120	600	0.20	200	0.60	3.0	0.74	4500	0.52	525	0.35	257
19G	50.25	33.08	325.61	188	120	600	0.19	200	0.59	3.0	0.54	4500	0.51	525	0.16	194
19H	50.15	34.87	318.17	58	120	600	0.21	200	0.66	3.0	0.70	4500	0.52	525	0.70	259
19I	55.02	34.02	323.59	53	120	600	0.44	200	0.74	3.0	1.72	4500	0.70	525	1.65	600
19J	7.46	9.04	50.6	47	120	150	0.22	76.7	0.36	0.5	0.19	-	-	-	-	-

¹ standard cm³/min² [N-(2,6-di(1-methylethyl)phenyl)amido](2-isopropylphenyl)(α -naphthalen-2-yl)(6-pyridin-2-yl)methane][hafnium dimethyl³ bis-(1-(2-methylcyclohexyl)ethyl)(2-oxo-3,5-di(t-butyl)phenyl)imino) zirconium dimethyl⁴ ppm in final product calculated by mass balance

Table 8B Additional Polymerization Conditions for Polymers 19A-J

Ex.	Poly Rate ⁵ lb/hr	Conv ⁶ wt%	Polymer wt%	$[\text{C}_2\text{H}_4]/[\text{Zn}]^7$	$[\text{Zn}]/[\text{C}_2\text{H}_4]$ *1000 ⁸	Eff. ⁹
19A	83.94	88.0	17.28	775	1.29	297
19B	80.72	88.1	17.2	2222	0.45	295
19C	84.13	88.9	17.16	775	1.29	293
19D	82.56	88.1	17.07	395	2.53	280
19E	84.11	88.4	17.43	513	1.95	288
19F	85.31	87.5	17.09	725	1.38	319
19G	83.72	87.5	17.34	1000	1.0	333
19H	83.21	88.0	17.46	752	1.33	312
19I	86.63	88.0	17.6	317	3.15	275
19J	-	-	-	1786	0.56	-

⁵ polymer production rate⁶ weight percent ethylene conversion in reactor⁷ molar ratio in reactor; $\text{Zn}/\text{C}_2 * 1000 = (\text{Zn feed flow} * \text{Zn concentration} / 1000000) / (\text{Mw of Zn} / (\text{Total Ethylene feed flow} * (1 - \text{fractional ethylene conversion rate}) / \text{Mw of Ethylene})) * 1000$. Please note that "Zn" in "Zn/C₂*1000" refers to the amount of zinc in diethyl zinc ("DEZ") used in the polymerization process, and "C₂" refers to the amount of ethylene used in the polymerization process.⁸ molar ratio in reactor⁹ efficiency, lb polymer/lb M where lb M = lb Hf + lb Z

Table 8C Polymerization Conditions for Polymers 20-23.

	Co.* Type	Co.*	Solv.	H ₂			Cat Al ²	Cat Al ¹	Cat B ₂ ³	Cat B2	DEZ	DEZ	Cocat	Cocat	[C ₃ H ₄]/[Zn] ⁴	[Zn]/[C ₃ H ₄]*1000 ⁵	Poly		
Ex.		kg/hr	kg/hr	scm ¹	T	°C	ppm	kg/hr	ppm	kg/hr	ppm Zn	kg/hr	Conc.	Flow	kg/hr		Rate ⁶	Conv ⁷	Solids
20	Octene	1.6	11.4	104.8	119	119	71.7	0.059	46.4	0.055	1688	0.018	1743	0.118	9166	0.11	1.6	90	11.4
21	Butene	1.6	10.5	9.9	120	120	94.2	0.065	10.5	0.100	9222	0.068	1168	0.057	442	2.26	1.7	90.5	12.2
22	Butene	1.6	10.5	37.5	120	120	94.2	0.064	10.5	0.088	9222	0.018	1168	0.054	1851	0.54	1.6	90	11.9
23	Propylene	1.4	9.8	4.9	120	120	53.1	0.024	58.1	0.098	3030	0.151	429.4	0.139	1030	0.97	1.1	82.5	9.4
																			Eff. ⁸

* "Co." stands for "comonomer".

1. standard cm³/min

2. [N-(2,6-di(1-methylethyl)phenyl)amido](2-isopropylphenyl)(2-oxo-1,3,5-di(t-butyl)phenyl)imino) zirconium dimethyl

3. bis-(1-(2-methylcyclohexyl)ethyl)(2-oxo-1,3,5-di(t-butyl)phenyl)imino) zirconium dibenzyl

4. molar ratio in reactor; Zn/C₂ *1000 = (Zn feed flow*Zn concentration/1000000/Mw of Zn)/(Total Ethylene feed flow*(1-fractional ethylene conversion rate)/Mw of Ethylene)*1000. Please note that "Zn" in "Zn/C₂*1000" refers to the amount of zinc in diethyl zinc ("DEZ") used in the polymerization process, and "C₂" refers to the amount of ethylene used in the polymerization process.

5. molar ratio in reactor

6. polymer production rate

7. percent ethylene conversion in reactor

8. efficiency, kg polymer/g M where g M = g Hf + g Zr

Table 9A Polymer Physical Properties

Ex.	Density (g/cc)	I ₂	I ₁₀	I ₁₀ /I ₂	Mw (g/mol)	Mn (g/mol)	Mw/Mn	Heat of Fusion (J/g)	T _m (°C)	T _c (°C)	TCRYSTAF (°C)	T _m -TCRYSTAF (°C)	CRYSTAF Peak Area (wt%)
19A	0.8781	0.9	6.4	6.9	123700	61000	2.0	56	119	97	46	73	40
19B	0.8749	0.9	7.3	7.8	133000	44300	3.0	52	122	100	30	92	76
19C	0.8753	5.6	38.5	6.9	81700	37300	2.2	46	122	100	30	92	8
19D	0.8770	4.7	31.5	6.7	80700	39700	2.0	52	119	97	48	72	5
19E	0.8750	4.9	33.5	6.8	81800	41700	2.0	49	121	97	36	84	12
19F	0.8652	1.1	7.5	6.8	124900	60700	2.1	27	119	88	30	89	89
19G	0.8649	0.9	6.4	7.1	135000	64800	2.1	26	120	92	30	90	90
19H	0.8654	1.0	7.0	7.1	131600	66900	2.0	26	118	88	-	-	-
19I	0.8774	11.2	75.2	6.7	66400	33700	2.0	49	119	99	40	79	13
19J	0.8995	5.6	39.4	7.0	75500	29900	2.5	101	122	106	-	-	-

Table 9B Polymer Physical Properties of Compression Molded Films

Example	Density (g/cm ³)	Melt Index (g/10 min)	Immediate Set after 100% Strain (%)	Immediate Set after 300% Strain (%)	Immediate Set after 500% Strain (%)	Recovery after 100% (%)	Recovery after 300% (%)	Recovery after 500% (%)
19A	0.878	0.9	15	63	131	85	79	74
19B	0.877	0.88	14	49	97	86	84	81
19F	0.865	1	-	-	70	-	87	86
19G	0.865	0.9	-	-	66	-	-	87
19H	0.865	0.92	-	39	-	-	87	-

Table 9C. Block Index for Selected Polymers

Example	Comonomer	Density (g/cc)	I ₂ g/10 min.	Zn/C ₂ H ₄ *1000	Average Block Index ("BI")	
					Average Weight Average BI	Second Moment About the Mean Weight Average BI
F*	Octene	0.8895	0.9	0	0	0
L*	Octene	0.905	0.8	-	0	0.01
M*	Octene	0.902	1.0	-	0	0
20	Octene	0.8841	1.0	0.11	0.2	0.45
8	Octene	0.8828	0.9	0.56	0.59	0.32
19A	Octene	0.8781	0.9	1.3	0.62	0.17
5	Octene	0.8786	1.5	2.4	0.53	0.136
19B	Octene	0.8749	0.9	0.45	0.54	0.35
19I	Octene	0.8774	11.2	3.15	0.59	0.22
21	Butene	0.8795	0.9	1.89	0.65	0.22
22	Butene	0.8802	1.1	1.71	0.66	0.33
23	Propylene	0.883	1.2	0.97	0.61	0.24

1) L* is a ultra low density polyethylene made by Ziegler-Natta catalysis and available from The Dow Chemical Company under the trademark of ATTANE™ 4203.

2) M* is a polyethylene copolymer made by constrained geometry catalysis (i.e., single-site catalyst) and available from The Dow Chemical Company under the trademark of AFFINITY® PL1880G.

[227] As shown in Table 9C, all the inventive polymers have a weight average block index of greater than zero, whereas the random copolymers (Polymers F*, L*, and M*) all have a block index of zero or substantially zero (such as 0.01).

[1] Figure 10 shows the block index distribution for Polymer F*, Polymer 20, Polymer 8, and Polymer 5 as a function of the ATREF temperature. For Polymer F*, the block index for all the ATREF fraction is zero or substantially zero (i.e., ≤ 0.01). Polymer 20 was made with a relatively low level of the shuttling agent, diethyl zinc ("DEZ"). While the weight average block index for the whole polymer is about 0.2, the polymer includes four fractions with a block index from about 0.7 to about 0.9. For Polymers 5 and 8, their weight average block indices are not drastically different (0.52 vs. 0.59), considering the DEZ level is about a four-fold difference. Moreover, most of their fractions have a block index of about 0.6 or higher. Similar results are seen between Polymer 5 and Polymer 19B, which is illustrated in Figure 11. However, there are some notable differences in the block index for the fractions which elute from about 70 °C to about 90 °C. Polymer 19B was made with a higher level (about four fold higher) of DEZ than Polymer 5. However, Polymer 5 has more fractions that have higher block indices. This seems to suggest that there might be an optimal DEZ level for making fractions with higher block indices (i.e., greater than about 0.6).

[229] The effect of the DEZ concentration level on the average block index for some of the polymers in Table 9C is illustrated in Figure 12. The plots seem to suggest that the average block index increases with increasing DEZ initially. Once $\text{Zn/C}_2\text{H}_4 \cdot 1000$ exceeds about 0.5, the average block index appears to level off and may even drop off if too much DEZ is used.

Figure 13 is a plot of the square root of the second moment about the mean weight average block index as a function of $[\text{Zn/C}_2\text{H}_4] \cdot 1000$. It appears to decrease as DEZ increases. This would indicate that the distribution of the block indices of the fractions are becoming narrower (i.e., more homogeneous).

TREF and NMR Data

Tables 10-14 list TREF, DSC, IR, and NMR data for Polymers 5, 8, 14, and 19 and various comparative polymers.

Table 10 – TREF Fractions from Ziegler-Natta LLDPE

Ex. L * - Ziegler-Natta Example (Attane™ 4203, 0.90 g/cm³, 0.8 I₂)

Fractionation Temperature	ATREF T (°C)	Mol % Octene (NMR)	Tm (°C)	DeltaH melt (J/g)
35-40	49	8.0	82	84
40-45	56.5	7.0	86	97
45-50	57.5	6.6	89	101
50-55	61	6.0	92	96
55-60	63.5	5.4	95	99
60-65	67.5	4.9	98	104
65-70	72	4.3	101	112
70-75	75.5	3.7	104	112
75-80	79	3.1	107	122
80-85	83.5	2.5	112	131
85-90	90	1.7	116	154
90-95	95.5	1.1	123	160
95-100	100	0.5	128	185
100-105	101	0.2	130	195

Table 11 – TREF Fractions from Random Copolymer

Ex. M* - Random Copolymer Example (AFFINITY® PL1880, 0.90 g/cm³, 1 I₂)

Fractionation Temperature	ATREF T (°C)	Mol % Octene (NMR)	Tm (°C)	DeltaH melt (J/g)
35-40	51.5	NM	83	102
40-45	56	7.3	87	96
45-50	61.5	6.5	90	101
50-55	63.5	5.7	93	100
55-60	66.5	5.3	95	104
60-65	69.5	4.9	97	105
65-70	72	4.4	99	111
70-75	74	4.2	101	111
75-80	76.5	3.8	106	112

Table 12 – TREF Fractions from Inventive Example 5

Inventive Example 5

Fractionation Temperature	ATREF T (°C)	Mol % Octene (NMR)	T _m (°C)	DeltaH melt (J/g)
60-65	70.5	12.6	106	45
65-70	73	12.2	108	48
70-75	77	11.7	111	51
75-80	81	10.5	113	57
80-85	84	9.8	115	68
85-90	88.5	7.0	119	83
90-95	92	5.2	123	110

Table 13 – TREF Fractions from Inventive Example 8

Inventive Example 8

Fractionation Temperature	ATREF T (°C)	Mol % Octene (NMR)	T _m (°C)	DeltaH melt (J/g)
50-55	20	16.5	98	28
55-60	57.5	16.2	104	29
60-65	61.5	16.5	106	28
65-70	65.5	16.2	109	29
70-75	70.5	15.7	112	31
75-80	73	15.5	114	32
80-85	81.5	11.6	117	37
85-90	89.5	10.7	120	58
90-95	96	4.6	126	125
95-100	96.5	1.5	129	180

Table 14 – ATREF Peak comonomer composition for random copolymers and examples 5,8,14,19

Example	Density (g/cc)	I ₂	Mol % Octene (NMR)	T _{ATREF} (°C)	Mol % Octene TREF Peak (Infra-red)	Infra-red FWHM CH ₂ Area	Infra-red FWHM CH ₃ Area	Infra-red FWHM CH ₃ /CH ₂ Area Ratio
N*	0.96	1.0	0	102	0.0	37.5	28.2	0.753
O*	0.9371	2.0	0.69	95	1.2	29.0	22.2	0.765
M*	0.9112	1.0	3.88	79	4.0	77.5	61.0	0.786
P*	0.9026	1.1	5.57	70	5.1	74.3	59.0	0.794
Q*	0.8872	0.9	9.06	57	9.2	30.9	25.5	0.824
Ex. 5	0.8786	1.5	NA	82	11.4	77.5	61.0	0.841

Example	Density (g/cc)	I ₂	Mol % Octene (NMR)	T _{ATREF} (°C)	Mol % Octene TREF Peak (Infra-red)	Infra-red FWHM CH ₂ Area	Infra-red FWHM CH ₃ Area	Infra-red FWHM CH ₃ /CH ₂ Area Ratio
Ex. 8	0.8828	0.9	NA	90	12.2	34.0	28.8	0.846
Ex. 14	0.9116	2.6	NA	92	6.5	23.4	18.8	0.805
Ex. 19	0.9344	3.4	NA	97	2.8	25.3	19.7	0.777

Infra-red detector calibration: Mol % Octene = 133.38 (FWHM CH₃/CH₂ Area) – 100.8

N* is an ethylene homopolymer.

O* is an ethylene/octene copolymer available from The Dow Chemical Company under AFFINITY®

5 HF1030.

P* is an ethylene/octene copolymer available from The Dow Chemical Company under AFFINITY®

PL1880.

Q* is an ethylene/octene copolymer available from The Dow Chemical Company under AFFINITY®

10 VP8770.

Calculation of Block Index

[230] With reference to Figures 8-9, the calculation of block indices is exemplified for Polymer 5. In the calculations, the following calibration equation is used:

$$\ln P = -237.8341/T_{ATREF} + 0.6390$$

15 [231] where P is the ethylene mole fraction, and T_{ATREF} is the ATREF elution temperature. In addition, the following parameters are used:

Parameter	Value	Explanation
T _A	372.15	Analytical TREF elution temperature (°K) of hard segment
P _A	1.000	Mole fraction of ethylene of hard segment
P _{AB}	0.892	Mole fraction of ethylene of whole polymer
T _{AB}	315.722	Calculated equivalent analytical TREF elution temperature (°K) of whole polymer from whole polymer ethylene content

[232] Table 15 gives details of the calculations for Polymer 5. The weighted average block index, ABI, for Polymer 5, is 0.531, and the square root of sum of weighted squared deviations about the weighted mean is 0.136. The partial sum of weights with fraction BI greater than zero (see note 2 below) is 0.835.

TABLE 15 Fractional Block Index (BI) Calculations

Fraction #	Weight Recovered (g)	ATREF Elution Temperature (°K)	Mole Fraction Ethylene (NMR)	Weight Fraction Recovered	Random Equivalent ATREF Temperature from NMR Ethylene Weight Fraction (°K)	Random Equivalent mole fraction ethylene from ATREF Temperature	Fractional Block Index based on Temperature formula	Fractional Block Index based on Log _e of mole fraction formula	Weighted Fractional Block Indices	Weighted Squared Deviations about the Weighted Mean (Note 2)
Array Variable Name->										
1	3.0402	(Note 1)	0.859	0.165	T_{X0} (Note 1)	P_{X0} (Note 1)	BI_i	BI_i	$w_i * BI_i$	$w_i * (BI_i - ABI) / ABI$ (Note 1)
2	1.9435	340	0.873	0.106	307	0.941	0.659	0.659	0.070	0.0017
3	0.7455	343.5	0.883	0.041	312	0.948	0.622	0.622	0.025	0.0003
4	1.0018	346	0.882	0.054	311	0.953	0.676	0.676	0.037	0.0011
5	2.3641	350	0.896	0.128	318	0.960	0.607	0.607	0.078	0.0007
6	4.1382	354	0.895	0.225	317	0.968	0.684	0.684	0.154	0.0052
7	3.5981	357	0.902	0.195	320	0.973	0.665	0.665	0.130	0.0035
8	1.2280	361.5	0.930	0.067	334	0.981	0.470	0.470	0.031	0.0003
9	0.3639	365	0.948	0.020	343	0.987	0.357	0.357	0.007	0.0006
Total Weight							Weighted Sums		ABI	0.0135
18.4233							Normalization check		0.531	
							1.000			

Note 1 : Fraction #1 does not crystallize in the analytical ATREF and is assigned $BI_i = 0$ Note 2 : The weighted squared deviations about the weighted mean use only $BI_i > 0$

Measurement of Weight Percent of Hard and Soft Segments

[233] As discussed above, the block interpolymers comprise hard segments and soft segments. The soft segments can be present in a block interpolpolymer from about 1 weight percent to about 99 weight percent of the total weight of the block interpolpolymer, preferably from about 5 weight percent to about 95 weight percent, from about 10 weight percent to about 90 weight percent, from about 15 weight percent to about 85 weight percent, from about 20 weight percent to about 80 weight percent, from about 25 weight percent to about 75 weight percent, from about 30 weight percent to about 70 weight percent, from about 35 weight percent to about 65 weight percent, from about 40 weight percent to about 60 weight percent, or from about 45 weight percent to about 55 weight percent. Conversely, the hard segments can be present in a similar range as above. The soft segment weight percentage (and thus the hard segment weight percentage) can be measured by DSC or NMR.

Hard Segment Weight fraction Measured by DSC

[234] For a block polymer having hard segments and soft segments, the density of the overall block polymer, ρ_{overall} , satisfies the following relationship:

$$\frac{1}{\rho_{\text{overall}}} = \frac{x_{\text{hard}}}{\rho_{\text{hard}}} + \frac{x_{\text{soft}}}{\rho_{\text{soft}}}$$

[235] where ρ_{hard} , and ρ_{soft} , are the theoretical density of the hard segments and soft segments, respectively. χ_{hard} , and χ_{soft} , are the weight fraction of the hard segments and soft segments, respectively and they add up to one. Assuming ρ_{hard} is equal to the density of ethylene homopolymer, i.e., 0.96 g/cc, and transposing the above equation, one obtains the following equation for the weight fraction of hard segments:

$$x_h = \frac{\frac{1}{\rho_{\text{Overall}}} - \frac{1}{\rho_{\text{Soft}}}}{-\frac{1}{\rho_{\text{Overall}}} + \frac{1}{0.96 \text{ g/cc}}}$$

[236] In the above equation, ρ_{overall} can be measured from the block polymer. Therefore, if ρ_{soft} is known, the hard segment weight fraction can be calculated accordingly.

Generally, the soft segment density has a linear relationship with the soft segment melting temperature, which can be measured by DSC over a certain range:

$$\rho_{\text{soft}} = A * T_m + B$$

[237] where A and B are constants, and T_m is the soft segment melting temperature in degrees Celsius. A and B can be determined by running DSC on various copolymers with a known density to obtain a calibration curve. It is preferable to create a soft segment calibration curve that span the range of composition (both comonomer type and content) present in the block copolymer. In some embodiments, the calibration curve satisfies the following relationship:

$$\rho_{\text{soft}} = 0.00049 * T_m + 0.84990$$

[238] Therefore, the above equation can be used to calculate the soft segment density if T_m in degrees Celsius is known.

[239] For some block copolymers, there is an identifiable peak in DSC that is associated with the melting of the soft segments. In this case, it is relatively straightforward to determine T_m for the soft segments. Once T_m in degrees Celsius is determined from DSC, the soft segment density can be calculated and thus the hard segment weight fraction.

[240] For other block copolymers, the peak associated with the melting of the soft segments is either a small hump (or bump) over the baseline or sometimes not visible as illustrated in Figure 14. This difficulty can be overcome by converting a normal DSC profile into a weighted DSC profile as shown in Figure 15. The following method is used to convert a normal DSC profile to a weighted DSC profile.

[241] In DSC, the heat flow depends on the amount of the material melting at a certain temperature as well as on the temperature-dependent specific heat capacity. The temperature-dependence of the specific heat capacity in the melting regime of linear low density polyethylene leads to an increase in the heat of fusion with decreasing comonomer content. That is, the heat of fusion values get progressively lower as the crystallinity is reduced with increasing comonomer content. See Wild, L. Chang, S.; Shankernarayanan, MJ. Improved method for compositional

analysis of polyolefins by DSC. Polym. Prep 1990; 31: 270-1, which is incorporated by reference herein in its entirety.

[242] For a given point in the DSC curve (defined by its heat flow in watts per gram and temperature in degrees Celsius), by taking the ratio of the heat of fusion expected for a linear copolymer to the temperature-dependent heat of fusion ($\Delta H(T)$), the DSC curve can be converted into a weight-dependent distribution curve.

[243] The temperature-dependent heat of fusion curve can be calculated from the summation of the integrated heat flow between two consecutive data points and then represented overall by the cumulative enthalpy curve.

[244] The expected relationship between the heat of fusion for linear ethylene/octene copolymers at a given temperature is shown by the heat of fusion versus melting temperature curve. Using random ethylene/octene copolymers, one can obtain the following relationship:

$$\text{Melt Enthalpy (J/g)} = 0.0072 \cdot T_m^2 (\text{°C}) + 0.3138 \cdot T_m (\text{°C}) + 8.9767$$

[245] For each integrated data point, at a given temperature, by taking a ratio of the enthalpy from the cumulative enthalpy curve to the expected heat of fusion for linear copolymers at that temperature, fractional weights can be assigned to each point of the DSC curve.

[246] It should be noted that, in the above method, the weighted DSC is calculated in the range from 0 °C until the end of melting. The method is applicable to ethylene/octene copolymers but can be adapted to other polymers.

[247] Applying the above methodology to various polymers, the weight percentage of the hard segments and soft segments were calculated, which are listed in Table 16. It should be noted that sometimes it is desirable to assign 0.94 g/cc to the theoretical hard segment density, instead of using the density for homopolyethylene, due to the fact that the hard segments may include a small amount of comonomers.

Table 16 Calculated Weight Percentage of Hard and Soft Segments for Various Polymers

Polymer Example No.	Overall Density	Soft Segment T _m (°C) from weighted DSC	Calculated Soft Segment Density	Calculated wt% Hard Segment	Calculated wt% Soft Segment
F*	0.8895	20.3	0.860	32%	68%
5	0.8786	13.8	0.857	23%	77%
6	0.8785	13.5	0.857	23%	77%
7	0.8825	16.5	0.858	26%	74%
8	0.8828	17.3	0.858	26%	74%
9	0.8836	17.0	0.858	27%	73%
10	0.878	15.0	0.857	22%	78%
11	0.882	16.5	0.858	25%	75%
12	0.870	19.5	0.859	12%	88%
13	0.872	23.0	0.861	12%	88%
14	0.912	21.8	0.861	54%	46%
15	0.8719	0.5	0.850	22%	78%
16	0.8758	0.3	0.850	26%	74%
18	0.9192	-	-	-	-
19	0.9344	38.0	0.869	74%	26%
17	0.8757	2.8	0.851	25%	75%
19A	0.8777	11.5	0.856	23%	77%
19B	0.8772	14.3	0.857	22%	78%
19J	0.8995	4.8	0.852	47%	53%

Hard Segment Weight Percentage Measured by NMR

[248] ¹³C NMR spectroscopy is one of a number of techniques known in the art for measuring comonomer incorporation into a polymer. An example of this technique is described for the determination of comonomer content for ethylene/ α -olefin copolymers in Randall (Journal of Macromolecular Science, Reviews in Macromolecular Chemistry and Physics, C29 (2 & 3), 201 - 317 (1989)), which is incorporated by reference herein in its entirety. The basic procedure for determining the comonomer content of an ethylene/olefin interpolymer involves obtaining a ¹³C NMR spectrum under conditions where the intensity of the peaks corresponding to the different carbons in a sample is directly proportional to the total number of contributing nuclei in the sample. Methods for ensuring this proportionality are known in the art and involve allowance for sufficient time for relaxation after a pulse, the use of gated-decoupling techniques, relaxation agents, and the like. The relative intensity of a peak or group of peaks is obtained in

practice from its computer-generated integral. After obtaining the spectrum and integrating the peaks, those peaks associated with the comonomer are assigned. This assignment can be made by reference to known spectra or literature, or by synthesis and analysis of model compounds, or by the use of isotopically labeled comonomers. The mole % comonomer can be determined by the ratio of the integrals corresponding to the number of moles of comonomer to the integrals corresponding to the number of moles of all of the monomers in the interpolymer, as described in the aforementioned Randall reference.

[249] Since the hard segment generally has less than about 2.0 wt% comonomer, its major contribution to the spectrum is only for the integral at about 30 ppm. The hard segment contribution to the peaks not at 30 ppm is assumed negligible at the start of the analysis. So for the starting point, the integrals of the peaks not at 30 ppm are assumed to come from the soft segment only. These integrals are fit to a first order Markovian statistical model for copolymers using a linear least squares minimization, thus generating fitting parameters (i.e., probability of octene insertion after octene, P_{oo} , and probability of octene insertion after ethylene, P_{eo}) that are used to compute the soft segment contribution to the 30 ppm peak. The difference between the total measured 30 ppm peak integral and the computed soft segment integral contribution to the 30 ppm peak is the contribution from the hard segment. Therefore, the experimental spectrum has now been deconvoluted into two integral lists describing the soft segment and hard segment, respectively. The calculation of weight percentage of the hard segment is straight forward and calculated by the ratio of the sum of integrals for the hard segment spectrum to the sum of integrals for the overall spectrum.

[250] From the deconvoluted soft segment integral list, the comonomer composition can be calculated according to the method of Randall, for example. From the comonomer composition of the overall spectrum and the comonomer composition of the soft segment, one can use mass balance to compute the comonomer composition of the hard segment. From the comonomer composition of the hard segment, Bernoullian statistics is used to calculate the contribution of the hard segment to the integrals of non 30 ppm peaks. There is usually so little octene, typically from about 0 to about 1 mol%, in the hard segment that Bernoullian statistics is a valid and robust approximation. These contributions are then subtracted out from the experimental integrals of the non 30 ppm peaks. The resulting non 30 ppm peak integrals are

then fitted to a first order Markovian statistics model for copolymers as described in the above paragraph. The iterative process is performed in the following manner: fit total non 30 ppm peaks then compute soft segment contribution to 30 ppm peak; then compute soft/hard segment split and then compute hard segment contribution to non 30ppm peaks; then correct for hard
 5 segment contribution to non 30 ppm peaks and fit resulting non 30 ppm peaks. This is repeated until the values for soft/hard segment split converge to a minimum error function. The final comonomer compositions for each segment are reported.

[251] Validation of the measurement is accomplished through the analysis of several *in situ* polymer blends. By design of the polymerization and catalyst concentrations the expected
 10 split is compared to the measured NMR split values. The soft/hard catalyst concentration is prescribed to be 74 % / 26 %. The measured value of the soft / hard segment split is 78 % / 22 %. Table 17 shows the chemical shift assignments for ethylene octene polymers.

Table 17 Chemical Shift Assignments for Ethylene/Octene Copolymers.

41-40.6 ppm	OOOE/EOOO $\alpha\alpha$ CH ₂
40.5-40.0 ppm	EOOE $\alpha\alpha$ CH ₂
38.9-37.9 ppm	EOE CH
36.2 – 35.7 ppm	OOE center CH
35.6 – 34.7 ppm	OEO $\alpha\gamma$, OOO center 6B, OOEE $\alpha\delta+$, OOE center 6B CH ₂
34.7 – 34.1 ppm	EOE $\alpha\delta+$, EOE 6B CH ₂
33.9 – 33.5 ppm	OOO center CH
32.5 – 32.1 ppm	3B CH ₂
31.5 – 30.8 ppm	OEEO $\gamma\gamma$ CH ₂
30.8 – 30.3 ppm	OE $\gamma\delta+$ CH ₂
30.3 – 29.0 ppm	4B, EEE $\delta+\delta+$ CH ₂
28.0 – 26.5 ppm	OE $\beta\delta+$ 5B
25.1 – 23.9 ppm	OEO $\beta\beta$
23.0 – 22.6 ppm	2B
14.5 – 14.0 ppm	1B

15 [252] The following experimental procedures are used. A sample is prepared by adding 0.25 g in a 10 mm NMR tube with 2.5 mL of stock solvent. The stock solvent is made by dissolving 1 g perdeuterated 1,4-dichlorobenzene in 30 mL ortho-dichlorobenzene with 0.025 M chromium acetylacetonate (relaxation agent). The headspace of the tube is purged of oxygen by

displacement with pure nitrogen. The sample tube is then heated in a heating block set at 150 °C. The sample tube is repeatedly vortexed and heated until the solution flows consistently from top of the solution column to the bottom. The sample tube is then left in the heat block for at least 24 hours to achieve optimum sample homogeneity.

5 [253] The ^{13}C NMR data is collected using a Varian Inova Unity 400 MHz system with probe temperature set at 125 °C. The center of the excitation bandwidth is set at 32.5 ppm with spectrum width set at 250 ppm. Acquisition parameters are optimized for quantitation including 90° pulse, inverse gated ^1H decoupling, 1.3 second acquisition time, 6 seconds delay time, and 8192 scans for data averaging. The magnetic field is carefully shimmed to generate a line shape
10 of less than 1 Hz at full width half maximum for the solvent peaks prior to data acquisition. The raw data file is processed using NUTS processing software (available from Acorn NMR, Inc. in Livermore, CA) and a list of integrals is generated.

 [254] Inventive Polymer 19A is analyzed for the soft/hard segment split and soft/hard comonomer composition. The following is the list of integrals for this polymer. The NMR
15 spectrum for Polymer 19A is shown in Figure 16.

	Integral limit	Integral value
	41.0 – 40.6 ppm	1.067
	40.5 – 40.0 ppm	6.247
	38.9 – 37.9 ppm	82.343
20	36.2 – 35.7 ppm	14.775
	35.6 – 34.7 ppm	65.563
	34.7 – 34.1 ppm	215.518
	33.9 – 33.5 ppm	0.807
	32.5 – 32.1 ppm	99.612
25	31.5 – 30.8 ppm	14.691
	30.8 – 30.3 ppm	115.246
	30.3 – 29.0 ppm	1177.893
	28.0 – 26.5 ppm	258.294
	25.1 – 23.9 ppm	19.707
30	23.0 – 22.6 ppm	100
	14.5 – 14.0 ppm	99.895

 [255] Using Randall's triad method, the total octene weight percentage in this sample is determined to be 34.6%. Using all the above integrals excluding the 30.3-29.0 ppm integral to
35 fit a first order Markovian statistical model, the values for P_{oo} and P_{eo} are determined to be

0.08389 and 0.2051, respectively. Using these two parameters, the calculated integral contribution from the soft segment to the 30 ppm peak is 602.586. Subtraction of 602.586 from the observed total integral for the 30 ppm peak, 1177.893, yields the contribution of the hard segment to the 30 ppm peak of 576.307. Using 576.307 as the integral for the hard segment, the weight percentage of hard segment is determined to be 26 %. Therefore the soft segment weight percentage is $100 - 26 = 74$ %. Using the above values for P_{oo} and P_{eo} , the octene weight percentage of the soft segment is determined to be 47 %. Using the overall octene weight percentage and the octene weight percentage of the soft segment as well as the soft segment weight percentage, the octene weight percentage in the hard segment is calculated to be negative 2 wt%. This value is within the error of the measurement. Thus there is no need to iterate back to account for hard segment contribution to non 30 ppm peaks. Table 18 summarizes the calculation results for Polymers 19A, B, F and G.

Table 18. Hard and Soft Segments Data for Polymers 19A, B, F and G

Example	wt% Soft Segment	wt% Hard Segment	wt% octene in Soft Segment
19A	74	26	47
19B	74	26	48
19F	86	14	49
19G	84	16	49

[256] As demonstrated above, embodiments of the invention provide a new class of ethylene and α -olefin block interpolymers. The block interpolymers are characterized by an average block index of greater than zero, preferably greater than 0.2. Due to the block structures, the block interpolymers have a unique combination of properties or characteristics not seen for other ethylene/ α -olefin copolymers. Moreover, the block interpolymers comprise various fractions with different block indices. The distribution of such block indices has an impact on the overall physical properties of the block interpolymers. It is possible to change the distribution of the block indices by adjusting the polymerization conditions, thereby affording the abilities to tailor the desired polymers. Such block interpolymers have many end-use applications. For example, the block interpolymers can be used to make polymer blends, fibers,

films, molded articles, lubricants, base oils, etc. Other advantages and characteristics are apparent to those skilled in the art.

[257] While the invention has been described with respect to a limited number of embodiments, the specific features of one embodiment should not be attributed to other
5 embodiments of the invention. No single embodiment is representative of all aspects of the invention. In some embodiments, the compositions or methods may include numerous compounds or steps not mentioned herein. In other embodiments, the compositions or methods do not include, or are substantially free of, any compounds or steps not enumerated herein. Variations and modifications from the described embodiments exist. The method of making the
10 resins is described as comprising a number of acts or steps. These steps or acts may be practiced in any sequence or order unless otherwise indicated. Finally, any number disclosed herein should be construed to mean approximate, regardless of whether the word "about" or "approximately" is used in describing the number. The appended claims intend to cover all those modifications and variations as falling within the scope of the invention.

What is claimed is:

1. An ethylene/ α -olefin interpolymer comprising polymerized units of ethylene and α -olefin, wherein the interpolymer is characterized by an average block index greater than zero and up to about 1.0 and a molecular weight distribution, M_w/M_n , greater than about 1.3.
- 5 2. An ethylene/ α -olefin interpolymer comprising polymerized units of ethylene and α -olefin, wherein the average block index is greater than 0 but less than about 0.4 and a molecular weight distribution, M_w/M_n , greater than about 1.3.
3. The ethylene/ α -olefin interpolymer of claim 1 or 2, wherein the average block index is in the range from about 0.1 to about 0.3.
- 10 4. The ethylene/ α -olefin interpolymer of claim 1, wherein the average block index is in the range from about 0.4 to about 1.0.
5. The ethylene/ α -olefin interpolymer of claim 1, wherein the average block index is in the range from about 0.3 to about 0.7.
6. The ethylene/ α -olefin interpolymer of claim 1, wherein the average block index is in the
15 range from about 0.6 to about 0.9.
7. The ethylene/ α -olefin interpolymer of claim 1, wherein the average block index is in the range from about 0.5 to about 0.7.
8. The ethylene/ α -olefin interpolymer of claim 1 or 2, wherein the interpolymer has a density of less than about 0.91 g/cc.
- 20 9. The ethylene/ α -olefin interpolymer of claim 1 or 2, wherein the interpolymer has a density in the range from about 0.86 g/cc to about 0.91 g/cc.
10. The ethylene/ α -olefin interpolymer of claim 1 or 2, wherein the α -olefin is styrene, propylene, 1-butene, 1-hexene, 1-octene, 4-methyl-1-pentene, norbornene, 1-decene, 1,5-hexadiene, or a combination thereof.
- 25 11. The ethylene/ α -olefin interpolymer of claim 1 or 2, wherein the α -olefin is 1-butene.

12. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the α -olefin is 1-octene.
13. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the M_w/M_n is greater than about 1.5.
14. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the M_w/M_n is greater than about 2.0.
15. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the M_w/M_n is from about 2.0 to about 8
16. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the M_w/M_n is from about 1.7 to about 3.5
17. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the ethylene/ α -olefin interpolymers are characterized by at least one melting point, T_m , in degrees Celsius, and a density, d , in grams/cubic centimeter, wherein the numerical values of T_m and d correspond to the relationship:

$$T_m > -2002.9 + 4538.5(d) - 2422.2(d)^2$$

18. The ethylene/ α -olefin interpolymers of claim 1 or 2, wherein the ethylene/ α -olefin interpolymers are characterized by an elastic recovery, Re , in percent at 300 percent strain and 1 cycle measured with a compression-molded film of the ethylene/ α -olefin interpolymers, and a density, d , in grams/cubic centimeter, wherein the numerical values of Re and d satisfy the following relationship when ethylene/ α -olefin interpolymers are substantially free of a cross-linked phase:

$$Re > 1481 - 1629(d)$$

19. An ethylene/ α -olefin interpolymers comprising polymerized units of ethylene and α -olefin, the interpolymers characterized by having at least one fraction obtained by Temperature Rising Elution Fractionation ("TREF"), wherein the fraction has a block index greater than about 0.3 and up to about 1.0 and the ethylene/ α -olefin interpolymers has a molecular weight distribution, M_w/M_n , greater than about 1.3.

20. An ethylene/ α -olefin interpolymers comprising polymerized units of ethylene and α -olefin, the interpolymers characterized by having at least one fraction obtained by TREF, wherein the fraction has a block index greater than about 0 and up to about 0.4 and the ethylene/ α -olefin interpolymers has a molecular weight distribution, M_w/M_n , greater than about 1.3.
- 5 21. The ethylene/ α -olefin interpolymers of claim 19 or 20, wherein the block index of the fraction is greater than about 0.4.
22. The ethylene/ α -olefin interpolymers of claim 19 or 20, wherein the block index of the fraction is greater than about 0.5.
- 10 23. The ethylene/ α -olefin interpolymers of claim 19 or 20, wherein the block index of the fraction is greater than about 0.6.
24. The ethylene/ α -olefin interpolymers of claim 19 or 20, wherein the block index of the fraction is greater than about 0.7.
25. The ethylene/ α -olefin interpolymers of claim 19 or 20, wherein the block index of the fraction is greater than about 0.8.
- 15 26. The ethylene/ α -olefin interpolymers of claim 19 or 20, wherein the block index of the fraction is greater than about 0.9.
27. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the ethylene content is greater than 50 mole percent.
- 20 28. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the interpolymers comprises one or more hard segments and one or more soft segments.
29. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the hard segments are present in an amount from about 5% to about 85% by weight of the interpolymers.
30. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the hard segments comprise at least 98% of ethylene by weight.

31. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the soft segments comprise less than 90% of ethylene by weight.
32. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the soft segments comprise less than 50% of ethylene by weight.
- 5 33. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the interpolymers comprises at least 10 hard and soft segments connected in a linear fashion to form a linear chain.
34. The ethylene/ α -olefin interpolymers of claim 33, wherein the hard segments and soft segments are randomly distributed along the chain.
- 10 35. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the soft segments do not include a tip segment.
36. The ethylene/ α -olefin interpolymers of claim 1, 2, 19, or 20, wherein the hard segments do not include a tip segment.